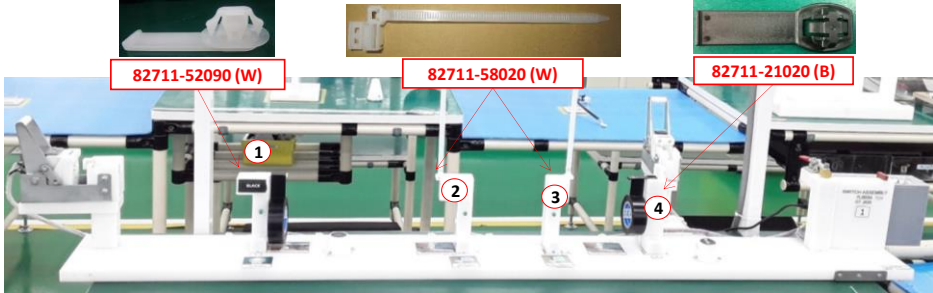
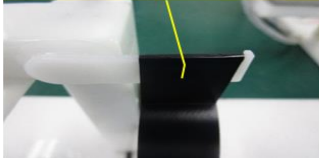
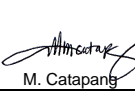

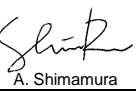
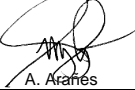
	<b>WORK INSTRUCTION</b>		Effectivity Date:	<b>March 22, 2021</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>		Validity Date:	n/a	
	Product Name/Code: <b>291B / 7L0034-7020</b>	Customer: <b>TRQSS</b>	Document No.:	<b>WI-ENG-PDE-192C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:

<b>PARTS:</b>	1. Clamp 82711-52090 (W) 2. Clamp 82711-58020 (W) [2pcs]	3. Clamp 82711-21020 (B) 4. Black tape (2pcs.)	JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp setting	<div>  <div> <div> <p>1. Get 1 pc of clamp <b>82711-52090 (W)</b> using right hand and set to clamp location <b>1</b> using both hands.</p> </div> <div> <p>2. Get 2 pcs of clamp <b>82711-58020 (W)</b> using right hand and set to clamp location <b>2</b> and <b>3</b> using both hands.</p> </div> <div> <p>3. Get 1 pc of clamp <b>82711-21020 (B)</b> using right hand and set to clamp location <b>4</b> using both hands.</p> </div> <div> <p>4. Get the <b>Black tape</b> using right hand and put pre-tape in clamp location <b>1</b> and <b>4</b> using both hands.</p> </div> </div> <div> <p><b>STANDARD TAPING FOR CLAMP</b></p> <p>One side tape under clamp</p>  </div> </div>	<div> <p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. Taping should be one side under (taping side of clamp before taping with COT).

Revision History								Prepared by	Reviewed by	Approved by	Noted by
03/22/21	2	Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					
11/12/20	1	Change process owner from Production (WI-PRO-ASY-046) to Engineering (WI-ENG-PDE-192C), Apply some improvements, include insertion jig, Update pictures.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	July 10, 2017			

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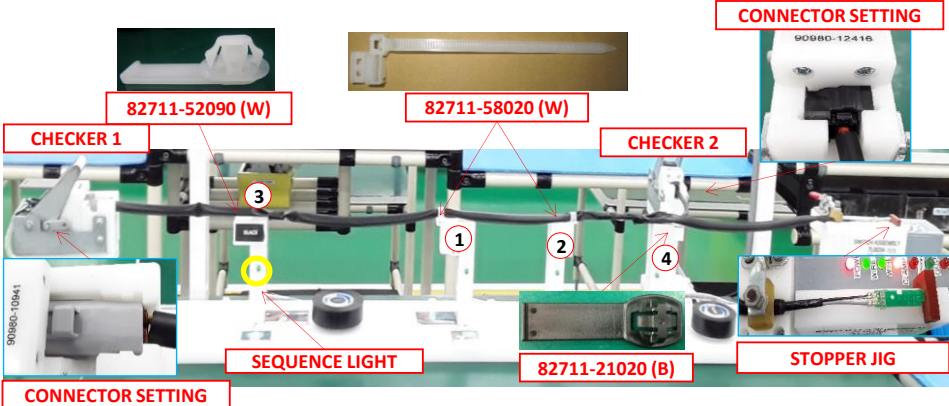
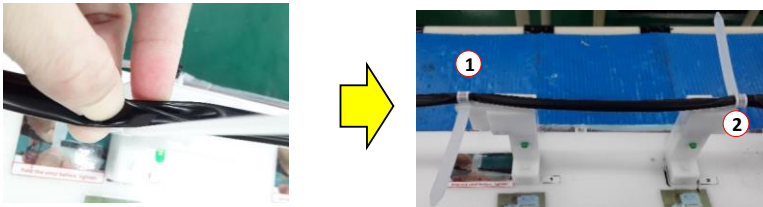
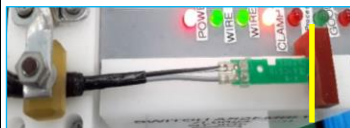
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# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

WORK INSTRUCTION					Effectivity Date:		March 22, 2021		
Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:		n/a		
Product Name/Code: 291B / 7L0034-7020				Customer: TRQSS		Document No.:		WI-ENG-PDE-192C	
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		2	Page No.:	2 of 4

