TAPING ASSEMBLY PROCESS Validity Date: TAPING ASSEMBLY PROCESS Validity Date: TRJ Document No: WH-RNG-PDE-353A Purpose: PROF DOTO THE PRE-LAUNCH Revision No: 1 Connector 7282-1027 (W) 2 Connector 7282-1027 (W) 2 Connector 7282-1027 (W) 3 Nays No: NO: PROCESS NAME WORK PROCEDURE ILLUSTRATION TOOLS/PFE QUALITY POINTERS AVSS 0.3 OR vire L=153-27mm 5. AVSS 0.3 OR vire L=153-27mm 6. Black Viring fube a7 L=1113-35mm 8. Black Viring fube a7 L=1113-35mm 9. Black Viring fube a7 L=11113-35mm 9. Black Viring fube a7 L=1113-35mm 9. Black Viring f					_	WORK	INSTRU	CTION					Effectivity Date):	December 9, 2022		
Purpose: PRCHOTYPE PRE-LAUNCH MASSIRRO Revision No.: 3 Page No.: 1 of 9 PARTS: 1. Connector 7465400-000 (W) 4. AVSSI 0.3 Y wire L=153±2mm 7. Black Vinyl tube a7 L=111±3mm 8. Black Vinyl tube a7 L=111±3mm 9. Black Vinyl tube a8 L=136±3mm 9. Black Vinyl tube a9 L=1			Process Name/Title:			TAPI	ING ASS	SEMBLY PR	ROCESS				Validity Date:			n/a	
PARTS: 2. Connector 4G5400-000 (W) 5. A AVSSI 0.3 OR wire L=153a:2mm 7. Black Vinyl tube a7 L=111.8mm 8. Black Vinyl tube a5 L=135a:3mm 9. JIG: 2. Connector 7282-1027 (W) 5. A AVSSI 0.3 OR wire L=153a:2mm 8. Black Vinyl tube a5 L=135a:3mm 9. JIG: 2. Pushing Jig 3. Insertion Jig 3. Jig 4. Insertion Jig 5. Pushing Jig 5. Insertion Jig 4. Insertion Jig 5. Insertion Jig 5. Insertion Jig 5. Insertion Jig 5. Insertion Jig 6. Black Vinyl tube 3. Insertion Jig 6. Pushing Jig 6. Insertion Jig 6. In			Model Code/ Part Number:	D01L	1	7M0651-7	7020C	Customer:		TI	RJ		Document No.	•	V	VI-ENG-PDE-35	3A
PARTS: 2. Connector 7282-1027 (N) 5. AVSSI 0.3 OR WIRE L=15322mm 6. Black Virty table 6. L=135.63mm JIC: 2. NVSSI 0.3 Pick virty table 6. L=06.93mm (No Sili) 9. Black tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PE QUALITY POINTERS TABLE LAY-OUT T			Purpose:		PROTOTYP	PE		PRE-LAUNCH		MASS	PRO		Revision No.:		3	Page No.:	1 of 9
PARTS: 2, Connector 7282-1027 (W) 5, AVSSI 0.3 OR WIR L=15322mm 6, Black Viral 10 9, Black tape 10 98, AVSSI 0.3 Feet to wear prescribed of the process of t		1												1			
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PE QUALITY POINTERS TABLE LAY-OUT TABLE LAY-OUT Connector 7282- 3027 (vy)/ Connector 1749 Connector 17	PARTS:													IIG:			
Table Lay-out Table	ARTO.							nm (No Slit)				L=100±01	11111	510.	2. Pushing jig		
Table Lay-out P1 Table Lay-out Revision History Revision His	NO.	PR	OCESS NAME			WORK	K PROCE	DURE/ ILLUS	STRATION				TOOLS	S/PPE	QUA	ALITY POINT	ERS
12/09/22 3 Improve Quality pointers on pages no. 1,3,5,6,7 and 8 due to document improvement. Improve work procedure/ illustration on process no.7- Connector lock due to process improvement. Inclusion of Quality checkpoints. 05/25/22 2 Remove Process no. 12,13,14,15 and 16 and transfer to P2 due to process improvement. 11/25/21 1 Change from Pre-launch to Masspro; Improve Work Procedure/ Illustration; Additional Table Lay-out. M.Ariola J. Loterte C. Villanueva A. Arañes M.Ariola J. Loterte C. Villanueva A. Arañes M.Ariola J. Loterte C. Villanueva A. Arañes	1	P1	Table Lay-out	4G5400-000 (W)/ Connector Tr Insertion Jig w/ switch	ray	Cor tu L=6	Black rrugated ube ø5 50±3mm	Black Vinyl tube ø7 L=111±3mm AVSSf 0.3 wire L=153±2	AVSSf 0.3 Y wire =153±2mm	(w)/ ttor Tray	tube ø5 L=135±3mm SSf 0.3 B 58±3mm Tape holder/Black		Be sure to wee personal pequipmer operation (glacots, costs, cost	er prescribed rotective it during oves, finger etc.) eeping and always e 5's. inings on the prohibited. our locker. evel e, inform the Assistant Line Leader e corrective	2. No exce A Docu 1. Refer Wire an 2. Refer	ument reference to WI-PRO-CNI d Strip length tol to WI-ENG-P	C-017 for erance. DE-353A
illustration on process no.7- Connector lock due to process improvement. Inclusion of Quality checkpoints. O5/25/22 2 Remove Process no. 12,13,14,15 and 16 and transfer to P2 due to process improvement. M.Ariola J. Loterte C. Villanueva A. Arañes M.Ariola J.	_					Revision Histo	tory					•		Prepared by	Reviewed by	/ Approved by	Noted by
05/25/22 2 Remove Process no. 12,13,14,15 and 16 and transfer to P2 due to process improvement. M.Ariola J. Loterte C. Villanueva A. Arañes	12/09/22 3								ure/	M.Ariola	J. Loterte	C. Villanu	ueva A. Arañes				
The state of the s	05/25/22 2									M.Ariola	J. Loterte	C. Villanu	ueva A. Arañes	holy	(Saw)	Month Tillow	SHOW
Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date: October 11, 2021	L	Change												M.Akiela	J. Loterte	C. Villanueva	A. Aranes
	Eff. Date Rev. No				Details of	of Change				Revised	Reviewed	Approv	red Noted	Est. Date:	October 11,	2021	

