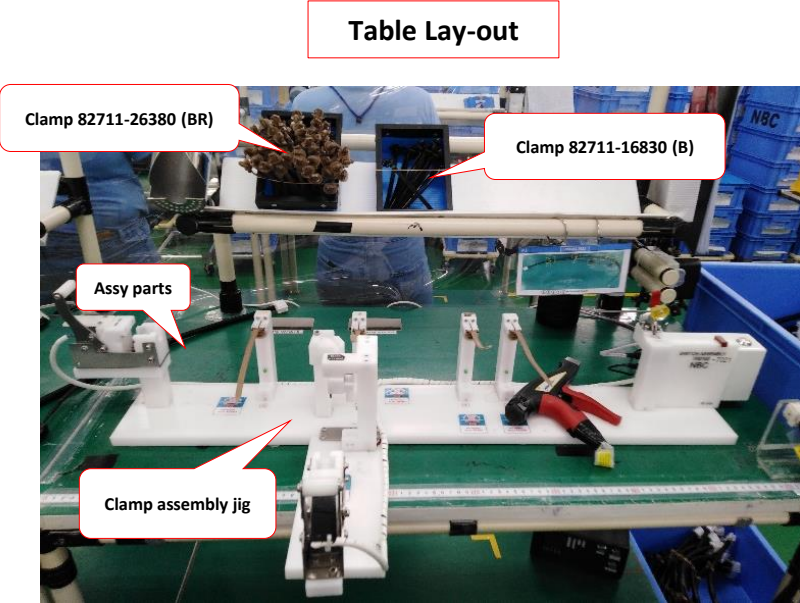




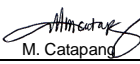


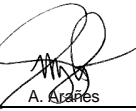
WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	February 10, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-397C		
Revision No.:	0	Page No.:	1 of 6

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	780B / 7R0103-7022	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts; Clamp 82711-26380 (BR); Clamp 82711-16830 (B)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out		<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 missing parts/tools 2. No excess parts/tools

Revision History

02/10/22	0	Initial issue. Wire color from Gray (GR) to Green (G) (MRSW CP TVSSf 0.3 from GR-B/W to MRSW CP TVSSf 0.3 G-B/W); Refer to CL-ENG-PDE-254A	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
										
Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	December 07, 2020		

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

Effectivity Date:

February 10, 2022

Process Name/Title:

Validity Date:

n/aModel Code/Part Number: **780B / 7R0103-7022**

Customer:

TRMX

Document No.:

WI-ENG-PDE-397C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts
2. Clamp 82711-26380 (BR) [4pcs.]

JIG

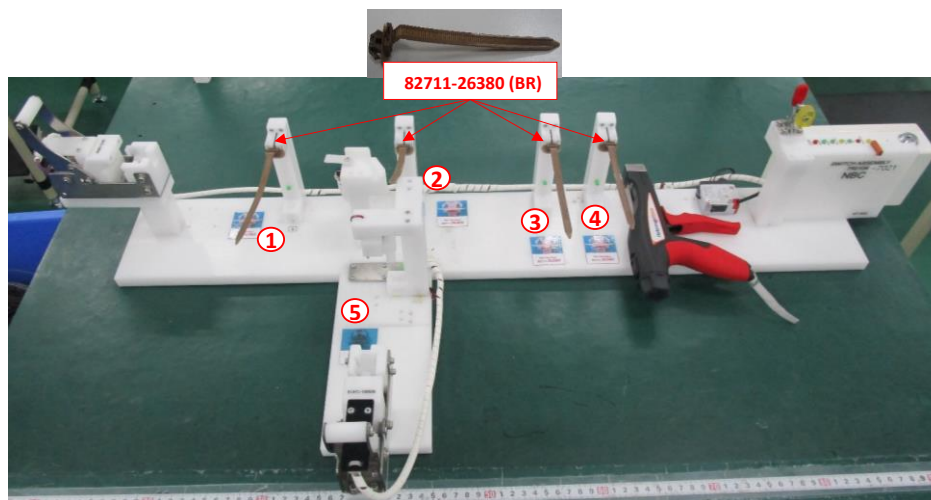
1. Clamp assembly jig

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

2

P3

Clamp setting



1. Get 2pcs. of clamp **82711-26380 (BR)** using right hand and set to clamp location **1 and 2** using both hands.

2. Get 2pcs. of clamp **82711-26380 (BR)** using right hand and set to clamp location **3 and 4** using both hands.

Note: Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.

n/a

1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

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TAPING ASSEMBLY PROCESS

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Process Name/Title:

Validity Date:

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Model Code/Part Number: 780B / 7R0103-7022

Customer:

TRMX

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Purpose:

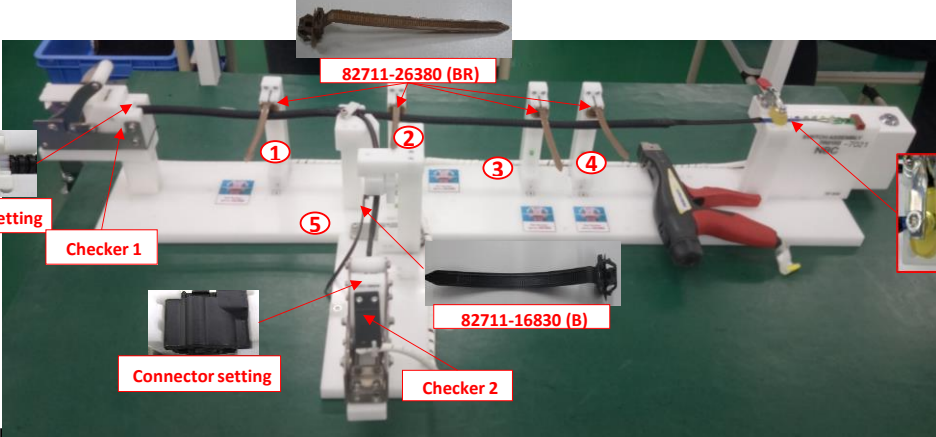
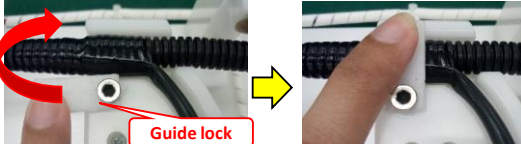

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts 2. Clamp 82711-16830 (B)			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp setting (Continuation)	 <p>3. Hold the assy parts and then set to jig. (<i>See above picture for correct setting</i>). First, set the connector 6189-1142 (W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. (<i>See below illustration for Y-Taping lock.</i>) Second, set the PCB to stopper jig and push down the toggle clamp. Last, set the connector 6189-1161 (B) to Checker 2 then push the checker fixture for continuity checking.</p>  <p>4. Using left index finger, push the guide lock to lock the Y-taping portion.</p> <p>5. Get 1pc. of clamp 82711-16830 (B) using right hand and set to clamp location 5 using both hands.</p> <p>6. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p>		n/a	 <p><i>Note: Make sure no clearance between PCB and stopper jig.</i></p> <p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p>

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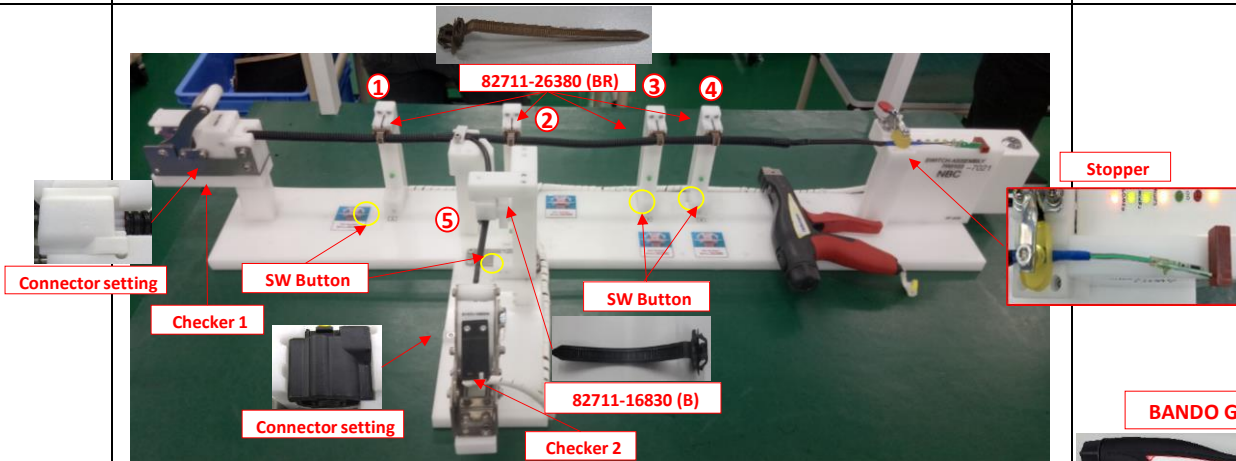
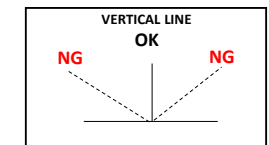


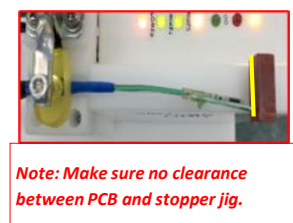
WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	February 10, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-397C		
Revision No.:	0	Page No.:	4 of 6

