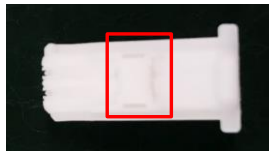
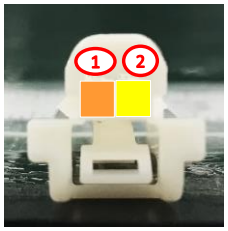
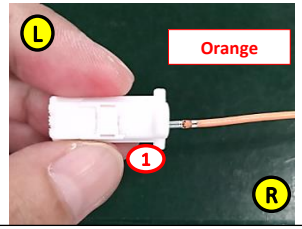
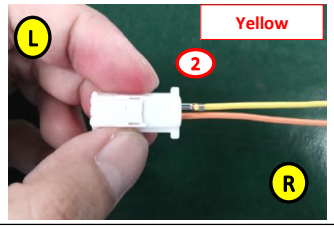
NBC	WORK INSTRUCTION	Effectivity Date:	March 31, 2022
	Process Name/Title: TAPING ASSEMBLY PROCESS	Validity Date:	n/a
	Model Code/Product Number: 200D / 7R0130-7020 — Customer: TRJ	Document No.:	WI-ENG-PDE-459
	Purpose: ☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO	Revision No.: 0	Page No.: 1 of 20

PARTS:	1.Connector 6098-6662(W) 2. AVSSf 0.3 Y-OR wire L=731±3mm	JIG	1. Locking Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Wire Insertion to Connector 6098-6662(W)	 **CONNECTOR ORIENTATION** **WIRE FACING**  **VISUAL REFERENCE**  1.Hold the connector using left hand. Get the Orange wire and insert to connector using right hand.  2. Get the Yellow wire and insert to connector using right hand.	**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 workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	***Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance*** 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 inserted. Conduct Pull-Push-Pull-Push after insertion. *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

Revision History

Eff.Date	Rev.No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
03/31/22	0	Initial Issue.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes	M.Ariola	J. Loterte	C. Villanueva	A.Arañes
							Est. Date:	March 31, 2022		

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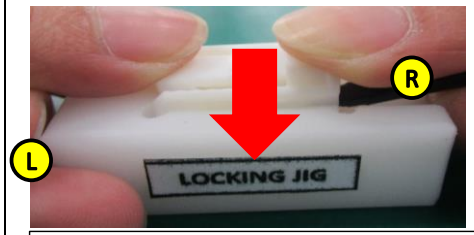
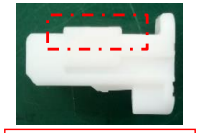
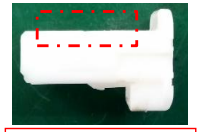
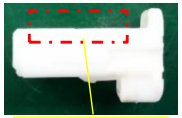
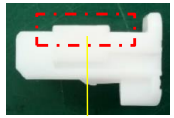
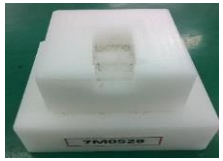
	Model Code/Product Number: 200D / 7R0130-7020		Customer: TRJ	Document No.:	WI-ENG-PDE-459	
	Purpose: ☐ PROTOTYPE	■ PRE-LAUNCH	☐ MASSPRO	Revision No.:	0	Page No.: 2 of 20

PARTS:	1.Connector 6098-6662(W) 2. AVSSf 0.3 Y-OR wire L=731±3mm 3. Black Corrugated tube (No slit) Ø5 L=94±3mm	JIG	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2		Connector Lock	 1. Put the connector into locking jig using both hands then press **2x** to lock using both hands. Touch the connector lock to confirm if properly locked. ***Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.***  **Before Pressing**  **After Pressing** **GOOD** **NG**  Fully Locked  Unlocked	**Locking jig** 	***NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK*** 1. Use the provided jig per connector 2. No unlock/half-locked connector
3		Wire insertion to Black Corrugated tube (No slit) Ø5 L=94±3mm	 1.Get the Black COT **Ø5 L=94±3mm** using right hand and insert **Y-OR wires** using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal

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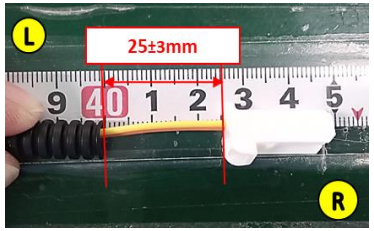
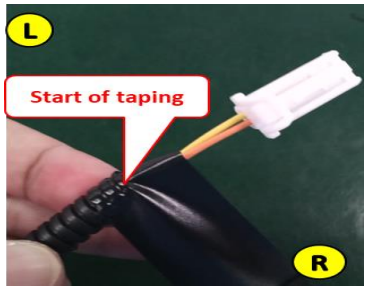
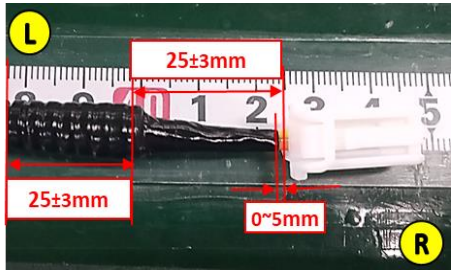
	Model Code/Product Number: 200D / 7R0130-7020	Customer: TRJ		Document No.:	WI-ENG-PDE-459	
	Purpose: ☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO			Revision No.:	0	Page No.: 3 of 20

