

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 8, 2023

Validity Date:

n/a

Model Code/Part Number:

320B

/

7M0653-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-689

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 8

PARTS:

1. Assy parts; Clamp 82711-52090 (W); Black tape [2pcs]; Gray tape

JIG:

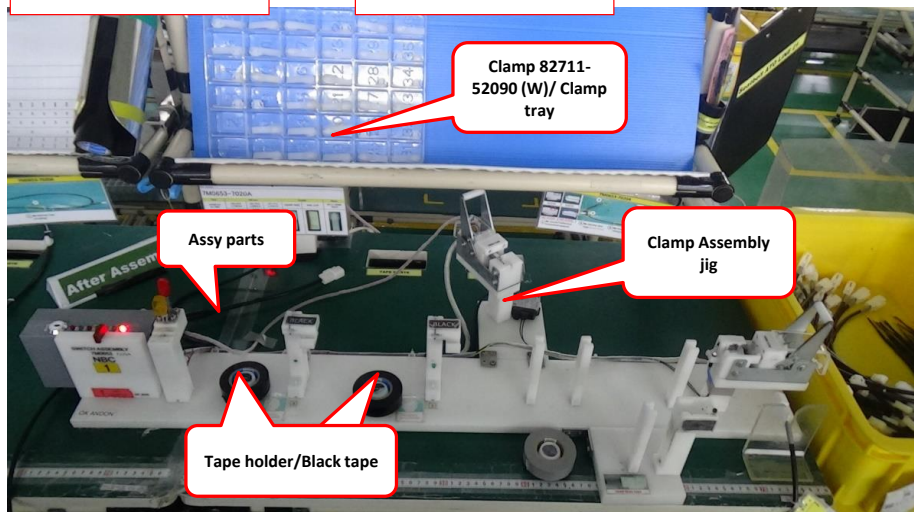
1. Clamp assembly jig

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

1

n/a

Table Lay-out

BATCHING**TABLE LAY-OUT****Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Important reminders/Notes/:

1. Please check the clamp first before start of assembly to avoid wrong use of parts

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
06/08/23	0	Initial issue Changed Part Name/Title from "TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS" Changed Document control number from "WI-ENG-PDE-133C" to "WI-ENG-PDE-689" due to separation of process								
			Revised	Reviewed	Approved	Noted	Est. Date:	June 8, 2023		

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PARTS:

1. Assy parts

2. Clamp 82711-52090 (W) [2pcs]

3. Black tape [2pcs]

4. Gray tape

JIG

1. Spot taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

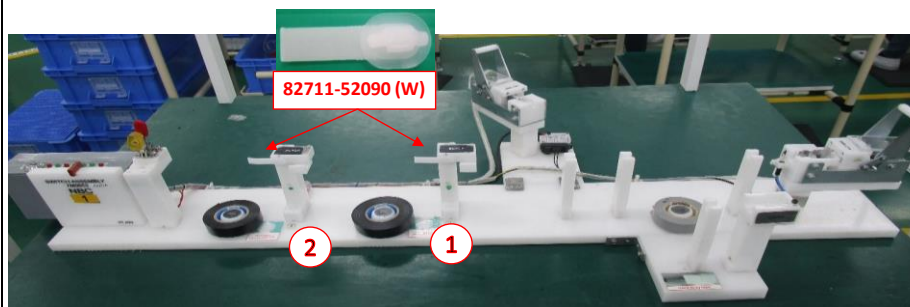
TOOLS/PPE

QUALITY POINTERS

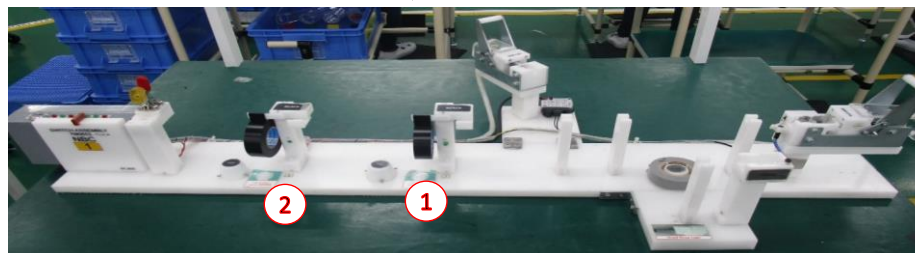
2

n/a

Clamp setting



1. Get 2 pieces of clamp **82711-52090 (W)** and set to **location 1** and **2** using both hands.



2. Initially attach **Black tape** on clamp location **1** and **2** using both hands.

n/a

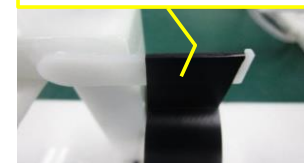
1. No damaged clamp
2. No wrong use of parts
3. No wrong use of tape

