

**WORK INSTRUCTION**

Effectivity Date:

May 03, 2021

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Product Name/Code:

**480B / A7043E**

Customer:

**TRQSS**

Document No.:

WI-ENG-PDE-185C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

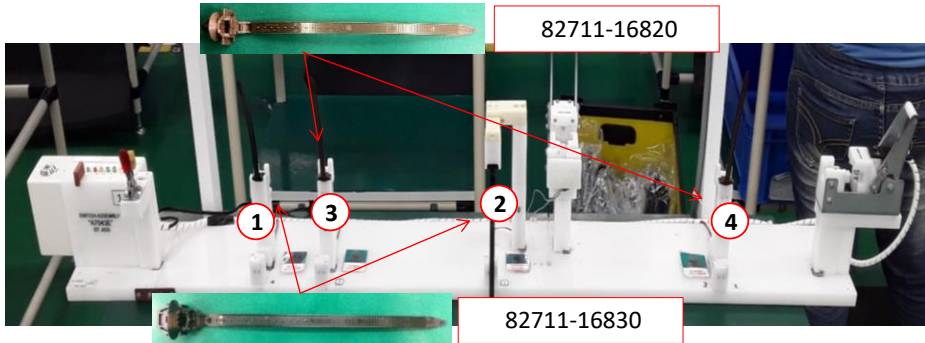
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**PARTS:**

1. Band Clamp 82711-16820 (BR) [2pcs]
2. Band Clamp 82711-16830 (B) [2pcs]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp Assembly setting	 <div> <p>2. Get 2 Band clamp <b>82711-16830 (B)</b> using right hand and set to clamp location <b>1</b> and <b>2</b> using both hands.</p> <p>1. Get 2 Band clamp <b>82711-16820 (BR)</b> using right hand and set to clamp location <b>3</b> and <b>4</b> using both hands.</p> </div>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<ol style="list-style-type: none"> <li>1. No wrong use of clamp</li> <li>2. No damaged clamp</li> </ol>

## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/03/21	4	Change the clamp setting sequence (from left to right); rephrase the band cut checking procedure	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/30/20	3	Transfer process owner from Production (WI-PRO-ASY-11C) to Engineering (WI-ENG-PDE-185C); Apply some improvements; Updated pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Initial issue.	J. Monetaalto/ L. Briones	O. Merin	T. Sugiyama	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	July 10, 2017		

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DCC Stamp



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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

2

P3

Clamp assembly



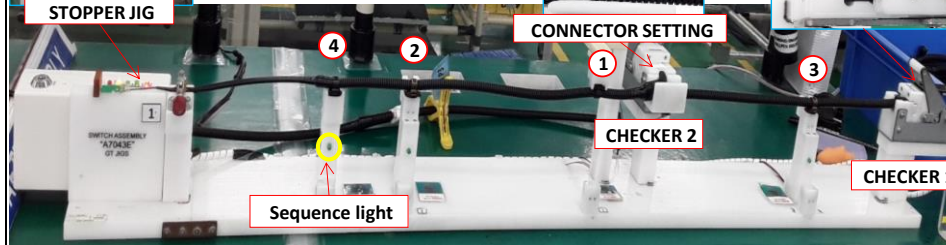
STOPPER JIG



CONNECTOR SETTING



CONNECTOR SETTING



Sequence light

CHECKER 2

CHECKER 1

1. Get the assy parts using right hand and set to jig. Put first the Black connector on checker 1 using both hands, Second put the White connector in Checker 2 using both hands and last, put the PCB on toggle clamp using both hands.  
*Please see above illustration for proper setting.*

2. Check the LED light for **POWER, CLAMP, WIRE 1** and **WIRE 2** and **SEQUENCE LIGHT** was **ON** in clamp location 1.  
If encountered abnormality, **STOP** the process, **CALL** the leader and **WAIT** for instruction.

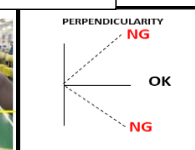
3. Initially tighten the band clamp on location 1, 2, 3 and 4 using both hands.