PARTS:	1.Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Taping 1 to Black Corrugated tube to wire near connector	 1. Measure from end of Corrugated tube up to end of connector **25±3mm** using both hands.  2. Get the **Black tape** using right hand then start taping process using both hands. ***Note: Please refer to WI-PRO-ASY-001 for taping procedure.***  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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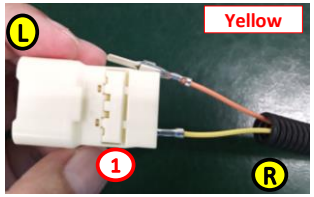
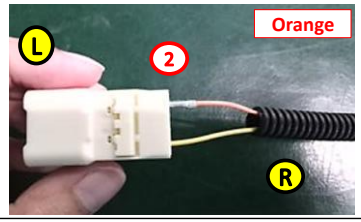
	Model Code/Product Number:	200D / 7R0130-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-459
	Purpose:	☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO		Revision No.:	0 Page No.: 4 of 20

PARTS:	1. Assy parts 2. Black Corrugated tube Ø7 L=296±3mm	3.Black Corrugated tube Ø7 L=268±3mm(No slit) 4.Connector 7282-1060 (W)	**JIG** 1. n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	Wire insertion to Black Corrugated tube Ø7 L=296±3mm (No Slit) Ø7 L=268±3mm (No Alit)	 1.Get the Black COT **Ø7 L=296±3mm (No slit)** using right hand and insert **Y-OR wires** using left hand. 1.Get the Black COT **Ø7 L=268±3mm (No slit)**using right hand and insert **Y-OR wires** using left hand.	n/a	1.No wrong usage of parts 2. No deformed terminal.
6		Wire Insertion to Connector 7282-1060 (W)	Visual Reference Connector Setting Wire facing  1.Hold the connector using left hand. Get the Yellow wire and insert to connector using right hand.  2. Get the Orange wire and insert to connector using right hand.	n/a	*Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance* 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 inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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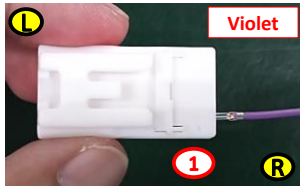
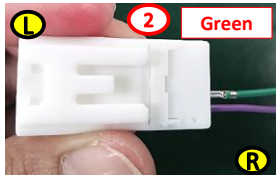
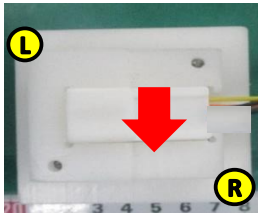
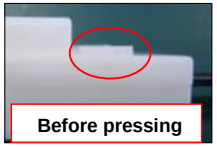
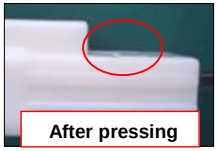
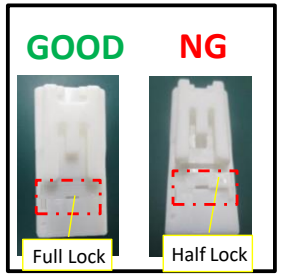
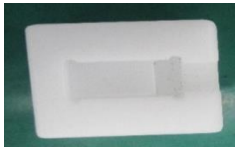
	Model Code/Product Number: 200D / 7R0130-7020		Customer: TRJ	Document No.:	WI-ENG-PDE-459	
	Purpose: ☐ PROTOTYPE	■ PRE-LAUNCH	☐ MASSPRO	Revision No.:	0	Page No.: 5 of 20

PARTS:	1. Connector 6098-3802 (W) 2. AVSSf 0.3 V-G L=707±3mm	JIG	1.Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	n/a	Wire insertion to connector 6098-3802 (W)	CONNECTOR WIRE FACING  1.Hold the connector using left hand. Get the Violet wire and insert to connector using right hand.  2. Get the Green wire and insert to connector using right hand.	n/a	***Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance*** 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 inserted. Conduct ***Pull-Push-Pull-Push*** *after insertion* *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*
8		Connector lock	 1. Put the connector into locking jig using right hand then press **2x** to lock. Touch the connector lock to confirm if properly locked. ***Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.***  Before pressing  After pressing 	LOCKING JIG 	***NOTE:*** ***MANUAL LOCKING MAY CAUSE DAMAGED LOCK.*** 1. Use the provided locking jig per model 2. No unlock/half-lock connector

