

	WORK INSTRUCTION				Effectivity Date:		June 16, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:				Document No.:		WI-ENG-PDE-298C	
	Product Name/Code: 480A / A7045D		Customer: TRQSS		Revision No.:		3	Page No.: 1 of 3
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO								

PARTS:	1. Clamp 82711-16830 (B) [2pcs] 2. Clamp 82711- 52090 (W)	3. Clamp 82711-3F440 (B) 4. Clamp 82712-75390 (B)	5. 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 Assembly setting	<div style="text-align: center;"> </div> <div style="display: flex; justify-content: space-between;"> <div style="width: 48%;"> <p>1. Get 2pcs of clamp 82711-16830 (B) using right hand and set to clamp location 1 and 2 using both hands.</p> <p>2. Get 1pc of clamp 82711-52090 (W) using right hand and set to clamp location 3 using both hands.</p> <p>3. Get 1pc of clamp 82711-3F440 (B) using right hand and set to clamp location 4 using both hands.</p> </div> <div style="width: 48%;"> <p>4. Get 1pc of clamp 82712-75390 (B) using right hand and set to clamp location 5 using both hands.</p> <p>5. Get Black tape using right hand and conduct pre-taping on clamp location 3 and 5 using both hands.</p> </div> </div> <div style="text-align: center; margin-top: 10px;"> STANDARD TAPING FOR CLAMP </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level 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		
06/16/21	3	Transfer process owner from Production (WI-PRO-ASY-010C) to Engineering (WI-ENG-PDE-298C); Change the process illustration	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	 J. Loterte	 C. Villanueva	 A. Shimamura	 A. Arañes	 J. Loterte	 C. Villanueva	 A. Shimamura	 A. Arañes
07/01/19	2	Include the Process Distribution/ Include Insertion Jig	J. Silang	A. Morcozo	O. Merin	n/a								
10/02/17	1	Correction of wire position in connector insertion. Change quality pointers from "No wrong insertion to corrugated" to "Wires must be properly aligned prior insertion".	J. Montealto L. Briones	O. Merin	T. Sugiyama	n/a								
07/10/17	n/a	Initial issue	J. Montealto L. Briones	O. Merin	T. Sugiyama	n/a								
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	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

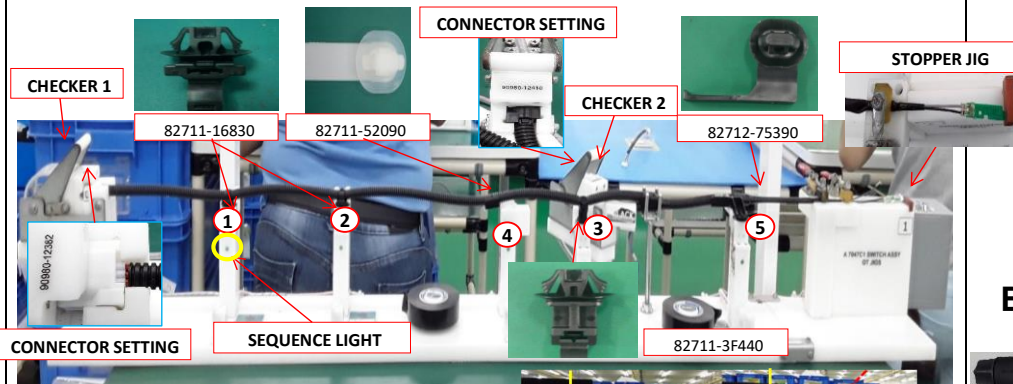
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp assembly



1. Get the assy parts using right hand and set to jig using both hands. First, Put the White connector to checker 1, second, put the Black connector to checker 2 then last, put the PCB to stopper jig and push down the toggle clamp using right hand. *See above illustration for proper setting.*

2. Check the LED light for **POWER, CLAMP, WIRE1&WIRE2** and **SEQUENCE** light was **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

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

6. After taping on location **5**, Press the SW button. Go sound will be heard. Conduct **POINT CHECKING** before removal from jig.

4. Get the Bando Gun using right hand and cut the Band clamp from Location **1, 2** and **3** using both hands. Press the SW button after every cutting of Band clamp.

Note: Follow the sequence light.

5. Hold the tape on location **4** using right hand and start taping on clamp using both hands. Make 3 winds and cut the tape. Press the SW button after taping. Apply this process to clamp location **5**.

Bando Gun



Make sure no clearance between PCB and stopper jig

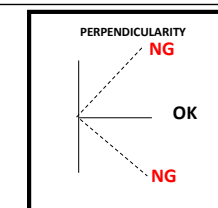


1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun
5. No wrong use of tape
6. No peel off tape
7. No missing tape



Fixed setting of band clamp cutter: 2~3

BANDO GUN ALIGNMENT



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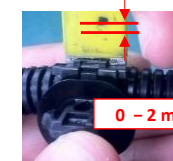
Visual/By Two's inspection

P3

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.



MASTER SAMPLE



4. Check the Y-taping orientation

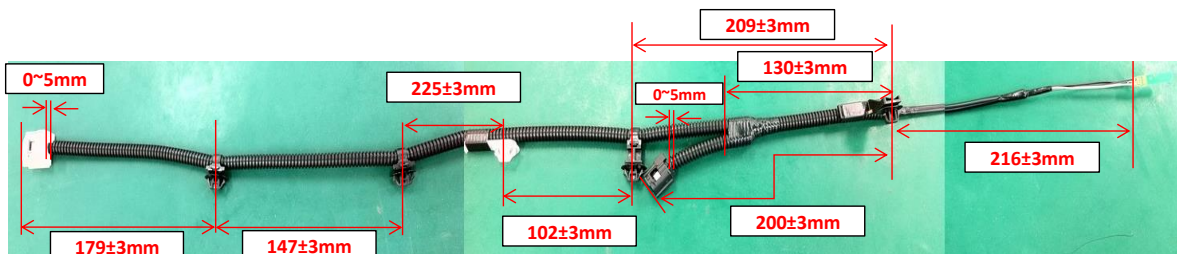
5. Compare to Master sample.
Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.

4

Measurement



Please use calibrated/verified measuring tape when getting the measurement.



FOR OWARIMONO AND HATSUMONO

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