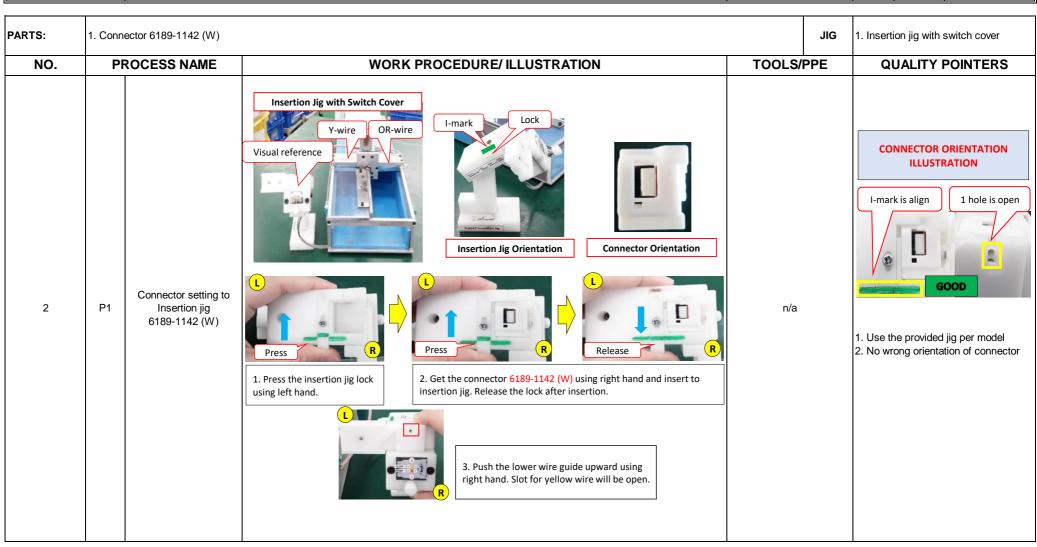
					WORK INSTRI	UCTION			Effectiv	vity Date:		February 1	9, 2022
		Process Name/Title:			TAPING A	SSEMBLY	PROCESS		Validity	y Date:		n/a	a
		Model Code/Pat Number:	780B	/ 7	7R0102-7022	Customer:	TRI	ИX	Docum	nent No.:		WI-ENG-PD	E-417A
		Purpose:	F	PROTOTYPE		PRE-LAUNG	н	MASSPRO	Revisio	on No.:		0 Page No.:	1 of 11
	_	<u>I</u>							l				
PARTS:	L=219±	s; Connector 6189-1142 (W 3mm; Black Vinyl ф5 L= 19 0.3 wires B/W L=642±3mm	4±3mm; Bla	ck Sunpren								Insertion jig with sw Locking jig Terminal cover jig	vitch cover
NO.	PI	ROCESS NAME			WORK PRO	CEDURE/ IL	USTRATION		Т	OOLS/P	PE	QUALITY PO	DINTERS
1	P1	Table lay-out	Connector 1142 (Connect Insertic 1 w/ sw cover Insertion n jig 2	(W)/ or tray on jig vitch			6189-1161 Connector	Black Sunpret tube \$\phi\$ L= 135±3mm Black COT \$\phi 7\$ L=205±3mr (no slit) MR SW CP L0125 7R01020-7050 (TVSSf 0.3 wires G L=642±3mr, B/W L=642±3mr	me equipment operation of the problem of the proble	ety Instru e sure to w scribed per protective uipment de eration (gle nger cots, e ousekeep . Maintain erays practic ersonal thir ne workplac hibited. Kee your locke your locke or any trou rm the Ass istant Supe Line Leade ediate corr action.	vear rssonal e uring oves, etc.) oing and re 5's. ngs on re is ep it in er. el ble, embly rvisor er for	Note: Please ref PRO-CNC-017 for Strip Length tole 1. No missing parts/tol 2. No excess parts/tol	r Wire and erance
	1				Revision History		·			F	Prepared by	y: Reviewed by: Approve	ed by: Noted by:
02/19/22 0	Initial iss	ue					M. /	Ariola J. Loterte	C.Villanueva	A. Arañes	M.Ariola	J. Loverte C. Villar	ueva A. Arañes
Eff. Date Rev. No	0			Details of C	hange		Re	vise Reviewed	Approved	Noted	Est. Date:	February 19,	