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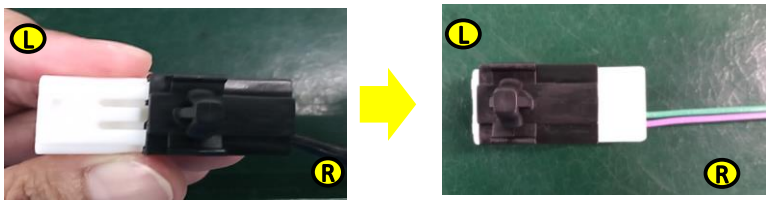
PARTS:	1. Assy parts. 2. Clip type clamp 82711-50491 (B)	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	n/a	Wire insertion to Assy parts	 1. Hold the connector using left hand, get the clip type clamp 82711-50491 (B) then insert the clamp using right hand. ***Note: Sound will be heard if properly inserted.***	n/a	1.Clamp must be fully inserted
10		Wire insertion to Black Corrugated tube(No slit) Ø5 L=71±3mm	 1.Get the Black COT **Ø5 L=71±3mm** using right hand and insert **V-G wires** using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal

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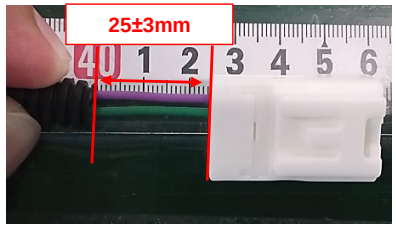
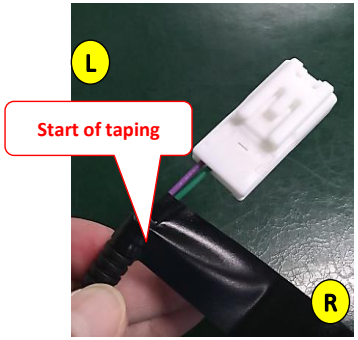
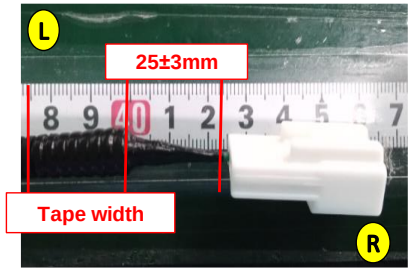
PARTS:	1. Assy parts. 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	n/a	Taping 2 Black Corrugated tube to Wire near connector	1. Measure from end of Black Corrugated tube up to end of connector **25±3mm** using both hands.   2. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping  3. After taping, check the measurement and taping condition.	MEASURING TAPE 	*Note: Please use calibrated/verified measuring tape when getting the measurement.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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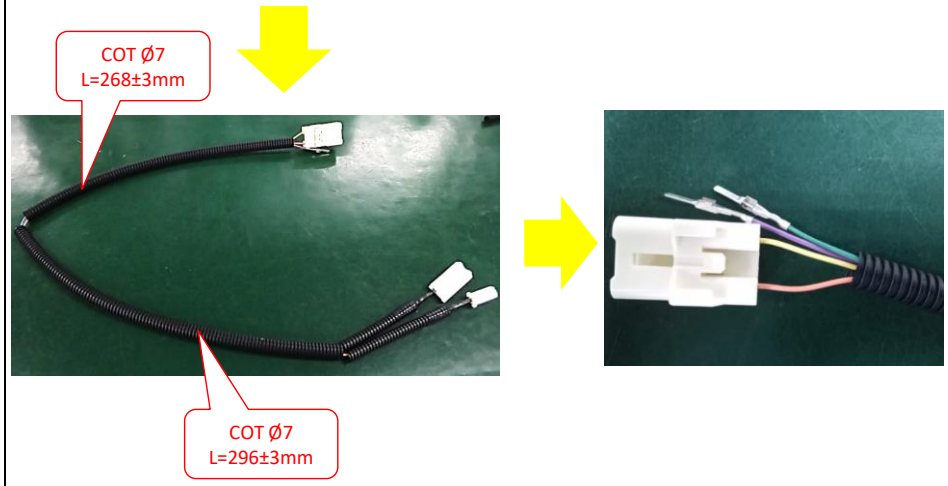
PARTS:	1. Assy parts.	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	n/a	Wire insertion to Assy parts	 1. Get the **V-G wires** and insert to **COT Ø7 L=296±3mm** (assy parts) using right hand. 2. Get the **V-G wires** and insert to **COT Ø7 L=268±3mm** (assy parts) using right hand. 	n/a	1. No wrong use of parts 2. No deformed terminal

