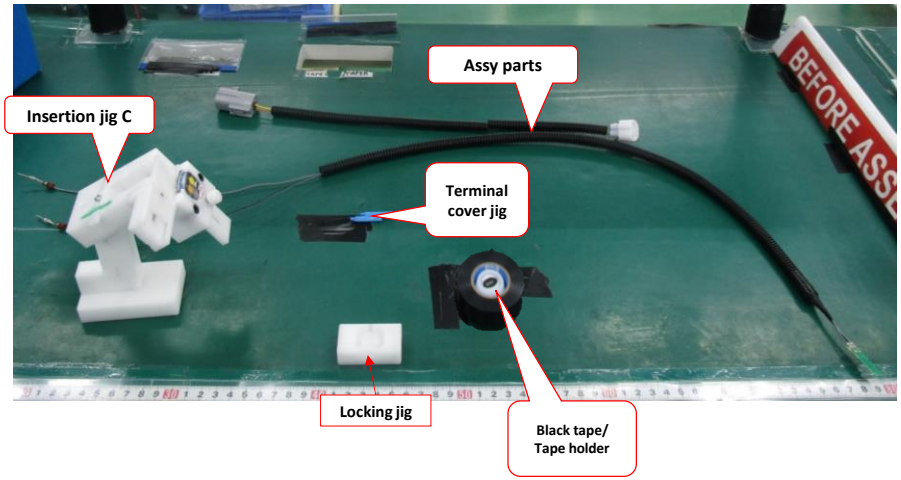
	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number: 178D / 7N0129-7020	Customer:	TRJ	Document No.:	WI-ENG-PDE-339B		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	1 of 7

PARTS:	1. Assy parts; Black tape [1pc]	JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
01/06/22	1	Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/20/21	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Est. Date:	September 20, 2021		

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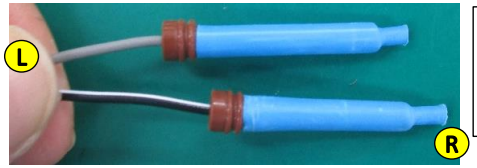
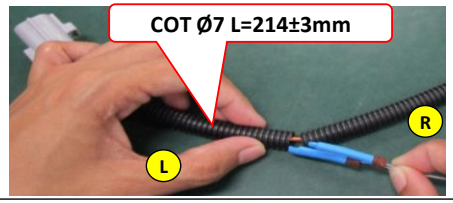
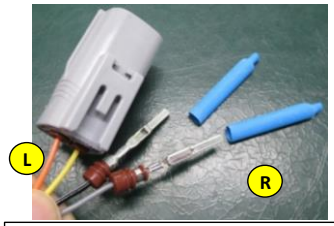
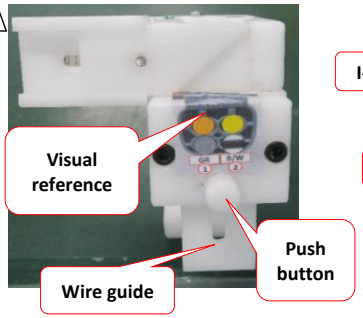
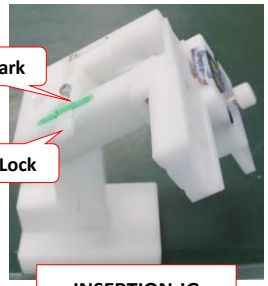
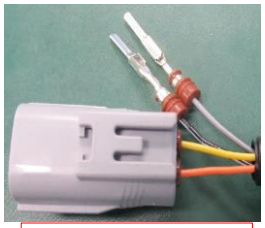
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 7

PARTS:	1. Assy parts	JIG	1. Terminal cover jig 2. Insertion jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to assy parts 1	 1. Get the **MRSW CP GR-B/W wires L=822±3mm** using both hands then insert the terminal cover jig using right hand.  2. Get the assy parts then hold the COT (no slit) **ϕ7 L=214±3mm** using left hand then insert the **MRSW CP GR-B/W wires L=822±3mm** using right hand.  3. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion
3		Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	1   	n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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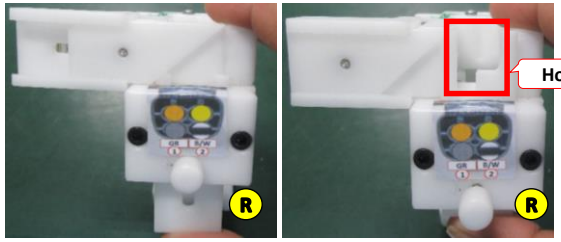
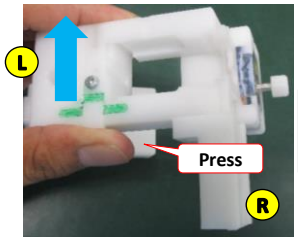
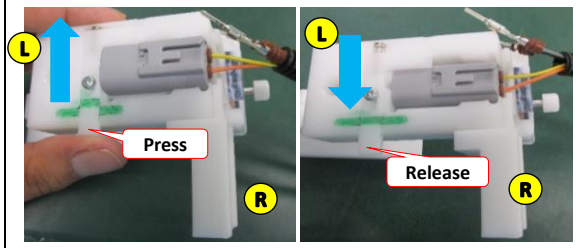
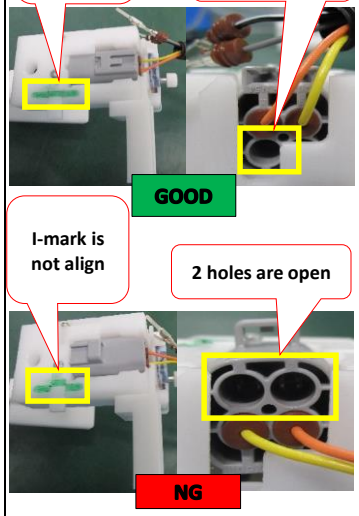
	Model Code/Part Number:	178D / 7N0129-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-339B	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 3 of 7

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Connector setting to insertion jig 6188-0066 (GR) (Assy parts) (Continuation)	1  1. Push the lower wire guide upward using right thumb. Slot for **Gray wire** will be opened.  2. Press the lock using left thumb.  3. Get the connector **6188-0066 (GR)** using right hand and insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.***	n/a	1 **CONNECTOR ORIENTATION ILLUSTRATION**  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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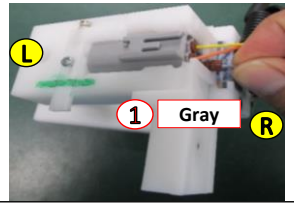
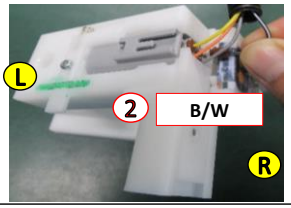
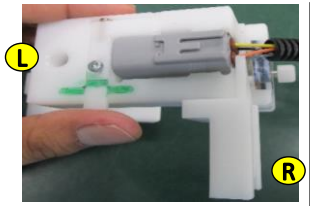
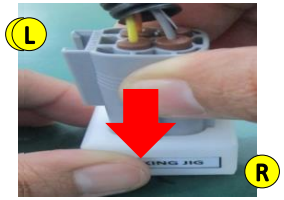
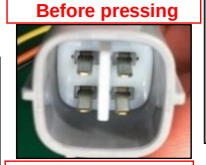
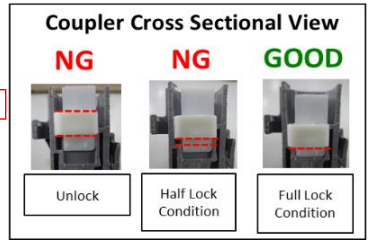
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 4 of 7

