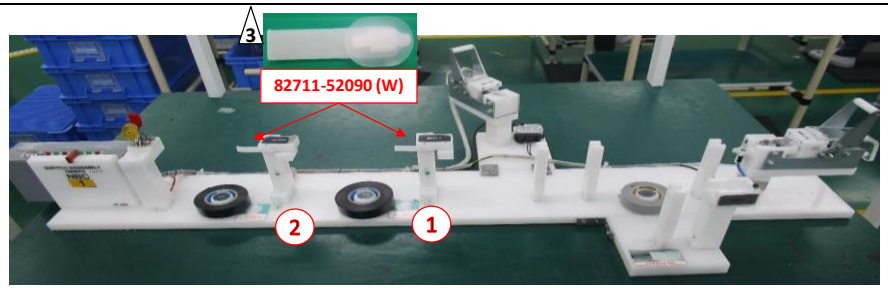
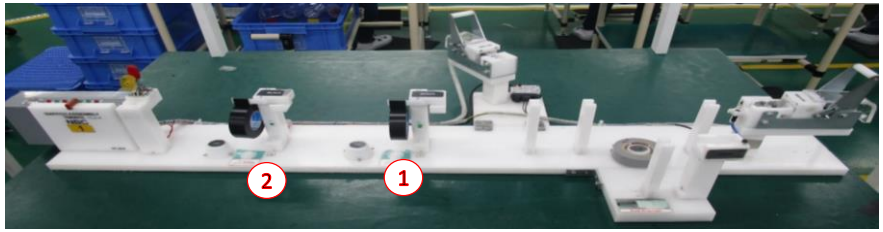
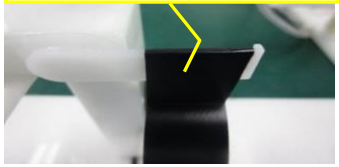
NBC	WORK INSTRUCTION			Effectivity Date:	April 09, 2021
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Product Name/Code:	320B / 7M0653-7020A	Customer: TRJ	Document No.:	WI-ENG-PDE-133C
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.: 3	Page No.: 1 of 4

PARTS: 3	1. Clamp 82711-52090 (W) [2pcs.] 2. Black tape [2pcs.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Clamp setting	 1. Get 2 pieces of clamp **82711-52090 (W)** and set to **location 1** and **2** using both hands. Note: Please check the clamp first before start of assembly to avoid wrong use of parts  2. Initially attach **Black tape** on clamp location **1** and **2** using both hands.	**Safety Instruction** Be sure to wear required 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.	**STANDARD TAPING ON CLAMP** One side tape under clamp  1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape

Revision History							Prepared by	Reviewed by	Approved by	Noted by
04/09/21	3	Revise due to standardize the color of clamp in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
10/08/20	2	Changed effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
09/14/20	0	Initial issue.	J. Silang	W. Carbillon	O. Merin	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	September 14, 2019		

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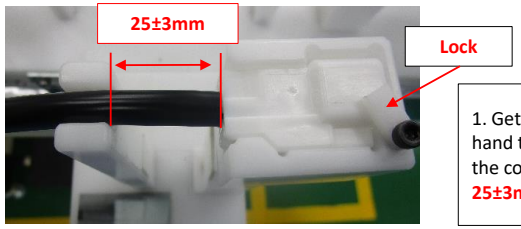
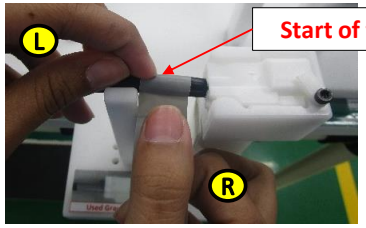
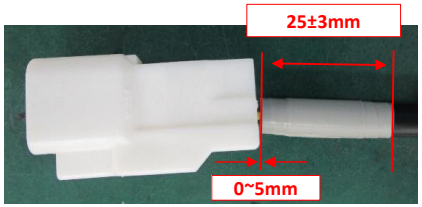
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	2 of 4

PARTS:	1. Assy parts 2. Gray tape	JIG	1. Spot taping jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Spot taping	 1. Get the assy part. Hold the connector using right hand then set to spot taping jig. After setting, lock the connector jig lock. Measurement of spot tape is **25±3mm.**  2. Get the **Gray tape** using right hand. Start the taping process from left side going to right using both hands. Conduct **1/3 shifting** going to connector then cut the tape.  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	NOTE: USE **GRAY TAPE** ONLY for Spot taping. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape Note: Please use calibrated/verified measuring tape when getting the measurement.