Important reminders/Notes/:

1. Please check the clamp first before start of assembly to avoid wrong use of parts

STANDARD TAPING ON CLAMP

One side tape under clamp



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PARTS:

1. Assy parts
2. Gray tape

JIG

1. Spot taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

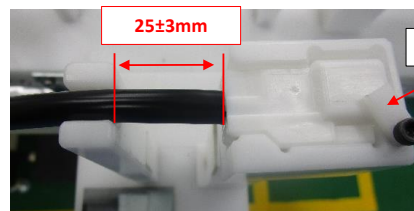
TOOLS/PPE

QUALITY POINTERS

3

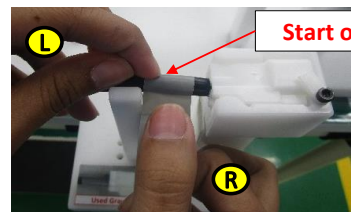
n/a

Spot taping



Lock

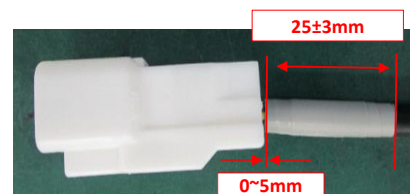
1. Get the assy part. Hold the connector using right hand then set to spot taping jig. After setting, lock the connector jig lock. Measurement of spot tape is **25±3mm**.



Start of taping

2. Get the **Gray tape** using right hand. Start the taping process from left side going to right using both hands. Conduct **1/3 shifting** going to connector then cut the tape.

MEASURING TAPE



3. After taping, check the measurement and taping condition.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No wrong dimension
5. No wrong use of tape

Important reminders/Notes/:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Use GRAY TAPE only for spot taping

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PROTOTYPE

☐ PRE-LAUNCH MASSPRO

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1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

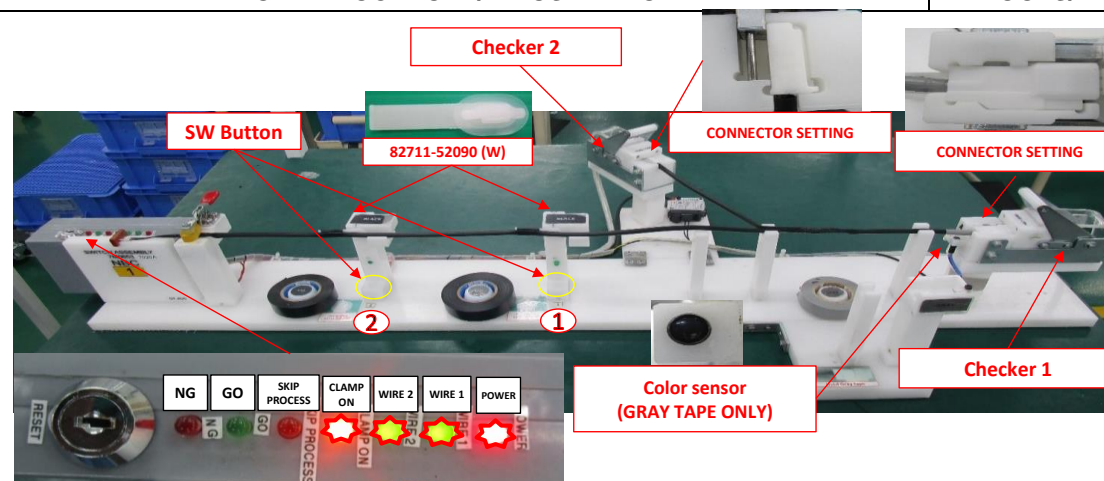
TOOLS/PPE

QUALITY POINTERS

4

n/a

Clamp Assembly



1. Get the assy parts and set into jig. (*See above picture for the correct setting*). First, set the connector **4GS400-0000 (W)** to **Checker 1** then pull the checker fixture for continuity checking. **Color sensor** light will beep/buzz if sensor detects the **Gray tape**. Second, set the connector **6098-2220 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Last, set the **B-B wires** with terminal end together within the stopper then press by **Toggle clamp**. Continue if the sequence light on location **1** was on.