PARTS:	1. Assy parts	JIG	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to connector 6188-0066 (GR) (Assy parts)	1  1 Hold the **GR wire** then insert to terminal slot **1** using right hand. WIRE FACING 2. Press the button using right thumb. The slot for **B/W wire** will be opened.  3. Hold the **B/W wire** then insert to terminal slot **2** using right hand.  4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force. ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***
5		Connector Lock	 1. Put the connector into locking jig using both hands and then conduct **2x** pressing. Check the connector if properly locked. Before pressing  After pressing 	**Locking jig** 	***NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK*** 1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock

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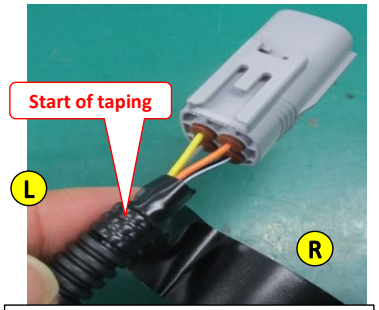
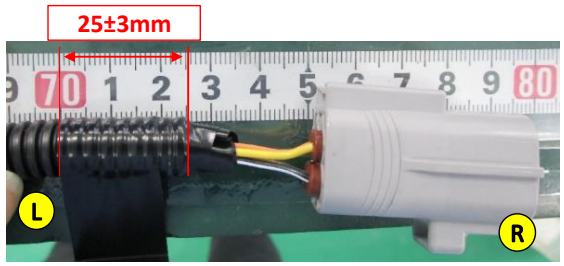
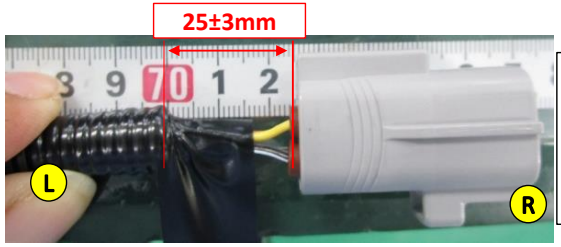
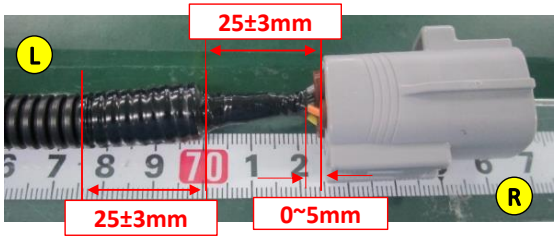
PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a	Taping 1 Black corrugated tube to wire near connector	 1. Hold the corrugated tube using left hand then start taping using right hand.  2. Confirm **25±3mm** measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.  3. Measure from end corrugated tube up to edge of connector **25±3mm** then continue the taping process using both hands.  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape ***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.*

