Process Name Title: TAPING ASSEMBLY PROCESS Noted Code Part Number: 900B/s10B / TN0101-702B Customer: TRJ Coocurrent No. WE-NO-PDE-458B Purpose: Purpose: Process Name Process Name: No. Process Name: P	_				W	ORK INSTRUCTION			Effectivity Date	:		August 15, 20	23
PARTS: 1. Assy parts: Black corrugated tube (with silt) at 1-275-3mm; Black tape NO. PROCESS NAME 1. Assy parts: Black corrugated tube (with silt) at 1-275-3mm; Black tape 1. Assy parts: Black corrugated tube (with silt) at 1-275-3mm; Black tape 1. Assy parts: Black corrugated tube (with silt) at 1-275-3mm; Black tape 1. Assy parts: Black corrugated tube (with silt) at 1-275-3mm; Black tape 1. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 2. COT Assiptor 3. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 4. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 5. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 6. Safety Instruction 6. Sure tube (with silt) at 1-275-3mm 7. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 8. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 9. Assy parts: Black corrugated tube (with silt) at 1-275-3mm 9. Co	NE			Process Name/Title:		TAPING ASSEMBLY PROC	ESS		Validity Date:			n/a	
PARTS: 1. Assy parts: Black corrugated tube (with sit) ø5 1275-5mmr, Black tope 1. Tarminal cover jip 2. COT Anapter TOOLSPPE OUALITY POINTERS Safety Instruction Be Sure to warr prescribed personal protective equipment during operation (glove), finger (rot, etc.) Housekeeping 1. Assy parts Table Lay-out Assy parts Table Lay-out Table L				Model Code/Part Number	900B/910B / 7N01 0	11-7020B Customer:	TRJ		Document No.:			WI-ENG-PDE-4	58B
NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Be sure to wear prescribed personal representation of the personal process of the personal representation of the personal r				Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO		Revision No.:		4	Page No.:	1 of 7
NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Be sure to wear prescribed personal representation of the personal process of the personal representation of the personal r										1			
Table Lay-out Page	PARTS:		1. Assy	parts: Black corrugated tul	be (with slit) ø5 L=275±3mm; Black ta	De .				JIG:			
Black corrugated tube (with slit) 95 L=275±3mm No missing parts/bools	N	0.		PROCESS NAME	4	WORK PROCEDURE/ ILLUSTRA	ATION		TOOL	S/PPE	(QUALITY POIN	TERS
Change table lay-out; Change Quality checkpoints. Transferred process of Taping 1- Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to vire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to vire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to P3 Black SV tube (Vi	1		P2	Table Lay-out	4	parts Tape holder/Black tape	•		Be sure prescribe protective during operating of the following operation of the following operation of the Assemb Supervisor of for immedia	to wear d personal equipment ation (gloves, ots, etc.) ceeping and always ce 5's. chings on the prohibited. cour locker. ceeping uble, inform ly Assistant r Line Leade te corrective	1. No missir 2. No exces		
connector 6188-0175 (GR), Taping 2 Black SV tube (Vinyl) to wire near connector 6098-3810 (W) from P1 to P2; Removed and Transferred process of Half wrap taping; Wire insertion to Black VM tube (Sunprene); Taping 2: Black sunprene tube to Black COT near PCB and terminal and Y-taping 1 to P3 due to new process distribution. Work instruction improvement. Change 4MP to 3MP. Transfer process from (Page 2, 5-10). Change term for Sunprene tube to VM tube (Sunprene). Inclusion of Quality Checkpoints (page 10) Inprove quality pointers: Reminders/notes and references in process no.2,3 and 7 due to document improvement. M. Ariola M. Ariola J. Loterte C. Villanueva A. Arañes M. Ariola J. Loterte C. Villanueva A. Arañes M. Ariola A. Arañes									Prepa	red by	Reviewed by	Approved by	Noted by
10/14/22 2 Improve quality pointers: Reminders/notes and references in process no.2,3 and 7 due to document improvement. D. Castillo J. Loterte C. Villanueva A. Arañes M. Arañes M. Arañes J. Loterte C. Villanueva A. Arañes M.	08/15/23		connecto Transferr COT nea	r 6188-0175 (GR); Taping 2 led process of Half wrap tapir r PCB and terminal and Y-tap	Black SV tube (Vinyl) to wire near connecting; Wire insertion to Black VM tube (Sunpiping 1 to P3 due to new process distribution	or 6098-3810 (W) from P1 to P2; Removed and ene); Taping 2: Black sunprene tube to Black n.	M. Ariola J. Loterte	e C. Villanueva A. Ar	añes				
The state of the s	04/06/23	3	Work ins	truction improvement. Chang (Sunprene). Inclusion of Qua	e 4MP to 3MP. Transfer process from (Pality Checkpoints (page 10)	ge 2, 5-10). Change term for Sunprene tube to	D. Castillo J. Loterte	C. Villanueva A. Ara	añes	Anelys	(Sho)	Month ifform	400
Eff. Date Revised Revised Reviewed Approved Noted Est. Date: April 12, 2022			Improve	quality pointers: Reminders/r	•	d 7 due to document improvement.						.C. Villanueva	/ A. Arañes
	Eff. Date	Rev. No			Details of Change		Revised Reviewe	d Approved No	ted Est. Date:	Ap	ril 12, 2022		

