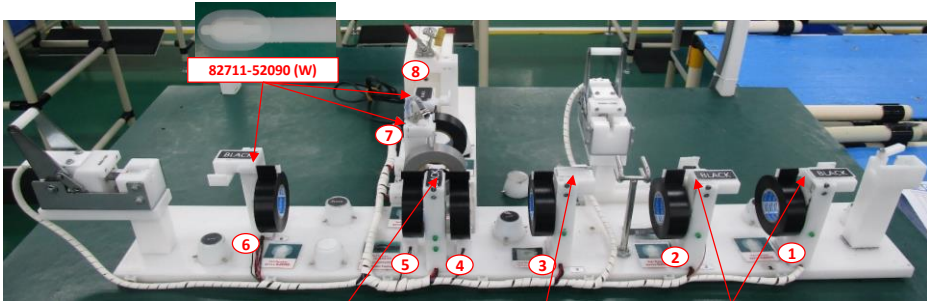




# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	May 21, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-180D		
Revision No.:	3	Page No.:	1 of 6

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	100B / 7M0595-7020B	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Clamp 82711-52090 (W) [5pcs.] 2. Clamp 82711-3A540 (W) 3. Clamp 82711-48210 (B)		4. Black tape [7pcs.] 5. Gray tape [1pc.]		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P4	Clamp setting	<div><div><div>82711-52090 (W)</div><div>82711-48210 (B)</div><div>82711-3A540 (W)</div><div>82711-52090 (W)</div></div></div> <div><div><div>2. Get 3pcs. of clamp 82711-52090 (W) using right hand then set to jig location 6, 7 &amp; 8 using both hands.</div><div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to clamp location 3 using both hands.</div></div><div><div>4. Get 1pc of clamp 82711-48210 (B) using right hand then set to clamp location 4~5 using both hands.</div><div>5. Get the Black tape and start pre-taping on clamp location 1-6 and location 8.</div><div>6. Get the Gray tape and start pre-taping on clamp location 7.</div></div><div><div>Note: Please check all clamp and band clamp before start of assembly to avoid wrong use of parts.</div></div></div> <div><div><div>Safety Instruction</div><div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping</div><div>1. Maintain and always practice 5's.</div><div>2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div> <div><div>STANDARD TAPING FOR CLAMP ONE SIDE</div><div>One side tape under clamp</div><div><div><div>1</div><div>One side taping</div></div><div><div>2</div><div>Two sides taping</div></div></div><div><div>1. No damaged clamp</div><div>2. No wrong use of parts</div><div>3. No wrong use of tape</div><div>4. No wrong insertion of clamp</div></div></div>				

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
05/21/21	3	Revise due to standardize the color of Clamp in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/20/20	2	Transfer process owner from Production (WI-PRO-ASY-120D) to Engineering (WI-ENG-PDE-180D). Apply some improvements/update pictures.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
05/02/18	0	Previously established as Engineering instruction (EI-ENG-PDE-034). Initial issue	D. Castillo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	May 02, 2018		

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# WORK INSTRUCTION

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Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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**PARTS:**

**3**

1. Assy parts
2. Black tape

**JIG**

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P4 3 Clamp Assembly	<p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting</i>). First, set the connector <b>6188-0407 (W)</b> to <b>Receiver base 1</b> and then lock. Second, set the connector <b>6098-3810 (W)</b> to <b>Checker 1</b> and then pull the checker fixture for continuity checking. Third, set the connector <b>6098-2220 (W)</b> to <b>Checker 2</b> and then pull the checker fixture for continuity checking. Last, set the hotmelted <b>GR-B/W wires</b> together within the stopper and then press by toggle clamp. Continue if the sequence light on location <b>1</b> was <b>ON</b>.</p> <p>2. Check if all <b>LED light</b> for <b>POWER ON, WIRE1, WIRE2, CLAMP ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader and <b>WAIT</b> for further instruction and then continue the process.</p>	n/a	<ol style="list-style-type: none"><li>1. No loose/tight clamp attached</li><li>2. No damage clamp</li><li>3. No missed tape</li><li>4. No missing parts</li><li>5. Make sure no clearance between PCB and stopper jig</li></ol>

