

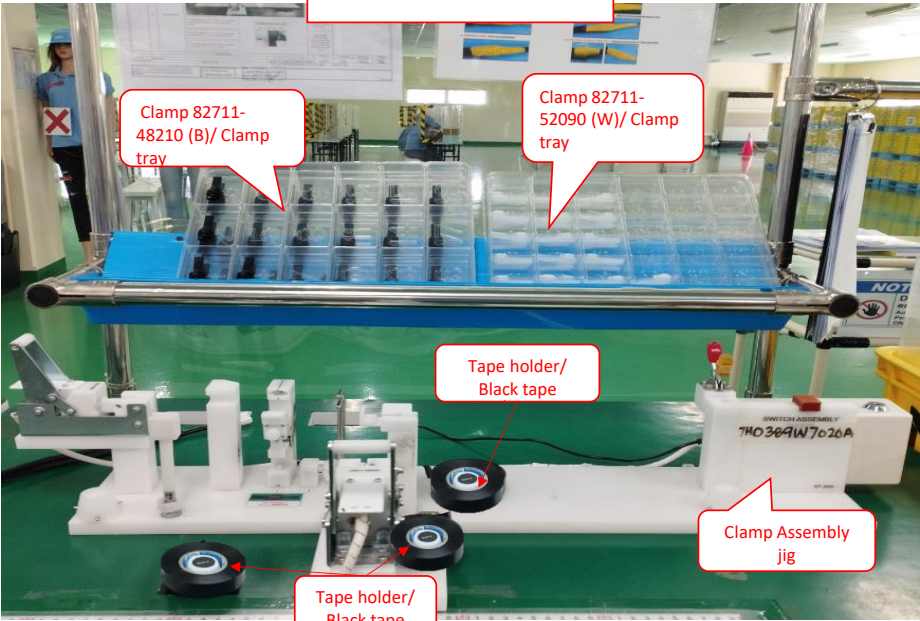


WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	April 27, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-468C		
Revision No.:	1	Page No.:	1 of 5

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Product Number:	N/A / 7H0389W7020A	Customer:	NBS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-52090 (W) 3. Black tape [3pcs.]	JIG	1. Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Table Lay-out		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/ tools. 2. no excess parts/ tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/27/22	1	Change from Pre-launch to Masspro. Additional Table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
04/07/22	0	Initial Issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Clamp 82711-48210 (B)
2. Clamp 82711-52090 (W)

3. Black tape [3pcs]

JIG

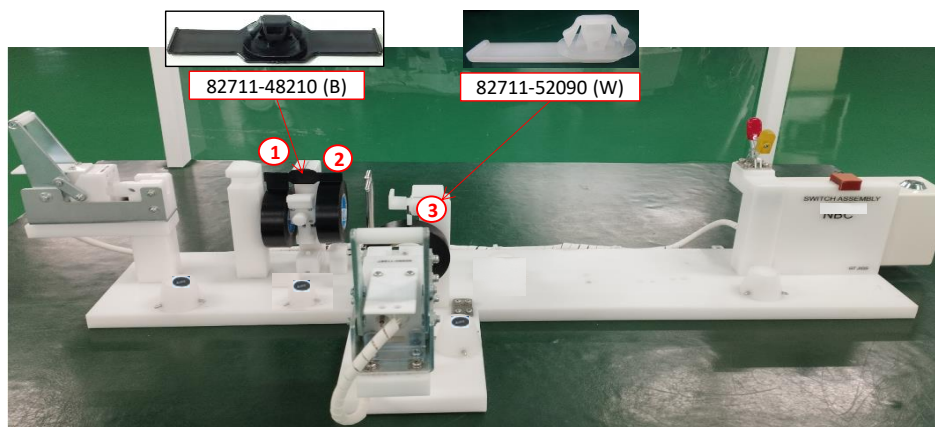
1. Clamp assembly jig

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

2

P3

Clamp setting



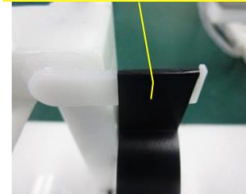
1. Get 1pc of Clamp **82711-48210 (B)** using right hand and set to location **1** and **2** using both hands.

2. Get 1pc Clamp **82711-52090 (W)** using right hand and set to **location 3** using both hands.

3. Get Black tape using right hand and conduct pre-taping from **location 1, 2** and **3**.

STANDARD TAPING FOR CLAMP

One side tape under clamp



n/a

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).

