PROCESS NameTrille: TAPING ASSEMBLY PROCESS Validity Date: Process NameTrille: Purpose Process NameTrille: Purpose Process NameTrille: Purpose Process NameTrille: NO. PROCESS NAME WORK PROCEDURE! ILLUSTRATION TOOLSPPE QUALITY POINTERS Safety Instruction Be sure to wear practiced personal during operation gloover, finger cots, set. 2 Personal things on the Occident Interests on the connector relation. No. Process Name WORK PROCEDURE! ILLUSTRATION TOOLSPPE QUALITY POINTERS Safety Instruction Be sure to wear practiced personal during operation gloover, finger cots, set. 2 Personal things on the Occident Interests on the connector relation. Note Process Name No viscole set problem. Lies the connector PRIVE QUALITY POINTERS Safety Instruction Be sure to wear practiced personal during operation gloover, finger cots, set. 2 Personal things on the No viscole set problem. No viscole set problem. Lies the connector relation. PRIVE QUALITY POINTERS Safety Instruction Be sure to wear practiced by Process Name No viscole set problem. A personal things on the No viscole set problem. No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the No viscole set problem. A personal things on the				_	NSTRUCTION		Effectivity	Date:		February 2, 20	23
PARTS: 1. Connector PBVP-08V-S (W) 2. Connector PBVP-08V-S (W) 3. Connector PBVP-08V-S (W) 4. Connector PBVP-08V-S (W) 5. Connector PBVP-08V-S (W) 6. Connector PBVP-08V-S (W) 7. Connector setting to insertion ig PBVP-08V-S (W) 7. PBVP-08V-S (W) 7. Connector setting to insertion ig PBVP-08V-S (W) 7. PBVP-08V-S (W) 7. Connector setting to insertion ig PBVP-08V-S (W) 7. Connector setting to insertion ig PBVP-08V-S (W) 7. PBVP-08V-S (W) 7. Connector setting to insertion ig PBVP-08V-S (W) 7. PBVP-08V-S (W) 7. Connector setting to insertion ig proscribed personal insertion ig processing to insertion in insertion ig processing to insertion in insertion ig processing to insertion in insertion ig processing to insertion insertion			Process Name/Title:	TAF	PING ASSEMBLY PROC	ESS	Validity Da	ate:		n/a	
PARTS: 1. Connector PBVP-0BV-S (W) NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION INSERTION JIG One Extra to war prescribed personal prescribed personal prescribed personal prescribed personal prescribed personal on the prescribed personal pres			Model Code/Part Number:	D01L / 75N353-001	1 Customer:	TRJ	Documen	t No.:		WI-ENG-PDE-1	17
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Connector Setting 10 INSERTION JIG Safety Instruction Sure to wear prescribed personal protective equipment during operation (gloves, infigure outs, etc.)			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision I	No.:	5	Page No.:	1 of 11
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Connector Setting 10 INSERTION JIG Safety Instruction Sure to wear prescribed personal protective equipment during operation (gloves, infigure outs, etc.)							1				,
INSERTION JIG Safety Instruction Be sure to wear prescribed personal protective equipment Louise personal protective exception Louise personal personal protective exception Louise personal personal personal protection exception Louise personal personal personal protection exception Louise p	PARTS:							JIG:	1. Insertion	iig	
Connector setting to insertion ig insertion ig in PBVP-04V-S (W) PBVP-04V-S (W) BEFORE PRESSING AFTER PRESS	NO.	F	PROCESS NAME	WOR	K PROCEDURE/ ILLUSTR	ATION	TO	OOLS/PPE	(QUALITY POIN	TERS
Revision History 02/03/23 5 Improve work procedure/Illustration on process no.13- Visual/ by two's Inspection. Inclusion of Quality checkpoints on pg.no. 04/13/22 4 Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 05/28/21 3 Removal of validity date. Apply some improvements. Revision History M. Ariola J. Loterte C. Villanueva A. Arañes M. Catapang C. Villanueva A. Arañes M. Ariola J. Loterte C. Villanueva A. Arañes	1	P1	insertion jig PBVP-08V-S (W)	Visual reference of Guide lock This is a second of the control of	Get the connector PBVP-08V-S (W) using the process for PBVP-04V-S (W). the: Follow the connector orientation.	ORIENTATION WINVL VIN R Ing right hand and set into insertion jig. 2. Press the guide lock button using	Be press protect during fin 1. Mai 1. Mai 2. Perso workpl Keep For an the As Supervi	sure to wear cribed personal ctive equipment operation (gloves, ger cots, etc.) susekeeping ntain and always oractice 5's. conal things on the ace is prohibited. it in your locker. Alert level y trouble, inform is sembly Assistant is or or Line Leader nediate corrective	2. No wrong 3. No wrong	orientation of conn use of connector	
14. M. Ariola J. Loterte C. Villanueva A. Aranes					<u> </u>		. '	Prepared by	Reviewed by	Approved by	Noted by
05/28/21 3 Removal of validity date. Apply some improvements. M. Catapang C. Villanueva A. Shimamura A. Arañes M. Ariola J. Loterte C. Villanueva A. Arañes	02/03/23 5	Improve 14.	work procedure/Illustration on pro	ocess no.13- Visual/ by two's Inspection. Inclu	sion of Quality checkpoints on pg.no.	M. Ariola J. Loterte C. Villanuev	a A. Arañes				
					ional quality pointers in wire insertion	K. Doria J. Loterte C. Villanueva	a A. Arañes	Monely	Stal	Jour House	Andrew
ETIL Pate Revised Checked Approved Noted Est. Date: March 14, 2019			of validity date. Apply some imp							Ć. Villanueva	/ A. Arañes
	∟п. Date Rev. No			Details of Change		Revised Checked Approved	Noted Est.	Date: Mare	ch 14, 2019		

