

**WORK INSTRUCTION**

Process Name/Title:

**END TAPE PRESSING PROCESS**

Effectivity Date:

**August 12, 2021**

Validity Date:

n/a

Product Name/Code:

**240B/970A / 17J613/17J711**

Customer:

**NBC**

Document No.:

**WI-ENG-PDE-309**

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

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**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

**PRESSURE GAUGE****PNEUMATIC PRESSING JIG SET-UP**

Emergency Button

Pressing Foam Top

Sensor

Pressing Foam Bottom

1. Perform the checking of Pneumatic Pressing jig using inspection checksheet.  
(Refer to F-PRO-ASY-024 A~B)

**Lever con Setting**

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	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañas	M. Catapang	C. Villanueva	A. Shimamura	A. Arañas

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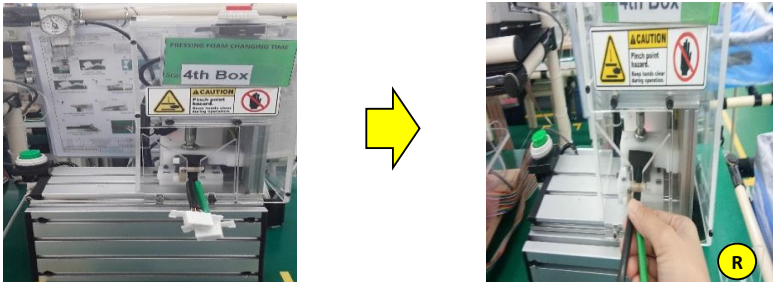
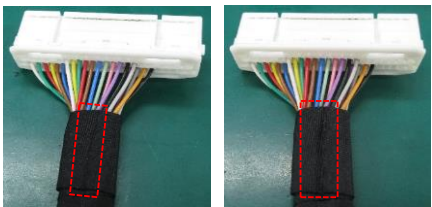
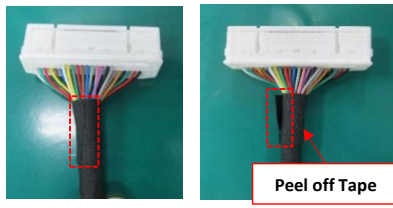
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Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:		0		Page No.: 2 of 2	

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

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