			WORK IN:	STRUCTION		Effectivity Date:	December 9, 2022
		Process Name/Title:	TAPIN	G ASSEMBLY PROCES	S	Validity Date:	n/a
		Model Code/ Part Number:	D01L / 7M0651-70	O20C Customer:	TRJ	Document No.:	WI-ENG-PDE-353A
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.: 2 of 9
PARTS:	1. Conn	ector 4G5400-0000 (W)				JIG	Insertion jig with switch cover
NO.	PI	ROCESS NAME	WORK F	PROCEDURE/ ILLUSTRATIO	N	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 4G5400-0000 (W)	Insertion Jig I-MARK Holes 1. Press the lock of insertion jig using left thumb.	Insertion jig Orientation 2. Insert the connector 4G5400-000 then release the lock using left thur Note: Follow the connector oriental Hole 3. Push the low	Release O W) using right hand nb.	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place 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. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

			WORK INS	TRUCTIO	N		Effectivity Date:		December	9, 2022
		Process Name/Title:	TAPING	3 ASSEN	IBLY PROCES	S	Validity Date:		n/a	
		Model Code/ Part Number:	D01L / 7M0651-70	20C Cu	ustomer:	TRJ	Document No.:		WI-ENG-PI	DE-353A
		Purpose:	☐ PROTOTYPE	☐ PR	E-LAUNCH	MASSPRO	Revision No.:		3 Page No.:	3 of 9
		<u>I</u>					1		<u>'</u>	
PARTS:		Sf 0.3 Y wire L=153±2mm Sf 0.3 OR wire L=153±2mr	m	3.	Black vinyl tube ø7 L=	:111±3mm		JIG	1. Insertion jig w/ swit	ch cover
NO.	PF	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					PPE	QUALITY POINTERS	
3	P1	Wire insertion to connector 4G5400-0000 (W)	1. Hold the insertion jig using left hand, get Yellow wire then insert to terminal slot 1 using right hand. C Orange 3. Get the Orange wire then insert to terminal slot 2 using right hand.		Wire Faci	2. Press the button using right hand, slot for Orange wire will be opened. 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 termi 5. No wrong wire facin 1. Please hold the wire terminal during inse 2. Make sure wires inserted. Conduct Pull-Push-Pinsertion. Do not exert extra for 1. Refer to GL-PRO-Pull-Push procedure 2. Refer to WI-PRO-Wire and Strip length	nal ng i/Note/s: ire near rtion. are properly ull-Push after orce. e/s: ASY-029 for . CNC-017 for
4		Wire insertion to Black vinyl tube Ø7 L=111±3mm		R	1. Hold the assy parts vinyl tube Ø5 L=111± insert the wires using	using left hand, get the 3mm using right hand then left hand.	n/a		No deformed termi No wrong usage of	

				WORK INSTRUC	CTION		Effectivity Date:	December 9, 2022
		Process Name/Title:		TAPING AS	SEMBLY PRO	DCESS	Validity Date:	n/a
		Model Code/ Part Number:	D01L /	7M0651-7020C	Customer:	TRJ	Document No.:	WI-ENG-PDE-353A
		Purpose:	☐ PROTOTY	/PE [PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.: 4 of 9
		<u> </u>						<u> </u>
PARTS:	1. Conn	ector 7282-1027 (W)					JIG	Insertion jig w/ switch cover
NO.	PI	ROCESS NAME		WORK PROCE	DURE/ ILLUST	TRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Connector setting to insertion jig 7282-1027 (W)	Insertion jig I-MARK Hol	wire OR-wire Button	Insertion Orient 2. Insert the connecrelease the lock usin Note: Follow the connecret to t	Connector Orientation tation Ctor 7282-1027 (W) using right hand then	n/a	Connector Orientation Illustration I-mark was align I hole is open I hole i

