



# WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **240B / 7M0516-7020C**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 23, 2021

Validity Date:

n/a

Document No.:

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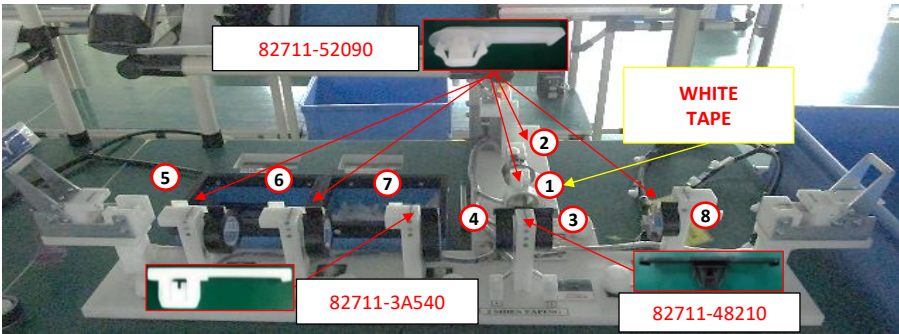
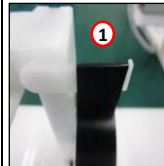
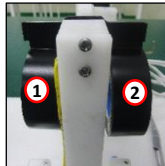
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<b>PARTS:</b>	<b>6</b> 1. Clamp 82711-52090 (W) [5pcs] 2. Clamp 82711-3A540 (W) 3. Clamp 82711-48210 (B)	<b>6</b> 4. Black tape [7pcs] 5. White tape	<b>JIG:</b> 1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp assembly (Setting)	<div><div><b>6</b> 1. Get 2 pcs of clamp <b>82711-52090 (W)</b> and set to clamp location <b>1</b> and <b>2</b>.</div><div><b>6</b> 2. Get 3 pcs of clamp <b>82711-52090 (W)</b> and set to clamp location <b>5, 6</b> and <b>8</b>.</div><div></div><div><b>6</b> 3. Get the clamp <b>82711-3A540 (W)</b> and set to clamp location <b>7</b>.</div><div>4. Get the clamp <b>82711-48210 (B)</b> and set to clamp location <b>3</b> and <b>4</b>.</div><div>5. Get <b>WHITE TAPE</b> using right hand and put pre-tape on the clamp on location <b>1</b>.</div><div>6. Get <b>BLACK TAPE</b> using right hand and put pre-tape on the clamp location <b>2</b>. Repeat the process from location <b>3</b> to <b>8</b>. <i>Note: See above pictures for pre-tape sequence reference.</i></div></div>	<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No damaged clamp 2. Missing tape 3. No peel off Tape 4. No flip out tape 5. No missing clamp</div> <div><b>STANDARD TAPING FOR CLAMP</b>  One side taping  Two sides taping</div>

## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/23/21	6	Change clamp colours in accordance with color standardization for plastic parts refer to GL-COM-003; put qty. on Black tape; Put measuring tape illustration and instruction on taping of COT to sunprene and on Measurement.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
09/30/20	5	Removal of cycle time; Apply some improvements	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
05/08/20	4	Update clamp assembly process, include color sensor detection. Changed length with .5 dimension.	J. Loterte	A. Shimamura	A. Arañes	n/a				
03/06/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-022). Initial issue.	J. Loterte	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
							Established Date: September 24, 2018			

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**PARTS:**

1. Black tape
2. Assy parts

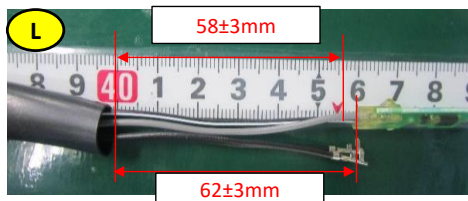
**JIG**

N/A

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

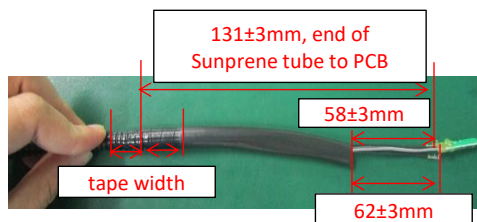
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P3

Taping 1  
Corrugated tube to  
Sunprene tube

1. Hold the corrugated tube using left hand and measure the sunprene tube up to hotmelt **58±3mm**, sunprene tube up to terminal tip **62±3mm**.

