
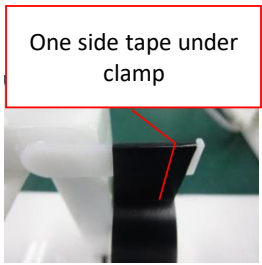
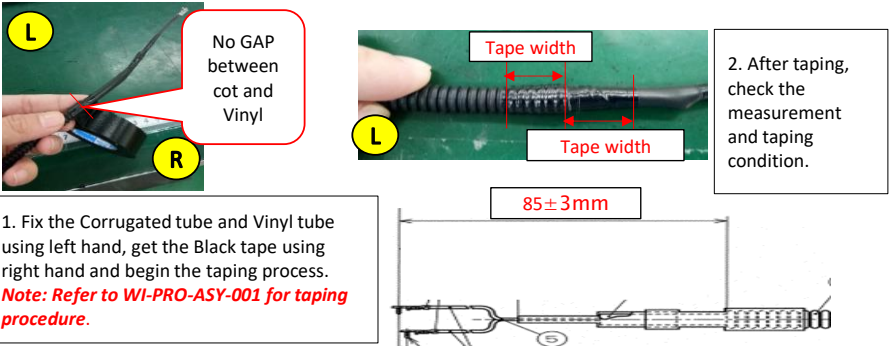

	WORK INSTRUCTION				Effectivity Date: July 06, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Product Name/Code: 948B / 7L0096-7021		Customer: TRQSS		Document No.: WI-ENG-PDE-068B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.: 1 of 3	

PARTS:	1. Clamp 82711-52090 (W) 2. Black tape 3. Assy parts			JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp assembly setting	 <p>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. Get the clamp 82711-52090 (W) and set to clamp location ① using right hand.</p> <p>2. Initially attach tape to location ① using right hand.</p>	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)	 <p>One side tape under clamp</p>
2	Taping 2 COT from vinyl tube	 <p>No GAP between cot and Vinyl</p> <p>2. After taping, check the measurement and taping condition.</p> <p>85 ± 3mm</p> <p>1. Fix the Corrugated tube and Vinyl tube using left hand, get the Black tape using right hand and begin the taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>	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.
			Measuring tape 	Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i>

Revision History					Prepared by	Reviewed by	Approved by	Noted by
07/06/21	3	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
01/09/21	2	Remove cycle time; change clamp color in accordance to standardization for plastic parts Add assy parts on page 2 parts section; add calibrated measuring tape picture and instruction on measurement	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		
06/22/21	1	Change effectivity and validity date; Add dimension from COT to terminal tip on page 1; Change dimension of clamp to terminal tip from 245mm to 246mm, COT to terminal tip from 84mm to 85mm	J. Loterte	A. Shimamura	A. Arañes	n/a		
03/13/20	0	Initial issue.	J. Loterte	A. Shimamura	A. Arañes	n/a	J. Loterte	C. Villanueva
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Note	Est. Date:	March 13, 2020

