	_				WORK INST	TRUCTION					Effe	ctivity Date:			March 31,	2022	
			Process Name/Title:		TAPING	<b>ASSEMBL</b>	Y PROC	ESS			Valid	dity Date:			n/a		
	-1		Model Code/Product Number:	200D /	7R0130-7020	Customer:		TRJ			Doc	ument No.:			WI-ENG-PD	E-459	
			Purpose:	☐ PROTOTY	PE	PRE-LAUNCH		MASS	PRO		Revi	ision No.:		0	Page No.:	1	of 20
<u>                                     </u>											•		<u>'</u>		•		
PARTS:			ector 6098-6662(W) of 0.3 Y-OR wire L=731±3n	nm									JIG	1. Locking Jig			
NC	).	PF	ROCESS NAME		WORK PR	OCEDURE/	ILLUSTRA	TION			-	TOOLS/P	PE		QUALITY PO	INTER	S
1		n/a	Wire Insertion to Connector 6098- 6662(W)		Orange Orange ector using left hand. Get the insert to connector using	WIRE FAC	ING  2. Get the Yell right hand.		1 (2) SUAL REFE  Yello 2	R	professional profe	Alert leve For any troul inform the ssembly Assi upervisor or Leader for immediate orrective act	ear sonal iring ves, itc.) ing and e 5's. iings ace is ep it ble, e stant tine	1. No loose in: 2. No wrong ir 3. One by one 4. No deforme 5. No wrong w  Make su inserted. Conduct insertion  Note: Rej Pull-Push	sertion insertion determinal ire facing re wires are pull-Push-Push-Push-Push-Push-Push-Push-Push	roperly ll-Push	after 19 for
1	1				Revision History		1		I	Г		Prepare	d by	Reviewed by	Approved	by	Noted by
03/31/22	0	Initial Iss	SUE					M.Ariola	J. Loterte	C. Villanueva	A.Arañes	M.Ario	nla	J. Loterte	C. Villanu	eva	A.Arañes
Eff.Date F		uai 153	Juo.	Details of	of Change			Revised	Reviewed	Approved	Noted	Est. Date:		March 31, 2022		cva	A.AIGIICS
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		WORK INSTRUCT	TION		Effectivity Date:		T	March 31	, 2022
	Process Name/Title:	TAPING ASS	EMBLY PROCESS		Validity Date:	-		n/a	a
	Model Code/Product Number:	200D / 7R0130-7020	Customer: <b>T</b>	RJ	Document No.:			WI-ENG-P	DE-459
	Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		0	Page No.:	2 of 20
PARTS:	1.Connector 6098-6662(W) 2. AVSSf 0.3 Y-OR wire L=731±3				T0010/	JIG	1. Lockii		
NO.	PROCESS NAME	WORK PROCEL	DURE/ ILLUSTRATION		TOOLS/	7PE	Q	UALITY PO	DINTERS
2	Connector Lock	1. Put the connector into locking jig using both hands then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked.  Note: Please refer to GL-PRO-ASY-017 for the	Before Pressing  GOOD	After Pressing  NG	Locking		1. Use the		

Wire insertion to Black
Corrugated tube (No slit)
Ø5 L=94±3mm



verification of connector lock.

1.Get the Black COT Ø5 L=94±3mm using right hand and insert Y-OR wires using left hand.

Fully Locked

Unlocked

No wrong use of parts
 No deformed terminal

n/a

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Model Code/Product Number:	200D	1	7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-	PDE-459		
Purpose:	<b>□</b> P	ROTOTY	PE	PRE-LAUNCH	☐ MASSPRO	Revision No.:	0	Page No.:	3 of 20		

1.Assy parts PARTS: JIG n/a 2. Black tape WORK PROCEDURE/ILLUSTRATION **QUALITY POINTERS** PROCESS NAME TOOLS/PPE NO. 25±3mm Note: 1. Measure from end of Corrugated tube up to Please use calibrated/verified end of connector 25±3mm using both hands. measuring tape when getting the measurement. **MEASURING TAPE** 678911123456789 25±3mm pale Total paper 20 Start of taping 1. No flip-out tape 2. No peel-off tape Taping 1 to Black 3. No loose tape 4 Corrugated tube to wire 4. No missing tape near connector 25±3mm 5. No wrong use of tape 0~5mm 6. No wrong dimension R 2. Get the Black tape using right hand then 3. After taping, check the measurement and start taping process using both hands. taping condition. Note: Please refer to WI-PRO-ASY-001 for taping procedure.

