




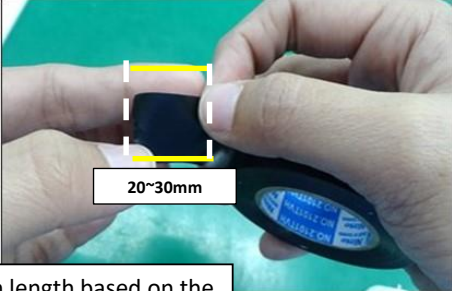


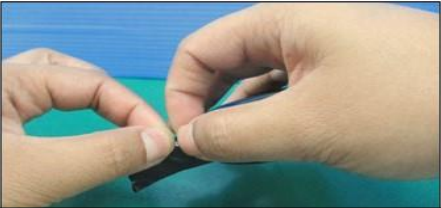













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| No. | Process Name | Work Procedure / Illustration | TOOLS/PPE | Records/Remarks/ Quality Pointers |
|-----|-----------------------|--|---|--|
| 1 | Tape Cutting Exercise |    <p>1.Get the BLACK Nitto Tape, W=19mm.</p> <p>2.Hold the tape properly using right hand.<i>NOTE:Fingers must be around the tape surface.Avoid inserting finger into tape core.</i></p>   <p>3.Using left hand, peel the tape with length based on the index finger line(20~30mm).</p> |  <p>TAPE HOLDER</p> | <p>1.Do not peel the tape with excessive length. 2.Avoid touching the full exposed adhesive tape during peeling.</p> |


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|----------------|---------|--|------------|---------------------|-------------|-----------------------------|-------|---------|
| 11/08/2024 | 6 | Inclusion of reminders for safety during process on page 2,and changes on sponge attachment on page 19 | L.Jasareno | C.Calayan | W.Carbillon | Prepare | Check | Approve |
| 07/26/2024 | 5 | Revise method of pressing end tape | | | | | | |
| 06/13/2024 | 4 | Added proper method of pressing/cutting of tape and good and no good adhesive of end tape | J.Jarito | A.Ayop | W.Carbillon | | | |
| 05/06/2024 | 3 | Include proper cutting of tape during taping | J.Jarito | A.Ayop | W.Carbillon | | | |
| 04/04/2024 | 2 | Include 1 wind of tape for undertape. | C.Recto | C.Calayan | W.Carbillon | | | |
| 04/08/2022 | 1 | Include proper hand level during taping and tape cutting | C.Recto | A.Porcalla/C.Lalica | O.Merin | | | |
| Eff./Rev. Date | Rev. No | Details of change | Revise | Check | Approve | Est. date: October 11, 2021 | | |






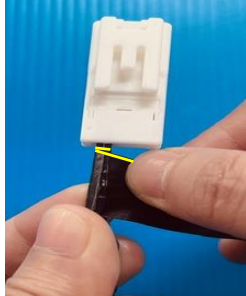


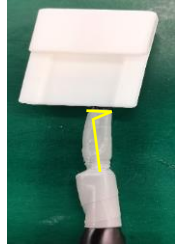

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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 2 | Tape Cutting (Continuation) | <div><div><p>4. Hold the tip of the peeled off tape using index and thumb of both hand. <i>Note: Do not touch the full adhesive surface.</i></p></div><div><div><p>Proper handling of tape during cutting.</p></div><div><p>5. Start cutting from top edge to bottom. <i>NOTE: Right hand must move in backward direction during cutting, avoid stretching the tape.</i></p><p>Proper hand level during taping and tape cutting, SHOULD BE CHEST LEVEL OR BELOW.</p><div><div><p>GOOD</p></div><div><div><p>End of tape has stretch mark and wrinkles due to stretching/pulling of tape during cutting.</p><p>End of tape was slantedly cut.</p></div></div></div></div></div></div> | | | N/A | <div>1. No stretchmark on end tape 2. No slanted cut of tape 3. No foreign material attached in the adhesive</div> <div>NOTE: All manpower required to wear glasses due to vision issues must wear them to avoid difficulties during the process and to maintain the required distance of the harness from the face for safety purposes."</div> |
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| No. | Process Name | Work Procedure / Illustration | Records/Remarks/ Quality Pointers |
|-----|--------------------------------|---|---|
| 3 | Tape Cutting (with harness) | Proper cutting of tape during taping to WIRE part. | Taping condition 1.No stretchmark on end tape 2. No touch on adhesive tape 3. Conduct 3x pressing to avoid peel off 4.No foreign material attached in the adhesive |
| | | ADHESIVE PART VIEW | |
| | | FRONT VIEW | |
| | | Proper cutting of tape during taping to Tube part | |
| | | ADHESIVE PART VIEW | |
| | | FRONT VIEW | |