2. Hold the COT using left hand and begin taping using right hand.  
*Note: Please refer to WI-PRO-ASY-001 for taping procedure.*



3. After taping, check the dimension, terminal appearance and taping condition.

**MEASURING TAPE**

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

1. No peel-off tape
2. No flip out tape
3. No loose tape

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PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly		N/A	
		<div><div><div>1. Get the harness and set to jig using both hands. First, insert the <b>GR connector</b> to <b>checker 1</b> then close. Second, insert the <b>White connector</b> to <b>Checker 2</b> then close. Lastly, put the <b>sunprene tube</b> to <b>toggle clamp</b> and push down to lock. Refer to below illustration for correct setting.</div><div><div>Stopper Jig</div><div>Connector setting</div><div>WHITE TAPE</div><div>Color sensor</div><div>CHECKER 1</div><div>CHECKER 2</div><div>Sequence light</div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div><div>6</div><div>7</div><div>8</div></div></div><div><div>2. Check if all LED light for <b>POWER, CLAMP, WIRE1 &amp; WIRE2, SEQUENCE LIGHT</b> was <b>ON</b>.If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the attention of the leader immediately and <b>WAIT</b> for instruction.</div><div><div>3. Begin taping on location <b>1</b> using both hands (3 winds). Beep sound will be heard if the color sensor detects the <b>WHITE tape</b>. Press the SW button after taping. Continue the process based on the sequence light, see above illustration.</div><div><div>4. After taping on the 8th location, press the <b>SWITCH BUTTON</b>. Go buzzer will be heard if <b>GOOD</b>.</div><div><div>5. Conduct <b>POINT CHECKING</b> before removing from jig to avoid missing tape.</div></div></div></div><div><div><div>Press</div><div>Note: After pressing the switch button, the sequence light of the next process will automatically ON. Follow the sequence light to avoid jig abnormality.</div></div><div><div>POWER ON</div><div>WIRE 1&amp;2</div><div>CLAMP ON</div><div>SEQUENCE LIGHT</div></div></div></div></div>			<div><div>Make sure no GAP between PCB and stopper jig</div><div></div><div><div>1. No damaged Clamp</div><div>2. Missing Tape</div><div>3. No peel off Tape</div><div>4. No flip out tape</div><div>5.No Missing clamp</div></div></div>

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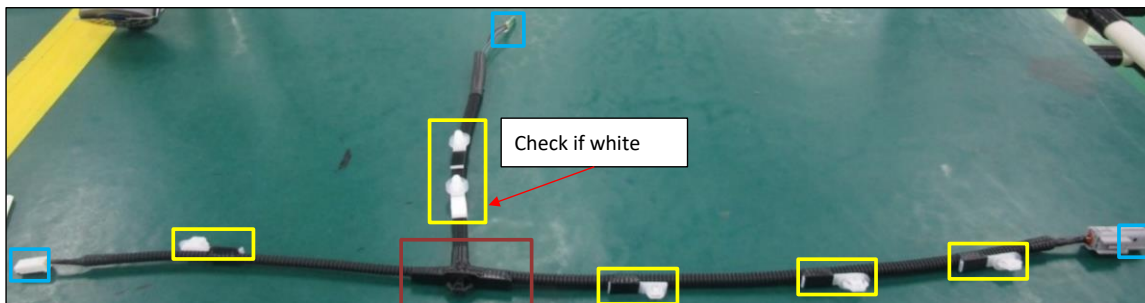

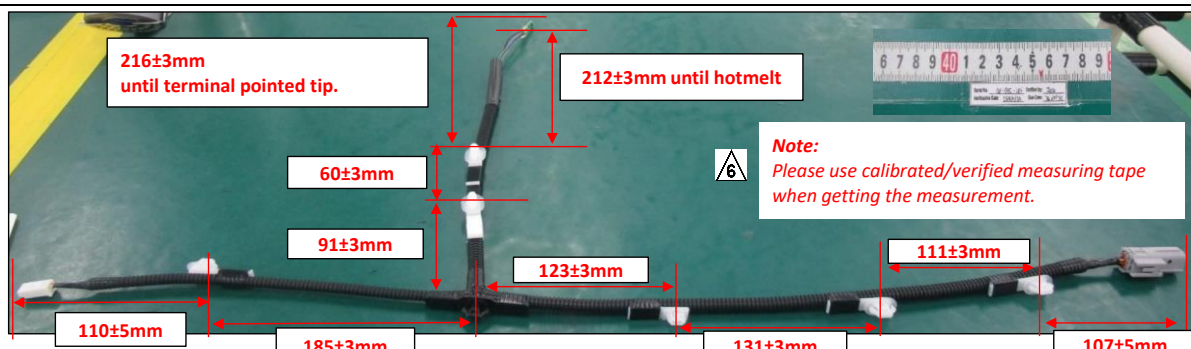
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PARTS:		n/a		JIG	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P3	Visual/By Two's Inspection	<div><div>1. Check the taping condition and clamp attachment. <input type="checkbox"/></div><div>2. Check the lock and terminal appearance. <input type="checkbox"/></div><div>3. Conduct bending of clamp with 2 sides taping. <input type="checkbox"/></div></div> <div></div> <div>4. Compare to Master sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's inspection of Sub-assy.</i></div>				<div>MASTER SAMPLE</div> 
		Measurement	<div></div> <div><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</div>				<div><i>Note: For Hatsumono and Owarimono</i></div> <div>1. No wrong dimension</div>

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