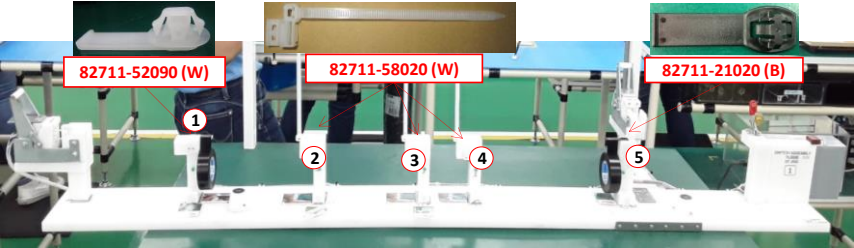
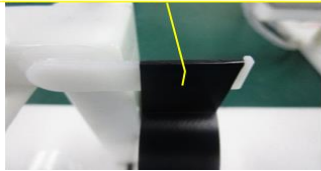
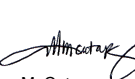

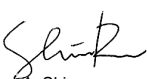

	WORK INSTRUCTION		Effectivity Date:	March 22, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code: 291B / 7L0035-7020	Customer: TRQSS	Document No.:	WI-ENG-PDE-196C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:

PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-58020 (W) [3pcs]		3. Clamp 82711-21020 (B) 4. Black tape (2pcs.)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
1	P3	<div>  <div> <div>1. Get 1 pc of clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.</div> <div>2. Get 3 pcs. of clamp 82711-58020 (W) using right hand and set to clamp location 2, 3 and 4 using both hands.</div> <div>3. Get 1 pc of clamp 82711-21020 (B) using right hand and set to clamp location 5 using both hands.</div> <div>4. Get the Black tape using right hand and put pre-tape on clamp location 1 and 5 using both hands.</div> </div> <div> <div>STANDARD TAPING FOR CLAMP</div>  <div>One side tape under clamp</div> </div> </div>				<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. Taping should be one side under (taping side of clamp before taping with COT.

Revision History								Prepared by	Reviewed by	Approved by	Noted by
03/22/21	2	Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					
11/12/20	1	Change process owner from Production (WI-PRO-ASY-047) to Engineering (WI-ENG-PDE-196C), Apply some improvements, include insertion jig, Update pictures.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date: July 10, 2017	

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: 291B / 7L0035-7020

Customer: TRQSS

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 22, 2021

Validity Date:

n/a

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2

Page No.:

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

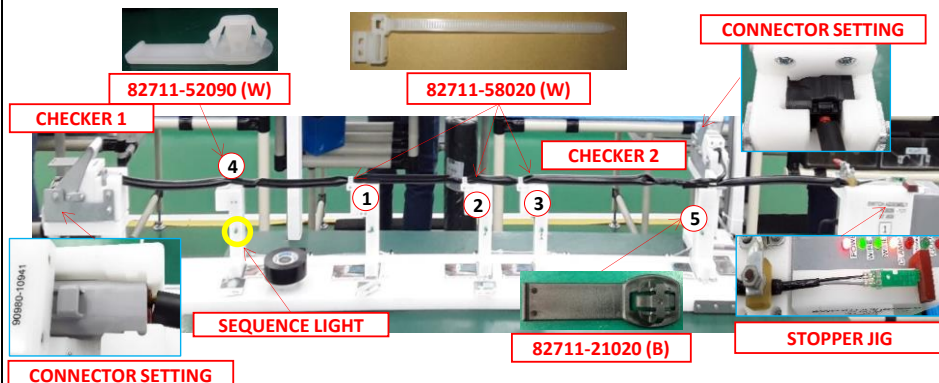
TOOLS/PPE

QUALITY POINTERS

2

P3

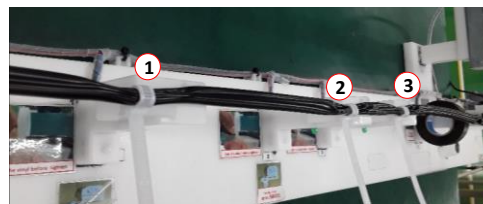
△
Clamp Assembly



1. Get the assy parts using right hand and set to jig using both hands. *(See above illustration for correct setting).* First, set the connector **6188-0066 (GR)** to **CHECKER 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-1161 (B)** to **CHECKER 2** then pull the checker fixture for continuity checking. Last, set the **PCB** within the stopper jig then press by toggle clamp. Continue the process if sequence light in location **1** was on.

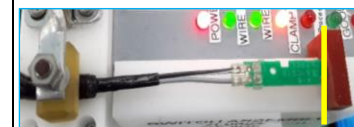
2. Check if LED light for **POWER, WIRE1 & WIRE2, CLAMP** and **SEQUENCE LIGHT** on location **1** is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

3. Initially tighten both band clamp on location **1, 2, 3** using both hands.
Note: Fold the Vinyl tube, see illustration below for proper folding.



n/a

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 use of tape
5. No peel off tape
6. No missing tape

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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WI-ENG-PDE-196C

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

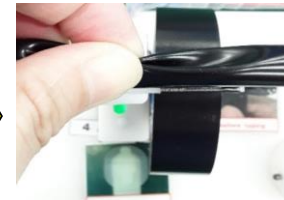
P3

2
Clamp Assembly
continuation



4. Get the Bando Gun using right hand and cut the band clamp on clamp location **1, 2** and **3**. Press the SW button after every cutting.
Note: Follow the sequence light for the next location.