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| 3 | Shift down before end of tape | <p><u>Slightly shift down</u> the tape from the original windings before tape cutting to avoid loose tape and peel off tape regardless of the tape position.</p> | <p>Taping condition</p> <ol style="list-style-type: none"> 1.No stretchmark on end tape 2. No touch on adhesive tape 3. Conduct 3x pressing to avoid peel off 4.No foreign material attached in the adhesive 5. End tape must be slanted. |
| | | <p align="center">SAMPLE ILLUSTRATION IN EVERY TAPING PROCESS</p> <div>     </div> <div>     </div> | |
| | | <div> <p align="center">END OF TAPE CONDITION</p> <p align="center">GOOD</p>  </div> <div> <p align="center">Slanted end tape</p> <p align="center">NO GOOD</p>  </div> | |





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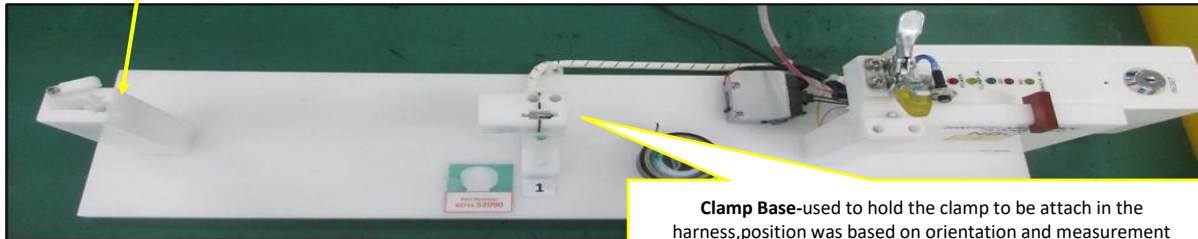

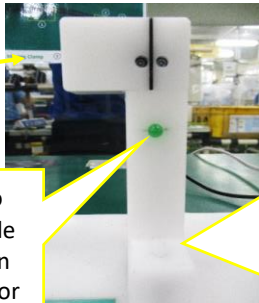
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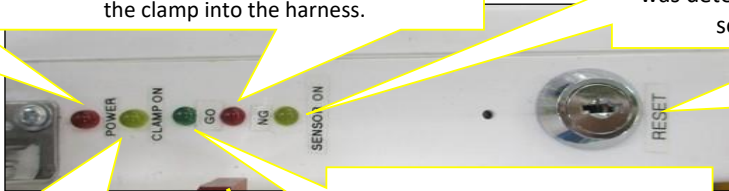
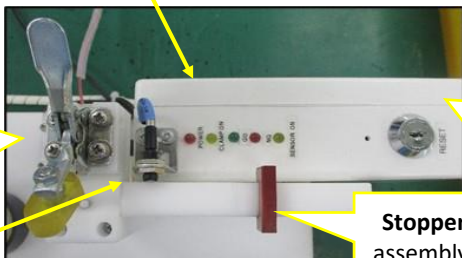


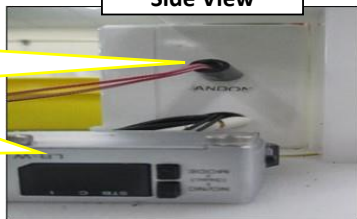
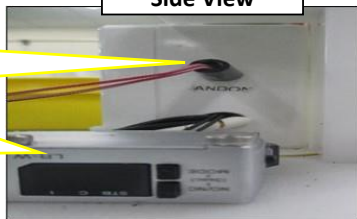


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| No. | Process Name | Work Procedure / Illustration | | Records/Remarks/ Quality Pointers |
|-----|------------------------------|---|--|--|
| 3 | Tape pressing (with harness) | <p>Proper pressing of end tape</p>  <p>Note: Left and right thumb orientation during pressing of end tape. Left: Press Right: Rotates</p>  <p>1st press - top part using left thumb (left to right) while right thumb rotates the harness (right to left).</p> <p>2nd press - middle part using left thumb (left to right) while right thumb rotates the harness (right to left).</p> <p>3rd press - bottom part using left thumb (left to right) while right thumb rotates the harness (right to left).</p> | <p>Improper pressing of tape</p> <p>FRONT VIEW</p>  <p>BACK VIEW</p>  <p>Note:</p> <p>Conduct 3x pressing regardless on what position of end of tape to prevent peel off and loose tape.</p> <p>while pressing avoid touching the adhesive</p> | <p>Taping condition</p> <ol style="list-style-type: none">1.No stretchmark on end tape2. No touch on adhesive tape3. Conduct 3x pressing to avoid peel off4.No foreign material attached in the adhesive |