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## PARTS:

1. Assy parts  
2. Black tape

## JIG

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P4 Clamp Assembly (Continuation)	<p>3. Hold the tape on clamp location <b>1</b>. Make <b>3 windings of tape</b> using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>2</b> was <b>ON</b>.</p> <p>4. On clamp location <b>2</b>, hold the black tape using right hand then tape the clamp with <b>COT 1</b>, make <b>2 windings</b>, do not cut the tape. Then, remove connector <b>6098-3810 (W)</b> from <b>Checker 1</b>. Combine with <b>COT 2</b>, then tape. Make <b>3 windings of tape</b> using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>3</b> was <b>ON</b>.</p> <p>Note: Make sure no gap between the hotmelted wires and the stopper jig.</p> <p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</p>	n/a	

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☐ PRE-LAUNCH

☒ MASSPRO

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**PARTS:**

**3**

1. Assy parts
2. Black tape

**JIG**

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P4 Clamp Assembly (Continuation)	<p>5. Hold the tape on clamp location <b>3</b>. Make <b>3 windings of tape</b> using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>4</b> was <b>ON</b>.</p> <p>6. Hold the tape on clamp location <b>4</b>. Make <b>3 windings of tape</b> using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>5</b> was <b>ON</b>.</p> <p>7. Hold the tape on clamp location <b>5</b>. Make <b>3 windings of tape</b> using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>6</b> was <b>ON</b>.</p> <p>8. Hold the tape on clamp location <b>6</b>. Make <b>3 windings of tape</b> using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>7</b> was <b>ON</b>.</p>	n/a	<p>Note: Make sure no gap between the hotmelted wires and the stopper jig.</p> <ol style="list-style-type: none"><li>1. No loose/tight clamp attached</li><li>2. No damage clamp</li><li>3. No missed tape</li><li>4. No missing parts</li><li>5. Make sure no clearance between PCB and stopper jig</li></ol>

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# WORK INSTRUCTION

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

Product Name/Code: **100B / 7M0595-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