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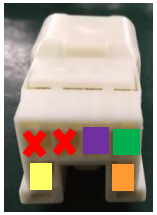
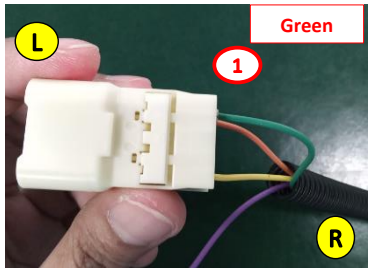
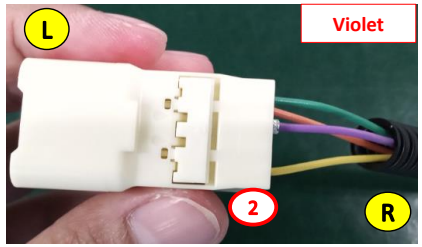
PARTS:	1. Assy parts. 2. AVSSf 0.3 V-G wires L= 707±3mm	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	n/a	Wire insertion to connector 7282-1060 (W)	Visual Reference  Connector Setting Wire facing   1. Hold the connector using left hand. Get the Green wire and insert to connector using right hand. 2. Get the Violet wire and insert to connector using right hand.	n/a	***Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance*** 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 inserted. Conduct Pull-Push-Pull-Push after insertion. *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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	Model Code/Product Number: 200D / 7R0130-7020	Customer: TRJ		Document No.:	WI-ENG-PDE-459	
	Purpose: ☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO			Revision No.:	0	Page No.: 10 of 20

PARTS:	1. Black Corrugated tube Ø5 L=200±3mm (No slit) 2. AVSSf 0.3 B wires L= 576±3mm	JIG	1. Terminal cover Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	n/a	Wire insertion to Black Corrugated tube Ø5 L=200±3mm (No slit)	 1. Get the terminal cover jig using right hand then insert the **B-B wires** using left hand. 2. Get the Black COT **Ø5 L=200±3mm(No slit)** using right hand and insert **B-B wires** using left hand. 3. After insertion, remove the terminal cover jig using right hand.	**Terminal cover Jig** 	1. No wrong use of parts. 2. No deformed terminal.

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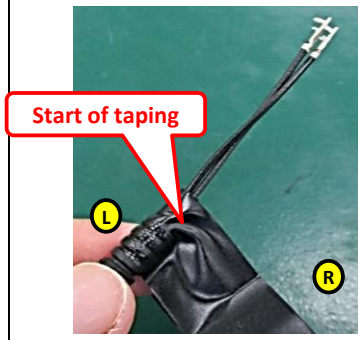
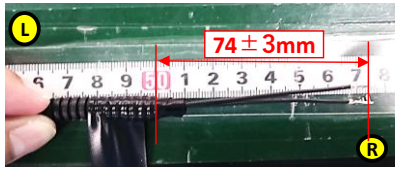
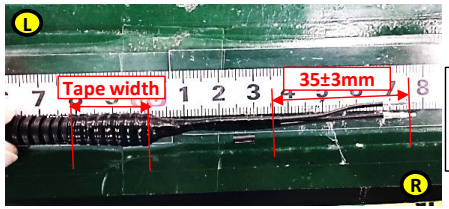
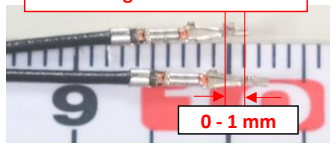
PARTS:	1 Assy parts 2.Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	n/a	Taping 3 Black Corrugated tube to wire near terminal	 1.Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.  2.Measure from end of COT up to terminal pointed tip **74±3mm** then continue the taping process using both hands.  3.After taping, check the measurement, terminal appearance and taping condition.	MEASURING TAPE 	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Wire alignment tolerance 

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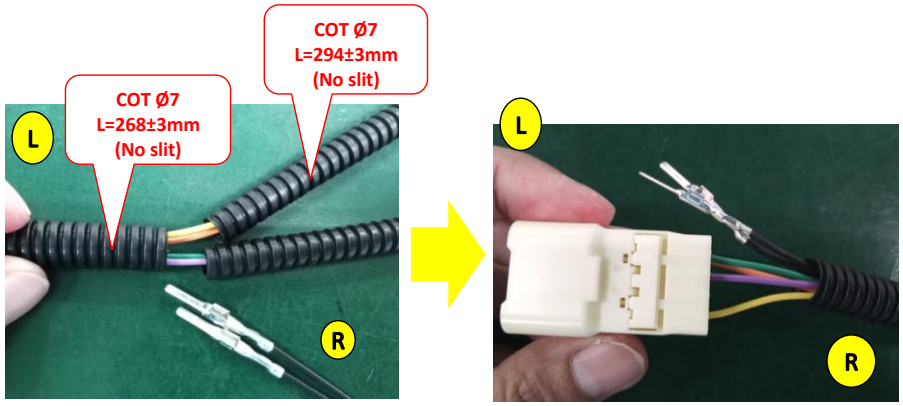
PARTS:	1. Assy parts 2. AVSSf 0.3 B wires L= 576±3mm	**JIG**	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
16	n/a	Wire insertion to Black COT Ø7 L=268±3mm (No slit) (Assy parts)	 1. Get the **B-B wires** and insert to **COT Ø7 L=268±3mm (No slit)** (assy parts) using right hand.	n/a	1. No wrong use of parts 2. No deformed terminal