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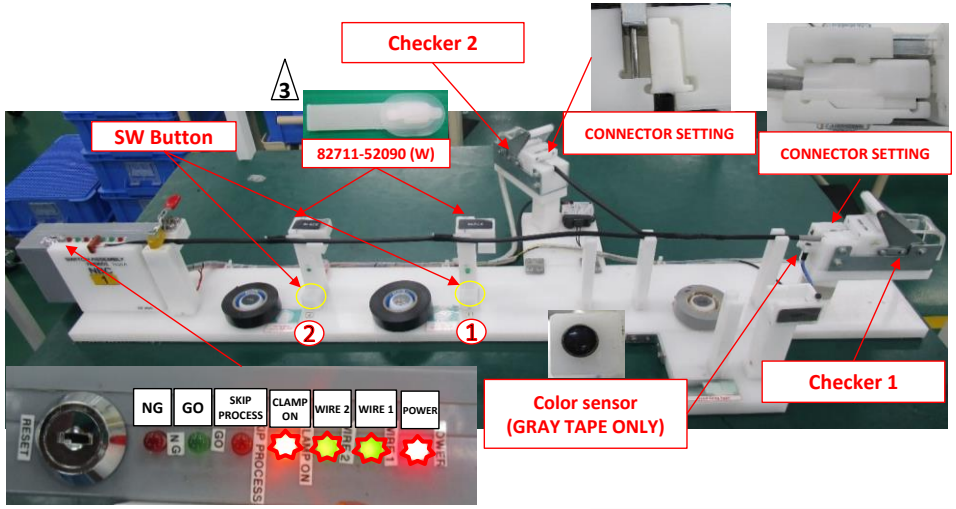
PARTS:	3 1. Assy parts	JIG	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	3 Clamp Assembly	 1. Get the assy parts and set into jig. *(See above picture for the correct setting).* First, set the connector **4G5400-000[] (W)** to **Checker 1** then pull the checker fixture for continuity checking. **Color sensor** light will beep/buzz if sensor detects the **Gray tape.** Second, set the connector **6098-2220 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Last, set the **B/B wires** with terminal end together within the stopper then press by **Toggle clamp.** Continue if the sequence light on location **1** was on. 2. Check if all **LED light** for **Power On, Clamp On, Wire1 & Wire2** was on. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. 3. Hold the tape on clamp location **1** and start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if the sequence light of location **2** was on. 4. Hold the tape on clamp location **2** and start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. **Go** sound will be heard. 5. Conduct **POINT CHECKING** before removing to Clamp Assy Jig.	n/a	 **Make sure no gap between terminal and stopper jig** 1. No damaged clamp 2. No missing tape 3. No missing clamp

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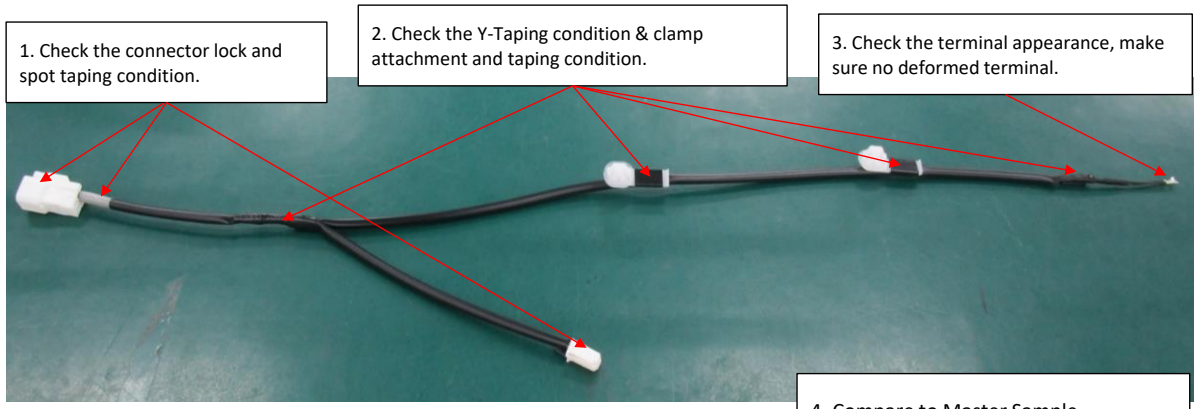
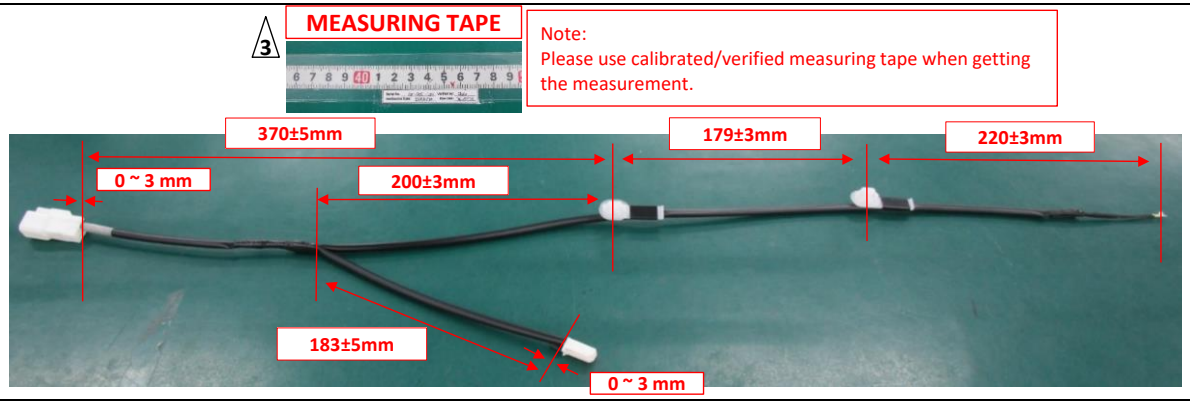
PARTS:	n/a	**JIG**	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	3 Visual/By Two's Inspection			MASTER SAMPLE
5		3 Measurement			NOTE: FOR HATSUMONO AND OWARIMONO 1. No wrong dimension

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