			WORK INSTR	UCTION		Effectivity Date:	February 2, 2023
		Process Name/Title:	TAPING /	ASSEMBLY PRO	CESS	Validity Date:	n/a
		Model Code/Part Number:	D01L / 75N353-0011	Customer:	TRJ	Document No.:	WI-ENG-PDE-117
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 2 of 14
PARTS:	1. AVSS	3 0.3 BR L=285±2mm; GR/B	L=161±2mm; GR L=161±2mm; W/G L=161	±2mm; Y L=161±2mm; (OR L=161±2mm; R/L L=285±2mm	JIG	1. Insertion jig
NO.	F	PROCESS NAME	WORK PRO	CEDURE/ ILLUST	RATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector PBVP-08V-S (W)	1. Get the BR wire using right hand and inser R/L. Note: Follow the insertion sequence based of	285 161 161 1	4 5 6 7 8 N/G Y OR X R/L 161 161 161 X 285	STEERING NAVIGATION CONTROLLER	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Document reference/s: 1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 2. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 3. Please refer to GL-PRO-ASY-029 for Pull-Push-procedure.



			WORK INSTRU	JCTI	ON			Effectivity Date:		February	y 2, 2023
Process Name/Title:			TAPING A	SSE	MBLY PRO	OCESS		Validity Date:		n	/a
Model Code/Part Number:	D01L	1	75N353-0011	С	Customer:		TRJ	Document No.:		WI-ENG-	PDE-117
Purpose:	□PF	ROTOTYI	PE	☐ P	PRE-LAUNCH		MASSPRO	Revision No.:	5	Page No.:	3 of 14

1. Assy parts PARTS: JIG n/a 2. Dark Gray VM tube (Sunprene) Ø6.5 L=119±3mm **PROCESS NAME** NO. **WORK PROCEDURE/ILLUSTRATION** TOOLS/PPE **QUALITY POINTERS** 1. No wrong usage of parts 2. No deformed terminal 1. Hold the wires using left hand, get the Dark Gray VM tube (Sunprene) Ø6.5 L=119±3mm using right hand then insert the long wires. Document reference/s: 2. Continue to insert the short wires. 1. Refer to WI-PRO-CNC-017 for Wire insertion to Wire and Strip Length Tolerance Dark Gray VM tube 3 P1 n/a (Sunprene) Ø6.5 L=119±3mm

