
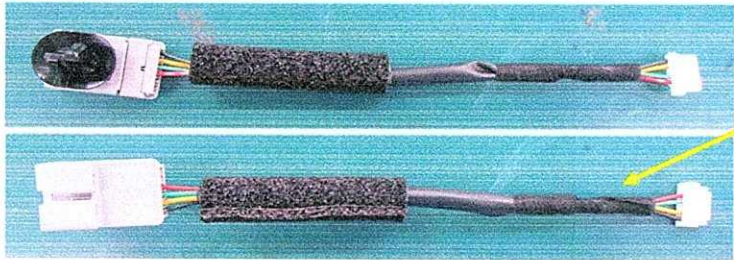
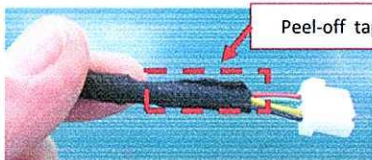


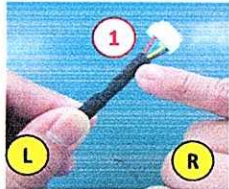

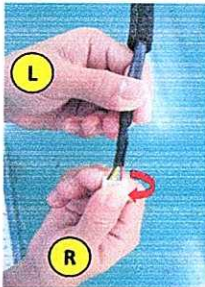

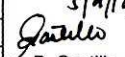
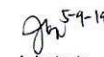
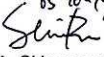





|  |                              |                 |                       |
|--|------------------------------|-----------------|-----------------------|
| Process Name/Title:<br><b>REPAIR PROCEDURE FOR PEEL-OFF TAPE</b> |                              | Document No:    | <b>WI-ENG-PDE-013</b> |
| WORK INSTRUCTION   |                              | Effective Date: | <b>May 10, 2019</b>   |
| Product Code/Name:<br>15E210-0091                                | Customer Code:<br><b>TRP</b> | Rev.No.: 0      | Page No.: 1 of 2      |


| No.            | Work Procedure / Illustration |  |  |                   |  |          | Records/Remarks/<br>Quality Pointers |  |   |   |  |
|----------------|-------------------------------|--|--|-------------------|--|----------|--------------------------------------|--|---|---|--|
| 1              | Check peel-off tape           | <div></div> <div>Get 1 piece of 15E210 harness that have peel-off tape.</div>   |  |                   |  |          |                                      | 1. Do not press the peel-off tape  |   |   |  |
| 2              | Push-up the tape              | <div></div> <div>1. Hold the harness using left hand then put your right pinky finger to the peel-off tape and slightly push-up the tape. Make it 3 times.</div> <div>2. After pushing up the tape, check the peel-off tape.</div> |  |                   |  |          |                                      | 1. Do not press the peel-off tape<br>2. Do not peel all of tape                                      |   |   |  |
| 3              | Bending wire and coupler      | <div></div> <div>After checking the peel-off tape. Hold the harness using left hand and slowly bend the coupler to enhance the peel-off tape for cutting.</div>  |  |                   |  |          |                                      | 1. Do not over bend  |   |   |  |
|                |                               |  |  |                   |  |          |                                      | Prepared   | Checked   | Approved  | Noted  |
|                |                               |  |  |                   |  |          |                                      | <br>D. Castillo | <br>J. Loterte | <br>A. Shimamura | <br>A. Aranes |
| Eff./Rev. Date |                               | Rev. No  |  | Details of change |  | Prepared | Checked                              | Approved   | Noted   | Est. date:  |  |


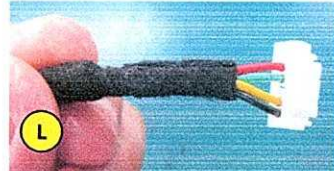


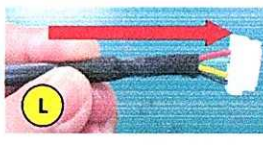
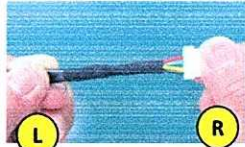
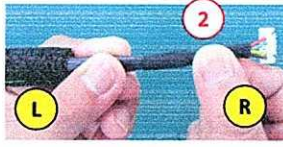
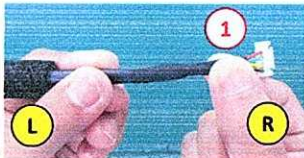

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|   |  |                       |                 |                       |
|---|--|-----------------------|-----------------|-----------------------|
|  | Process Name/Title:<br><b>REPAIR PROCEDURE FOR PEEL-OFF TAPE</b> |                       | Document No:    | <b>WI-ENG-PDE-013</b> |
|   | <b>WORK INSTRUCTION</b>  |                       | Effective Date: | <b>May 10, 2019</b>   |
|   | Product Code/Name:<br>15E210-0091                                | Customer Code:<br>TRP | Rev.No.: 0      | Page No.: 2 of 2      |

| No. | Work Procedure / Illustration |  | Records/Remarks/<br>Quality Pointers                                     |
|-----|-------------------------------|--|--|
| 4   | Cutting peel-off tape         | <div><div></div><div></div></div> <div><p>1. Hold the harness using left hand and hold the scissor using right hand. Then cut peel-off tape slowly and carefully.</p><p>2. After cut, check the peel-off residue.</p></div> <div><div><p><b>GOOD</b></p><p>WITH BEND</p></div><div><p><b>NG</b></p><p>WITHOUT BEND</p></div></div> | <p>1. Do not cut the wire</p> <p>2. No tape, coupler and wire damage</p> |
| 5   | Pressing the tape             | <div></div> <div><p>1. After cutting the tape, make 2 times pressing.</p><p>2. Hold the coupler using right hand then straight the wire and coupler slowly.</p></div>   | <p>1. No peel-off tape</p> <p>2. No flip-out tape</p>                    |
| 6   | Visual inspection             |    |  |