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				WORK INSTRUC	CTION		Effectivity Date:		March 31, 2022
		Process Name/Title:		TAPING ASS	SEMBLY PRO	OCESS	Validity Date:		n/a
		Model Code/Product Number:	200D /	7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-PDE-459
		Purpose:	☐ PROTOTYP	E	PRE-LAUNCH	MASSPRO	Revision No.:		0 Page No.: 4 of 20
PARTS:	1. Assy 2. Black	parts Corrugated tube Ø7 L=290	6±3mm	3.Black Corrugated tube 4.Connector 7282-1060		No slit)		JIG	1. n/a
NO.	PF	ROCESS NAME		WORK PROCE	DURE/ ILLUS	TRATION	TOOLS/	PPE	QUALITY POINTERS
5		Wire insertion to Black Corrugated tube Ø7 L=296±3mm (No Slit) Ø7 L=268±3mm (No Alit)	L		slit) using rigusing left had  1.Get the Blaslit) using righusing left han	nck COT <b>Ø7</b> L=268±3mm (No ht hand and insert Y-OR wires	n/a		No wrong usage of parts     No deformed terminal.
6	n/a	Wire Insertion to Connector 7282-1060 (W)	Visual Reference  1. Hold the connecto the Yellow wire and using right hand.	Yellow R or using left hand. Get	2. Get the Orang right hand.	Wire facing  Orange  R  ge wire and insert to connector using	n/a		Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance  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.  Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.

					WORK INSTRUC	TION			Effectivity Date:		T	March 31	I, 2022
		Process Name/Title:			TAPING ASS	SEMBLY PRO	CESS		Validity Date:			n/	a
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		Purpose:	☐ PROT	OTYPE	•	PRE-LAUNCH		MASSPRO	Revision No.:		0	Page No.:	5 of 20
											T		
PARTS:		nector 6098-3802 (W) SSf 0.3 V-G L=707±3mm								JIG	1.Lockin	g jig	
NO.	P	PROCESS NAME			WORK PROCE	DURE/ ILLUS	RATION		TOOLS/	PPE	QI	JALITY P	OINTERS
7	n/a	Wire insertion to connector 6098-3802 (W)		and ins	CONNECTOR  Violet  R  using left hand. Get sert to connector	2. Get the Gree right hand.	n wire and ins	Green R	n/a		1. No loc 2. No wr 3. One b 4. No de 5. No wr Make si inserted Conductinsertio	cond Strip Tole  cose insertion  cong insertion  cong insertion  formed termi  cong wire faci  cure wires are  d.  ct Pull-Push-Pu	n on inal ing properly ull-Push after
8		Connector lock	right hand the	n press	nto locking jig using 2x to lock. Touch the firm if properly locked.	Before pressin	ng Eu	OOD NG  I Lock  Half Lock	LOCKING	3 JIG	1. Use the	UAL LOCKING AGED LOCK.	ocking jig per

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Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.

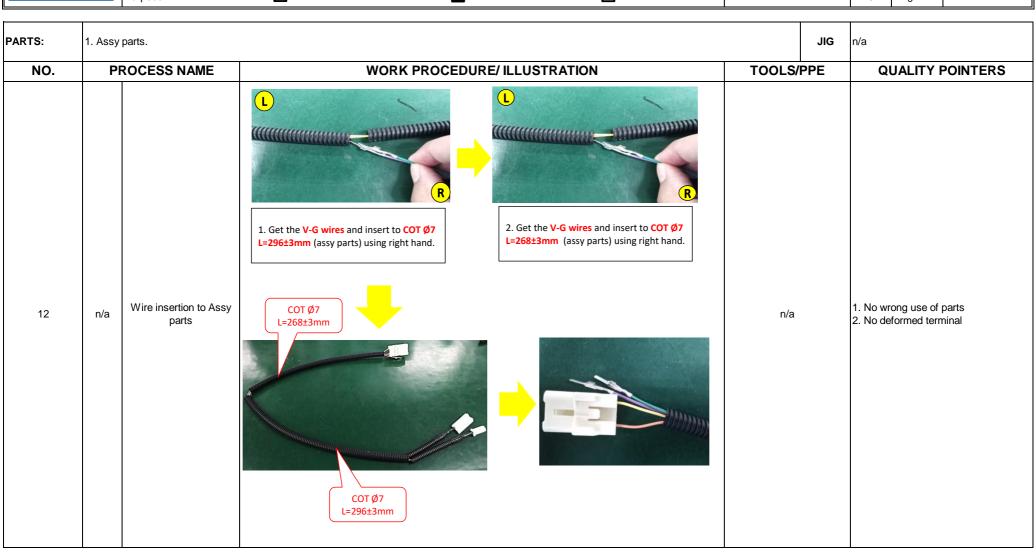
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	Model Code
	Purpose:

			WORK INSTRU	JCTION		Effectivity Date:		March 3	31, 2022
Process Name/Title:			TAPING AS	SSEMBLY PRO	CESS	Validity Date:		n	n/a
Model Code/Product Number:	200D	1	7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-	PDE-459
Purpose:	☐ P	ROTOTY	PE	PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.:	6 of 20

TS:	1. Assy 2. Clip t	parts. ype clamp 82711-50491 (B			JIG	n/a
NO.	PI	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/	PPE	QUALITY POINTER
9		Wire insertion to Assy parts	1. Hold the connector using left hand, get the clip type clamp 82711-50491 (B) then insert the clamp using right hand.  Note: Sound will be heard if properly inserted.	n/a		1.Clamp must be fully inserted
10	n/a	Wire insertion to Black Corrugated tube(No slit) Ø5 L=71±3mm	1.Get the Black COT Ø5 L=71±3mm using right hand and insert V-G wires using left hand.	n/a		No wrong use of parts     No deformed terminal

					WORK INSTRU	CTION		Effectivity Date:			March 31,	2022
		Process Name/Title:			TAPING AS	SEMBLY P	ROCESS	Validity Date:			n/a	
		Model Code/Product Number:	200D	/	7R0130-7020	Customer:	TRJ	Document No.:			WI-ENG-PD	E-459
		Purpose:		PROTOTYP	PE	PRE-LAUNCH	MASSPRO	Revision No.:		0	Page No.:	7 of 20
PARTS:	1. Assy 2. Black	parts. tape							JIG	n/a		
NO.	PF	ROCESS NAME			WORK PROC	EDURE/ ILLU	STRATION	TOOLS	/PPE	QI	UALITY PO	INTERS
11	n/a	Taping 2 Black Corrugated tube to Wire near connector	Start of	f taping the assy pa	n end of Black Corrugated or 25±3mm using both han Reference to the state of the st	L B	25±3mm 25±3mm 9 4 0 1 2 3 4 5 6  a width  R  g, check the measurement and taping	6 7 8 9 40 1 2 3 1	4 5 6 7 8 9 6	1. No flij 2. No pe 3. No loo 4. No m	Please use ated/verified when getting urement.  p-out tape pel-off tape pose tape issing tape arong use of tape arong dimension	the e

