						WORK INST	RUCTION				Effe	ctivity Date:		May 10, 20	23	
			Process Name/Title:			TAPING	ASSEMBLY PROC	ESS			Valid	dity Date:		n/a		
			Model Code/Part Number:	177D	1	7L0127-7020A	Customer:	TR	QSS		Doc	ument No.:		WI-ENG-PDE-	351B	
			Purpose:	PR	ОТОТҮР	E	PRE-LAUNCH	MASS	SPRO		Rev	sion No.:	4	Page No.:	1 of 8	
													1	•		
PARTS:		1. Assy 2. Black	parts tape [2pcs]									JIG:		Insertion jig 3. Spot taping jig Locking jig		
NC	C	F	ROCESS NAME			WORK PR	ROCEDURE/ ILLUSTRA	TION				TOOLS/PPE		QUALITY POINTERS		
1		P2	Table Lay-out	Insertion	n jig	Assy par	Tape holder/I tape	Black VL0127-1000A	Spot taping jig Tape hold tap	er/Black be	Bi Bi Co	Safety Instruction e sure to wear requipersonal protective equipment during peration (gloves, fir cots, etc.) Housekeeping I. Maintain and alwe practice 5's. Personal things on vorkplace is prohibitive in your lock Alert level for any trouble, infoliate the Assembly Assist approvisor or Line Lear immediate correct action.	ays the 2. No exited. er. orm ant ader	ssing parts/tools cess parts/tools		
1		ı				Revision History			1			Prepared by	Reviewed by	Approved by	Noted by	
05/10/23	3	Remove	of quality checkpoints Process no.2 and transfer to P1 s. Change table lay-out	due to process	improve	ment. Improve work procedu	ure/Illustration, quality pointers	J. Loterte M. Ariola	C. Villanueva J. Loterte	A. Arañes C. Villanueva	n/a A. Arañes	<u> </u>				
01/19/22	2	Revise d	ue to inclusion of spot taping jig t	tools and spot ta	aping pro	cess.		K. Doria	J. Loterte	C. Villanueva	A. Arañes					
01/17/22	1		from Pre-launch to Masspro. Add e in COT length from φ7 L=537±				0127-7020 to 7L0127-7020A due e from COT to MR SW.	K. Doria		C. Villanueva		J. Lotterte	S. Villanueva	A. Arañes	n/a	
Eff. Date	Rev No	l		De	tails of (Change		Revised	Reviewed	Approved	Noted	Est Date:	October 13, 2021	1		

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		Effectivity Date:	May 10, 2023						
Process Name/Title: TAPING ASSEMBLY PROPCESS Validity Date:							n/a		
Model Code/Part Number: 177		1	7L0127-7020A	Customer:	TRQSS	Document No.:	WI-ENG-PDE-351B		PDE-351B
Purpose:	☐ PROTOTYPE		E \square	PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	2 of 8

1. Assy parts PARTS: JIG 1. Insertion jig 2. Connector: 6188-0066 (GR) TOOLS/PPE NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION **QUALITY POINTERS CONNECTOR ORIENTATION ILLUSTRATION** I-mark I-mark is 1 hole is open align Visual Lock reference CONNECTOR ORIENTATION button INSERTION JIG ORIENTATION guide GOOD I-mark is 2 holes are not align open Hole 1. Push the lower wire guide upward Connector setting to using right thumb. Slot for Green wire insertion jig will be opened. 2 P2 n/a 6188-0066 (GR) (Assy parts) 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector Important reminders/Note/s: 1. Follow the connector orientation R Press 2. Press the lock of insertion jig 3. Get the connector 6188-0066 (GR) using right hand and insert to using left thumb. insertion jig. Release the lock after insertion.

