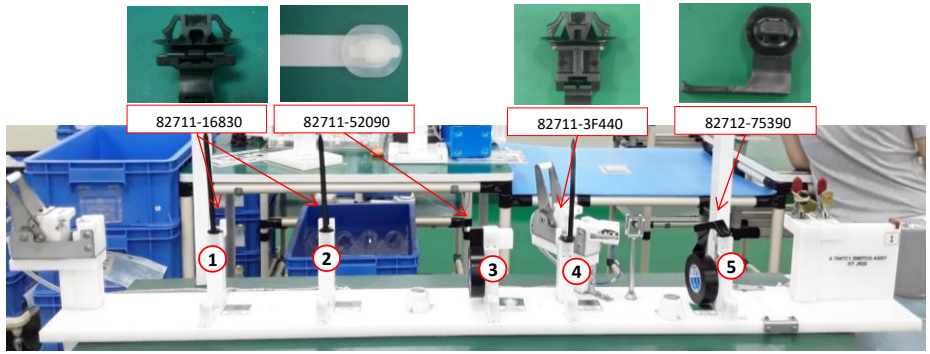
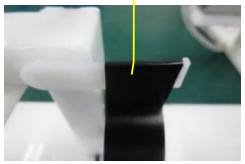
	WORK INSTRUCTION			Effectivity Date:	April 30, 2021		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Product Name/Code:	480B / A7047E	Customer: TRQSS	Document No.:	WI-ENG-PDE-186C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.:	1 of 3

PARTS:	1. Clamp 82711-16830 (B) [2pcs] 2. Clamp 82711- 52090 (W)	3. Clamp 82711-3F440 (B) 4. Clamp 82712-75390 (B)	△4 5. Black tape [2pcs]	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Clamp Assembly Setting	 1. Get 2pcs of clamp 82711-16830 (B) using right hand and set to clamp location 1 and 2 using both hands. 2. Get 1pc of clamp 82711-52090 (W) using right hand and set to clamp location 3 using both hands. 3. Get 1pc of clamp 82711-3F440 (B) using right hand and set to clamp location 4 using both hands. 4. Get 1pc of clamp 82712-75390 (B) using right hand and set to clamp location 5 using both hands. 5. Get Black tape using right hand and conduct pre-taping on clamp location 3 and 5 using both hands. **STANDARD TAPING FOR CLAMP** One side tape under clamp 	**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.	1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted
04/30/21	4	Add quantity of Black tape in clamp assembly setting	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
10/30/20	3	Transfer process owner from Production (WI-PRO-ASY-012C) to Engineering (WI-ENG-PDE-126C); Apply some improvements; Updated pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
11/09/18	2	Include process distribution/jigs and tools/PPE	A. Roxas	A. Morcozo W. Carbillon	O. Merin	n/a
07/10/17	0	Initial issue.	J. Montealto L. Briones	O.Merin	T. Sugiyama	n/a

Prepared by	Reviewed by	Approved by	Noted by
J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes

Est. Date: July 10, 2017

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DCC Stamp

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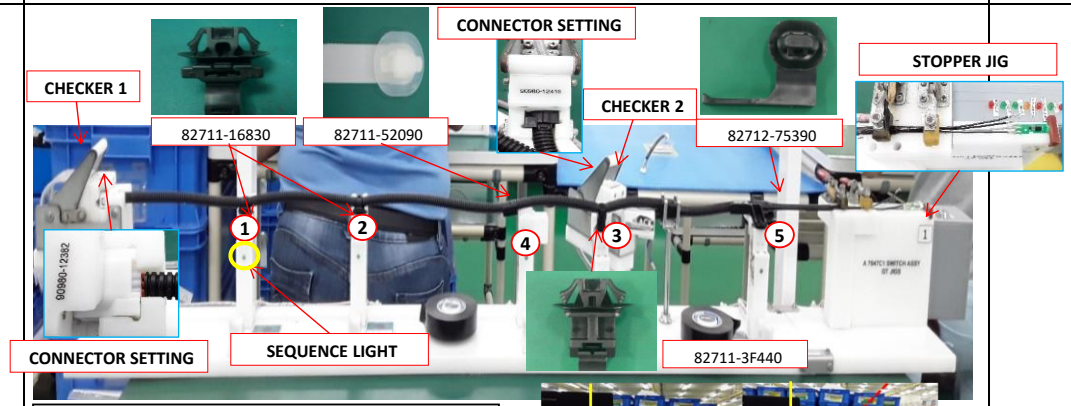
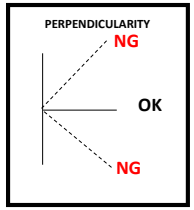
PARTS:	1. Assy parts	**JIG**	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp Assembly	 1. Get the assy parts using right hand and set to jig using both hands. First, Put the White connector to checker 1, second, put the Black connector to checker 2 then last, put the PCB to stopper jig and push down the toggle clamp using right hand. *See above illustration for proper setting.* 2. Check the LED light for POWER, CLAMP, WIRE1&WIRE2 and SEQUENCE light was ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction. 3. Initially tighten the band clamp on clamp location 1, 2 and 3 using both hands. 4. Get the Bando Gun using right hand and cut the Band clamp from Location 1, 2 and 3 using both hands. Press the SW button after every cutting of Band clamp. *Note: Follow the sequence light.* 5. Hold the tape on location 4 using right hand and start taping on clamp using both hands. Make 3 winds and cut the tape. Press the SW button after taping. Apply this process to clamp location 5. 6. After taping on location 5, Press the SW button. Go sound will be heard. Conduct POINT CHECKING before removal from jig.	**BANDO GUN** 	Note: Make sure no clearance between PCB and stopper jig 1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No wrong use of tape 6. No peel off tape 7. No missing tape Fixed setting of band clamp cutter: 3 ~ 4 **BANDO GUN ALIGNMENT** 