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **780B / 7R0103-7022** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	<div></div> <div><p>1. Initially tighten the band clamp on clamp location 1, 2, 3, 4, and 5 using both hands.</p><p>2. Get the Bando Gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 2 was ON.</p><p>3. Cut the band clamp on clamp location 2 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location</p><p>4. Cut the band clamp on clamp location 3 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 4 was ON.</p></div> <div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div>	<div><p>Note: Make sure no clearance between PCB and stopper jig.</p></div> <div><p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p></div>	

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TAPING ASSEMBLY PROCESS

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Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 780B / 7R0103-7022

Customer: TRMX

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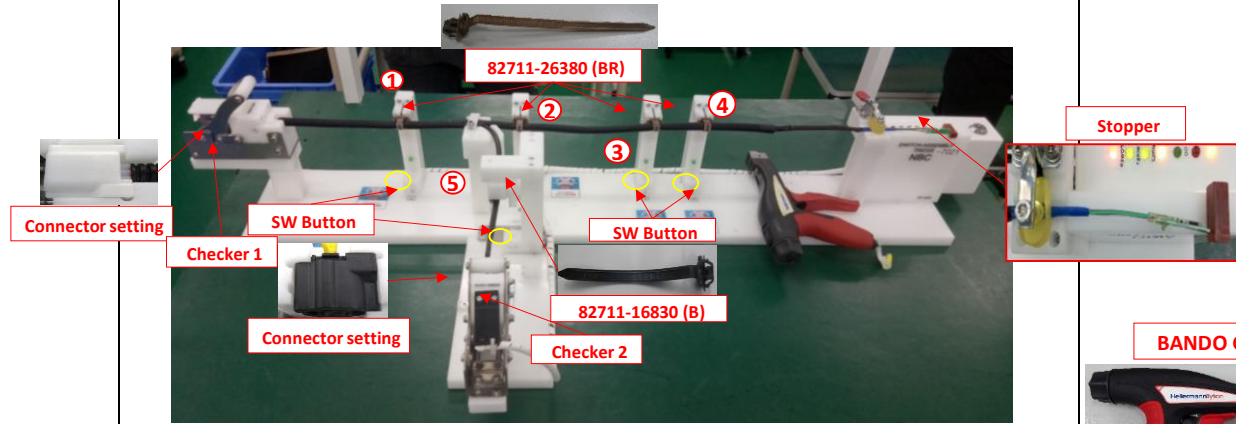



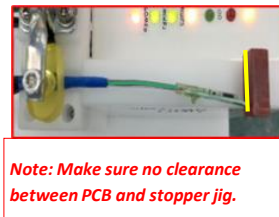
Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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 (Continuation)	<div></div> <div><p>5. Cut the band clamp on clamp location 4 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 5 was ON.</p><p>6. Cut the band clamp on clamp location 5 using both hands. (<i>See below illustration</i>). Press the SW button after cutting of band clamp. Go sound will be heard.</p></div> <div><div><p>HORIZONTAL LINE</p><p>NG</p><p>OK</p><p>NG</p></div><div></div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div></div> <div><p>7. Conduct POINT CHECKING before removing the harness from jig.</p></div>		<div></div>	<div><p>Note: Make sure no clearance between PCB and stopper jig.</p></div> <div><p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p></div>

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TAPING ASSEMBLY PROCESS

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Model Code/Part Number: **780B / 7R0103-7022**

Customer: **TRMX**

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH


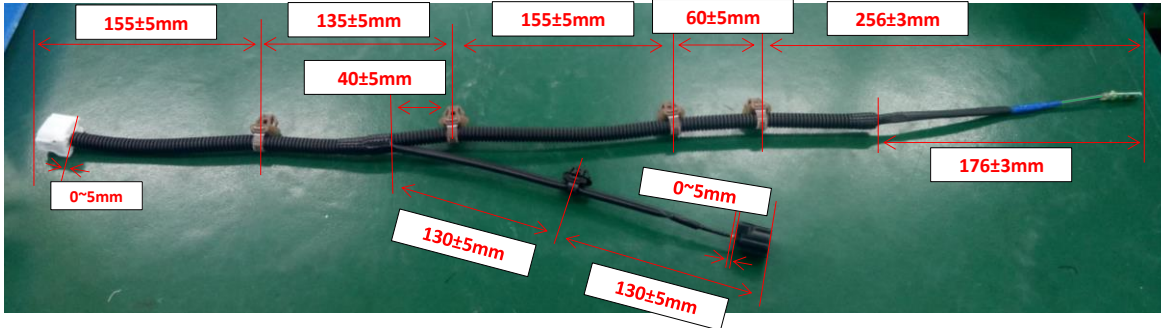
☒ MASSPRO

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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	<p>1. Check the connector if properly locked.</p> <p>2. Check the clamp attachment and alignment.</p> <p>3. Check the hotmelt appearance make sure no damage.</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>5. Compare to Master sample. <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></p>		<p>MASTER SAMPLE</p> 	
5	Measurement	<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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