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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 4 | Clamp Assembly Jig Overview | <div><div><div>Connector Receiver Base</div></div><div><div>Connector slider Lock-use to properly lock the connector in the receiver base,if cannot be locked possible connector condition was unlocked or halflocked(applicable to specific model).</div></div><div><div>GOOD</div></div><div><div>NO GOOD</div><div>Slider lock cannot adjust as connector was not fit on the receiver base due to halflocked condition.</div></div><div><div>Halflocked Condition</div></div></div> <div><div><div>Clamp Base-used to hold the clamp to be attach in the harness,position was based on orientation and measurement needed in the model.</div></div></div> <div><div><div>Clamp Base</div><div>Pokayoke-designed to avoid operator from attaching the clamp in wrong orientation.</div></div><div><div>Clamp Base Top View</div></div><div><div>Limit Switch-used to detect the prescence or absence of clamp during attachment.</div></div><div><div>Sequence Light-used to provide visual and audible indicators to operator on which clamp will be first or next to be attached.</div></div><div><div>Clamp Base</div><div>SWITCH BUTTON-used after attachment of clamp ,press to transfer the sequence light to the next clamp to be attached or when clamp assembly process are being done.</div></div></div> | | | N/A | <div>NOTE:Sample jig only</div> |
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| 5 | Clamp Assembly Jig Overview (continuation) | <div><p>Power Light-light indication when assembly jig power is ON.</p><p>NG/Skip Process-lights on when operator skip pressing the switch button then remove the harness into clamp assembly jig or operator press all needed switch but forgot to assembly the clamp into the harness.</p><p>GO Light-lights after finishing all clamp assembly process,indication to operator that harness was already FINISHED.</p><p>SENSOR ON-lights on when correct tape color was detected by color sensor.</p><p>Reset-for leaders purpose only.</p><p>Clamp on-lights on when there is a harness placed in assembly jig.</p><p>Toggle clamp-use to hold the unit during clamp assembly.</p><p>Controller Box-a box containing the device by which something may be regulated and controlled within the system.</p><p>Stopper Jig-use as a guide of harness in assembly jig to prevent wrong dimension during clamp assembly.</p><p>ANDON CONNECTOR-must be always plugged in to directly appeared the Line No.on the andon board one's an abnormality occur in jig.</p><p>COLOR SENSOR-helps to detect wrong usage of tape(applicable in models with colored tape).</p><p>SENSOR CONTROL-for maintenance purposes only.</p></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> | N/A | <div>NOTE:Sample jig only</div> |


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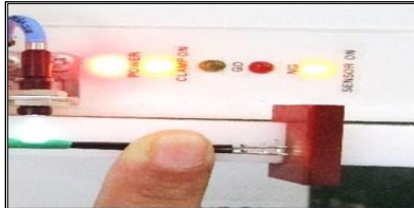

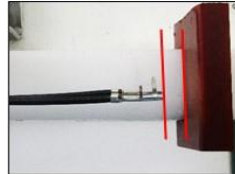

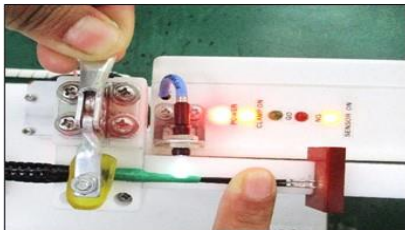

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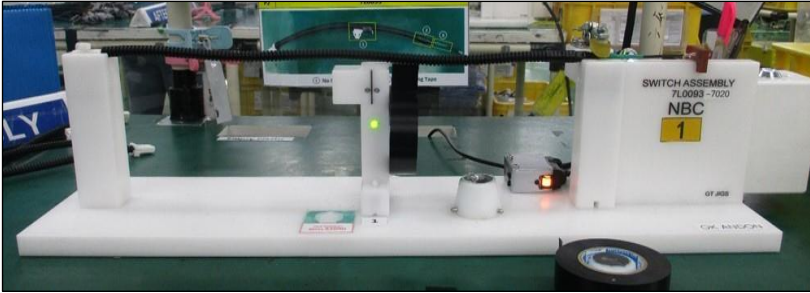

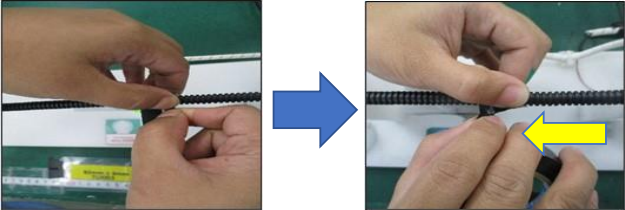
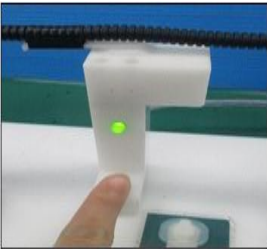