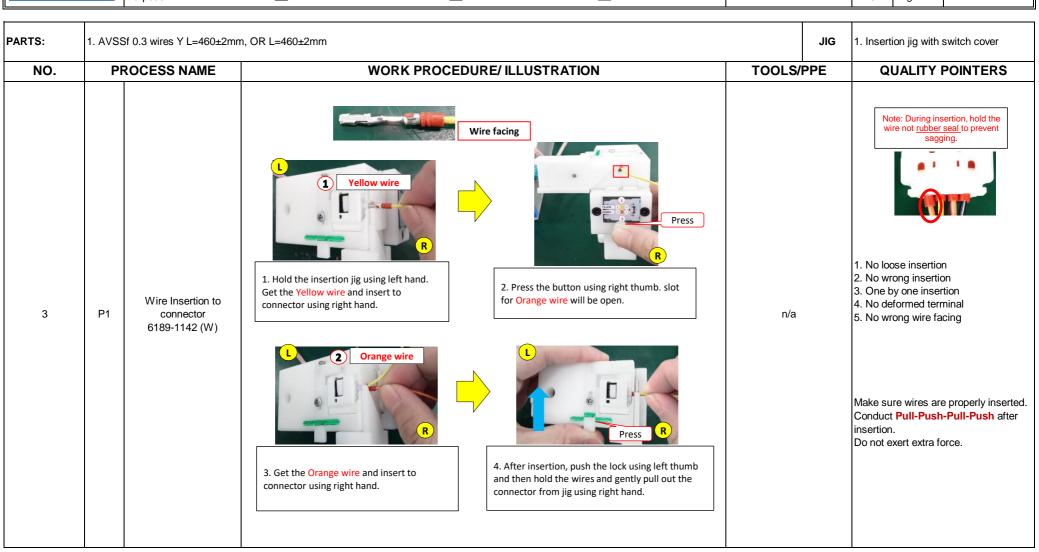


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Model Code/Part Number:	er: 780B / 7R0102-7 0		7R0102-7022	Customer:	TRMX	Document No.:	WI-ENG-F	PDE-417A
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Model Code/Part Number:	del Code/Part Number: 780B / 7R0102-70		7R0102-7022	Customer:	TRMX	Document No.:	No.: WI-ENG-PD		PDE-417A
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Model Code/Part Number:	art Number: 780B / 7R		7R0102-7022	Customer:	TRMX	Document No.:	WI-ENG-PDE		PDE-417A
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3. Black Vinyl tube φ5 L= 194±3mm 1. Assv parts PARTS: JIG 1. Insertion jig 2. Black Vinyl tube φ7 L= 219±3mm 4. Connector 6189-1161 (B) PROCESS NAME WORK PROCEDURE/ILLUSTRATION **QUALITY POINTERS** TOOLS/PPE NO. Wire insertion to Vinyl tube 1. No wrong use of parts φ7 L= 219±3mm 4 n/a 2. No deformed terminal φ5 L= 194±3mm 1. Get the Vinyl tube ϕ 7 L= 219±3mm using 2. Get the Vinyl tube $\phi 5$ L= 194±3mm using right hand then insert the yellow wire and right hand then insert the yellow wire and orange wire by using left hand. orange wire by using left hand. Insertion Jig **CONNECTOR ORIENTATION ILLUSTRATION** I-mark is 1 hole is open P1 align I-mark Visual reference Insertion Jig **Connector Orientation** GOOD Connector setting to I-mark is 5 Insertion jig n/a 1 hole is open not align 6189-1161 (B) 3. Push the lower wire 2. Get the connector 6189-1161 (B) using right hand 1. Press the insertion guide upward using and insert to insertion jig. Release the lock after jig lock using left hand. right hand. Slot for insertion. 1. Use the provided jig per model yellow wire will be 2. No wrong orientation of connector open.