2. 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.

3. Hold the tape on clamp location **1** and start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if the sequence light of location **2** was on.

4. Hold the tape on clamp location **2** and start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. **Go** sound will be heard.

5. Conduct **POINT CHECKING** before removing to Clamp Assy Jig.



Important reminders/Note/s:

1. Make sure no gap between terminal and stopper jig

1. No damaged clamp
2. No missing tape
3. No missing clamp

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PARTS:

n/a

JIG

n/a

NO.

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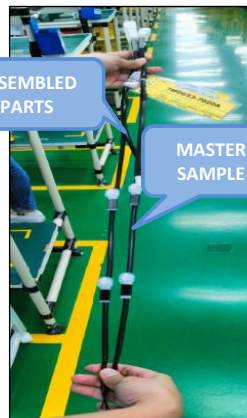
TOOLS/PPE

QUALITY POINTERS

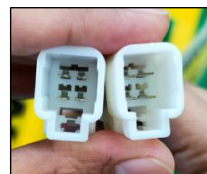
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n/a

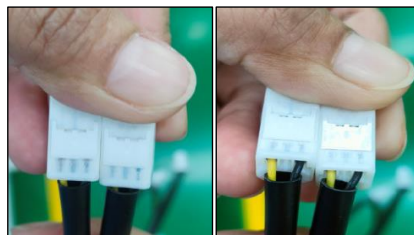
Visual/By Two's Inspection

ASSEMBLED
PARTSMASTER
SAMPLE

1. Conduct **alignment of harness (Master sample vs. Assembled part)** using both hands



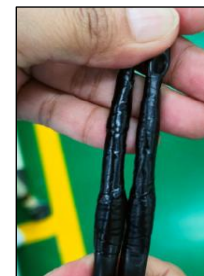
2. Check the **connector lock condition, wire insertion** and **terminal**



4. Check the **connector lock condition, wire insertion** and **terminal**



3. Check the **spot taping, taping condition** and **color of tape (Must be GRAY TAPE only)**



5. Check **Y-taping condition**.

MASTER SAMPLE



1. No skip checking during inspection

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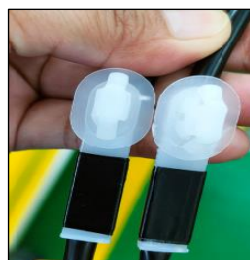
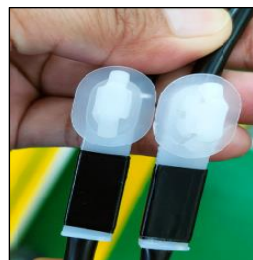
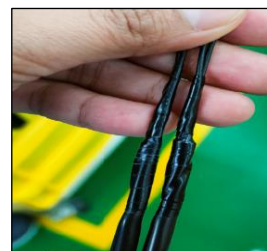
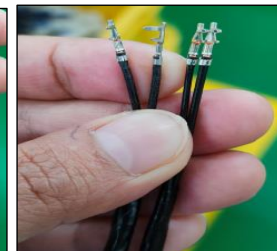
JIG

n/a

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

5

n/a

Visual/By Two's Inspection
(Continuation)**ACTUAL PRODUCT**7. Check the **appearance of all clamp attachment** and **taping condition**.8. Check **the taping conditon** **SV tube (Vinyl)** to wire.9. Check **the terminal appearance**. **Must be no deformed terminal**.**MASTER SAMPLE**