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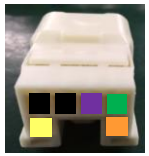
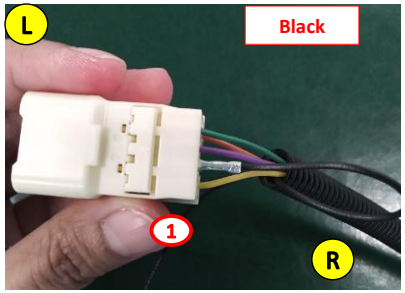
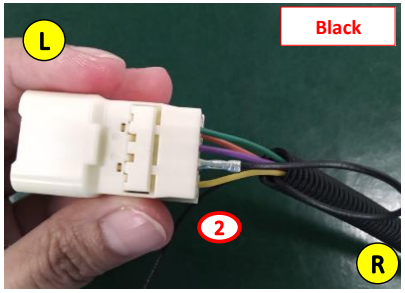
PARTS:	1. Assy parts. 2. AVSSf 0.3 B wire L= 576±3mm	JIG	1.Connector Lock

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
17	n/a	Wire Insertion to Connector	Visual Reference  Connector Setting Wire facing  1. Hold the connector using left hand. Get the 1st wire and insert to connector using right hand.  2. Get the 2nd Black wire using left hand and insert to connector using right hand.	n/a	***Note: Refer to WI-PRO-CNC-017 for Wire and Strip Tolerance*** 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 inserted. Conduct ***Pull-Push-Pull-Push*** *after insertion* *Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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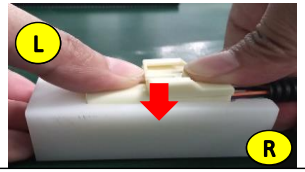
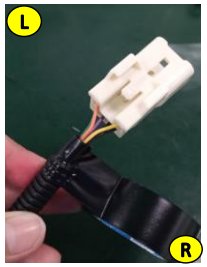
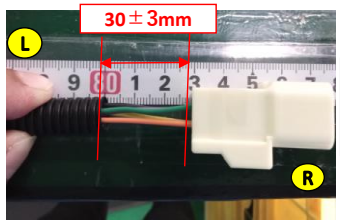
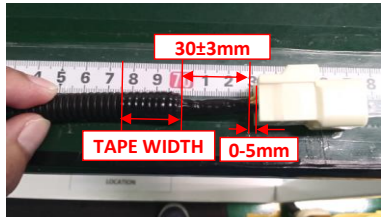
PARTS:	1. Assy parts	**JIG**	1. Locking Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
18	n/a	Connector Lock	 1. Put the connector into locking jig using right hand then press **2x** to lock. Touch the connector lock to confirm if properly locked. ***Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.*** BEFORE PRESSING AFTER PRESSING	LOCKING JIG 	1. Use the provided locking jig per model 2. No unlock/half-lock connector ***NOTE:*** ***MANUAL LOCKING MAY CAUSE DAMAGED LOCK.***
19		Taping 4 Black Corrugated tube to wire near connector	1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.   2. Measure from end of vinyl tube up to end of connector **30±3mm** using both hands. 3. After taping, check the measurement and taping condition. 	MEASURING TAPE 	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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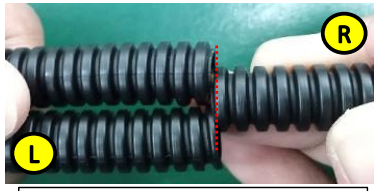
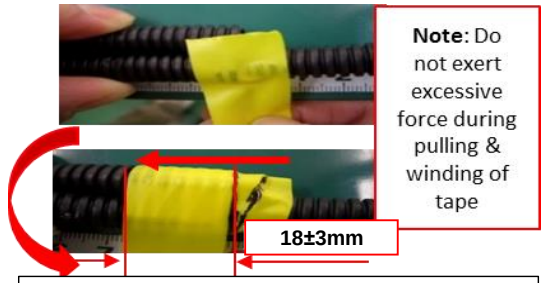
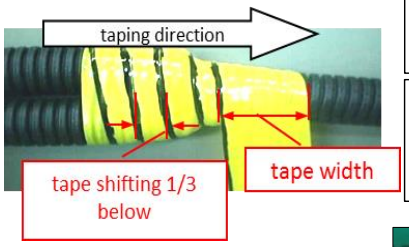
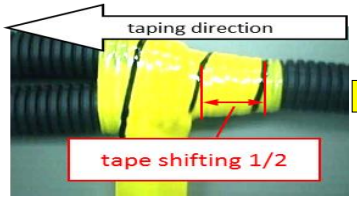
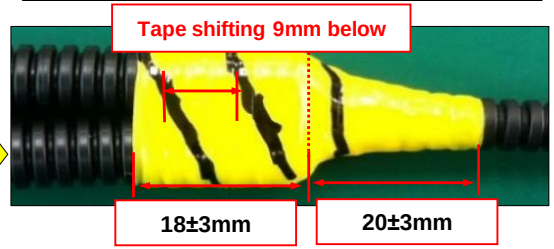
PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
20	n/a	Y-Taping 1	 1. Fix the corrugated tube .  **Note:** Do not exert excessive force during pulling & winding of tape 2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **18±3mm.**  3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **20mm.**  4.Winding the tape backward 1/2 shifting.  5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* **Measuring tape** 	**NOTE:** **USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.** 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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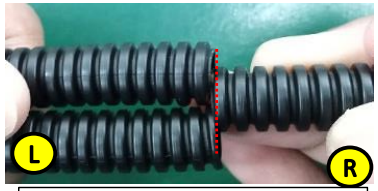
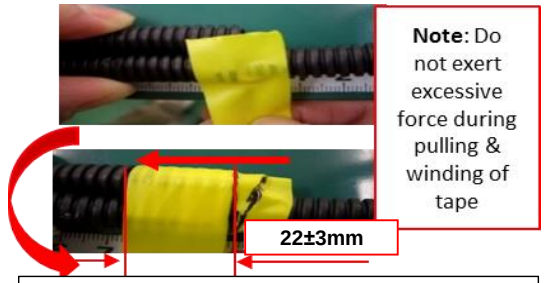
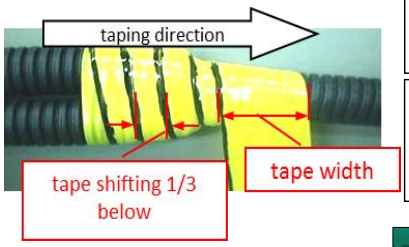
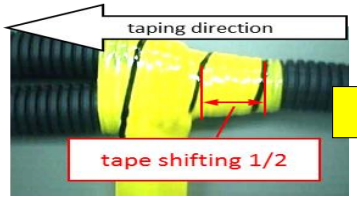
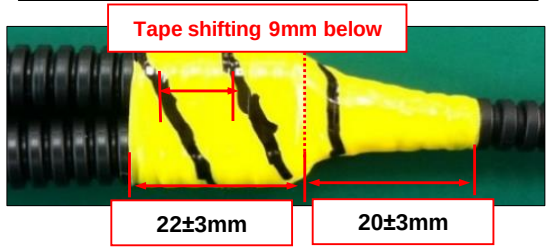
	WORK INSTRUCTION			Effectivity Date:	March 31, 2022	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Product Number: 200D	7R0130-7020	Customer: TRMX	Document No.:	WI-ENG-PDE-459	
	Purpose:	☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO		Revision No.:	0	Page No.: 16 of 20

PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
21	n/a	Y-Taping 2	 1. Fix the corrugated tube .  **Note**: Do not exert excessive force during pulling & winding of tape 2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **22±3mm.**  3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **20mm.**  4.Winding the tape backward 1/2 shifting.  5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.	***Note:*** *Please use calibrated/verified measuring tape when getting the measurement.* **Measuring tape** 	**NOTE:** **USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.** 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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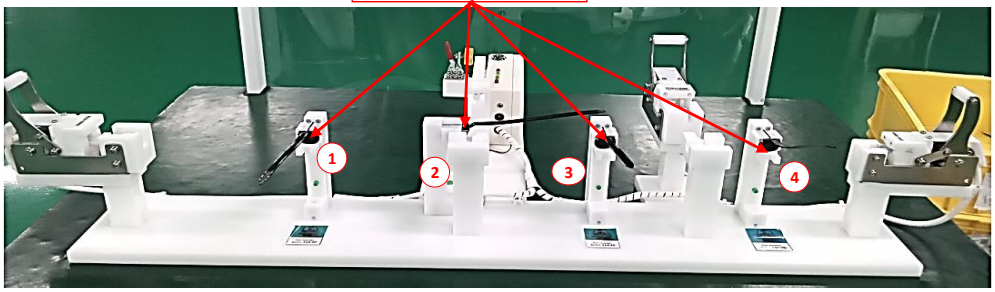
PARTS:	1.Assy parts 2.Clamp 82711-16830 (B)	JIG	1.Clamp Assemly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
22	n/a	Clamp setting	 82711-16830 (B)  1. Get 1pc of Band clamp **82711-16830 (B)** using right hand and set to clamp location **1** using both hands. 2. Get 1pc of Band clamp **82711-16830 (B)** using right hand and set to clamp location **2** using both hands. 3. Get 1pc of Band clamp **82711-16830 (B)** using right hand and set to clamp location **3** using both hands. 4. Get 1pc of Band clamp **82711-16830 (B)** using right hand and set to clamp location **4** using both hands *Note: Please check the clamp first before start assembly to avoid wrong use of clamp.*		1. No wrong use of clamp 2. No damaged clamp 3. no damaged clamp

