					WORK INS	TRUCTIO	N				Effec	tivity Date:		June 22, 202	21
		Process Name/Title:			TAPING	ASSEM	IBLY PROC	ESS			Valid	ity Date:		n/a	
		Product Name/Code:	100B	1	7M0594-7020D	Custome	er:	TRJ			Docu	ment No.:		WI-ENG-PDE-2	286D
		Purpose:	PI	ROTOTYPE		PRE-LAUN	NCH	MASS	PRO		Revis	sion No.:	2	Page No.:	1 of 9
														ı	
PARTS:	2. Clam	np 82711-48210 (B) np 82711-3A640 (B) np 82711-35730 (B)				4. Clamp 5. Black	82711-52090 (W tape [5pcs.]	")				JIG:	1. Clamp a	ssembly jig	
NO.	PI	ROCESS NAME			WORK PR	OCEDUR	RE/ ILLUSTRA	TION				TOOLS/PPE	(QUALITY POIN	ITERS
1	P4	Clamp setting	2. Get 1pc. c then set to c	of clamp 82 clamp location		82711-3A640 4 t hand inds.	(B) 82711-35	730 (B) Note: before wrong amp 82711-ip location 6	using both ha	the Clamp find the cl	p dui	Bafety Instructio Be sure to wear prescribed personal rotective equipmering operation (glow finger cots, etc.) Housekeeping Maintain and alwa practice 5's. Personal things on orkplace is prohibite eep it in your locked and the surface of the sur	nt stri	aged clamp g use of parts g use of tape g insertion of clam	er clamp
		-			Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/22/21 2 03/17/20 1	in accord	process owner from Producti dance with color standardizati n all process.	on for plastic pa	arts (Refer t	to GL-COM-003). Apply so			M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	Almsware	15:H	(Ce-b.	
03/17/20 1			move marker/marking/include hang of tape J. Silang A. Morcozo O. Merin eering instruction (EI-ENG-PDE-030). Initial issue D. Castilo R. Alcantara A. Arañes					n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arabes			
Eff. Date Rev. No		ny colabilatica ao Engineening		Details of C				Revised	Checked	Approved	Noted	Est. Date:	November 10, 2018	•	Z Z. All galles
	•										•				

					WORK INSTRUC	TION			Effectivity Date:		June 22	2, 2021	
		Process Name/Title:			TAPING ASS	EMBLY	PROCES	S	Validity Date:		n/	a	
		Product Name/Code:	100B	1	7M0594-7020D	Customer:		TRJ	Document No.:		WI-ENG-F	DE-286D	
		Purpose:		ROTOTYPE		PRE-LAUNCH	1	MASSPRO	Revision No.:		2 Page No.:	2 of 9	
	2. Black tape								JIG	1. Clamp Assembly	Jig		
NO.	P	ROCESS NAME			WORK PROCEI	DURE/ ILL	.USTRATIO	ON	TOOLS	PPE	QUALITY POINTERS		
2	P4	Receiver base Clamp Assembly (Continuation)	1. Put t (GR) to 6098-3: checker and B/I 2. Check if and CLAMI STOP and i	he assy into Receiver ba 802 (W) to 0 r fixture for 1 B wires toge all LED light P ON was Olimmediately	Checker 1 4 4 2 2 3 2 3 2 3 2 2 3 2 2 3 2 2 3 2	Receive Receiv	ting). First, set it inuity checking 1161 (B) to Recharness in jig. Laclamp.	the connector 6188-0066 g. Second, set the connector eiver base 2 then pull the	Stopper n/a		Note: Make sure no stopper jig and hote. 1. No loose/tight cla 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no cle PCB and stopper jig	melted terminals. mp attached p arance between	

				WORK INSTRUC	TION		Effectivity Date:		June 22	, 2021
		Process Name/Title:		TAPING ASS	EMBLY PRO	CESS	Validity Date:		n/a	ı
		Product Name/Code:	100B /	7M0594-7020D	Customer:	TRJ	Document No.:		WI-ENG-P	DE-286D
		Purpose:	PROTOTY	PE [PRE-LAUNCH	MASSPRO	Revision No.:		2 Page No.:	3 of 9
PARTS:	1. Assy 2. Black							JIG	1. Clamp Assembly .	lig
NO.	PI	ROCESS NAME		WORK PROCE	OURE/ ILLUSTR	RATION	TOOLS/	PPE	QUALITY P	OINTERS
2	P4	Receiver bas Clamp Assembly (Continuation)	4. Initially tighten th using right hand. 5. Get the bando gur clamp on location 1.	2711-48210 (B) e band clamp on clamp location n using right hand then cut the Press the SW button after tag ence light on clamp location 2	CONNECTOR SETTING Receiver base 2 SW Button GC SW Button BANDO GUN ALIGN VERTICAL	COLOR SENSOR PINK TAPE ONLY.	topper		Note: Make sure no stopper jig and hotm 1. No loose/tight clar 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clea PCB and stopper jig	elted terminals.