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PARTS:

1. Assy parts

JIG

1. Temporary Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

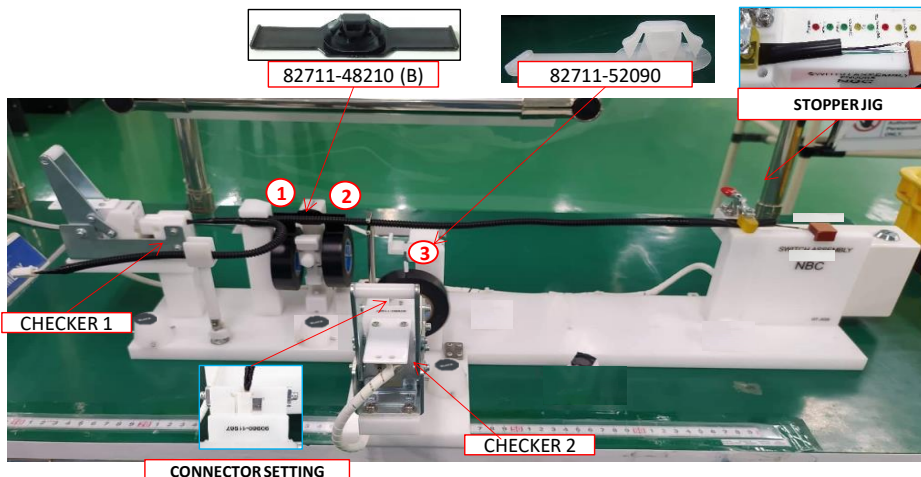
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly



n/a

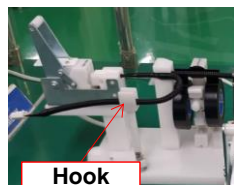
1. No wrong use of tape
2. No lacking and excess tape windings
3. No missing tape

1. Get the assy parts using right hand and set to jig using both hands. First, put the first **Connector 1** to **checker 1**, second, put the Sunprene tube to **toggle clamp** and last, initially put the **COT (with connector 2)** in **HOOK**.

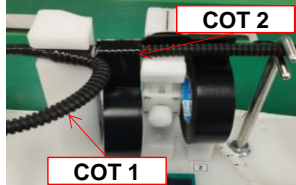
Note: Refer to above illustration for correct setting

2. Wrap the **COT2 & Side A** of the clamp (**2 windings**) using both hands.

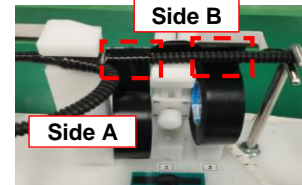
3. Wrap the **COT2 & Side B** of the clamp (**2 windings**) using both hands.



Hook



COT 1



Side B

Side A

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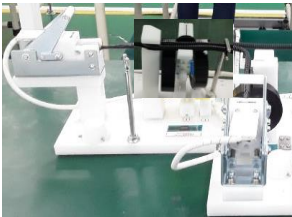

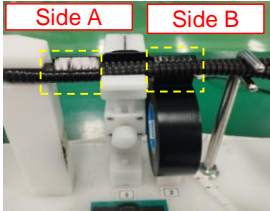
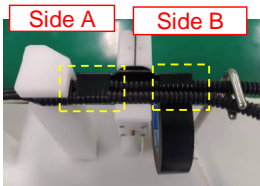
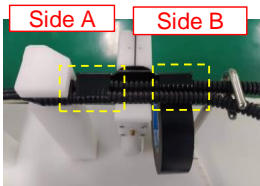
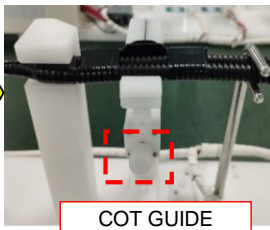
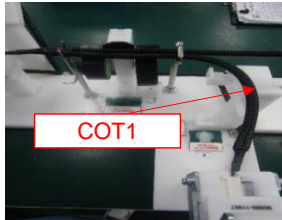
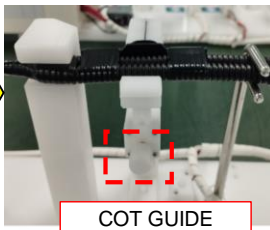
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PARTS:

1. Assy parts

JIG

1. Temporary Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Clamp Assembly (continuation)	<p>Connector Setting</p>   <p>4. Put the Connector 2 to checker 2 using both hands. <i>Refer to above illustration for correct setting.</i></p> <p>Side A Side B</p>   <p>5. Check the LED light for POWER, CLAMP, WIRE1 and WIRE2 and sequence light is ON. If encountered abnormality, STOP the process, CALL the attention of Leaders and WAIT for instructions.</p> <p>Side A Side B</p>   <p>6. Combine the COT1 and COT2 from clamp side A (3 windings). Press the SW button after taping.</p> <p>7. Combine the COT1 and COT2 from clamp side B (3 windings). Press the SW button after taping.</p> <p>8. Tape clamp 82711-52090 (W) location 3 (3 windings). Press the SW button after taping Go sound will be heard.</p> <p>9. Press the COT guide using right thumb and conduct POINT CHECKING before removal from jig.</p> <p>Note: Push the COT guide upward using right thumb.</p> <p>COT1</p>  <p>COT GUIDE</p> 	n/a	<p>1. No wrong use of tape 2. No lacking and excess tape windings 3. No missing tape</p>

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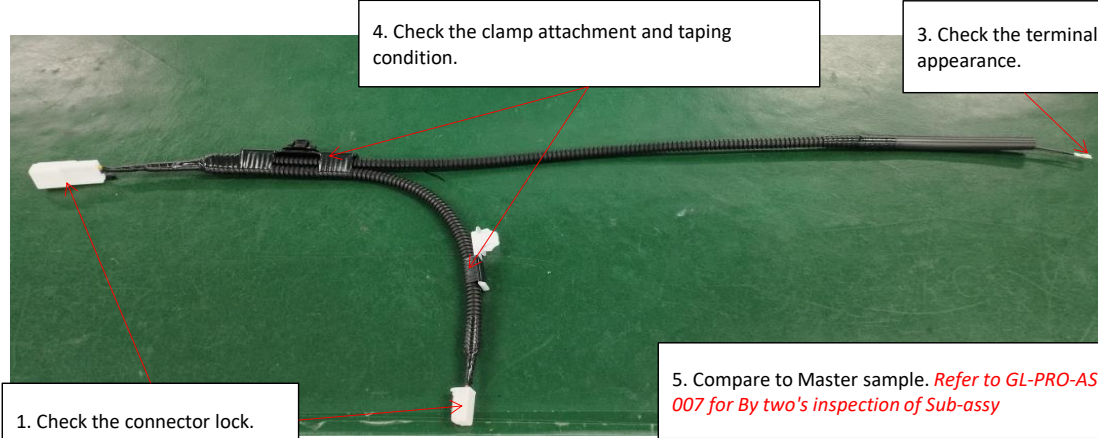

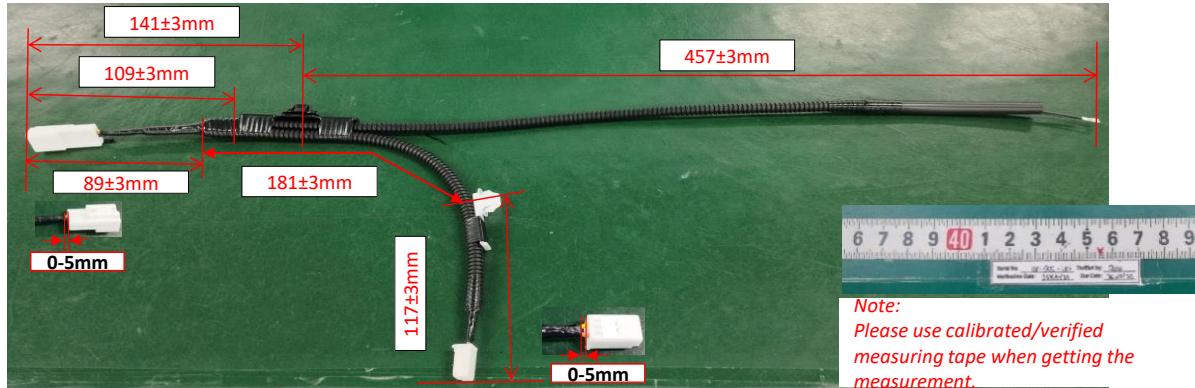
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PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Visual/By two's inspection	 <p>1. Check the connector lock.</p> <p>2. Check the clamp attachment and taping condition.</p> <p>3. Check the terminal appearance.</p> <p>4. Compare to Master sample. <i>Refer to GL-PRO-ASY 007 for By two's inspection of Sub-assy</i></p>		Master Sample 
6	Measurement	 <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>		FOR HATSUMONO/ OWARIMONO ONLY

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