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			WORK INSTRUCT		Effectivity Date:	May 10, 2023	
Process Name/Title: TAPING ASSEMBLY PROPCESS Validity Date:							n/a
Model Code/Part Number:	177D	77D / 7L0127-7020A Customer: TRQSS Document No.:		Document No.:	WI-ENG-PDE-351B		
Purpose: PROTOTYPE		PE	PRE-LAUNCH	MASSPRO	Revision No.:	4 Page No.: 3 of 8	

	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	4 Page No.: 3 of 8
PARTS:	1. Assy parts	l work		TION	JIG	, ,
NO.	P2 Wire insertion to connector 6188-0066 (GR) (Assy parts)	1 Hold the G wire then insert to terminusing right hand	R L 4. After insertion, push	In the lock using left thumb then notly pull out the connector from jig	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. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document references: 1. Refer to GL-PRO-ASY-029 for Pul Push procedure.

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				WORK INSTRUC	TION		Effectivity Date):		May 10, 2	2023
		Process Name/Title:		TAPING ASS	SEMBLY PROP	CESS	Validity Date:		n/a WI-ENG-PDE-351B		
		Model Code/Part Number:	177D	/ 7L0127-7020A	Customer:	TRQSS	Document No.	:			
		Purpose:	☐ PI	ROTOTYPE [PRE-LAUNCH	MASSPRO	Revision No.:		4	Page No.:	4 of 8
PARTS:	1. Ass	y parts		JIG	1. Locking jig						
NO.		PROCESS NAME	NAME WORK PROCEDURE/ ILLUSTRATION					/PPE	QUALITY POINTERS		
			L			r into locking jig using both hands or pressing. Check the connector if	LOCKIN	G JIG	model 2. No u 3. No da	the provided loo nlock/half-locke amaged lock portant remind	ed connector

Connector Lock

Before pressing After pressing

R

Coupler Cross Sectional View

NG

ONG JIG

NG

GOOD



Unlock



Half Lock Condition

Full Lock Condition damaged connector lock.

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			WORK INSTRUCTION	Effectivity Date:	May 10, 2023		
		Process Name/Title:	TAPING ASSEMBLY PROPCESS	Validity Date:	n/a		
		Model Code/Part Number:	177D / 7L0127-7020A Customer: TRQSS	Document No.:	WI-ENG-PDE-351B		
		Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ☐ MASSPRO	Revision No.:	4 Page No.: 5 of 8		
PARTS:	1. Assy 2. Black			JIG	n/a		
NO.	I	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
5	P2	Y-taping	NO GAP BETWEEN CORRUGATED TUBES 2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left sid width must be same with tape (19mm) taping direction taping direction taping direction Tape shifting 1/3 below Tape shifting 1/3 below Tape width 4. Wind the tape backward 1/2 shifting other side of corrugated tube (must be tape width)	MEASURING TAPE 6 7 8 9 ① 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. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be black tape. 2. Please use calibrated/ verified measuring tape when getting the measurement. 3. Do not exert excessive force during pulling & winding of tape 4. Must be no gap between Corrugated tubes Y-TAPING ORIENTATION		

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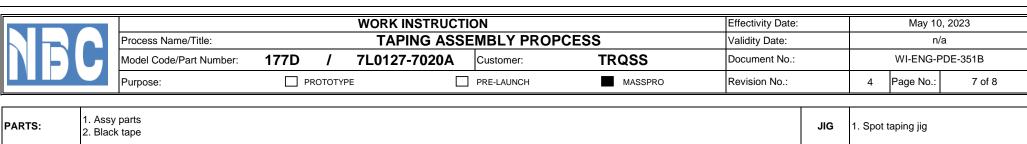
				Effectivity Date:		May 10, 2023					
		Process Name/Title:		TAPING AS	SEMBL	Y PROPCESS		Validity Date:		n/a	
		Model Code/Part Number:	177D	/ 7L0127-7020A	Custon	mer: TF	RQSS	Document No.:		WI-ENG-PDE-351B	
		Purpose:	☐ PRO	DTOTYPE	PRE-LA	AUNCH	MASSPRO	Revision No.:		4 Page No.: 6 of 8	
	,	I						<u> </u>			
PARTS:	1. Assy 2. Black								JIG	n/a	
NO.		PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE		QUALITY POINTERS	
5	P2	Y-taping (continuation)	5. Wind the t corrugated to	tape 1/2 shifting going to other sube. Taping direction tape shifting 1/3 below	0~5mm	Taping dire	side the COT then wind it shifting until it reach the to wires then cut.	6 7 8 9 10 1 2 3 4 5 6	PE 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. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be black tape. 2. Please use calibrated/ verified measuring tape when getting the measurement. 3. 0-5mm end or tape up to connector (Includes rubber seal).	