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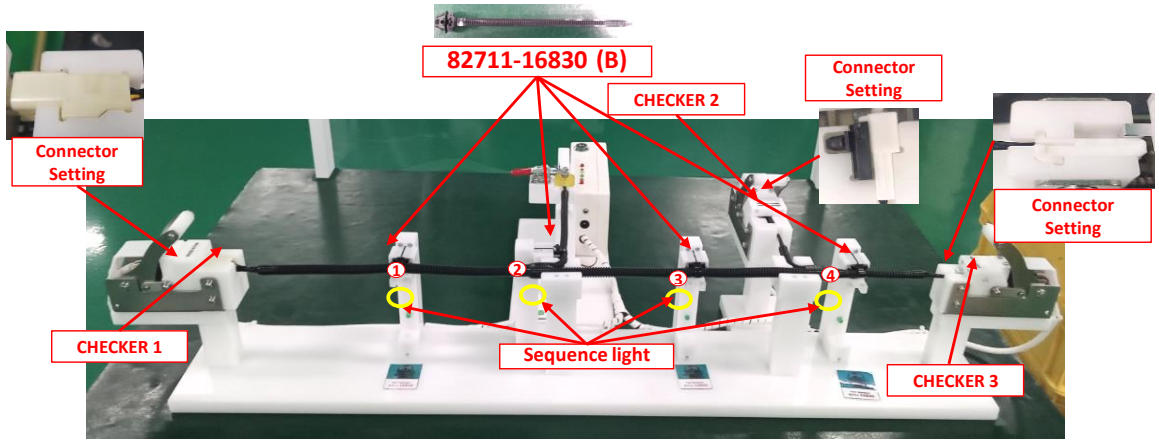
PARTS:	1.Assy parts 2.Clamp 82711-16830 (B)	JIG	1.Clamp Assemly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
23	n/a	Clamp assembly	 1. Put the assy into jig. ***(See above picture for the correct setting).*** First, set the white connector **(7282-1060)** to **Checker 1** and lock. Second, set the next white connector **(6098-6662)** to **Checker 2** and then pull the checker fixture for continuity checking. Third, set the white connector **(6098-3802)** to **Checker 3** then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the **B/B wires** together within stopper then press by toggle clamp. 2. Check if LED light for POWER, CLAMP,and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction 3. Initially tighten the clamp on location **1, 2, 3** and **4** using both hands.		1. No wrong use of clamp 2. No damaged clamp 3. no damaged clamp

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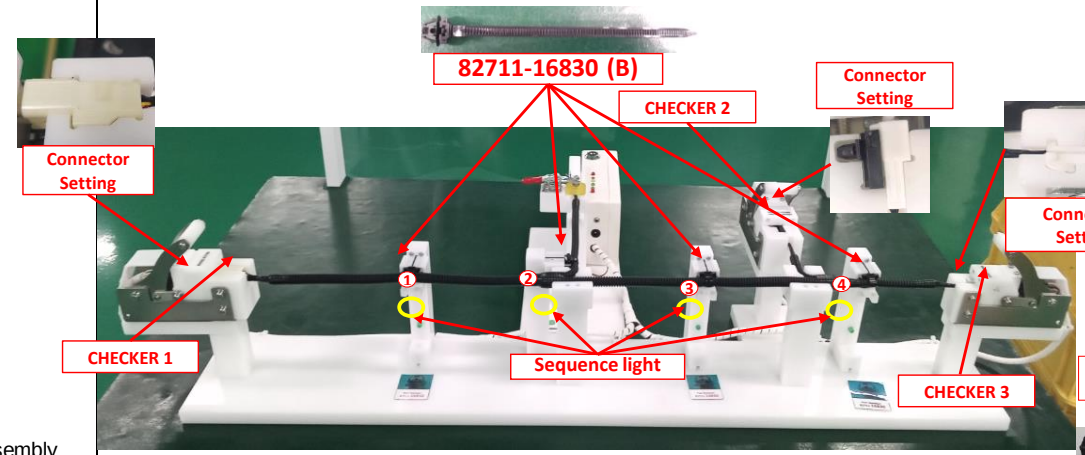
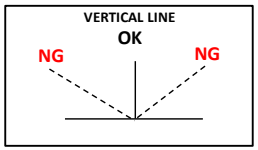
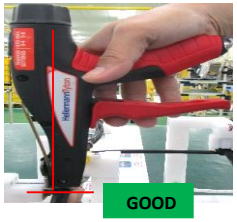
	WORK INSTRUCTION			Effectivity Date:	March 31, 2022	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Product Number: 200D / 7R0130-7020	Customer: TRJ		Document No.:	WI-ENG-PDE-459	
	Purpose: ☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO			Revision No.:	0	Page No.: 19 of 20

