

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

Effectivity Date:

March 1, 2021

Product Name/Code: **780B / 7R0102-7020B**Customer: **TRMX**

Validity Date:

-

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-201C

Revision No.:

1

Page No.:

1 of 4

PARTS:	1. Clamp 82711-16830 (B) [2pcs] 2. Clamp 82711-52090 (W)	3. Black tape	JIG	1. Clamp Assembly
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Clamp assembly setting	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	Note: <i>Please check the clamp first before setting to clamp assembly to avoid wrong use of clamp.</i> 1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
03/01/21	1	Part number change; change status from pre-launch to masspro; change dimension of Clamp to PCB from 372mm to 396mm	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes

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DCC Stamp



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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

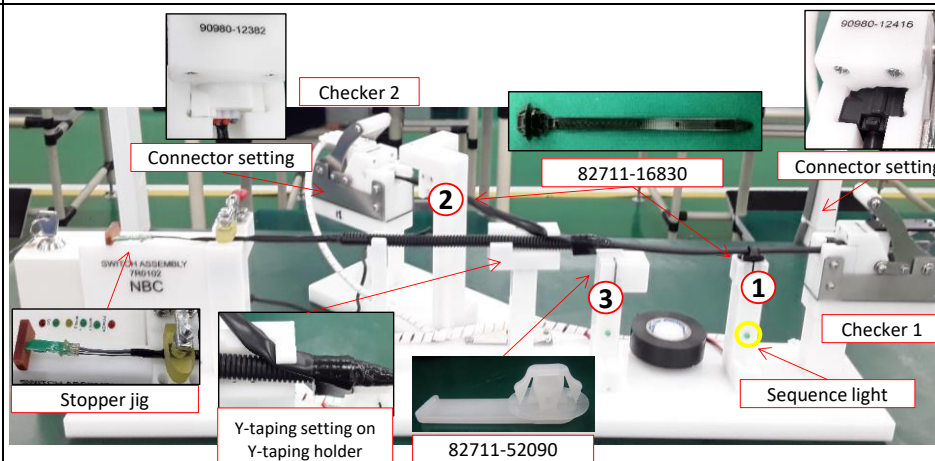
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly



1. Get the assy parts using both hands. Put first the Black connector to **Checker 1** then lock. Second, put the Y-part of the harness to holder (check the correct Y-taping setting). Third, put the PCB to **stopper jig** then pull down the toggle clamp. And last, put the White connector into **Checker 2** then lock.

Refer to the above illustration for the correct setting.

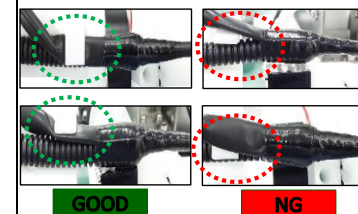
3. Initially tighten the band clamp on clamp location **1** and **2** using both hands.

2. Check if LED for **POWER, CLAMP, WIRE1&WIRE2** and **SEQUENCE LIGHT** in the first location is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.



n/a

Y-TAPING SETTING IN CLAMP ASSEMBLY JIG



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



Make sure no clearance between PCB and stopper jig

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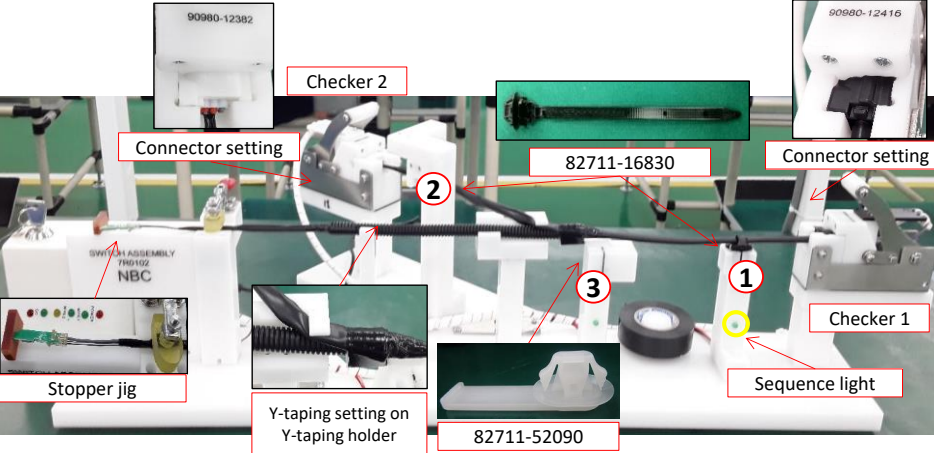
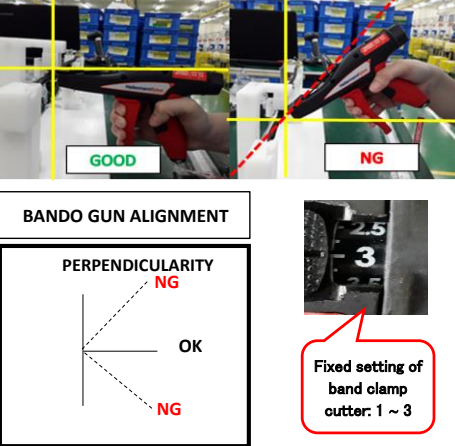
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PARTS:	1. Assy parts			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp Assembly (continuation)		BANDO GUN 	 Note: Make sure no clearance between PCB and stopper jig 1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun
		 <p>4. Get the Bando gun using right hand and cut the band clamp on clamp location 1 and 2 using both hands. Press the switch button after every cutting.</p> <p>5. Tape the clamp on location 3 using both hands. Make 3 winds and cut the tape. Press the switch button after taping. Go sound will be heard.</p> <p>6. Conduct POINT CHECKING before removing from jig.</p>  BANDO GUN ALIGNMENT PERPENDICULARITY NG OK NG Fixed setting of band clamp cutter: 1 ~ 3			

