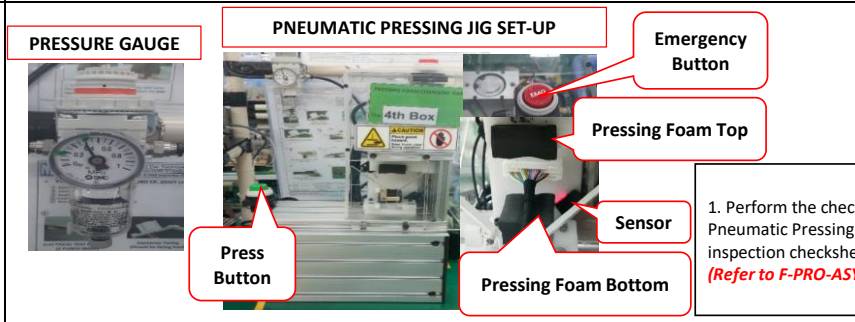
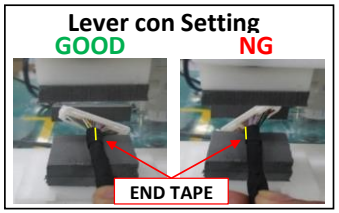
NBC	WORK INSTRUCTION	Effectivity Date:	May 10, 2021
	Process Name/Title: END TAPE PRESSING PROCESS	Validity Date:	n/a
	Product Name/Code: 5 Levercon / 17J796/17J924/17L544 — Customer: TRP	Document No.:	WI-ENG-PDE-096
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO	Revision No.: 5	Page No.: 1 of 2

PARTS:	1. Assy parts	JIG:	1. Pneumatic pressing jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Wire harness setting to pressing jig	 1. Perform the checking of Pneumatic Pressing jig using inspection checksheet. *(Refer to F-PRO-ASY-024 A~B)*  2. Set the lever con to pressing jig using right hand. Place the lever con in the middle and place the **END tape** into top. 3. Hold the lever con using right hand then press the Green button using left 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.	1. No damage parts 2. No floating or peel-off tape 3. No foreign material

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted
05/10/21	5	Revise due to use of 'Levercon' as product name and inclusion of 17L544 in product code.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
02/09/21	4	Remove cycle time in every process.Conduct semi-annual review of documents.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/20/18	0	Peviously established as Engineering instruction (EI-ENG-PDE-056). Initial issue	D. Castillo	R. Alcatara	A. Arañes	n/a

Prepared by:	Checked by:	Approved by:	Noted by:
M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Est. Date:	July 20, 2018		

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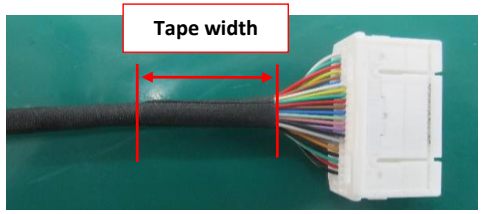
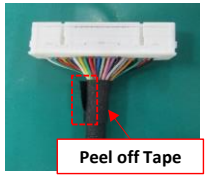
	WORK INSTRUCTION			Effectivity Date:	May 10, 2021	
	Process Name/Title:	END TAPE PRESSING PROCESS		Validity Date:	n/a	
	Product Name/Code: 5 Levercon / 17J796/17J924/17L544	Customer:	TRP	Document No.:	WI-ENG-PDE-096	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	5	Page No.: 2 of 2

PARTS:	1. Assy parts	JIG	1. Pneumatic pressing jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE/QUALITY POINTERS
1	Wire harness setting to pressing jig (Continuation)	4. After 20-30 seconds, pressing jig will automatically release. 5. Get the lever con using right hand.	1. No damage parts 2. No floating or peel-off tape 3. No foreign material
2	Visual inspection	**After Pressing** 2 seconds above 1 second 1. Check the end tape appearance.  GOOD NG  Peel off Tape	**NOTE:** **Replace the pressing foam from top to bottom every 500 shots** 1. No damage parts 2. No floating or peel-off tape 3. No foreign material

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