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

4. Get the Bando gun using right hand and cut the band clamp on location 1, 2, 3 and 4 based on sequence light. Press the SW button after every cutting.  
*Refer to sequence light for cutting sequence.*

*Refer to sequence light for cutting sequence.*

### BANDO GUN ALIGNMENT



### BANDO GUN



Make sure no clearance between PCB and stopper jig



- 1.No loose/tight attachment
- 2.No damaged clamp
3. No missing parts.

### BANDO GUN SETTING



Fixed setting of band clamp cutter: 2~3

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**PARTS:**

n/a

**JIG**

n/a

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

3

Visual/By Two's inspection

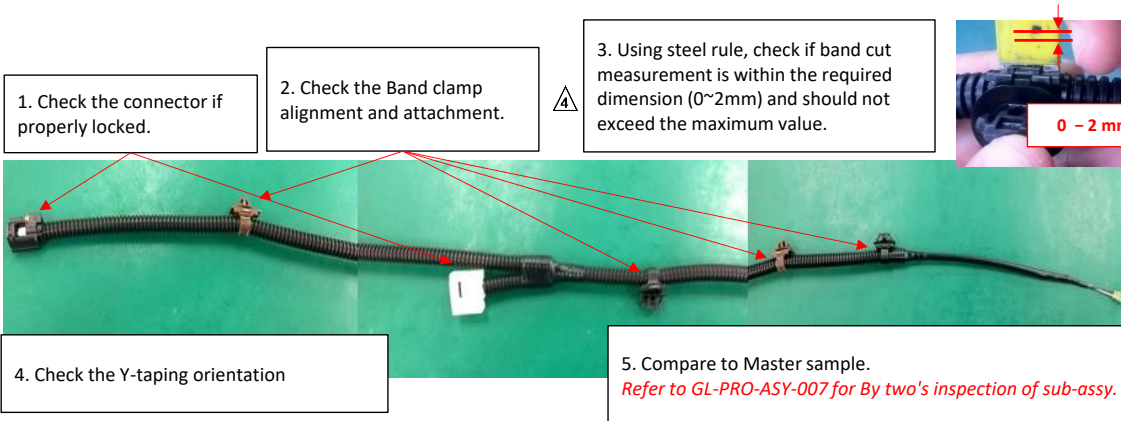
1. Check the connector if properly locked.

2. Check the Band clamp alignment and attachment.

3. Using steel rule, check if band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.

4. Check the Y-taping orientation

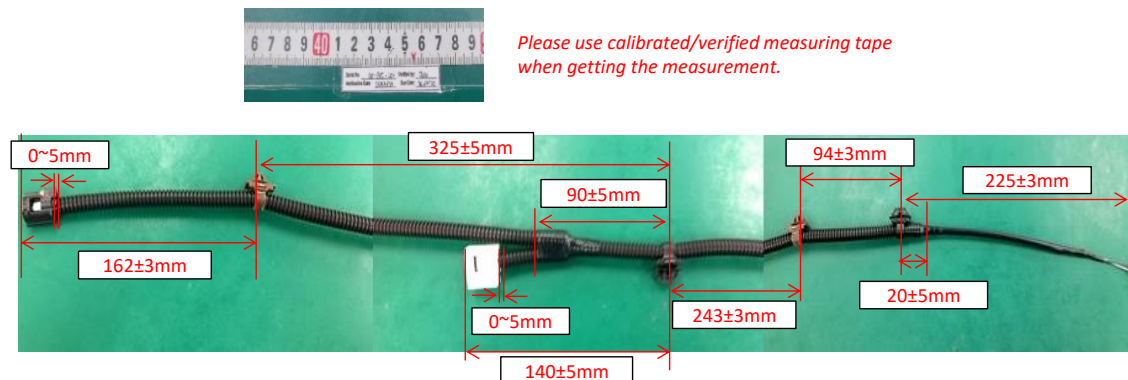
5. Compare to Master sample.  
*Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.*

**MASTER SAMPLE**

P3

4

Measurement

**FOR OWARIMONO AND HATSUMONO**

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