			WORK INSTRUCT	ΓΙΟΝ		Effectivity Date:		March 31, 2022		
Process Name/Title:			TAPING ASS	EMBLY PRO	CESS	Validity Date:		n/a	l	
Model Code/Product Numb	er: <b>200D</b>	1	7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-PI	DE-459	
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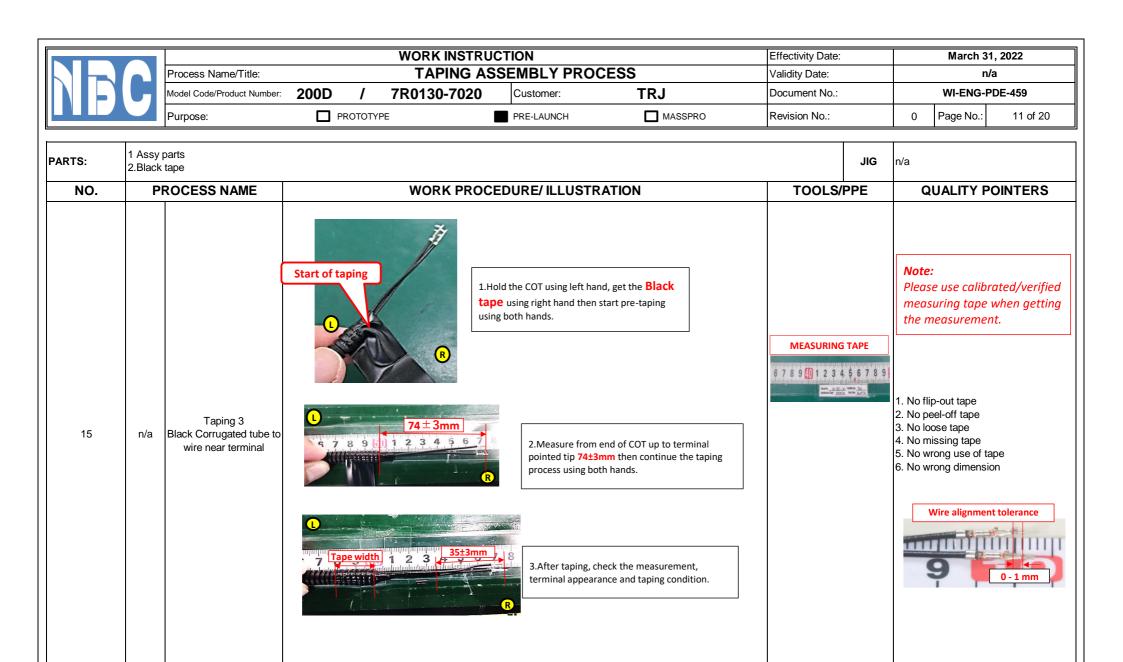


			WORK INSTRU	CTION		Effectivity Date:		March 3	31, 2022	
Process Name/Title:			TAPING AS	SSEMBLY PRO	CESS	Validity Date:		n/a		
Model Code/Product Number:	200D	1	7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-	PDE-459	
Purpose:		PROTOTY	PE	PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.:	9 of 20	

1. Assy parts. PARTS: JIG n/a 2. AVSSf 0.3 V-G wires L= 707±3mm **QUALITY POINTERS PROCESS NAME** WORK PROCEDURE/ILLUSTRATION TOOLS/PPE NO. Note: Refer to WI-PRO-Visual **CNC-017 for Wire and Strip** Reference **Tolerance** Wire facing **Connector Setting** 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal Violet 5. No wrong wire facing Wire insertion to connector 13 n/a n/a 7282-1060 (W) Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Note: Refer to GL-PRO-ASY-1. Hold the connector using left hand. Get the 029 for Pull-Push 2. Get the Violet wire and insert to connector Green wire and insert to connector using right using right hand. procedure. hand.

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	•						l .			
PARTS:	1. Black 2. AVSS	Corrugated tube Ø5 L=20 of 0.3 B wires L= 576±3mn	0±3mm (No slit) า					JIG	1. Terminal cover c	lig
NO.	PF	ROCESS NAME		WORK PROCE	DURE/ ILL	USTRATION	ТО	OLS/PPE	QUALITY	POINTERS
14	n/a	Wire insertion to Black Corrugated tube Ø5 L=200±3mm (No slit)	1. Get the terminal chand then insert the hand.		3. After insert jig using right	2. Get the Black COT Ø5 L=200±3mm slit) using right hand and insert B-B was using left hand.  on, remove the terminal covernand.	Term	inal cover Jig	1. No wrong use of 2. No deformed ter	





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					RK INSTRU				Effectivity Date:			March 31	
		Process Name/Title:				SEMBLY PI			Validity Date:			n/a	
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										ı	1		
PARTS:	1. Assy 2. AVSS	parts of 0.3 B wires L= 576±3mn	า							JIG	n/a		
NO.	PF	ROCESS NAME		WC	ORK PROCI	EDURE/ ILLU	STRATION		TOOLS/	PPE	Q	UALITY P	OINTERS
16	n/a	Wire insertion to Black COT Ø7 L=268±3mm (No slit) (Assy parts)	L=268		COT Ø7 L=294±3mm (No slit)  R  ne B-B wires and by parts) using rig	insert to COT Ø7 L=	-268±3mm (No	R	n/a			rong use of p eformed termi	