PARTS:		1. Assy parts			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P3  Clamp Assembly	 <p>1. Get the assy parts using right hand and set to jig using both hands. <i>(See above illustration for correct setting).</i> First, set the connector <b>6188-0066 (GR)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>6189-1161 (B)</b> to <b>Checker 2</b> then pull the checker fixture for continuity checking. Last, set the <b>PCB</b> within the stopper jig then press by toggle clamp. Continue the process if sequence light in location <b>1</b> was on.</p> <p>2. Check if LED light for <b>POWER, WIRE1 &amp; WIRE2, CLAMP</b> and <b>SEQUENCE LIGHT</b> on location <b>1</b> is <b>ON</b>. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the Leader and <b>WAIT</b> for instruction.</p> <p>3. Initially tighten both band clamp on location <b>1</b> and <b>2</b> using both hands. <i>Note: Fold the Vinyl tube, see illustration below for proper folding.</i></p> 			n/a	<p>Note: Make sure no clearance between PCB and stopper jig</p>  <ol style="list-style-type: none"> <li>1. No wrong setting of clamp</li> <li>2. No wrong use of clamp</li> <li>3. No Loose attachment of clamp</li> <li>4. No wrong use of tape</li> <li>5. No peel off tape</li> <li>6. No missing tape</li> </ol>

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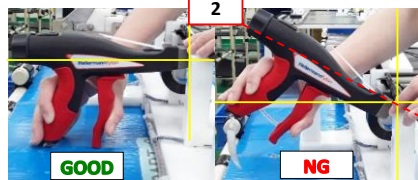

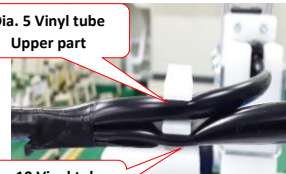

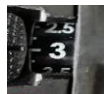
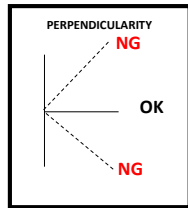
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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 22, 2021		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	291B / 7L0034-7020	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 <div>△ 2 Clamp Assembly continuation</div>	<div><div><div></div><div></div></div><div>4. Get the Bando Gun using right hand and cut the band clamp on clamp location <b>1</b> and <b>2</b>. Press the SW button after every cutting. <b>Note: Follow the sequence light for the next location.</b></div><div><div>5. Hold the tape on location <b>3</b> using right hand and start taping on clamp using both hands. Make <b>3 windings</b> and cut the tape. Press the SW button after taping. <b>Note: Fold the Vinyl tube, see illustration on the right for proper folding.</b></div><div></div></div><div><div>6. Hold the tape on location <b>4</b> using right hand and start taping on clamp using both hands. Make <b>3 windings</b> and cut the tape. Press the SW button after taping. <b>Go</b> sound will be heard. <b>Note: No folding required. See illustration on the right for proper orientation of Y-taping.</b></div><div><div><div>Dia. 5 Vinyl tube Upper part</div><div>Dia. 10 Vinyl tube Lower part</div></div></div></div><div>7. After taping, conduct <b>POINT CHECKING</b> before removal from jig.</div></div>		<div>Bando gun</div> 	<div><div>Fixed setting of band clamp cutter: 3 ~ 4</div></div> <div>BANDO GUN ALIGNMENT</div> <div><div>PERPENDICULARITY NG OK NG</div></div> <div>1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No wrong use of tape 6. No peel off tape 7. No missing tape</div>

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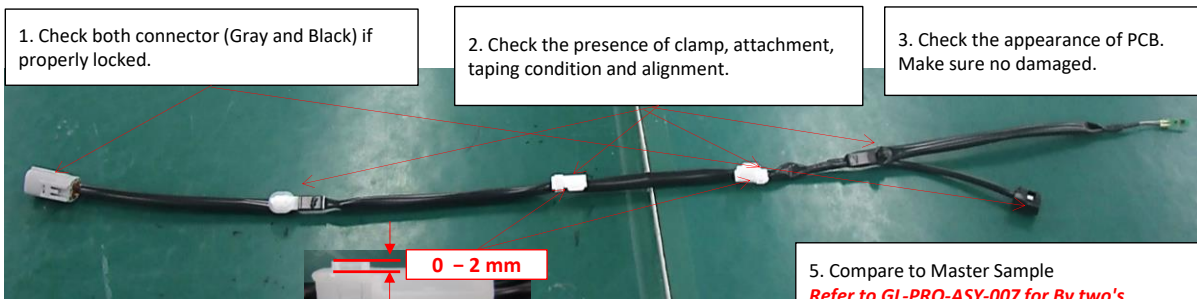
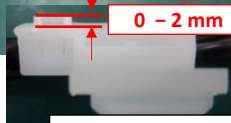



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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

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Product Name/Code: 291B / 7L0034-7020				Customer: TRQSS		Document No.:		WI-ENG-PDE-192C	
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		2	Page No.:	4 of 4

PARTS:	n/a				JIG	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P3	Visual/By two's inspection	<div>1. Check both connector (Gray and Black) if properly locked.</div> <div>2. Check the presence of clamp, attachment, taping condition and alignment.</div> <div>3. Check the appearance of PCB. Make sure no damaged.</div> <div></div> <div></div> <div>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.</div> <div>5. Compare to Master Sample <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></div>				<div>MASTER SAMPLE</div> <div></div>
4		Measurement	<div></div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div></div>			<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>	

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