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			WORK INSTRU	JCTION		Effectivity Date:		February	19, 2022
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Model Code/Part Number:	Model Code/Part Number: 780B / 7R0102-70		7R0102-7022	Customer:	TRMX	Document No.:	WI-ENG-PDE-4		PDE-417A
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RTS:	I. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to connector 6189-1161 (B)	1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. 2. Press the button using right thumb. slot for Orange wire will be open. 2. Press the button using right thumb. slot for Orange wire will be open. 4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	n/a	Note: During insertion, hold the wire not rubber seal to prevent sagging. 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 inse Conduct Pull-Push-Pull-Push affinsertion. Do not exert extra force.



			WORK INSTRI	UCTIO	N		Effectivity Date:		February	19, 2022
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ARTS:	1. Assy 2. Black	parts Sunprene tube φ5 L= 13	5±3mm	3. MR SW CP L0125-7R01020-7050 B/W L=642mm)	(TVSSf 0.3 wires G L	_=642mm, JIG	1. Locking jig
NO.	PF	ROCESS NAME	WORK PR	OCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock	1. Put the connector into locking jig and push down to lock 2x using right thumb. Check the connector if properly locked.	Half lock	GOOD Full lock Condition	LOCKING JIG	No unlock/Half-locked connecte No damaged lock
8		Wire insertion to Sunprene tube φ5 L= 135±3mm	1. Get the Sunprene tube of the G and B/W hotmelted w	R 15 L= 135±3mm using left hand then insert wires by using right hand.		n/a	No wrong use of parts No deformed terminal



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TS:	1. Black	k tape				JIG	n/a	
NO.	Р	ROCESS NAME	WORK PROCEDURE/	ILLUSTRATION	TOOLS/PPE		QUALITY POINTER	
9	P1	Taping Sunprene tube to wire near PCB	1. Hold the Sunprene tube using left hand. Measure the end of Sunprene up to the edge of hotmelted wires 51±3mm using right hand.	2. Hold the Sunprene tube using left hand. Get the Black tape using right hand and start taping. Refer to WI-PRO-ASY-001 for taping procedure.	MEASURING	5 6 7 8 9 6	Note: Please use calibrated/verified measuring tape when getting th measurement. 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape	
			tape width 31±3mm 6 7 8 tape width R	3. After taping, check the measurement and taping condition.				



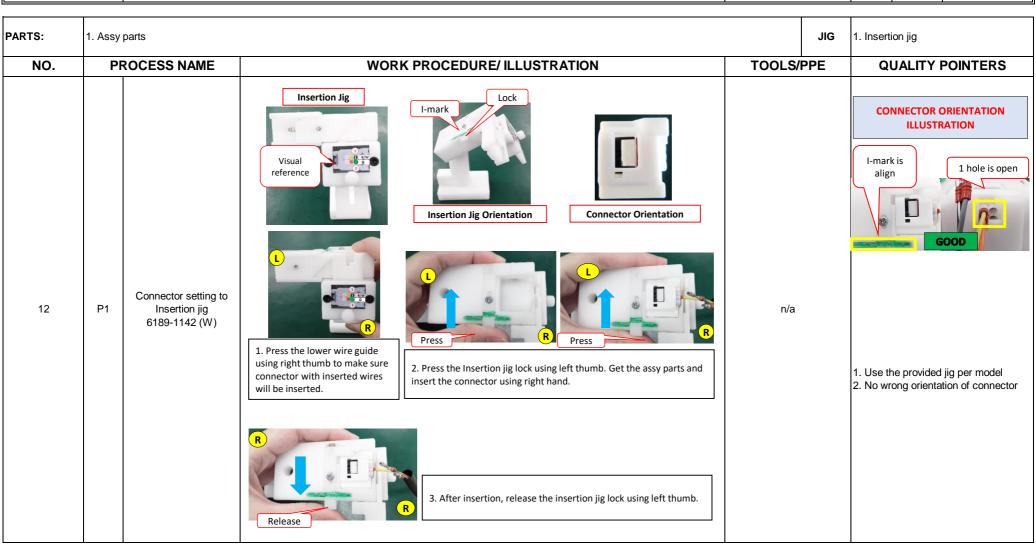
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Process Name/Title: TAF			TAPING AS	SSEMBLY PRO	OCESS	Validity Date:	n/a		
Model Code/Part Number:	Code/Part Number: 780B / 7R0102-7		7R0102-7022	Customer:	TRMX	Document No.:	WI-ENG-F	PDE-417A	
Purpose:	□ P	ROTOTYP	E	PRE-LAUNCH	MASSPRO	Revision No.:	0 Page No.:	8 of 11	

