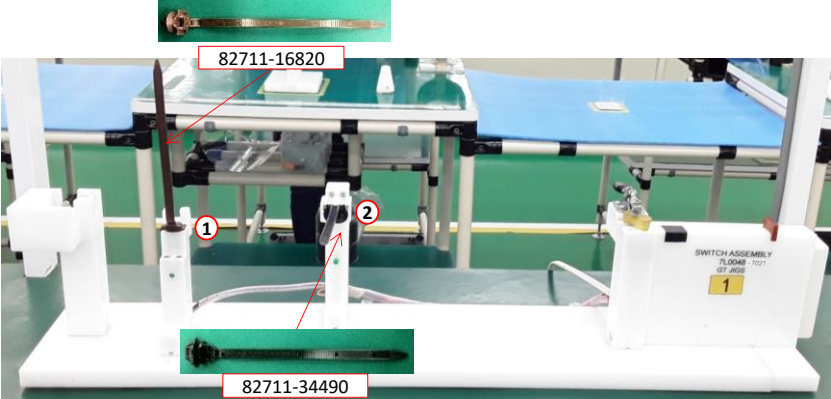


	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 7, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:				Document No.:		WI-ENG-PDE-217C	
	Product Name/Code: <b>241B / 7L0048-7021</b>		Customer: <b>TRQSS</b>		Revision No.:		4	Page No.: 1 of 4
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO								

<b>PARTS:</b>	1. Clamp 82711-16820 (BR) 2. Clamp 82711-34490 (B)	JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp Assembly setting	 <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="border: 1px solid black; padding: 5px; width: 45%;">           1. Get 1pc of Band clamp <b>82711-16820 (BR)</b> using right hand and set to clamp location <b>1</b>.         </div> <div style="border: 1px solid black; padding: 5px; width: 45%;">           2. Get 1pc of Band clamp <b>82711-34490 (B)</b> using right hand and set to clamp location <b>2</b>.         </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the work place is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            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

Revision History						Prepared by	Reviewed by	Approved by	Noted by		
07/07/21	4	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
12/15/20	3	Transfer process owner from Production (WI-PRO-ASY-090C) to Engineering (WI-ENG-PDE-217C); Apply some improvement; update all picture etc.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
06/19/19	1	Include process distribution	E. Resurreccion	W. Carbillon	O. Merin	n/a					
03/13/18	n/a	Previously established Engineering Instruction (EI-ENG-PDE-023). Initial Issue.	S. Manalo	R. Alcantara	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date: July 19, 2018				

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Product Name/Code: **241B / 7L0048-7021**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 7, 2021

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n/a

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**PARTS:**

1. Assy parts
2. Clamp 82711-48240 (W)

**JIG**

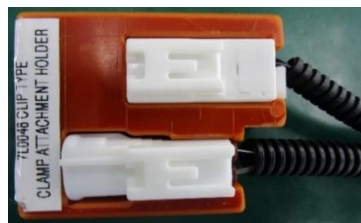
1. Clamp attachment holder jig

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

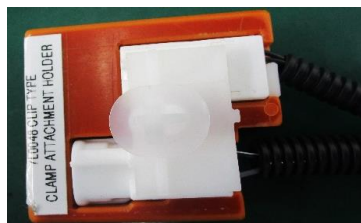
2

P3

Clamp Attachment

**CONNECTOR SETTING**

1. Set the 2 connectors into clamp holder jig using both hands.  
*Follow the above illustration for the correct setting.*

**Pushing direction**

2. Hold the clamp using right hand, strongly push the clamp, sound will be heard if fully inserted.

3. After inserting the clamp, remove the 2 connectors from clamp holder jig using both hands.  
Check the clamp attachment.

**Clamp Attachment Holder jig**

1. No wrong attachment of clamp
2. No damage on parts
3. No unlock attachment

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **241B / 7L0048-7021**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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### PARTS:

1. Assy parts

### JIG

1. Clamp Assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

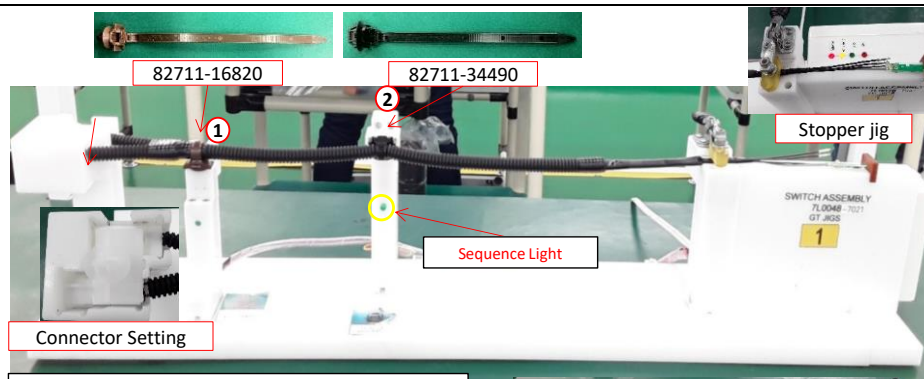
### TOOLS/PPE

### QUALITY POINTERS

3

P3

Clamp Assembly



1. Get the assy parts using both hands. Put first the connectors to receiver base, second, put the terminal/PCB to stopper jig then pull down the toggle clamp using right hand.  
**Refer to above illustration for the correct setting.** Check if LED for **POWER, CLAMP and SEQUENCE** light in clamp location 1 is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

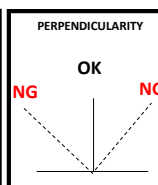
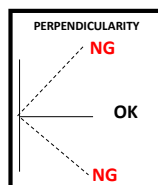


2. Initially tighten the band clamp from location 1~2 using both hands.

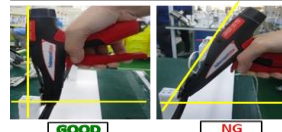
3. Get the bando gun and cut the band clamp on location 1. Press the switch button after cutting.



#### BANDO GUN ALIGNMENT



4. Cut the band clamp on location 2. Press the switch button after cutting. Go sound will be heard.



5. Conduct POINT CHECKING before removing from clamp assembly jig.

### Bando Gun



Note:  
Make sure no gap between stopper jig and PCB



1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp



Fixed setting  
of band  
clamp cutter:  
3 ~ 4

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## WORK INSTRUCTION

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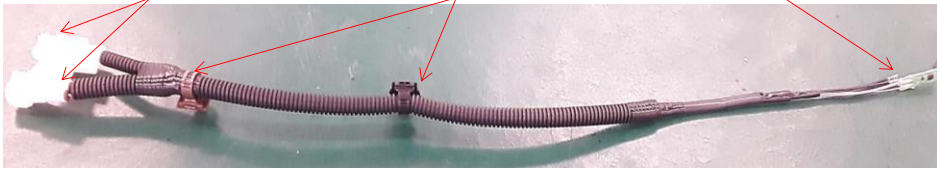
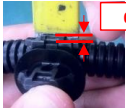

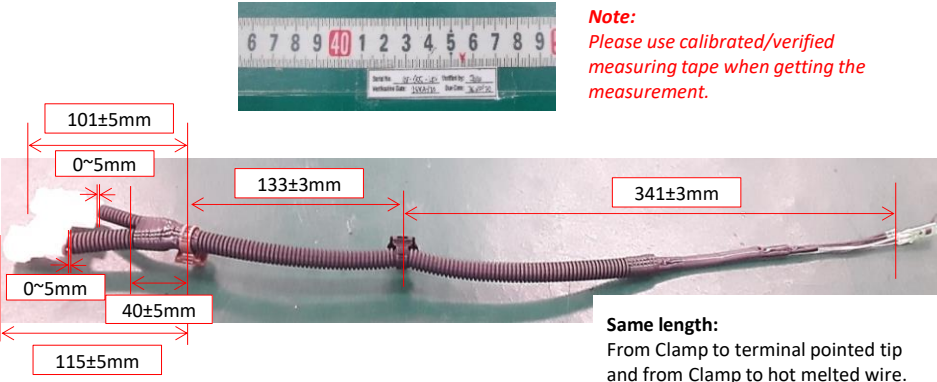
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PARTS:	n/a				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Visual/By two's inspection	<div>1. Check the connector if properly locked.</div> <div>2. Check the clamp attachment and alignment.</div> <div>3. Check the terminal condition. Make sure no deformed terminal.</div>  <div>4. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div>  <div>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div>			n/a	<b>Master Sample</b> 
5	P3 Measurement	 <div><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div><b>Same length:</b> From Clamp to terminal pointed tip and from Clamp to hot melted wire.</div>			n/a	<b>For Hatsumono and Owarimono</b>

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