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

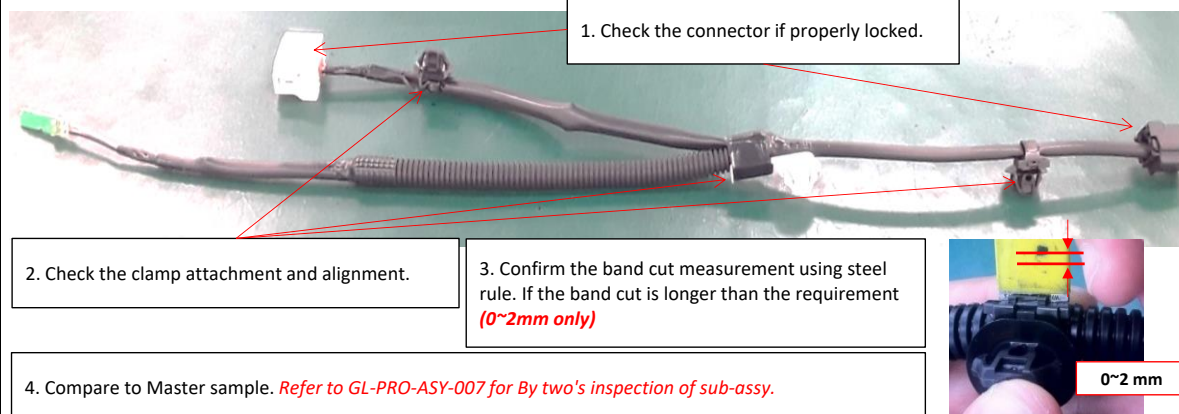
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Visual/By two's inspection



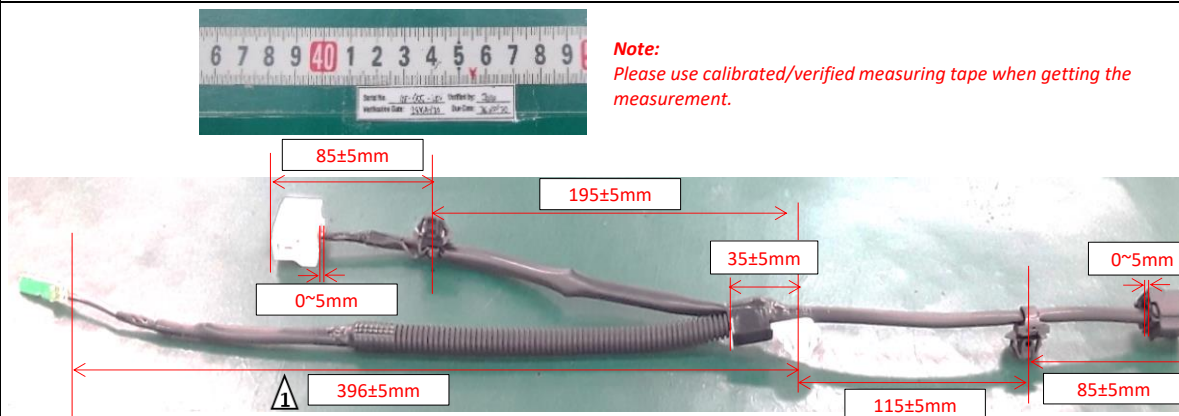
MASTER SAMPLE



P3

4

Measurement



For Hatsumono and Owarimono

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