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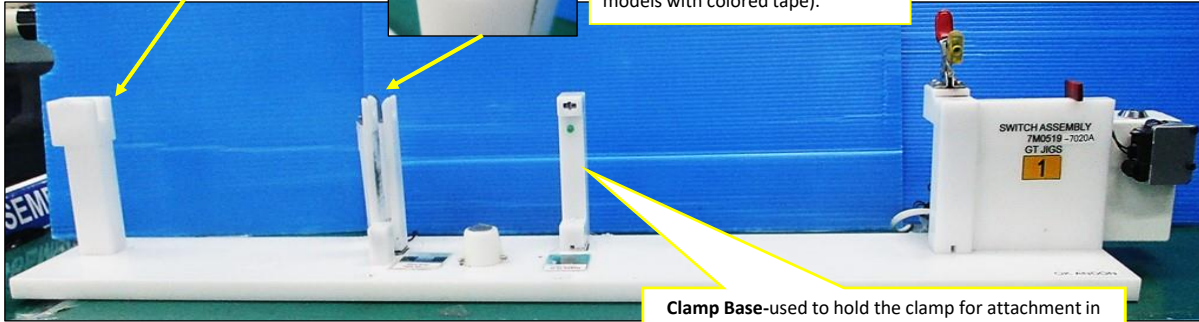


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| 6 | Clamp Setting | <div><div><p>1.Get 1 pc. of clamp(82711-52090) using right hand and set to jig location 1 using both hands.</p></div><div><p>GOOD -clamp attach counter in the pokayoke.</p></div><div><p>NO GOOD -clamp attach in the pokayoke part,cannot tape the clamp.</p></div><div><p>2.Get black tape using right hand then initially attach on the back side of the clamp using both hands.</p></div><div><p>3.Conduct 1 wind of tape to fully cover the backside of the clamp using both hands.</p></div><div><p>NO GOOD -backside of clamp is not fully covered</p></div><div></div></div> <div><p>SAMPLE CLAMP POSITION WITH CORRECT UNDERTAPE</p><div></div></div> | | | N/A | <div><p>NOTE:Sample jig only</p></div> <div><p>1.No damage clamp 2.No wrong use of clamp 3.No wrong use of tape 4.No missing under tape 5.No insufficient under tape</p></div> |
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| 7 | Assembled Harness Setting |  | | <div><div>GOOD</div><div>Connector slider lock is on the top middle of connector</div></div> <div><div>NO GOOD</div><div>Not using of connector slider lock</div><div>Not using of connector slider lock and not properly setting of connector</div><div>Used of connector slider lock but not properly set connector</div></div> | | N/A | <div>NOTE:Sample jig only</div> <div>1.No wrong orientation of connector 2.Correct usage of connector slider lock 3.No gap between terminal and stopper jig 4.Correct usage of toggle clamp 5.No twisted part of the harness.</div> |
| | |  | | <div><div>GOOD</div><div>End of terminal touches the stopper jig</div></div> <div><div>NO GOOD</div><div>With GAP between the terminal and stopper jig</div><div>Terminal was beyond the stopper jig</div></div> | | | |
| | |  | |  | | | |
| | | <div>1.Get the assembly harness then set the connector in receiver base using both hands.<i>NOTE:Make sure to properly set the connector to receiver base using connector slider lock.</i></div> <div>2.Put the terminal into stopper jig.</div> <div>3.Push down the toggle clamp until the harness locked.</div> | | <div>4.Check if "CLAMP ON" and "SENSOR ON"(if applicable) lights up.</div> | | | |
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| 8 | Clamp Attachment (Taping) | <div></div> <div><div>1. Hold the tape using right hand and corrugated tube using left hand then start winding the tape 3 times in same position .</div><div>2. Cut the tape using both hands. Place the left thumb near the tip of tape in the COT then hold the free tape using right thumb and index finger and with slight force move it going to left side. Conduct 3X pressing of end tape.</div><div>3. Press SWITCH BUTTON after taping.</div><div>4. Conduct point checking and remove harness from jig.</div></div> <div>N/A</div> <div><div>NOTE: Sample jig only</div><div>1. No damage clamp 2. No missing clamp 3. No wrong use of tape 4. No missing tape 5. No wrong attachment of clamp 6. No loose/tight clamp 7. No insufficient windings of tape 8. No excessive windings of tape</div></div> | | | | |
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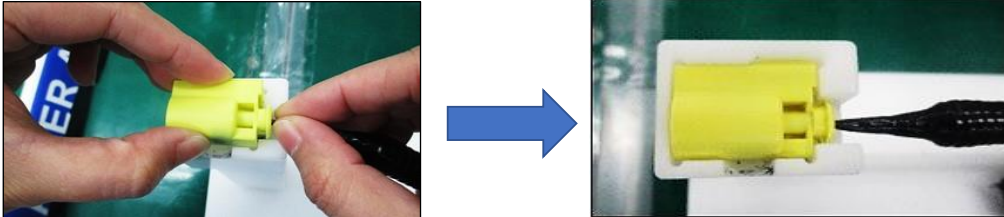