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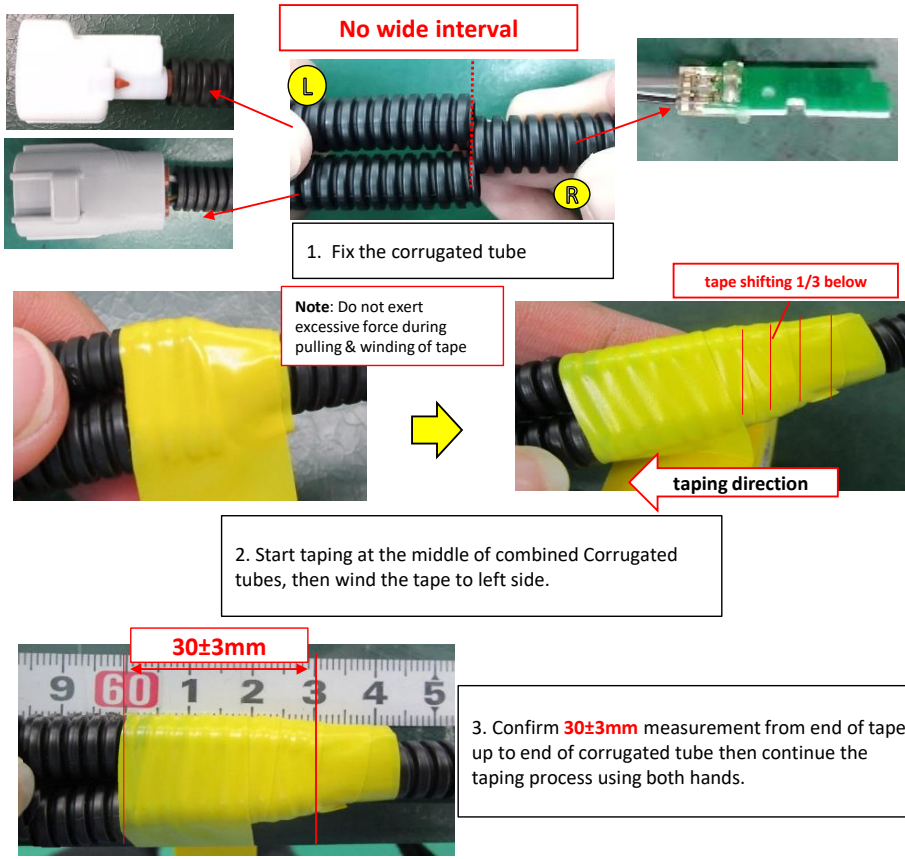
PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	n/a	Y-Taping		MEASURING TAPE 	**Note:** USE **YELLOW TAPE** FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE **BLACK TAPE.** 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape ***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.*

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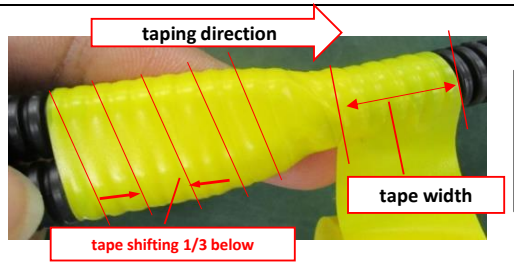
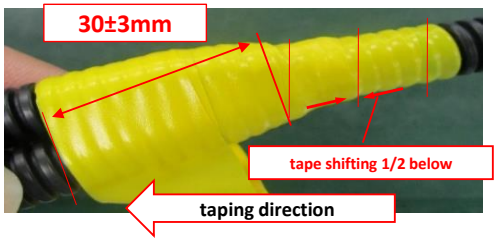
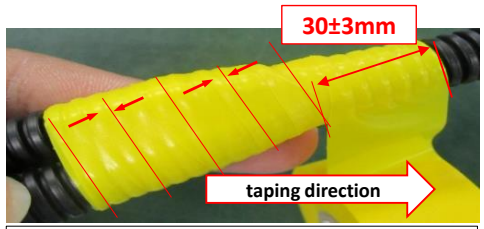
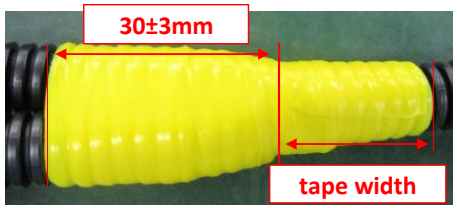
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	7 of 7

PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	n/a	Y-Taping (Continuation)	 4. Wind the tape **1/3 shifting** until it reach the other side of corrugated tube (must be tape width).  5. Make **2 windings** of tape then wind **1/2 shifting** going to other side.  6. Make **2 windings** of tape then wind the tape **1/2 shifting** going to other side of corrugated tube then make **3 windings** of tape and cut.  7. After taping, check the measurement and tape condition.	MEASURING TAPE 	**Note:** USE **YELLOW TAPE** FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE **BLACK TAPE.** 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape ***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.*

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