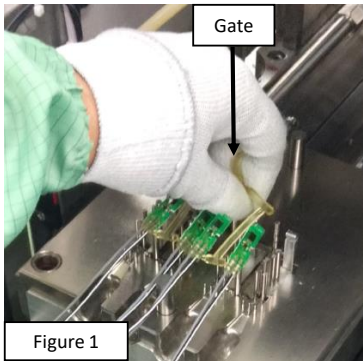
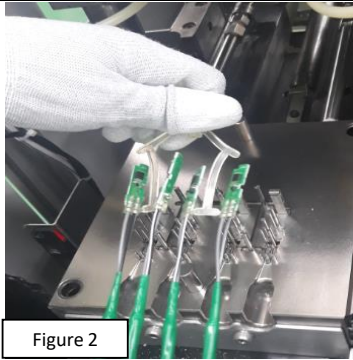
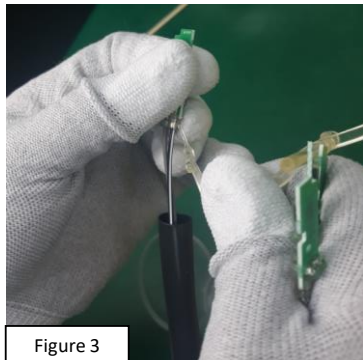
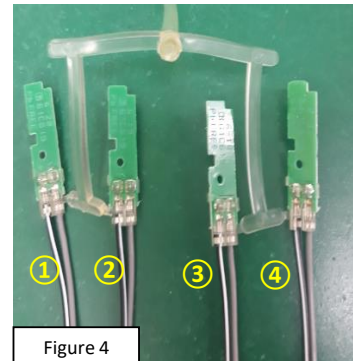
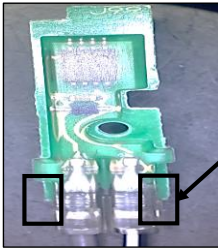
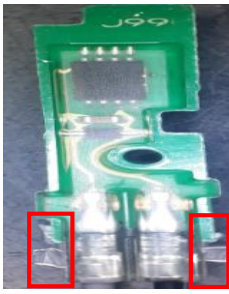

	Process Name/ Title:		Document No:	WI-PRO-SHM-028	
	Gate Cuts, Gate Inspection and Pin Gauge Confirmation				
	WORK INSTRUCTION		Effective Date:	February 12, 2022	
	Product Code/Name: ALL	Customer Code: ALL	Rev. No.: 2	Page No.:	Page 1 of 2


No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
1	<p>Hold the gate (Refer to Figure 1)</p> <p>Remove/Pull out the 4 hotmelted parts in the lower die (Refer to Figure 2)</p>	 	<p>Ensure to wear ESD gloves</p> <p>Hold and remove/pull out the gates from the lower die</p>
2	<p>Hold the PCB by one hand and remove/cut the gates by the other hand (Refer to Figure 3)</p> <p>Ensure to follow the sequence in gate removal (Refer to Figure 4)</p>	 	<p>Remove/ Separate the gate from the PCB carefully</p> <p>Avoid Hotmelt Damages</p>
3	<p>Inspect the Hotmelted PCB (Refer to Figure 5 and 6)</p>	<div> <p>Figure 5</p> <p>GOOD</p>  <p>Inspection Point Both Sides</p> <p>No waste/excess gate on gate cut part</p> </div> <div> <p>Figure 6</p> <p>NO GOOD</p>  <p>Excess Gate</p> <p>Max.0.5mm</p> <p>Max.0.5mm</p> <p>Max.0.5mm</p> <p>Has waste/excess gate on gate cut part</p> </div>	<p>Ensure that there is no excess gate</p> <p>Ensure that the gate is less than 0.5mm</p> <p>Call the attention of Leader if encountered abnormality</p> <p>If problem encountered: STOP-CALL-WAIT</p>

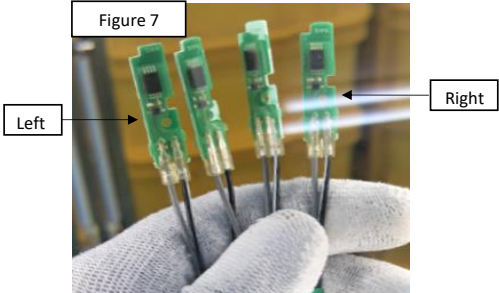
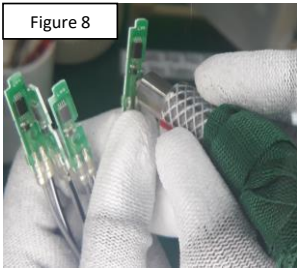
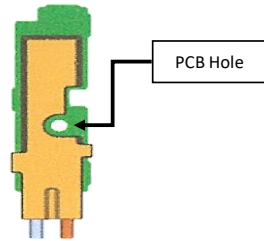