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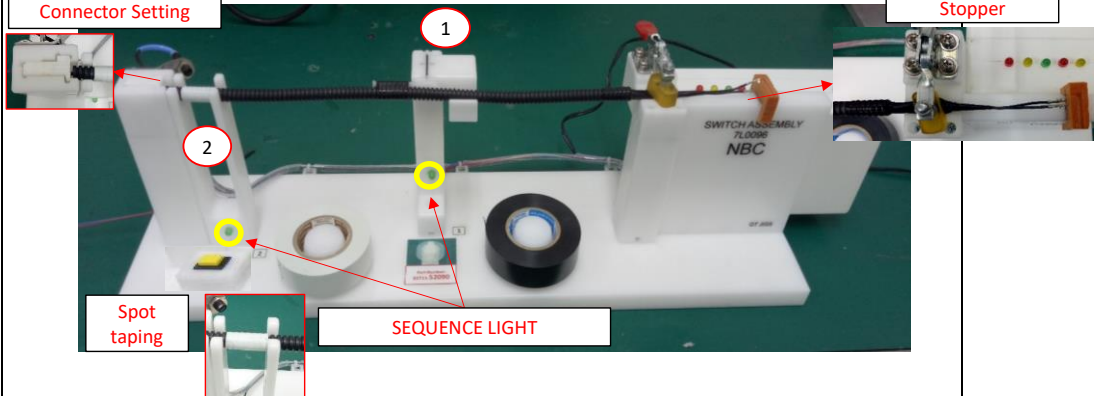
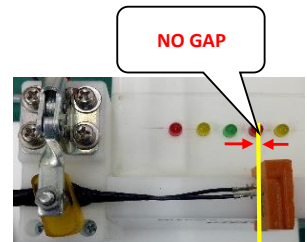
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PARTS:		1. Assy parts 2. Black tape 3. White tape		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp Assembly	<div><div><div>Connector Setting</div><div></div><div>Spot taping</div><div>SEQUENCE LIGHT</div></div></div> <div><div><div>1. Put the assy. First, set the connector to Receiver base. Last, set the B/B wires with terminal end together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.</div><div><div>2. Check if all LED light for POWER, CLAMP and SEQUENCE light of clamp location 1 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div><div>4. Get the White tape and start taping. Make 2 winds before cut the tape. Press the sequence light button. Go buzzer will be heard. Note: The GO buzzer will be heard if the sensor detect the White tape.</div><div>5. CONDUCT POINT CHECKING before removing from jig.</div></div></div></div> <div><div><div>NOTE: YOU WILL HEAR THE NG BUZZER IF THE SENSOR DETECT WRONG USE OF TAPE AND MISSING TAPE.</div><div><div></div><div>Make sure no gap between terminal and stopper jig</div></div></div><div><div>1. No damaged clamp</div><div>2. No missed tape</div><div>3. No missing clamp</div></div></div>		

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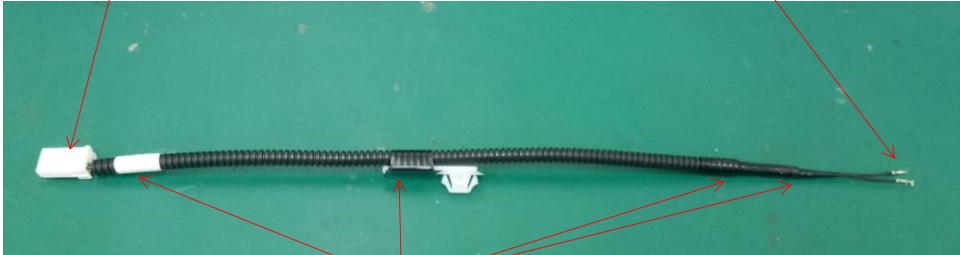

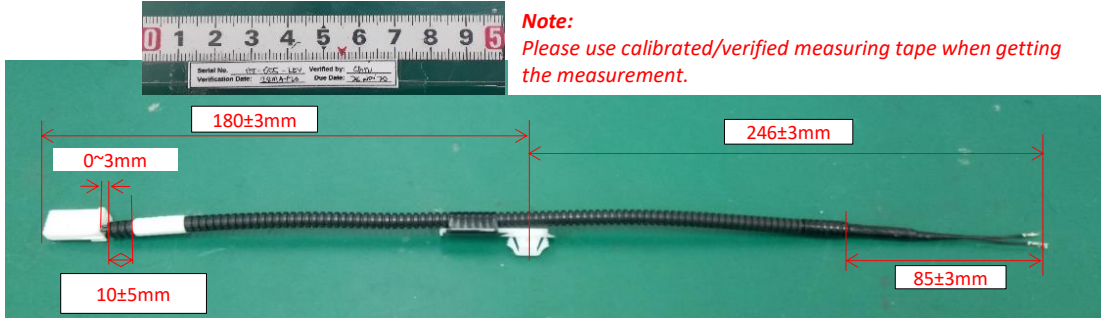
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		N/A			JIG	N/A	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2	Visual Inspection/By Two's inspection	<div>1. Check the connector lock</div> <div>2. Check the terminal appearance.</div>  <div>3. Check the clamp attachment and taping condition.</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> 
5		Measurement	 <div>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div>				<div>NOTE: HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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