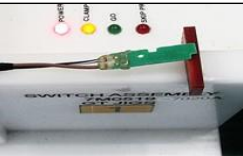

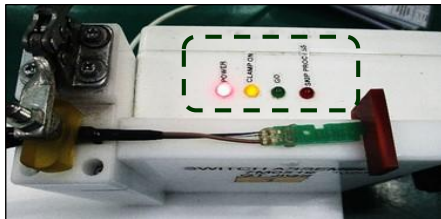

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| 9 | Clamp Assembly Jig Overview | <div><div>Connector Receiver Base</div><div></div><div>Connector Receiver Base-used as base of connector for easy setting of harness into jig,created depends on the shape or characteristic of the given connector and attached to jig based on the orientation and measurement needed in the model.</div><div></div><div>COLOR SENSOR-helps to detect wrong usage of tape(applicable to models with colored tape).</div><div></div><div>Clamp Base-used to hold the clamp for attachment in the harness,position was based on orientation and measurement needed in the model.</div><div>Limit Switch-used to detect the prescence or absence of clamp during attachment.</div><div>SWITCH BUTTON-use after attachment of clamp ,press to transfer the sequence light to the next clamp to be attached or when clamp assembly process are being done.</div><div>Clamp Base</div><div>Sequence Light-used to provide visual and audible indicators to operator on which clamp will be first or next to be attached.</div><div><p>NOTE:Other models with possibility to produce wrong attachment/orientation of bandclamp have also existing POKAYOKE. Sample:</p><div></div><div>Clamp Base Pokayoke-designed to avoid operator attach the clamp in wrong orientation.</div></div></div> | | | N/A | <div>NOTE:Sample jig only</div> |
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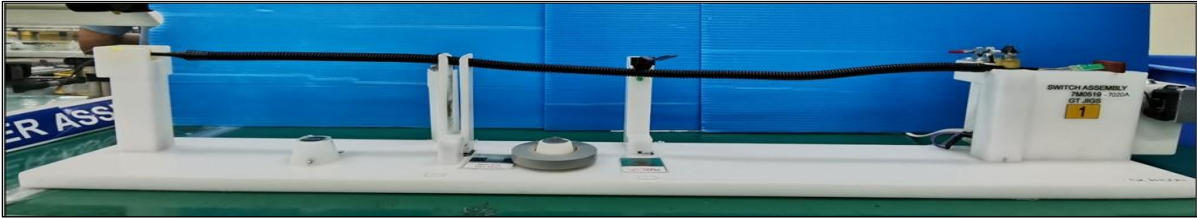
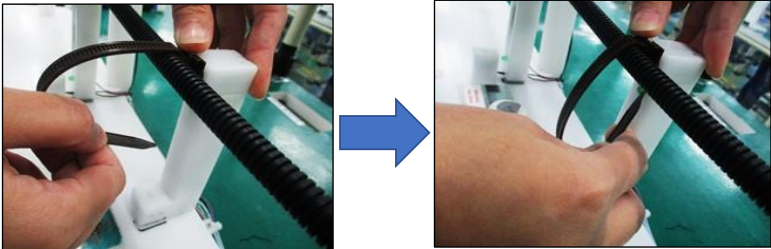
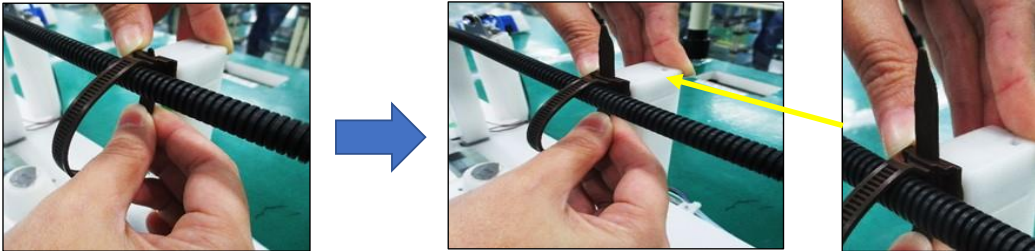
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| 10 | Clamp Assembly Jig Overview (continuation) | <p>NG/Skip Process-lights on when operator skip pressing the switch button then remove the harness into clamp assembly jig or operator press all needed switch but forgot to assembly the clamp into harness.</p> <p>Power Light-light indicator when assembly jig power is ON</p> <p>Clamp on-lights on when there is harness placed in assembly jig.</p> <p>GO Light-lights after finished all clamp assembly process,indicator to operator that harness was already FINISHED.</p> <p>Reset-for leaders purpose only.</p> <p>Toggle clamp-use to hold instantly the unit during clamp assembly.</p> <p>Controller Box-a box containing the device by which something may be regulated and controlled within the system.</p> <p>SENSOR CONTROL-for maintenance purposes only.</p> <p>Stopper Jig-use as a guide of harness in assembly jig to prevent wrong dimension during clamp assembly.</p> <p>Side View</p> <p>ANDON</p> <p>ANDON CONNECTOR-must always be plugged in to directly appeared the Line No.on the andon board one's there is an abnormality occur in jig.</p> | N/A | <p>NOTE:Sample jig only</p> |