				WORK INSTRUC	TION		Effectivity Date:			June 22,	, 2021
		Process Name/Title:		TAPING ASS	EMBLY PR	OCESS	Validity Date:			n/a	ı
		Product Name/Code:	100B /	7M0594-7020D	Customer:	TRJ	Document No.:			WI-ENG-PE	DE-286D
		Purpose:	PROTOTYPE	: C	PRE-LAUNCH	MASSPRO	Revision No.:		2	Page No.:	4 of 9
		1					1				
PARTS:	1. Assy 2. Black							JIG	1. Clamp	p Assembly J	ig
NO.	PI	ROCESS NAME		WORK PROCEI	DURE/ ILLUS	TRATION	TOOLS	PPE	QUALITY POINTERS		
2	P4	Connector Setting Receiver ba Clamp Assembly (Continuation)	6. Hold the Black tape taping using both hand windings of tape then button after taping. Co on location 3 was ON. 8. Hold the Black tag 3 windings of tape t location 5 was ON.	Checker 1 4 2 3 711-48210 (B) using right hand then start do no clamp location 2. Make cut the tape. Press the SW ontinue if the sequence light do using right hand and then the using right hand and then	Receiver base SW Button 7. Hold the B taping using b windings of the button after location 4 wastart taping using b would be the button after taping using b windings of the button after taping usi	COLORSENSOR PINKTAPE ONLY. Ack tape using right hand and then start to the hands on clamp location 3. Make 3 ape then cut the tape. Press the SW taping. Continue if the sequence light on is ON. Tooth hands on clamp location 4. Make ing. Continue if the sequence light on	n/a		1. No loc 2. No da 3. No mi 4. No mi 5. Make	ose/tight clam amage clamp issed tape issing parts	elted terminals.

				WORK INSTRUC	TION		Effectivity Date:		June 22,	2021
		Process Name/Title:		TAPING ASS	EMBLY PROC	ESS	Validity Date:		n/a	
		Product Name/Code:	100B /	7M0594-7020D	Customer:	TRJ	Document No.:		WI-ENG-PD	E-286D
		Purpose:	PROTOTY	PE [PRE-LAUNCH	MASSPRO	Revision No.:		2 Page No.:	5 of 9
							l			
PARTS:	1. Assy 2. Black							JIG	1. Clamp Assembly Ji	g
NO.	PF	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					PE	QUALITY POINTERS	
2	P4	Receiver bas Clamp Assembly (Continuation)	stopper jig	82711-3A64 TING Checker 1 4 22711-48210 (B)	CONNECTOR SETTING Receiver base 2 9. Hold then star location street the tape. Guide	REPORT TO THE STOPPER JIE. 82711-35730 (B) 82711-520 82711-520 SOLUTION OF THE STOPPER JIE. 82711-520 SOLUTION OF	topper n/a		Note: Make sure no g stopper jig and hotme 1. No loose/tight clam 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clear PCB and stopper jig	p attached

				WORK INSTRUC	TION		Effectivity Date:		June 22	, 2021	
		Process Name/Title:		TAPING ASS	EMBLY PRO	CESS	Validity Date:		n/a	3	
		Product Name/Code:	100B /	7M0594-7020D	Customer:	TRJ	Document No.:		WI-ENG-P	DE-286D	
		Purpose:	PROTOT	YPE [PRE-LAUNCH	MASSPRO	Revision No.:		2 Page No.:	6 of 9	
	 Assy Shaf Blac 	t Webbing stopper 7H0738	-0200					JIG	1. Clamp Assembly .	Jig	
NO.	Р	ROCESS NAME		WORK PROCE	DURE/ ILLUSTR	ATION	TOOLS/	PPE	QUALITY POINTERS		
2	P4	Receiver base Clamp Assembly (Continuation)	Stopper jig 11. Get the SHAFT and the Note: Color	82711-3A64 TTING Checker 1 4 82711-48210 (B) Shaft PINK tape using right hand the fit into guide then make 2 wind sensor will beep/buzz if sensor be cover by Pink tape; Follow	CONNECTOR SETTING Receiver base 2 SW Button Guide in initially attach to clamings of tape before shift detects PINK TAPE of the content o	COLOR SENSOR PINK TAPE ONLY. Stopper jig The using both hands, get the fiting. The unit in the initial black tape on th	Stopper		Note: Make sure no stopper jig and hotm 1. No loose/tight clar 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clea PCB and stopper jig	np attached	