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				WORK INSTRU	JCTION		Effectivity Date:		February	2, 2023
		Process Name/Title:		TAPING A	SSEMBLY PRO	CESS	Validity Date:		n/a	а
		Model Code/Part Number:	D01L	/ 75N353-0011	Customer:	TRJ	Document No.:		WI-ENG-F	PDE-117
		Purpose:	□PR	ROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		5 Page No.:	4 of 14
PARTS:		S 0.3 R L=154±2mm; R/W L=	154±2mm					JIG	Insertion jig	
NO.	F	PROCESS NAME		WORK PRO	CEDURE/ ILLUSTF	RATION	TOOLS	PPE	QUALITY P	OINTERS
4	P1	Wire insertion to connector PBVP-04V-S (W)	1st and	R	Wire f	acing 3 4 R/W 154 X The process for R/W wire. Skip the	CONTRO	TION	1. Use provided jig p 2. No wrong usage o 3. One by one insert 4. No wrong insertion 5. No deformed term 6. No stuck of termin Important remin 1. Please hold the terminal during insertion of wire left to right. 3. Make sure wires inserted. Conduct Pull-Pushinsertion. Document ref 1. Refer to WI-ENG-I Steering Navigation procedure. 2. Please refer to WI for Wire and Strip lef 3. Please refer to GL for Pull-Push-proced	of parts ion inal inal inal tip oders/Note/s: wire near sertion. must be from are properly Pull-Push after oerence/s: PDE-044 for Controller -PRO-CNC-017 ingth tolerancePRO-ASY-029

			WORK INSTRU	JCTION		Effectivity Date:	February 2, 2023
		Process Name/Title:	TAPING A	SSEMBLY PROCES	SS	Validity Date:	n/a
		Model Code/Part Number:	D01L / 75N353-0011	Customer:	TRJ	Document No.:	WI-ENG-PDE-117
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 5 of 14
	1					1	
PARTS:	1. Assy 2. Black	parts VM tube (Sunprene) Ø5.5 L	=112±3mm			JIG	1. Insertion jig
NO.	F	ROCESS NAME	WORK PRO	CEDURE/ ILLUSTRATION	ON	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black VM tube (Sunprene) Ø5.5 L=112±3mm	1. Hold the wires using left hand, get the Black value (Sunprene) Ø5.5 L=112±3mm using right hand.		3. Remove the 1st connector with inserted wires Black VM tube (Sunprene). Check the terminal tip condition. Second connector with inserted wire is still on the jig.	n/a	1. No wrong usage of parts 2. No deformed terminal Document reference/s: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion Terminal tip must be visible
6		Wire insertion to assy parts	BEFORE PRESSING 1. Press the guide lock button using left indefinger.	75N353 - A	2. Hold the Black VM tube (Sunprene)using left hand, then insert the wires from Dark Gray VM tube (Sunprene) using right hand.	n/a	No wrong usage of parts No deformed terminal

			WORK INSTR	UCTION		Effectivity Date:		February	2, 2023
		Process Name/Title:	TAPING F	ASSEMBLY PRO	CESS	Validity Date:		n/a	а
		Model Code/Part Number:	D01L / 75N353-0011	Customer:	TRJ	Document No.:		WI-ENG-F	'DE-117
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		5 Page No.:	6 of 14
						<u>'</u>		<u> </u>	
PARTS:	1. Assy	parts					JIG 1.	Insertion jig	
NO.	F	ROCESS NAME	WORK PRO	CEDURE/ ILLUSTR	RATION	TOOLS/PP	E	QUALITY P	OINTERS
7	P1	Wire insertion to connector PBVP-04V-S (W)	1. Hold the R/L wire and insert to Note: Follow the insertion seque	R/L R 285 154 To terminal slot 1 and BR winence on the above illustrative content of the slot of the	re to terminal slot 4.	STEERING NAVIGATION CONTROLLER	2. 3. 4. 5. 6. 1 t t 2 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Use provided jig p No wrong usage of One by one insert No wrong insertion No deformed term No stuck of termin Important remina 1. Please hold the verterminal during ins 2. Insertion of wire left to right. 3. Make sure wires inserted. Conduct Pull-Push- insertion. Document refe 1. Refer to WI-ENG Steering Navigation procedure. 2. Please refer to W for Wire and Strip I 3. Please refer to G for Pull-Push-procedure. Terminal tip n visible	of parts cion n ninal nal tip ders/Note/s: wire near sertion. care properly Pull-Push after erence/s: -PDE-044 for n Controller VI-PRO-CNC-017 length tolerance