1. Black Corrugated tube φ7 L= 205±3mm (no slit) PARTS: 3. Assy parts 2 (Y and OR wires) JIG n/a 2. Assy parts 1 (G and B/W wires) PROCESS NAME WORK PROCEDURE/ILLUSTRATION **QUALITY POINTERS** TOOLS/PPE NO. Wire insertion to COT 1. No wrong use of parts 10 φ7 L= 205±3mm 1. Get the Corrugated tube ϕ 7 L= 205±3mm (no slit) n/a 2. No deformed terminal (no slit) using left hand then insert the G and B/W wires from assy parts 2 by using right hand. φ5 L= 194±3mm φ7 L= 219±3mm P1 1. Get the assy parts 2 using both hands. Insert the G and B/W wire to Vinyl tube φ7 L= 219±3mm using right hand. Wire insertion to Assy 1. No wrong insertion 11 n/a 2. No deformed terminal parts 2

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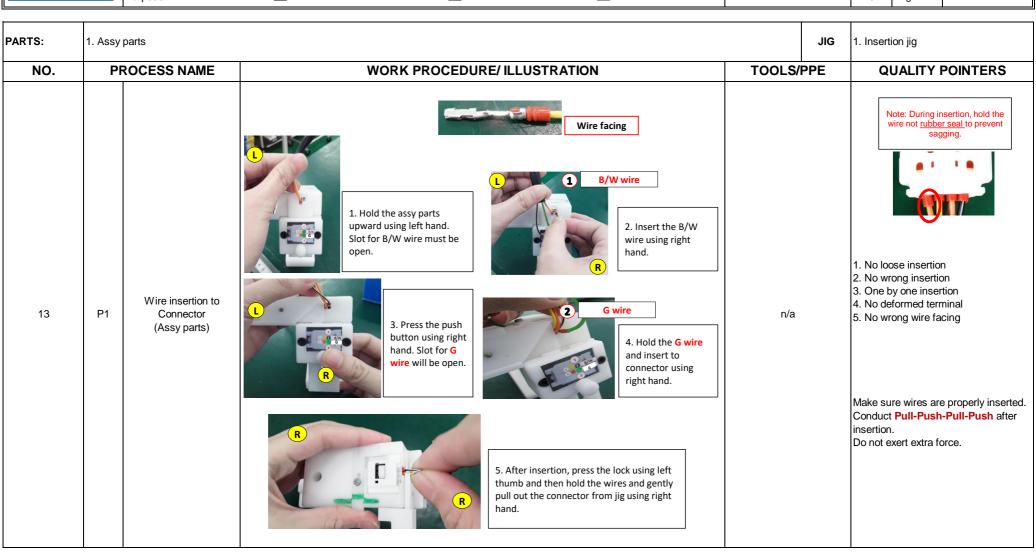


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	Process
	Model C
	Purpose

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RTS:	1. Assy	parts		JIG	1. Locking jig		
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/	PPE	QUALITY POINTERS	
14	P1	Connector lock	1. Put the connector into locking jig and push down to lock 2x using right thumb. Check the connector if properly locked.	LOCKING	a JIG	No unlock/Half-locked connect No damaged lock	
	P1						