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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers | |
| 11 | Bandclamp Setting | <div><div>1.Get 1 pc. of bandclamp(82711-34490) using right hand and set to jig location 1 using both hands.</div></div> | | | N/A | <div>NOTE:Sample jig only</div> | |
| | | <div><div>GOOD</div><div></div></div> | | <div><div>NO GOOD</div><div></div></div> | | <div>NOTE:Bandclamp orientation during setting depends on the given model.</div> | |
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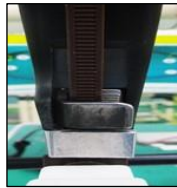







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| No. | Process Name | Work Procedure / Illustration | TOOLS/PPE | Records/Remarks/ Quality Pointers | |
| 12 | Assembled Harness Setting | <div><p>1.Get the assembly harness then set the connector in receiver base using both hands. <i>NOTE:Make sure to properly set the connector to receiver base.</i></p></div> <div><div><p>2.Put the PCB into stopper jig.</p></div><div><div><p>GOOD</p><p>End of PCB touches the stopper jig</p></div><div><p>NO GOOD</p><div><p>With GAP between the PCB end and stopper jig</p><p>PCB was beyond the stopper jig</p></div></div></div><div><div><p>3.Push down the toggle clamp until the harness locked.</p></div><div><p>4.Check if "CLAMP ON" and "SENSOR ON"(if applicable) lights up.</p></div></div></div> | | <div><p><i>NOTE:Sample jig only</i></p><ol style="list-style-type: none">1.No wrong orientation of connector2.Correct usage of connector slider lock3.No gap between PCB end and stopper jig4.Correct usage of toggle clamp5.No twisted part of the harness</div> | |
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| 13 | Bandclamp Attachment |   <p>1. Hold the clamp tail using right hand and clamp head in the base using left hand then bend until reach the hole in head part of the clamp tail.</p>  <p>2. Insert the end of clamp tail into the hole until the needed length comes out to hold it during tightening.</p> | | <p>NOTE: Sample jig only</p> <p>1. No damage clamp 2. No missing clamp 3. No wrong attachment/orientation of clamp</p> |

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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 14 | Bandclamp Attachment (continuation) | <div><div>3.Hold the protruded clamptail then pull upward to initially tighten.</div><div></div><div></div><div></div><div>4.Get the bando gun using right hand then insert the bandclamp tail from its side.</div><div></div><div></div><div>5.Slightly press the trigger for additional tightening of bandclamp then back to the normal position.</div><div></div><div>6.Press again the trigger with additional force to totally cut the bandclamp tail.</div><div>7.Press the SWITCH BUTTON after attachment.</div><div>8.Conduct point checking and remove harness from jig.</div><div>GOOD</div><div>NO GOOD</div></div> <td></td> <td><div>NOTE:Sample jig only</div><div>NOTE:Bando gun must be perpendicularly aligned on the receiving base of bandclamp during cutting.</div><div><div>NG</div><div>OK</div><div>NG</div></div><div>1.No damage clamp 2.No missing clamp 3.No wrong attachment of clamp 4.No loose/tight clamp</div><div></div><div>NOTE:Check the bandclamp setting depend on diameter of COT. ø=5mm,1-2 ø=7mm,3-4</div></td> | | |  | <div>NOTE:Sample jig only</div> <div>NOTE:Bando gun must be perpendicularly aligned on the receiving base of bandclamp during cutting.</div> <div><div>NG</div><div>OK</div><div>NG</div></div> <div>1.No damage clamp 2.No missing clamp 3.No wrong attachment of clamp 4.No loose/tight clamp</div> <div></div> <div>NOTE:Check the bandclamp setting depend on diameter of COT. ø=5mm,1-2 ø=7mm,3-4</div> |