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**PARTS:**

**3**

1. Assy parts
2. Gray tape
3. Black tape

**JIG**

1. Clamp Assembly jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

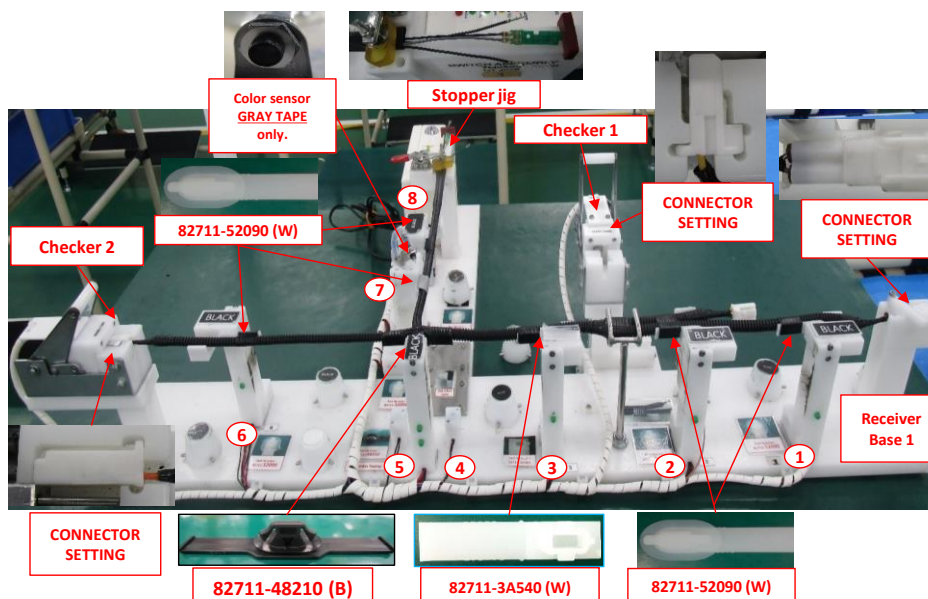
**TOOLS/PPE**

**QUALITY POINTERS**

**2**

**P4**

**Clamp Assembly  
(Continuation)**



9. Hold the **Gray tape** using right hand and then start taping using both hands on clamp location **7**. Make **3 windings of tape** then cut the tape. **Color sensor** light will beep/buzzer if sensor detects **Gray tape**. Press the **SW button** after taping. Continue if the sequence light on location **8** was **ON**.  
**Note: Use GRAY TAPE only.**

10. Hold the tape on clamp location **8**. Make **3 windings of tape** using both hands then cut the tape. Press the **SW button** after taping. **Go** sound will be heard.

11. Conduct **POINT CHECKING** of all clamps & all taping before removing from jig.

**n/a**



**Note: Make sure no gap between the hotmelted wires and the stopper jig.**

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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## TAPING ASSEMBLY PROCESS

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

3

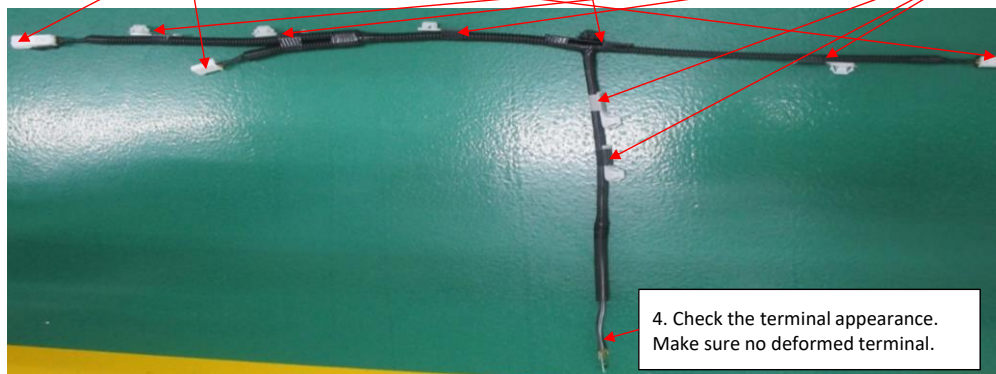
Visual/By two's inspection

P4

1. Check all the connector lock.

2. Check the taping condition and conduct bending of 2 sides clamp.

3. Check the clamp attachment and taping condition.



4. Check the terminal appearance. Make sure no deformed terminal.

5. Compare to Master Sample  
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy*

MASTER SAMPLE



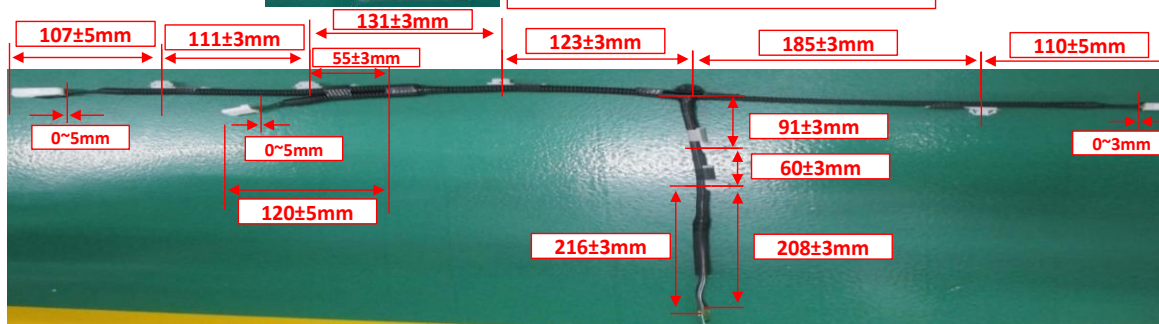
4

3

Measurement

MEASURING TAPE

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



NOTE: FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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