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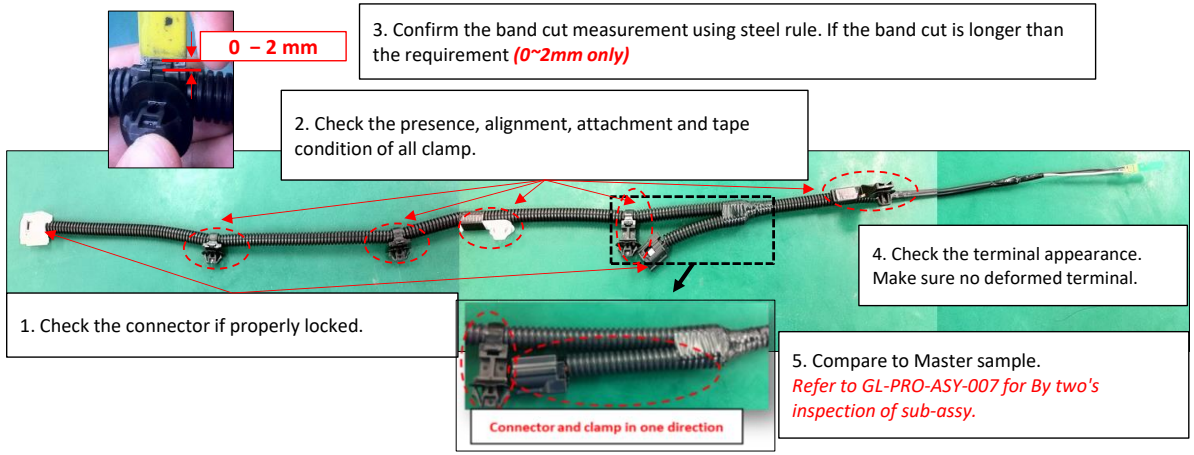
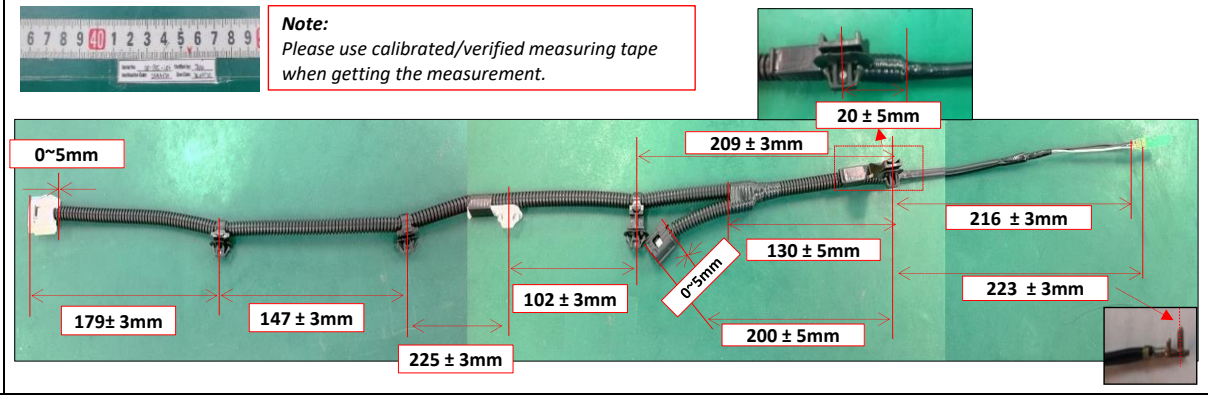
PARTS:	n/a	**JIG**	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Visual/By two's inspection			**MASTER SAMPLE**
4		Measurement			**FOR HATSUMONO/OWARINOMO ONLY**

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