

**WORK INSTRUCTION**Process Name/Title: **END TAPE PRESSING PROCESS**

Effectivity Date:

**January 29, 2021**Product Name/Code: **GC7 / 15E210-0091**Customer: **TRP**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-108**

Revision No.:

**2**

Page No.:

**1 of 3****PARTS:**

n/a

JIG:

1. PNEUMATIC PRESSING JIG

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

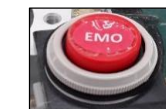
1

2  
Machine Set-up

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

Press Button

Emergency Button



Pressing Foam Top

Pressing Foam Bottom

Harness Holder

1. Perform the checking of Pneumatic Pressing jig using inspection checksheet.  
**Note: Refer to F-PRO-ASY-029**

**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.

**NOTE : Replace the pressing foam top and bottom every 500 shots.**

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
01/29/21	2	Remove cycle time. Conduct semi-annual review of documents.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
06/30/20	1	Transferred process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-167 to WI-ENG-PDE-108. Additional cycle time.	M. Catapang	J. Loterte	A. Shimamura	A. Arañes	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp

**WORK INSTRUCTION**

Effectivity Date:

January 29, 2021

Process Name/Title:

**END TAPE PRESSING PROCESS**

Validity Date:

n/a

Product Name/Code:

**GC7 / 15E210-0091**

Customer:

**TRP**

Document No.:

**WI-ENG-PDE-108**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

2 of 3

**PARTS:**

1. Assy parts

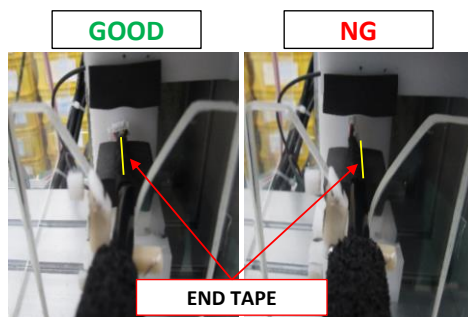
**JIG**

1. PNEUMATIC PRESSING JIG

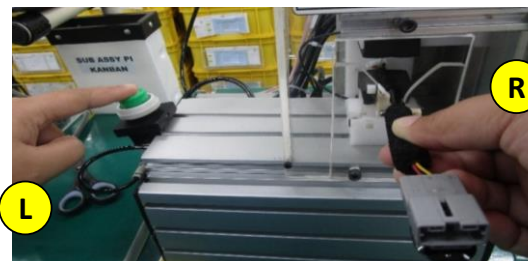
**NO.****PROCESS NAME****WORK PROCEDURE/ILLUSTRATION****TOOLS/PPE/QUALITY POINTERS**

2

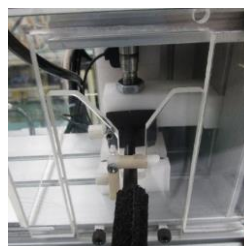
2

Harness setting to  
Pneumatic Pressing  
jig

1. Set the assy parts to pressing jig using right hand. Place the assy parts in the middle and place the **END tape** into top.



2. Hold the assy parts using right hand then press the button using left hand.



3. After **15-18 seconds**, pressing jig will automatically release.

**NOTE : Replace the pressing foam top and bottom every 500 shots.**

1. No damage parts
2. No floating or peel off tape
3. No foreign material

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



# WORK INSTRUCTION

Process Name/Title:

## END TAPE PRESSING PROCESS

Effectivity Date:

January 29, 2021

Product Name/Code:

GC7 / 15E210-0091

Customer:

TRP

Document No.:

WI-ENG-PDE-108

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

3 of 3

### PARTS:

1. Assy parts

### JIG

1. PNEUMATIC PRESSING JIG

### NO.

### PROCESS NAME

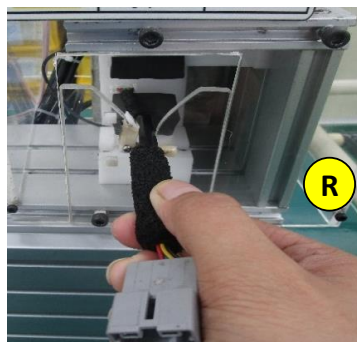
### WORK PROCEDURE/ILLUSTRATION

### TOOLS/PPE/QUALITY POINTERS

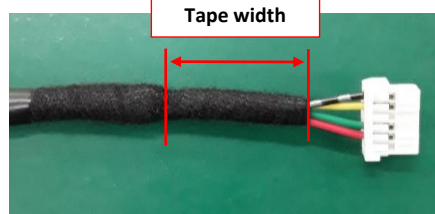
3

2

Removal of harness  
from Pneumatic  
Pressing jig

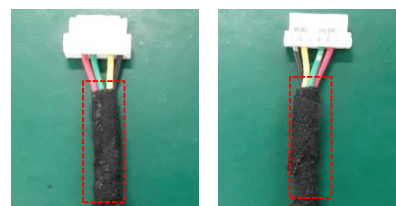


1. Get the harness using right hand.



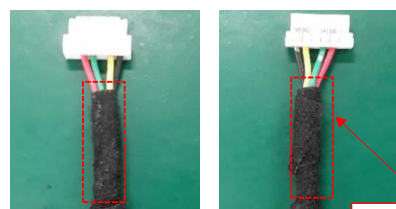
2. Check the end tape appearance.

### After Pressing



2 seconds above

1 second



GOOD

NG

Peel off Tape

**NOTE : Replace the pressing foam top and bottom every 500 shots.**

1. No damage parts
2. No floating or peel off tape
3. No foreign material

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp