

	WORK INSTRUCTION				Effectivity Date:		February 18, 2022	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model Code/ Part Number: 587B / 7M0533-7021		Customer: TRJ		Document No.:		WI-ENG-PDE-412B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 6

PARTS:	All parts; Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [4pcs]; Yellow tape [1pc]	JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out		<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 missing parts/ tools. 2. No excess parts/ tools.

Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/18/22	0	Initial Issue.						 M. Ariola	 J. Loterte	 C. Villanueva	 A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 18, 2022

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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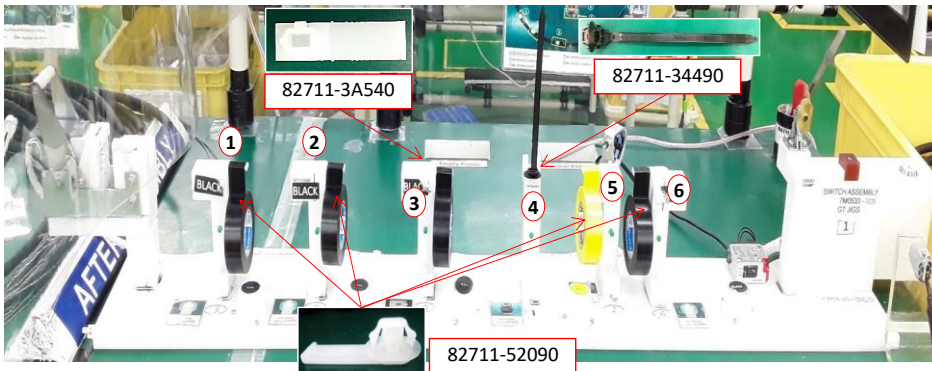
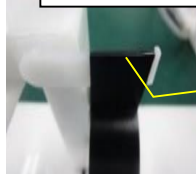
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PARTS:1. Clamp 82711-52090 (W) [4pcs]
2. Clamp 82711-3A540 (W)3. Clamp 82711-34490 (B)
4. Black tape [4pcs]

5. Yellow tape

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp assembly setting	<div><p>1. Get 4 pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 1, 2, 5 and 6 using both hands.</p><p>2. Get 1 piece of clamp 82711-3A540 (W) using right hand and insert to location 3 using both hands.</p><p>3. Get 1 piece of clamp 82711-34490 (B) using right hand and insert to location 4 using both hands.</p><p>4. Initially attach Yellow tape on clamp location 5 using both hands.</p><p>5. Initially attach Black tape on clamp location 1, 2, 3 and 6 using both hands.</p><p>STANDARD TAPING FOR CLAMP</p><p>One side tape under clamp</p></div>	n/a	1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

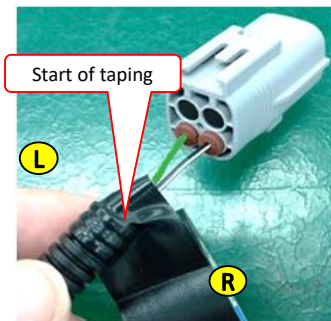
TOOLS/PPE

QUALITY POINTERS

3

P2

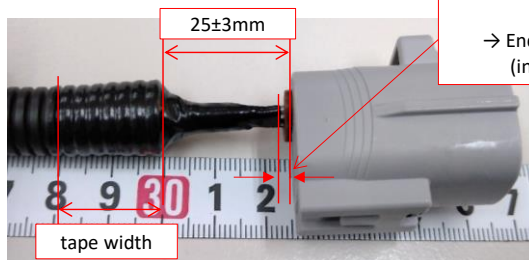
Taping
COT to wire near
connector



1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.



2. Measure from end of corrugated tube up to connector **25±3mm** then continue the taping process using both hands.
Refer to WI-PRO-ASY-001 for taping procedure.



Note: 0~5mm
→ End tape up to connector
(includes rubber seal)

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

MEASURING TAPE



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

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PARTS:

1. Assy parts

JIG

1. Bando Gun
2. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

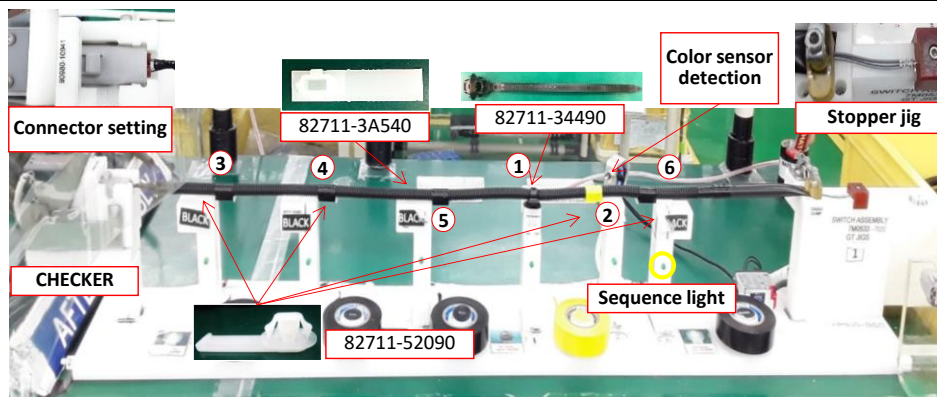
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp assembly



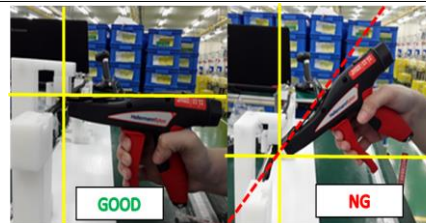
1. Get the assy parts using both hands and set to jig. First put the connector to checker using right hand and pull down the checker using left hand to check if properly locked. Second, put the terminal into stopper jig using left hand and then pull down the toggle clamp using right hand.
Refer to the above illustration for the proper setting.

3. Initially tighten the Band clamp on clamp location 1 using both hands.



2. Check the LED light for **POWER**, **CLAMP** and **SEQUENCE LIGHT** on clamp location 1 is **ON**. If encountered abnormality, **STOP** the process, **CALL** the attention of the Leader and **WAIT** for instruction.

4. Get the Bando Gun using right hand. Cut the Band clamp on clamp location 1 using both hands. Press the SW button after cutting. Follow the sequence light for the next process.



BANDO GUN



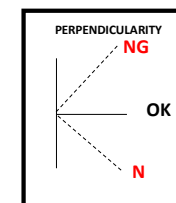
Make sure no Gap between terminal and stopper jig

- 1.No wrong use of clamp
- 2.No damaged clamp
3. No wrong setting of bando gun



Fixed setting of band clamp cutter: 3 ~ 4

BANDO GUN ALIGNMENT



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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

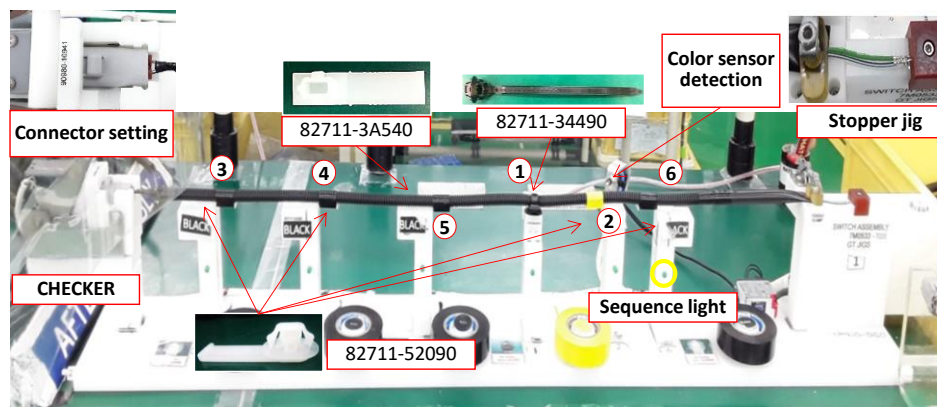
TOOLS/PPE

QUALITY POINTERS

5

P2

Clamp assembly
(continuation)



5. Conduct taping on clamp location **2** using both hands. Make **3 windings**. Beep sound will be heard if the color sensor detects the **Yellow tape**. Press the **SW button** after taping.

6. Proceed the taping process on clamp location **3, 4, 5 and 6**. Make **3 windings**. Press the **SW button** after every taping. Go sound will be heard after taping on clamp location **6**.

7. Conduct **POINT CHECKING** before removal from jig using right hand.

n/a



Make sure no Gap between terminal and stopper jig

1. No wrong use of tape
2. No missing tape
3. No peel-off tape

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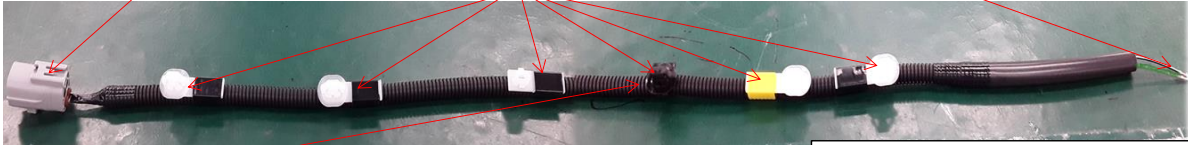


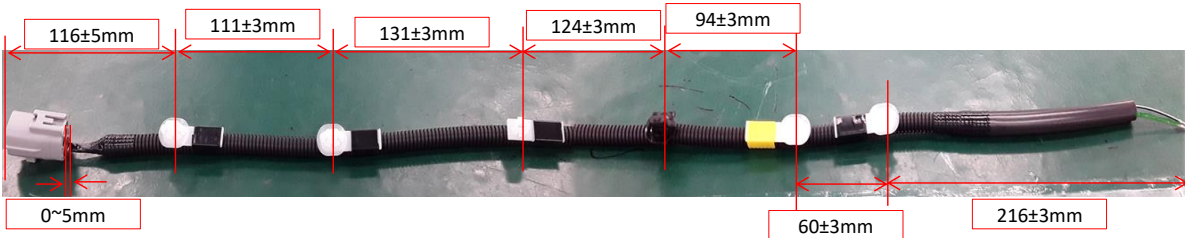
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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7		Visual/By two's inspection	<div>1. Check the connector if properly locked.</div> <div>2. Check the clamp attachment, alignment and taping condition.</div> <div>4. Check the terminal condition. Make sure no deformed terminal.</div> <div>3. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div> <div></div> <div>5. . Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div> <div></div>		MASTER SAMPLE 
8	P2	Measurement	<div></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div></div>		FOR HATSUMONO AND OWARIMONO ONLY

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