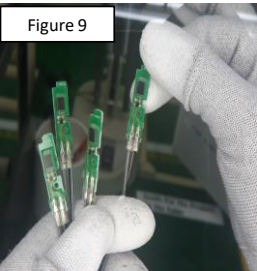
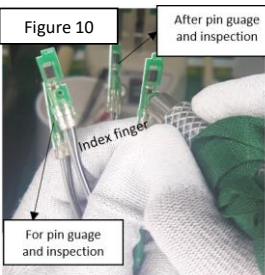
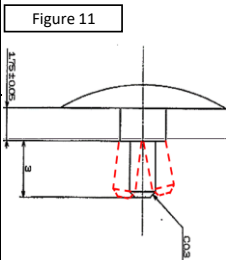
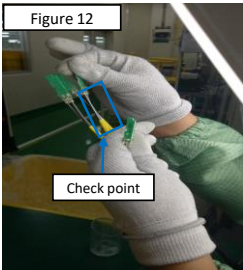
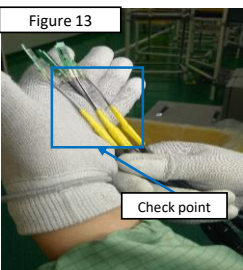
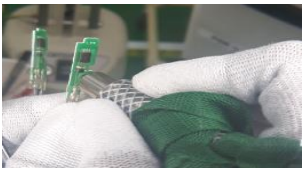
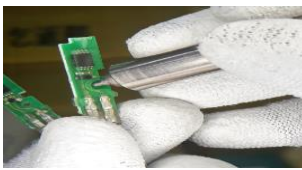
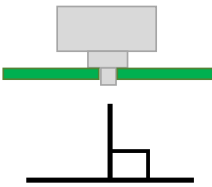
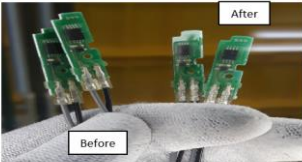
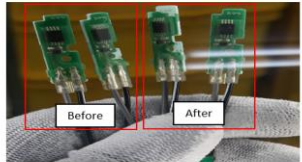
02/12/2022		Change reference from "WI-PRO-SHM-022and 023" to "IS-PRO-SHM-013"	C. Lalican	W. Carillon	O. Merin	Prepare	Check	Approve
02/07/2020	1	Combine WI (WI-PRO-SHM- 027, 031, 028) General revision: Base on actual procedure	C. Luna	D. Cornero	O. Merin			
-	NA	Previous establish work instruction from NBC Japan(for history purpose only)	Shibazaki	Tanabe	Nakano	C. Lalican	W. Carillon	O. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date: 01/29/2020		

CONFIDENTIAL: ©2017 NBC; all rights reserved. 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

	Process Name/ Title: Gate Cuts, Gate Inspection and Pin Gauge Confirmation		Document No:	WI-PRO-SHM-028	
	WORK INSTRUCTION		Effective Date:	February 12, 2022	
	Product Code/Name:	Customer Code:	Rev. No.: 2	Page No.: Page 1 of 2	

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
4	Confirm the PCB hole from right to left (Refer to Figure 7)		Ensure to check the PCB hole in order
5	Left Hand: Hold the hotmelted PCB Right Hand: Using pin gauge to confirm the PCB hole (Figure 8)	 	Ensure that the gauge is fitted inside the PCB hole Ensure to use good pin gauge If encounter NG pin gauge call the attention the Leader (Figure 11)
 6	After Inspection IS-PRO-SHM-013 Rev.2 Hotmelt Visual Inspection Right Hand: Move the inspected PCB and wire at the back of index finger (Figure 10 and Figure 12)	 	 Ensure to move at the back of index finger the inspected PCB
7	After pin gauge inspection Check all 4 pcs (Figure 13) before putting to designated box	 	Ensure that the wire or harness are free from damage.
8	Proper usage of pin gauge	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; padding: 5px; text-align: center;"> GOOD  PCB and pin gauge should be perpendicular with each other </div> <div style="border: 1px solid black; padding: 5px; text-align: center;"> NO GOOD  PCB and pin gauge are not perpendicular with each other </div> </div>	Ensure that PCB and pin gauge are perpendicular (refer below) with each other to avoid damage PCB 
9	Proper separation of after and before inspection	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; padding: 5px; text-align: center;"> GOOD  To distinguish workpiece after inspection divide using index finger </div> <div style="border: 1px solid black; padding: 5px; text-align: center;"> NO GOOD  Cannot distinguish what workpiece are already completed the inspection </div> </div>	Ensure to properly separate before and after inspection to avoid mixing