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			Effectivity Date:		December 9, 2022				
Process Name/Title:			TAPING ASS	SEMBLY PRO	OCESS	Validity Date:		n	/a
Model Code/ Part Number:	D01L	1	7M0651-7020C	Customer:	TRJ	Document No.:		WI-ENG-F	PDE-353A
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RTS:	1. Assy p	oarts				JIG 1. Insertion jig
NO.	PR	ROCESS NAME	WORK P	ROCEDURE/ ILLUSTRATION	TOOLS/PP	PE QUALITY POINTERS
6	P1	Wire insertion to connector 7282-1027 (W)	1. Hold the insertion jig using left hand, get Yellow wire then insert to terminal slot 1 using right hand. 2 Orange 3. Hold the insertion jig using left hand, get Orange wire then insert to terminal slot 2 using right hand.	Wire Facing 2. Press the button using right hand, slot for Orange wire will be opened. 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 Important reminders/Note/s: 1. Please hold the wire near termiduring insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

NAA	Process Nam
	Model Code/ Pa
	Purpose:

			Effectivity Date:		December 9, 2022				
Process Name/Title:			TAPING ASS	EMBLY PRO	CESS	Validity Date:		n/	'a
Model Code/ Part Number:	D01L	1	7M0651-7020C	Customer:	TRJ	Document No.:		WI-ENG-P	PDE-353A
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1. Assy parts PARTS: 1. Pushing jig 2. Black vinyl tube ø5 L=135±3mm NO. **PROCESS NAME** WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE **QUALITY POINTERS** 1. No wrong usage of parts 2. No deformed terminal Important reminders/Note/s: **BEFORE PRESSING** 1. Manual locking may cause damaged connector lock 2. Position of pushing jig **PUSHING JIG** 1. Place the connector on the table while holding using left hand. Get the locking must be slanted. Pushing jig using right hand and start the sequential locking based on above 7 Connector Lock **AFTER PRESSING** Push the lower part of the connector lock first and then push the upper part Note: Position of pushing jig during locking must be slanted. P1 4. Ensure that connector is in locked condition by slide touching the connector lock GOOD based on the sequence illustrated. 1.Get the B-B wire using left hand and get Wire insertion to the vinyl tube ø5 L=135±3mm then insert 1. No deformed terminal 8 Black vinyl tube n/a using right hand. 2. No wrong usage of parts ø5 L=135±3mm

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			WORK IN	STRUCTION		Effectivity Date:	December 9, 2022
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		Model Code/ Part Number:	D01L / 7M0651-7	020C Customer:	TRJ	Document No.:	WI-ENG-PDE-353A
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<u> </u>							
PARTS:	1. Assy 2. Black					JI	G n/a
NO.	PI	ROCESS NAME	WORK	PROCEDURE/ ILI	LUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Taping 1 Black Vinyl tube to wire near terminal	25±3mm 65±3m C 8 9 50 1 2 3	1. f ter	Measure from end of vinyl tube up to minal pointed tip 65±3mm using both hands. Using right hand then start taping nds.	6 7 8 9 10 1 2 3 4 5 6 7	1. No flip-out tape
			25±3mm U 25±3mm		After taping, check the measurement, bing condition and terminal appearance.		9 0-1mm

		WORK INSTRUCTION	Effectivity Date:	December 9, 2022
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	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ☐ MASSPRO	Revision No.:	3 Page No.: 8 of 9
	T			
PARTS:	Assy parts Black corrugated tube Ø5 L=	3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	Wire insertion to Black corrugated tub (No slit) Ø5 L=60±3mm	1. Get the corrugated tube (No Slit) Ø5 L=60±3mm using right hand then insert using left hand.	n/a	No deformed terminal wrong usage of parts
11	P1 Taping 2 Black Corrugated tub to Black Vinyl tube	Note: Must be no gap between COT and vinyl 1. Fix the corrugated tube to vinyl tube using left hand then get Black tape and start taping using right hand. 2. After taping, check the tape condition & measurement.	6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 12 3 4 5 6 7 8 9 10 12 3 4 5 6 7 8 9 10 12 3 4 5 6 7 8 9 10 10 10 10 10 10 10 10 10 10 10 10 10	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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Must be no gap between the COT and vinyl.

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Purpose: Prototype Pre-launch Masspro	Revision No.:	3 Page No.: 9 of 9
PARTS: n/a	JIG	n/a
QUALITY CHECKPOINTS	-	
P1 7M0651-7020C		
		6 Sample Referrence
GOOD		
NO GOOD 3		GOOD
No Unlock/ Half Lock Connector No Missing Technology	ssing Tape	NO GOOD
	nal Backing	