PARTS:	1.Assy parts 2.Clamp 82711-16830 (B)	JIG	1.Clamp Assemly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
24	n/a	Clamp Assembly (Continuation)	 4. Get the Bando Gun using right hand and cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was on. 5. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was on. 6. Cut the band clamp on clamp location **3** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **4** was on.   	BANDO GUN 	1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.** **For: ø5 - 1~2, ø7 - 3~4**

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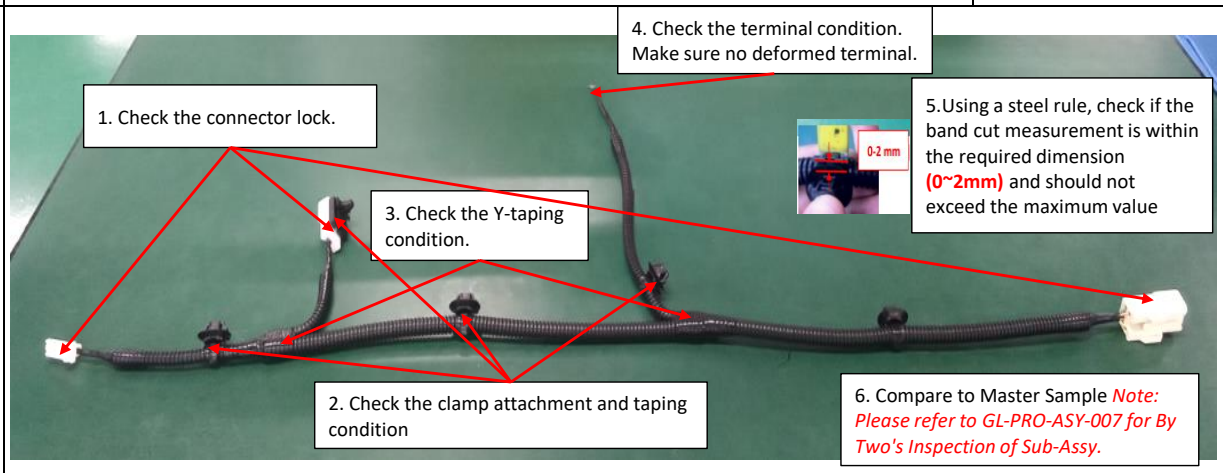
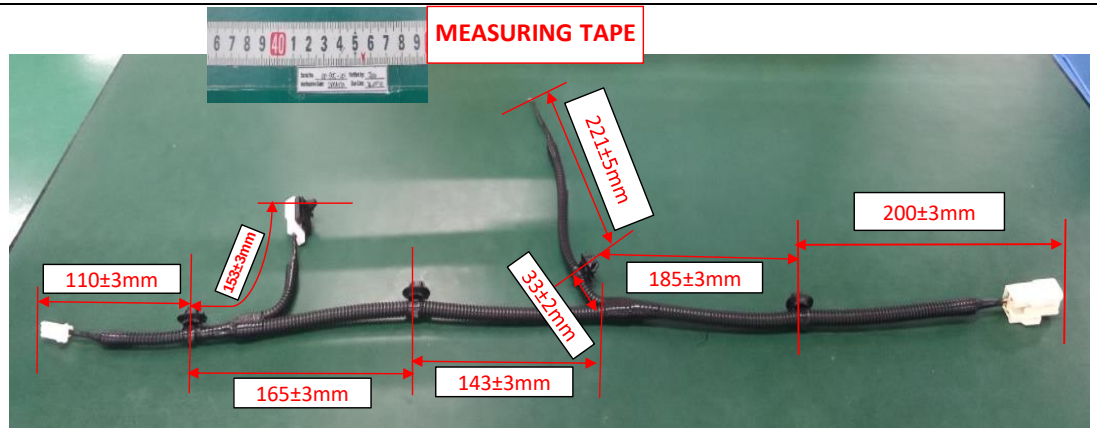
	WORK INSTRUCTION			Effectivity Date:	March 31, 2022	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Product Number: 200D / 7R0130-7020	Customer: TRJ		Document No.:	WI-ENG-PDE-459	
	Purpose: ☐ PROTOTYPE ■ PRE-LAUNCH ☐ MASSPRO			Revision No.:	0	Page No.: 20 of 20

PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
25	n/a	Visual/ By two's inspection			MASTER SAMPLE
26		Measurement			NOTE: FOR HATSUNOMO OWARIMONO 1. No wrong Dimension

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