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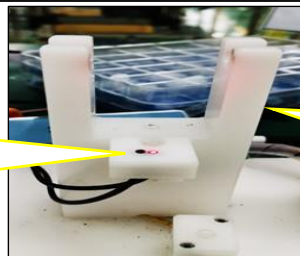



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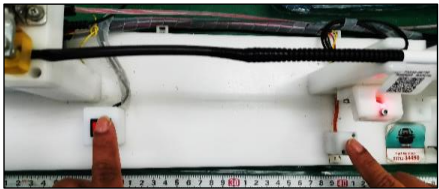

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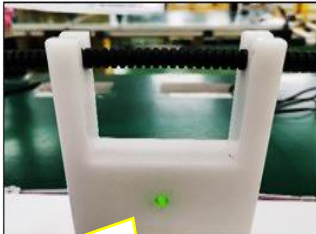



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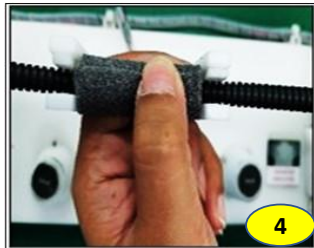

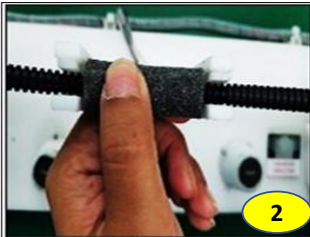
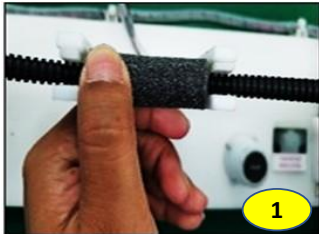
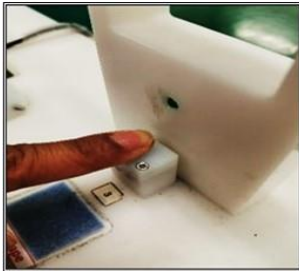
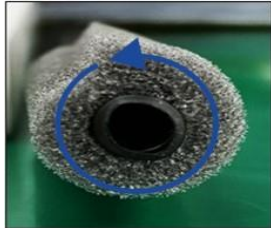
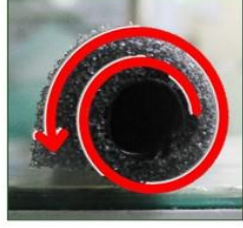

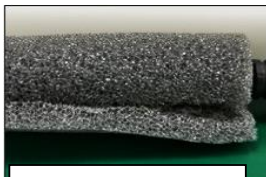
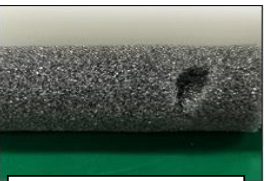



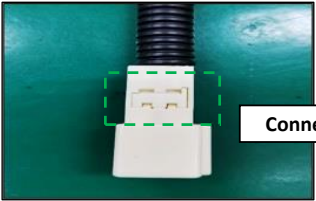

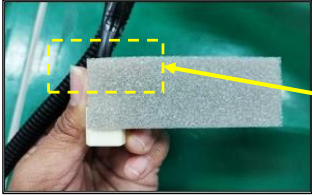




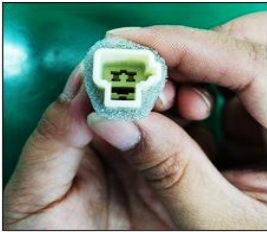



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|--------|--------------------|--|-----------|--------------------------------------|-----------|--------|-------------|------------------|--------|-------------|---------------|--------|-------------|-----------------|--------|-------------|--------------|-----|---|
| 15 | QR code Attachment | <div><div><div>LABEL ATTACHMENT GUIDE</div><div><div><div>LABEL SENSOR-helps to detect missing QR code.</div><div></div><div><div>LABEL ATTACHMENT GUIDE-used as guide to easily attach the label depends on the location required per model.</div></div></div></div><div><div></div><div><div><div>30</div><div>Model Code</div></div><div><div>73230-06750 PASSENGER MANUAL 7L0032</div><div>Item No. and Name</div></div></div><div><table><tr><th>Model</th><th>Item No.</th><th>Item Name</th></tr><tr><td>7L0030</td><td>73230-06750</td><td>Passenger Manual</td></tr><tr><td>7L0031</td><td>73230-06740</td><td>Driver Manual</td></tr><tr><td>7L0032</td><td>73230-06620</td><td>Passenger Power</td></tr><tr><td>7L0033</td><td>73230-06760</td><td>Driver Power</td></tr></table></div></div><div><div>1.Get the label on label dispenser provided.NOTE:Check the model code,item no. and name.</div><div><div><div><div>Item No. and Name</div><div>Model Code</div></div><div><div>2.Align edge of the label near the printed model code in the lower part of the guide then attach the center at the back of COT.</div><div><div>3.Fold the center part of label then align both edges properly.</div></div></div></div></div></div></div></div> | Model | Item No. | Item Name | 7L0030 | 73230-06750 | Passenger Manual | 7L0031 | 73230-06740 | Driver Manual | 7L0032 | 73230-06620 | Passenger Power | 7L0033 | 73230-06760 | Driver Power | N/A | 1.No wrong use of QR code 2.No wrong orientation/facing of QR code |
| Model | Item No. | Item Name | | | | | | | | | | | | | | | | | |
| 7L0030 | 73230-06750 | Passenger Manual | | | | | | | | | | | | | | | | | |
| 7L0031 | 73230-06740 | Driver Manual | | | | | | | | | | | | | | | | | |
| 7L0032 | 73230-06620 | Passenger Power | | | | | | | | | | | | | | | | | |
| 7L0033 | 73230-06760 | Driver Power | | | | | | | | | | | | | | | | | |