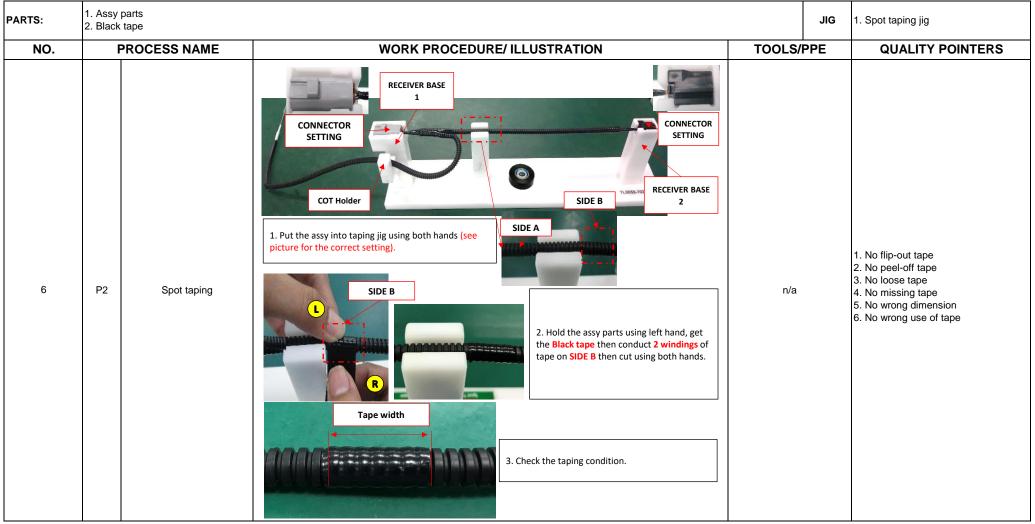
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Process Name/Title: TAPING ASSEMBLY PROPCESS Validity Date: N/a TAPING ASSEMBLY PROPCESS Validity Date: N/a Model Code/Part Number: 177D / 7L0127-7020A Customer: TRQSS Document No.: WI-ENG-PDE-351B PARTS: 1. Assy parts JIG 1. Spot taping jig PARTS: 1. Assy parts JIG 1. Spot taping jig NO GOOD NO GOOD 1 2 No missing Spot tape														
Model Code/Part Number: 177D / 7L0127-7020A Customer: TRQSS Document No.: Wi-ENG-PDE-351B Purpose: PROTOTYPE Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.: 4 Page No.: 8 of 8 PARTS: 1. Assy parts JIG 1. Spot taping jig TL0127-7020A P2							Effectivity Da	ate:		May 10,	2023			
PARTS: 1. Assy parts PRELAUNCH MASSPRO Revision No.: 4 Page No. 8 of 8	Proce	ss Name/Title:		TAPING ASS	EMBLY PROF	Validity Date):		n/a					
PARTS: 1. Assy parts P2 TL0127-7020A NO GOOD One of the ping jig to the pi	Mode!	I Code/Part Number:	177D /	7L0127-7020A	Customer:	TRQSS	Document N	0.:		WI-ENG-PI	DE-351B			
P2 TL0127-7020A NO GOOD One of the control of th	Purpo	ose:	☐ PROTOTYF	PE [PRE-LAUNCH	MASSPR	O Revision No	.:	4	Page No.:	8 of 8			
P2 TL0127-7020A NO GOOD One of the control of th							.	1		<u> </u>				
P2 TL0127-7020A NO GOOD One of the control of th	PARTS: 1. Assy parts							JIG	1. Spot	taping jig				
P2 7L0127-7020A No GOOD No missing Spot tape														
NO GOOD 1 2 No missing Spot tape				<u>/4\</u> QUA	ALITY CHECKPO	DINTS								
NO GOOD 1 2 No missing Spot tape														
NO GOOD 1 2 No missing Spot tape	P2 7L0127-7020A													
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