				WORK INSTRUC	TION		Effectivity Date:			June 22,	, 2021
		Process Name/Title:		TAPING ASS	EMBLY PRO	CESS	Validity Date:			n/a	1
		Product Name/Code:	100B /	7M0594-7020D	Customer:	TRJ	Document No.:			WI-ENG-PE	DE-286D
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PARTS:	1. Assy 2. Black							JIG	1. Clamp	o Assembly J	lig
NO.	PI	ROCESS NAME		WORK PROCE	DURE/ ILLUSTF	RATION	TOOLS	TOOLS/PPE		QUALITY POINTERS	
2	P4	Receiver base Clamp Assembly (Continuation)	1/3 shifting	82711-3A64 Checker 1 4 82711-48210 (B) Nake 1/3 shifting going to corracke 3 windings of tape before cuthe sequence light on location 6	Receiver base 2 SW Button Tape tape ugated tube until it reat. Press the SW buttor	COLOR SENSOR PINKTAPE ONLY. width ach tape width then	Stopper n/a		1. No loc 2. No da 3. No mi 4. No mi 5. Make	ose/tight clam image clamp issed tape issing parts	elted terminals.

				WORK INSTRUC	TION		Effe	ectivity Date:			June 22	, 2021
		Process Name/Title:		TAPING ASS	EMBLY PRO	OCESS	Vali	idity Date:			n/a	ì
		Product Name/Code:	100B	/ 7M0594-7020D	Customer:	TRJ	Doo	cument No.:			WI-ENG-PI	DE-286D
		Purpose:	PROT	ОТУРЕ	PRE-LAUNCH	MASSPRO	Rev	vision No.:		2	Page No.:	8 of 9
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PARTS:	1. Assy 2. Black								JIG	1. Clamp	o Assembly J	lig
NO.	PI	ROCESS NAME		WORK PROCE	DURE/ ILLUST	RATION		TOOLS/	PPE	QUALITY POINTERS		
2	P4	CONNECTOR SETTING Receiver base Clamp Assembly (Continuation)		82711-3A64 Checker 1 1 4 82711-3A64 Checker 1 1 3 82711-48210 (B) 13. Hold the Black tape using right clamp location 6. Make 3 winding after taping. GO sound will be heat 14. After taping, CONDUCT POINT	Receiver base SW Button Shand and then starts of tape then cut the cut the cut.	COLOR SENSOR PINKTAPE ONLY. Laping using both hands on e tape. Press the SW button	82711-52090 (W) Stopper			1. No loc 2. No da 3. No mi 4. No mi 5. Make	ose/tight clan image clamp issed tape issing parts	elted terminals.

			WORK	INSTRUCT	ION		Effectivity Date:		June 22, 2021
		Process Name/Title:	TAI	PING ASSE	MBLY PROCESS		Validity Date:		n/a
		Product Name/Code:	100B / 7M059	4-7020D	Customer: TR.	J	Document No.:		WI-ENG-PDE-286D
		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		2 Page No.: 9 of 9
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PARTS:	n/a							JIG r	n/a
NO.	Р	ROCESS NAME	WOR	K PROCEDI	TOOLS/PF	PΕ	QUALITY POINTERS		
			1. Check the connector lock	2. Check the pre	esence of all clamp attachment lition.	5. Check the terminal a deformed terminal.	appearance, make sure	e no	MASTER SAMPLE
3	P4	Visual/By Two's Inspection	3. Using a steel rule, check if the boundary measurement is within the require (0~2mm) and should not exceed the	d dimension	4. Check the presence of share.	oft. Note: Please r	Master Sample refer to GL-PRO-ASY-0 inspection of Sub-Assy.		
4	2	Measurement	160±5mm 0~5mm 115±3mm		11010.		208±3mm 216±3mm		NOTE: FOR HATSUMONO AND OWARIMONO 1. No wrong dimension