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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 16 | QR code Attachment (continuation) | <div><p>4.After attaching of edges,press the label with both fingers until both side was properly attached.</p></div> <div><p>5.Press the label in upward and downward direction using finger to properly attached around the COT.</p></div> <div><p>GOOD</p><p>Acceptable tolerance for uneven attachment : 0~1mm</p></div> <div><p>NO GOOD more than 1mm</p></div> <div><p>NO GOOD Loose attachment</p></div> <div><p>6.Press the SWITCH BUTTON after label attachment.</p></div> <div><p>7.Conduct POINT CHECKING and remove the harness from jig.</p></div> | | | N/A | 1.No wrong use of QR code 2.No wrong orientation/facing of QR code 3.No loose attachment 4.No damage 5.No peel-off 6.No wrinkle 7.No bubbles 8.No missing parts |
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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 17 | Sponge Tape Attachment (with jig/in COT) | <div><div>Sponge Attachment Guide</div><div></div><div>SPONGE ATTACHMENT GUIDE- used as guide to easily attach the label depending on the location required per model.</div></div> <div><div></div><div></div><div></div><div>1.Get and slightly peel the sponge tape then attach directly on the upper part of corrugated tube using both hands.Avoid touching the adhesive of sponge tape during attachment.</div><div>2.Press the edge of sponge tape against the COT to properly attached the adhesive.</div><div>3.Slowly wrap to corrugated tube using right hand.Follow the guide for the correct location of sponge tape. <i>NOTE:Do not stretch or pull the sponge tape.</i></div></div> <div>N/A</div> <div>1.No wrong attachment 2.No wrong use of sponge tape 3.No damage sponge tape</div> | | | | |
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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 18 | Sponge Tape Attachment (with jig/in COT) (continuation) | <div>3.After attachment of sponge tape,make 5 times slow pressing from left to right using left thumb.</div> <div></div> <div><div>4.Press the SWITCH BUTTON after attachment.</div></div> <div><div>Standard Attachment</div></div> <div><div>NO GOOD stretch attachment</div></div> | | | N/A | <div>1.No peel-off attachment 2.No loose/tight attachment 3.No wrong attachment 4.No missing sponge tape 5.No wrong use of sponge tape 6.No damage sponge tape</div> <div><div>No Good Attachment of Sponge Tape</div><div>with gap on guide of jig</div></div> <div><div>Peel-off Sponge</div></div> <div><div>Damaged Sponge</div></div> |
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| No. | Process Name | Work Procedure / Illustration | | | TOOLS/PPE | Records/Remarks/ Quality Pointers |
| 19 | Sponge Tape Attachment (manual/ connector) | <div><p>Connector Lock</p></div> <div><p>1. Identify the right facing of connector to attach the urethane foam, connector lock must be visible.</p></div> <div></div> <div><p>2. Get the sponge tape then hold the connector using left hand and begin the attachment.</p></div> <div></div> <div><p>3. Attach the foam in all sides of the connector. <i>NOTE: Follow the attachment sequence based on the illustration.</i></p></div> <div><p>4. Press the sponge tape side by side after attachment.</p></div> <div><p>0-3mm tolerance from edge of sponge tape to Connector</p></div> | | | N/A | <div><p>DO NOT STRETCH THE SPONGE TAPE DURING ATTACHMENT</p><p>GOOD</p><p>NO GOOD (tight attachment) -sponge tape stretch during attachment</p><p>1.No peel-off attachment 2.No loose/tight attachment 3.No wrong attachment 4.No missing sponge tape 5.No wrong use of sponge tape 6.No damage sponge tape</p></div> |
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