5. Hold the tape on location **4** using right hand and start taping on clamp using both hands. Make **3 windings** and cut the tape. Press the SW button after taping.
Note: Fold the Vinyl tube, see illustration on the right for proper folding.



6. Hold the tape on location **5** using right hand and start taping on clamp using both hands. Make **3 windings** and cut the tape. Press the SW button after taping.
Note: No folding required. See illustration on the right for proper orientation of Y-taping.



Dia. 5 Vinyl tube
Upper part



Dia. 10 Vinyl tube
Lower part

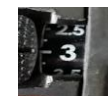
7. After taping on location **5**, press the SW button. **Go** sound will be heard.

8. Conduct **POINT CHECKING** before removal from jig.

Bando gun

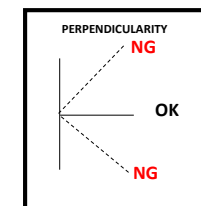


1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun
5. No wrong use of tape
6. No peel off tape
7. No missing tape



Fixed setting of
band clamp
cutter: 3 ~ 4

BANDO GUN ALIGNMENT



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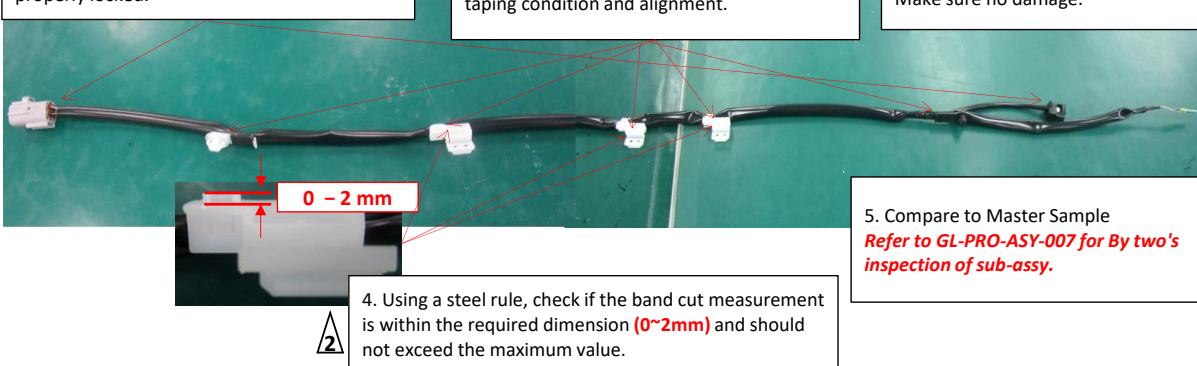

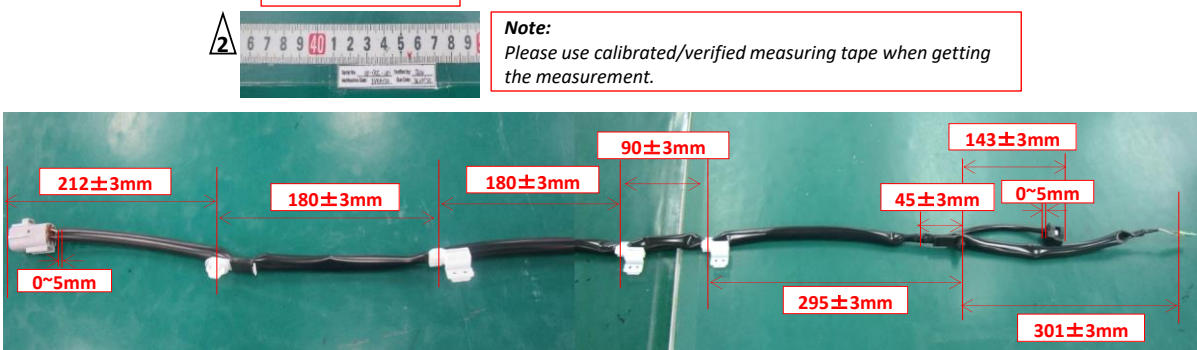
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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:	TAPING ASSEMBLY PROCESS		Effectivity Date:	March 22, 2021	
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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-196C		
			Revision No.:	2	Page No.: 4 of 4

PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3	<p>1. Check both connector (Gray and Black) if properly locked.</p> <p>2. Check the presence of clamp, attachment, taping condition and alignment.</p> <p>3. Check the appearance of PCB. Make sure no damage.</p> <p>5. Compare to Master Sample <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></p> <p>4. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p> 		<p>MASTER SAMPLE</p> 	
4		<p>MEASURING TAPE</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> 		<p>NOTE: FOR HATSUMONO AND OWARIMONO</p> <p>1. No wrong dimension</p>	

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