				WORK INSTRUCTI	ON			Effectivity Date:			August 15	5, 2023
		Process Name/Title:		TAPING ASS	EMBLY P	ROCESS		Validity date		n/a		
		Model Code/Part Number:	900B/910B	/ 7N0101-7020B	Customer:	7	ΓRJ	Document No.:			WI-ENG-PE)E-458B
		Purpose:	☐ PF	ROTOTYPE	PRE-LAUNCH		MASSPRO	Revision No.:		4	Page No.:	2 of 7
PARTS:	1. Assy 2. Black								JIG	1. Locking	g jig	
NO.	I	PROCESS NAME		WORK PROCE	DURE/ ILLU	STRATION		TOOLS/F	PPE	QI	JALITY P	OINTERS
2	4 \P2	Taping 1 Black SV tube (Vinyl) to wire near connector	25±3mm us	25 ± 3mm 25 ± 3mm	ctor 2.1 get sta	et the Black tape art taping proces	e (Vinyl) using left hand, using right hand then is using both hands.	n/a MEASURING	6 TAPE	3. No loos 4. No mis 5. No wro 6. No wro 1. Pleas measur measur Docum 1. Plea	el-off tape se tape se tape ssing tape ong dimensio ong use of tap ant reminder se use calibrat ing tape when ement. ment reference	rs/Note/s: ted/verified n getting the ce/s:

			WORK INSTRU	CTION	Effectivity Date:	August 15, 2023	
		Process Name/Title:	TAPING A	SSEMBLY PROCESS	Validity date	n/a	
		Model Code/Part Number:	900B/910B / 7N0101-7020E	Customer: TRJ	Document No.:	WI-ENG-PDE-458B	
		Purpose:	□ РКОТОТУРЕ	PRE-LAUNCH MASSPRO	Revision No.:	4 Page No.: 3 of 7	
	1						
	1. Assy 2. Black				JIG	1. Locking jig	
NO. PROCESS NAME		PROCESS NAME	WORK PRO	CEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P2	Taping 2 Black SV tube (Vinyl) to wire near connector	25 ± 3mm Start of taping 25 ± 3mm 25 ± 3mm 25 ± 3mm 25 ± 3mm		MEASURING TAPE 6 7 8 9 (0 1 2 3 4 5 6 7 8 9	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. Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.	

			WORK INSTRUCTI	ON		Effectivity Date:	August 15, 2023
		Process Name/Title:	TAPING ASS	SEMBLY PROCES	S	Validity date	n/a
		Model Code/Part Number:	900B/910B / 7N0101-7020B	Customer:	TRJ	Document No.:	WI-ENG-PDE-458B
		Purpose:	☐ PROTOTYPE ☐	PRE-LAUNCH	MASSPRO	Revision No.:	4 Page No.: 4 of 7
		l .				<u> </u>	
PARTS:	1. Assy	parts				JIG	1. Terminal cover jig
NO.		PROCESS NAME	WORK PROCE	DURE/ ILLUSTRATIO	ON	TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to assy parts	2. Hold the hand then i	1. Get the cover jig tright hand. R corrugated tube (no slit) Ø7 Lensert B-B wires using right hand. 3. After insertion, remove the right hand.	nd.	TERMINAL COVER JIG	No wrong insertion No deformed terminal

			WORK INSTRUCTION	ON	Effectivity Date:		August 15, 202	3	
		Process Name/Title:	TAPING ASS	EMBLY PROCESS	Validity date		n/a		
		Model Code/Part Number:	900B/910B / 7N0101-7020B	Customer: TRJ	Document No.:		WI-ENG-PDE-45	8B	
		Purpose:	☐ PROTOTYPE ☐	PRE-LAUNCH MASSPRO	Revision No.:		4 Page No.:	5 of 7	
		l							
PARTS:	1. Assy 2. Black			3. Black corrugated tube (w/ slit) ø5 L=275±3mm		JIG	1. COT Adaptor		
NO.		PROCESS NAME	WORK PROCED	OURE/ ILLUSTRATION	TOOLS/I	PPE	QUALITY POIN	TERS	
5		Taping 3 Spot taping	then make 2 wir	1. Fix the hotmelted wire and terminal pointed tip using both hands. s using left hand, get the Black tape using right hand ndings of tape using both hands. If spot taping must be right beside White tape.	n/a		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		
6	1 P2	Wire insertion to Black Corrugated tube (w/slit) ø5 L=275±3mm	1. Hold the COT adaptor using left hand then insert wires using right hand.	2. Hold the COT adaptor with wires using left hand, get the Black corrugated tube (w/slit) ø5 L=275±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.	COT Adap	ptor	No wrong use of parts No wires left inside COT	with slit	

			WORI	K INSTRUCTION			Effectivity Date:	August 15, 2023
		Process Name/Title:	Т	APING ASSEME	BLY PROCES	S	Validity date	n/a
		Model Code/Part Number:	900B/910B / 7N01	01-7020B Cust	stomer:	TRJ	Document No.:	WI-ENG-PDE-458B
		Purpose:	☐ PROTOTYPE	☐ PRE-	E-LAUNCH	MASSPRO	Revision No.:	4 Page No.: 6 of 7
		I						
PARTS:	1. Assy 2. Black						JIG	n/a
NO.		PROCESS NAME	We	ORK PROCEDUR	RE/ ILLUSTRATI	ON	TOOLS/PPE	QUALITY POINTERS
7	P2	Taping 4 Black Corrugated tube (w/slit) to wire near PCB and terminal tip	1. Hold the corrugated tube of then start taping using right I 123 ± 131 3. Measure from end of COT up to and COT to PCB L=123±3mm the both hands.	to CC hand hand.	onfirm measurement of the continue the dot. 131±3mm; occess using of the continue	of 25±3mm from end of tape up taping process using both	6 7 8 9 (D) 1 2 3 4 5 6 7 8 9 (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.