				WORK INSTRI	UCTION		Effectivity Date:			February 2	2, 2023
		Process Name/Title:		TAPING A	SSEMBLY PRO	CESS	Validity Date:			n/a	
		Model Code/Part Number:	D01L /	75N353-0011	Customer:	TRJ	Document No.:			WI-ENG-PI	DE-117
		Purpose:	PROTOT	TYPE	PRE-LAUNCH	MASSPRO	Revision No.:		5	Page No.:	7 of 14
PARTS:	1. Coni	nector 1318386-2 (B)						JIG	1. Inser	tion jig	
NO.		PROCESS NAME		WORK PRO	CEDURE/ ILLUST	RATION	TOOLS/	PPE	Q	UALITY PO	OINTERS
8	P1	Connector setting to insertion jig 1318386-2 (B)	75N353-		aide lock con iide lock CONNEC	Note: Check the connector before TOR ORIENTATION Note: Check the connector before Note: Check the connector before 1386-2 (B) using right hand and set to ar orientation. 2. Press the upper and lower guide lock using left hand (same timing). You will notice the holes that needs to be inserted are only open.	n/a		2. No w 3. No w 4. No da COI Impo 1. Aut the ut termi half-la	ANNECTOR LOCK CHECK CH	APPEARANCE K NG HALF-LOCKED s/Note/s: pose and replace untered bend finsertion and

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		Model Code/Part Number:	D01L	/ 75N353-0011	Customer:	TRJ	Document No.:			WI-ENG-F	PDE-117
		Purpose:	PRC	OTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		5	Page No.:	8 of 14
<u> </u>											
PARTS:	1. Assy	parts						JIG	1. Insert	ion jig	
NO.	F	PROCESS NAME		WORK PRO	CEDURE/ ILLUSTR	ATION	TOOLS/I	PPE	Q	UALITY F	POINTERS
9	P1	Wire insertion to connector 1318386-2 (B)	2ND ROW 1ST ROW 1. Insert the right hand.	P P	9 10 11 GR/B R/W L 161 154 129 1 2 3 GR OR Y 161 161 161 BLACK SUNPRENE TUBE COND ROW (LEFT TO RIGH	W/G X R X X X 154 X X X X X X X X X X X X X X X X X X X	n/a		2. No wr 3. No wr 4. No wr 5. No de 6. No str 1. Pleatermir 2. Inseleft to 3. Malinserta Conduinserta 4. Auto the unitermin half-lo	rong usage of rong orientation of insertion of terminate hold the mal during in ertion of wire right. We sure wire ed. In the control of the	tion of connector n ninal nal tip nders/Note/s: wire near section. e must be from as are properly n-Pull-Push after spose and replace pointered bend of insertion and for. GE-PDE-044 for on Controller wil-PRO-CNC-Strip length

					WORK INSTRU				Effectivity Date:			February	2, 2023
		Process Name/Title:			TAPING A	SSEMBI	LY PROCESS		Validity Date:			n,	'a
		Model Code/Part Number:	D01L	1	75N353-0011	Custon	mer:	TRJ	Document No.:			WI-ENG-	PDE-117
		Purpose:	PF	ROTOTY	PE	PRE-LAI	UNCH	MASSPRO	Revision No.:		5	Page No.:	9 of 14
	Τ												
PARTS:	1. Assy 2. AVSS	parts S 0.5 L L=129±1mm				3. Blac	ck VM Tube (Sunpre	ne) Ø3 L=113±3mm		JIG	1. Inser	tion jig	
NO.	F	PROCESS NAME	<u> </u>		WORK PRO	CEDURE/	ILLUSTRATION	I	TOOLS/	PPE	Q	UALITY F	POINTERS
9	P1	Wire insertion to connector 1318386-2 (B) (Continuation)	GRAY S	2. li teri Not	Insert the wires from Dark minal slot 1 using right har the: Follow the insertion sec	nd. Repeat the quence based	3. Get the GR, then insert to wire on termi Note: Follow	GR wire and insert to s. ted above. (B wires using right hand and terminal slot 9 and W/G	n/a		2. No wi 3. No wi 4. No wi 5. No de 6. No st Impo 1. Ma insert Conda insert 2. Aut replace encoud difficul locked	rong usage or rong oriental rong insertion of terminate o	tion of connector on ninal nal tip nders/Note/s: es are properly n-Pull-Push after dispose and fonce di terminal, tion and half-
10		Wire insertion to Black VM tube (Sunprene) Ø3 L=113±3mm		Ø3 L=11:	using left hand and Black vastamm using right hand and gleft hand.	VM tube 2		Black VM tube (Sunprene)	6 7 8 9 @ 1 2 3 4		2. No de Impo	ase use calib uring tape w urement.	ninal inders/Note/s: orated/verified when getting the ould be covered