1. No skip checking during inspection

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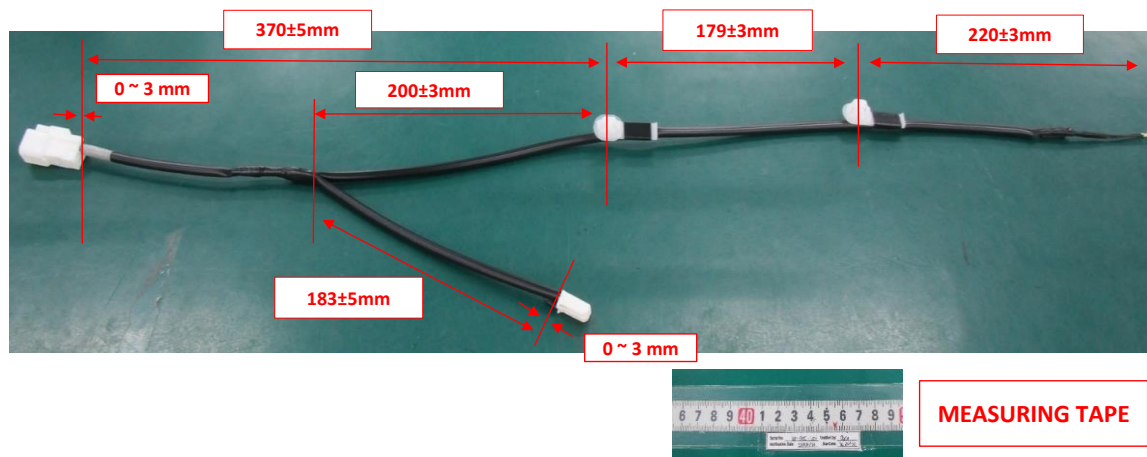
JIG

n/a

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

6

Measurement

**Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and owarimono

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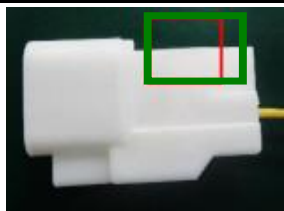
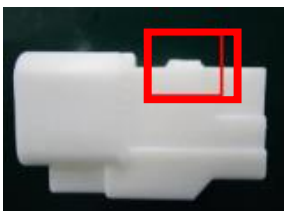
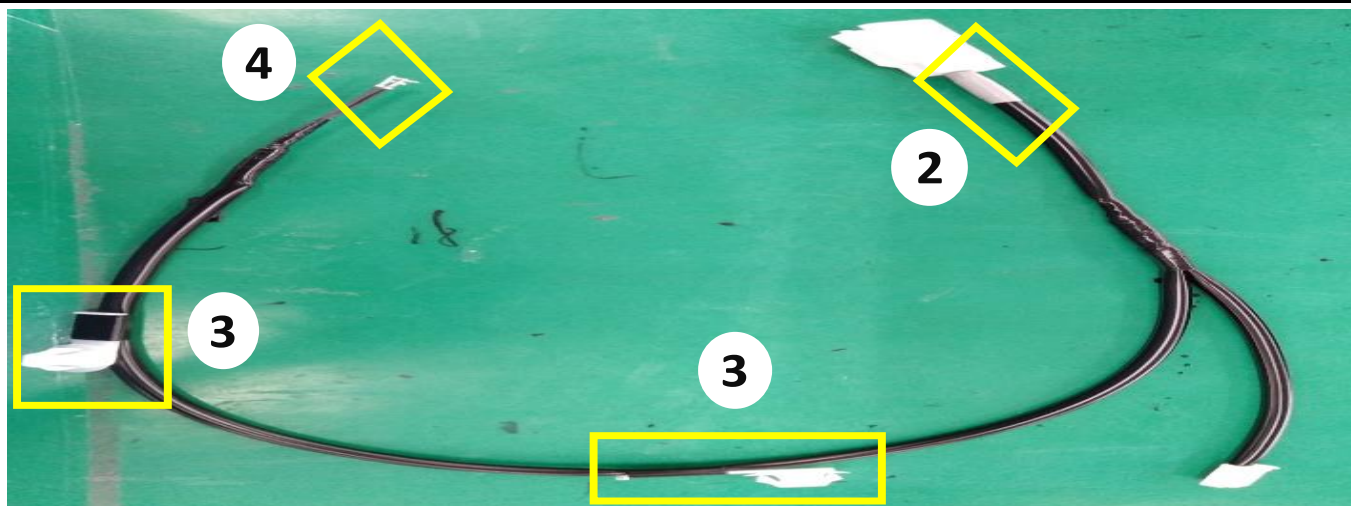
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PARTS:

n/a

JIG

n/a

QUALITY CHECKPOINTS**CLAMP
ASSEMBLY****7M0653-7020A****GOOD****GOOD****NO GOOD****NO****1** No Unlock/Halflocked
Connector(2 connector)**2** No Missing Spot
Tape (gray tape)**3** No Missing
Clamp(2pcs.)**4** No Deformed
Terminal

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