			WOR	KINSTRUCTION		Effectivity Date:			March 31	, 2022
Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.: 0 Page No.:  1. Assy parts.		Process Name/Title:	TA	PING ASSEMBLY PR	OCESS	Validity Date:			n/a	1
DAPTS: 1. Assy parts.		Model Code/Product Number:	200D / 7R01	<b>0-7020</b> Customer:	TRJ	Document No.:			WI-ENG-PI	)E-459
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO	Revision No.:		0	Page No.:	13 of 20
							JIG	1.Connec	ctor Lock	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY P	NO.	PROCESS NAME	WC	RK PROCEDURE/ ILLUS	TRATION	TOOLS/	PPE	Ql	JALITY PO	DINTERS

Visual Reference







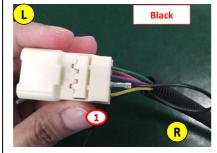
Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance

- 1. No loose insertion
- 2. No wrong insertion
- 3. One by one insertion
- 4. No deformed terminal

n/a

5. No wrong wire facing

Wire Insertion to 17 n/a Connector



Black

Make sure wires are properly inserted. Conduct Pull-Push-Pull-**Push** after insertion

1. Hold the connector using left hand. Get the 1st wire and insert to connector using right hand.

2. Get the 2nd Black wire using left hand and insert to connector using right hand.

Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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		Model Code/Product Number:	200D	1	7R0130-7020	Customer:	TRJ	Document No.:	
		Purpose:	☐ PI	ROTOTY	PE	PRE-LAUNCH	MASSPRO	Revision No.:	
									1
PARTS:	1. Assy	parts							JIG

TS:	1. Assy	рапѕ				J	JIG 1. Locking Jig
NO.	Pi	ROCESS NAME	WOR	K PROCEDURE/ ILLUST	TOOLS/PPE	QUALITY POINTERS	
18		Connector Lock	1. Put the connector into locking press 2x to lock. Touch the conne properly locked. Note: Please refethe verification of connector locked.	ector lock to confirm if fer to GL-PRO-ASY-017 for	BEFORE PRESSING  AFTER PRESSING	LOCKING JIG	1. Use the provided locking jig permodel 2. No unlock/half-lock connector  NOTE:  MANUAL LOCKING MAY CAUS DAMAGED LOCK.
19	n/a	Taping 4 Black Corrugated tube to wire near connector	Black tape using right taping.  30 ± 3mm	connector 30±3mm using		6 7 8 9 10 1 2 3 4 5 6 1	1. No flip-out tape 2. No peel-off tape 3. No loose tape

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		Process Name/Title:	TAPING	ASSE	EMBLY PROCES	38		Validity Date:			n/	<i>l</i> a	
		Model Code/Product Number:	200D 7R0130-702	20	Customer:	TRM	X	Document No.:			WI-ENG-F	'DE-459	
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	1									1			
PARTS:	1. Assy 2. Black								JIG	n/a			
NO.	PF	ROCESS NAME	WORK PF	ROCEDI	URE/ ILLUSTRATI	ION		TOOLS/F	PPE	Q	UALITY P	OINTERS	
20	n/a	Y-Taping 1	1. Fix the corrugated tube .  taping direction  tape shifting 1/3 below  tape shifting 1/2  4. Winding the tape backward 1/2 shifting.	2. Stubbull 3. Noth	Start taping at the midd bes, then winding the tabes, width must be 18±3  Winding the tape 1/3 sher side of corrugated to 18±3mm  Ing the tape 1/2 shifting ted tube then cut the tape of tape.	ape going to Bmm.  hifting until ube, width r  9mm below	it reach the must be 20mm.  O±3mm  her side of	Note: Please use calibrated/ver measuring tap when getting measurement  Measuring	the	1. No flii 2. No pe 3. No lo 4. No m 5. No w	p-out tape eel-off tape ose tape issing tape rong use of ta rong dimension	ACTUAL ACK.	

			WORK INSTR				Effectivity Date:	March 31, 2022
		Process Name/Title:		<b>ISSE</b>	MBLY PROCES	iS	Validity Date:	n/a
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PARTS:	1. Assy 2. Black						JIG	n/a
NO.	P	ROCESS NAME	WORK PRO	CEDL	URE/ ILLUSTRATION	ON	TOOLS/PPE	QUALITY POINTERS
21	n/a	Y-Taping 2	shifting.	3. V oth	Start taping at the middl bes, then winding the tap bes, width must be 22±31  Winding the tape 1/3 sh her side of corrugated tu  Tape shifting 9  22±3mm	aifting until it reach the ube, width must be 20mm.  Domm below 20±3mm	Note: Please use calibrated/verified measuring tape when getting the measurement.  Measuring tape	NOTE: USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.  1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension



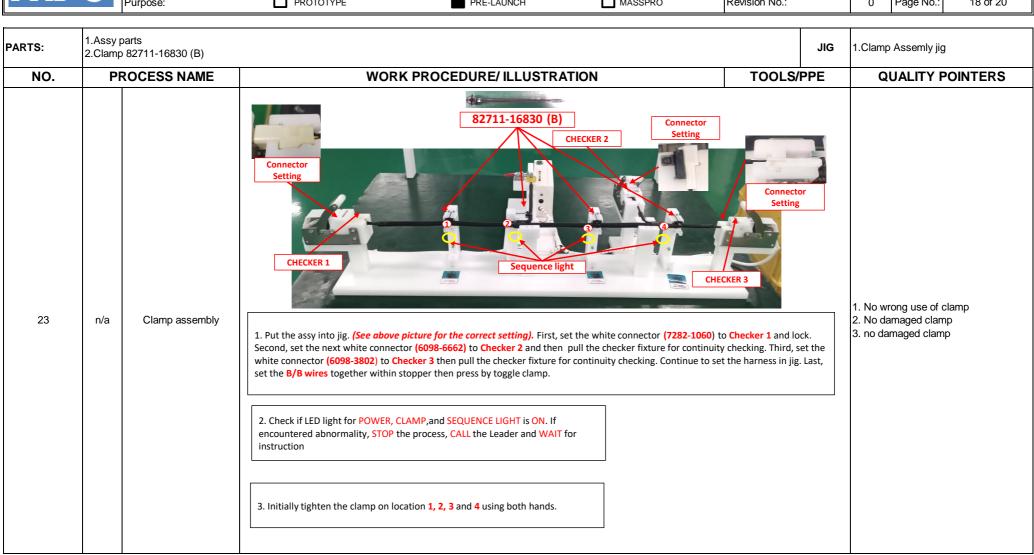
			WORK INSTRU	CTION		Effectivity Date:		March 31, 2022			
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Model Code/Product Number:	ber: <b>200D</b> / <b>7R0130-70</b> 2		7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-PDE-459			
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1.Assy parts PARTS: 1.Clamp Assemly jig JIG 2.Clamp 82711-16830 (B) **QUALITY POINTERS** PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE NO. 82711-16830 (B) 1. No wrong use of clamp 1. Get 1pc of Band clamp 82711-16830 (B) using right hand and set to 22 Clamp setting 2. No damaged clamp n/a clamp location 1 using both hands. Note: Please check the clamp first before 3. no damaged clamp start assembly to avoid wrong use of clamp. 2. Get 1pc of Band clamp 82711-16830 (B) using right hand and set to clamp location 2 using both hands. 3. Get 1pc of Band clamp 82711-16830 (B) using right hand and set to clamp location 3 using both hands. 4. Get 1pc of Band clamp 82711-16830 (B) using right hand and set to clamp location 4 using both hands

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Model Code/Product Number:	200D / 7R0130-7020		7R0130-7020	Customer:	TRJ	Document No.:		WI-ENG-	PDE-459		
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PARTS:	1.Assy 2.Clamp	parts 5 82711-16830 (B)						JIG	1.Clamp	Assemly jig	
NO.	P	ROCESS NAME		WORK PROC	EDURE/ ILLUS	STRATION	TOOLS/I	PPE	Q	UALITY PO	DINTERS
24	n/a	Connect Setting Continuation)	4. Get the Bando on location 1 usic cutting of bando was on.  5. Cut the bando Press the SW but process if clamp  6. Cut the band of Press the SW but	82711  O Gun using right hand and cut ng both hands. Press the SW becamp. Continue the process if the clamp on clamp location 2 using too after cutting of band clamp location 3 was on.  Itamp on clamp location 3 using too after cutting of band clamp on clamp location 4 was on.	Sequence light  the band clamp that a fter clamp location 2  g both hands. p. Continue the		BANDO GI	JN	2. No da 3. No wr 4. No loc  Note: Se depends tube.	ong use of cla imaged clamp ong setting of ose/tight clamp etting of band clar on the size of the 1~2, ø7 - 3~4	bando gun o attachment

				WORK INSTR	Effectivity Date:		March 31, 2022			
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