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					WORK INSTRU	UCTION		Effectivity Date	:	Februar	y 2, 2023
		Process Name/Title:			TAPING A	SSEMBLY PR	ROCESS	Validity Date:		r	/a
		Model Code/Part Number:	D01L	1	75N353-0011	Customer:	TRJ	Document No.:		WI-ENG-	PDE-117
		Purpose:	□ F	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		5 Page No.:	10 of 14
								l e e e e e e e e e e e e e e e e e e e			
PARTS:	1. Assy	parts							JIG	1. Insertion jig	
NO.	F	PROCESS NAME			WORK PRO	CEDURE/ ILLUS	TRATION	TOOLS	/PPE	QUALITY	POINTERS
11	P1	Wire insertion to connector 1318386-2 (B)	2.	1. usi	Get the L wire with insering right hand.	9 10 11 GR/B R/W L 161 154 129 1 2 3 GR OR Y 161 161 161 161	W/G X R X X X A A A A A A A A A A A A A A A			1. Please hold the terminal during 2. Insertion of weleft to right. 3. Make sure winserted.	of parts ation of connector on minal inal tip inders/Note/s: we wire near insertion. ire must be from res are properly sh-Pull-Push after or dispose and if once and terminal, rtion and half- r. eference/s: NG-PDE-044 for tion Controller or WI-PRO-CNC- di Strip length or GL-PRO-ASY-

				TRUCTION	DOCECC	Effectivity Date:		\prod	February 2	
		Process Name/Title:		G ASSEMBLY P		Validity Date:		+	n/a	
		Model Code/Part Number:	D01L / 75N353-00	Customer:	TRJ	Document No.:			WI-ENG-P	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		5	Page No.:	11 of 14
PARTS:	1. Assy	/ parts					JIG	n/a		
NO.		PROCESS NAME	WORK F	ROCEDURE/ ILLU	ISTRATION	TOOLS/	PPE	C	QUALITY PO	DINTERS
					Hold the harness using both hands and conduct wire arrangement.			1. Re	Document rej efer to WI-ENC trical Test	
12	P1	Wire arrangement	Folded wire (BR, R/L) must be in back position		Folded wire (BR, R/L) is in front position	Terminal tip is visible		2. No ta	vrong orientation angled wires vrong harness	on of connector facing

Terminal tip

is not visible

Double lock in

upward position

Terminal tip is not visible

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GOOD FACING

Double lock in

upward position

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		Model Code/Part Number:	D01L	/ 75	5N353-0011	Customer:	TR	RJ	Document No.:			WI-ENG-	PDE-117
		Purpose:	☐ PR	ОТОТҮРЕ		PRE-LAUNCH	MAS	SPRO	Revision No.:		5	Page No.:	12 of 14
									1				
PARTS:	n/a									JIG:	n/a		
NO.		PROCESS NAME		<u></u>	WORK PRO	CEDURE/ ILLU	STRATION		TOOLS/	PPE	Q	UALITY F	POINTERS
13	P1	Visual/By Two's Inspection	of connecto electrical te	the orientatic	in	2. Check the wire alig tangled wires. Black VM tube (Sunpre	ene)	one fully insert	rminal if with backing ed) or deformed terms. Sunprene)		2. No Ta 3. No mi	rong facing of angled wires issing parts. MASTER S	

				WORK INSTRU	Effectivity Date:	February 2, 2023			
		Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date:						n/a	
		Model Code/Part Number:	D01L / 75N353-0011 Customer: TRJ Doct			Document No.:	WI-ENG-PDE-117		
		Purpose:	☐ PR	ОТОТУРЕ	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 13 of 14	
PARTS:	n/a						JIG:	n/a	
NO.	F	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
14	P1	Measurement			L=175:	± 3mm	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 1	1. No wrong facing of harness 2. No Tangled wires 3. No missing parts Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono.	

	WORK II	Effectivity Date:	February 2, 2023										
Process Name/Title:	TAP	Validity Date:	n/a										
Model Code/Part Number:	D01L / 75N353	-0011 Customer:	TRJ	Document No.:	WI-ENG-PDE-117								
Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 14 of 14								
PARTS: n/a		A		JIG:	n/a								
© QUALITY CHECKPOINTS													
75N353													
6. Compare to master sample. CORRECT FACING	Dark Gray	Make sur Bla VVM tube (Sunprene)	he wire alignment. e no tangled wires. Ck VM tube (Sunpre		1. Check the connector lock.								
3. Check the orien	tation of harness.	4. Check if no mi	ssing parts.		or deformed terminal								