



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

January 24, 2022

Process Name/Title:

Valid -

n/a

Model Code/Part Number: 370B / 4 7L0047-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-173C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

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**PARTS:**

1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-16820 (BR); Label (7V2200-0020); Black tape [3pcs.]

JIG:

1. Clamp assembly jig
2. Label Dispenser

NO.

PROCESS NAME

**4 WORK PROCEDURE/ ILLUSTRATION**

TOOLS/PPE

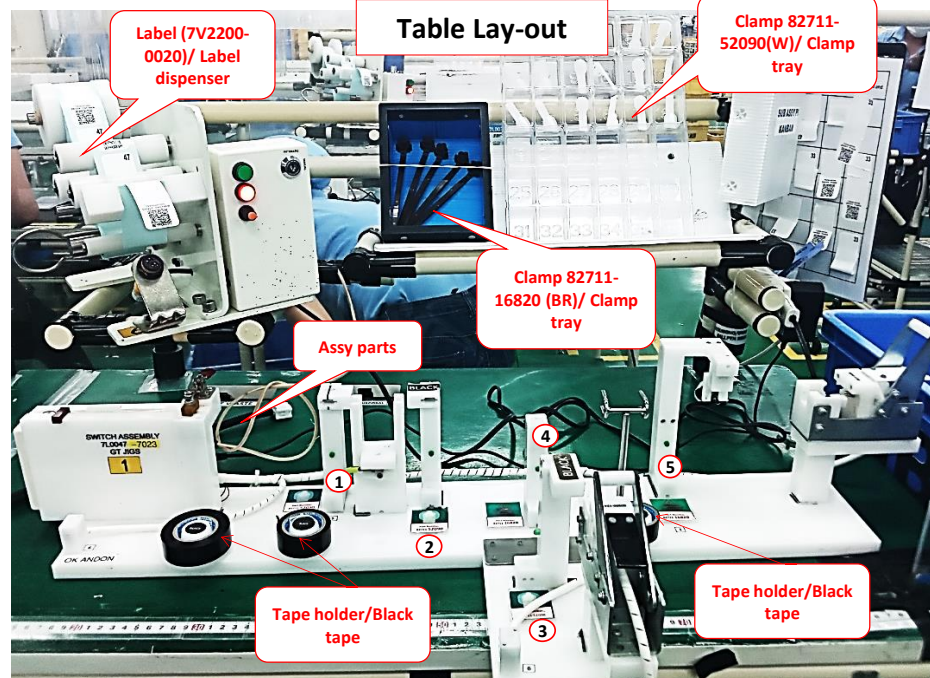
QUALITY POINTERS

1

P3

4

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

**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.

1. No missing parts/tools
2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
01/24/22	4	Change part number from 7L0047-7022 to 7L0047-7023 due to additional quantity of clamp 82711-52090 (W) from 2pcs. to 3 pcs. Improve work procedure and illustration. Additional table lay-out.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes
03/29/21	3	Change clamp color in accordance with color standardization for plastic parts; Rephrase the instruction for Band clamp cut checking; Put measuring tape illustration and instruction in Measurement	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
09/24/20	2	Transfer process owner from Production (WI-PRO-ASY-074B) to Engineering (WI-ENG-PDE-173B) Apply some improvements/pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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### PARTS:

1. Clamp 82711-52090(W) [3pcs] 2. Clamp 82711-16820(B) [2pcs] 3. Black tape [3pcs]

### JIG

1. Clamp Assembly jig

### NO.

### PROCESS NAME

4

### WORK PROCEDURE/ ILLUSTRATION

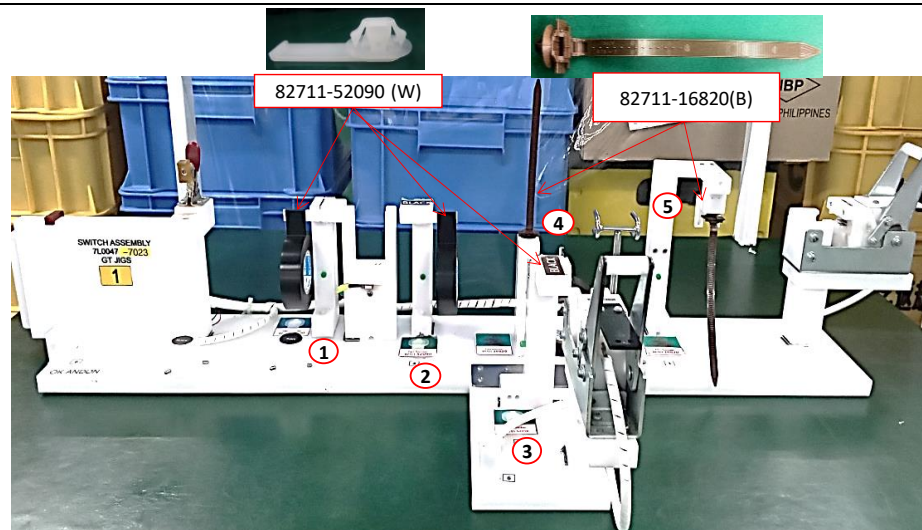
### TOOLS/PPE

### QUALITY POINTERS

2

P3

Clamp setting



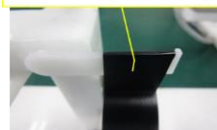
1. Get 3 clamps 82711-52090 (W) using right hand and insert to location 1, 2 and 3 using both hands.

2. Get 3 clamps 82711-16820 (BR) using right hand and insert to location 4 and 5 using both hands.

3. Get Black tape using right hand and conduct pre-taping on clamp in location 1, 2 and 3 using both hands.

#### STANDARD TAPING FOR CLAMP

One side tape under clamp



BANDO GUN

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
5. No wrong use of tape
6. No peel off tape
7. No missing tape

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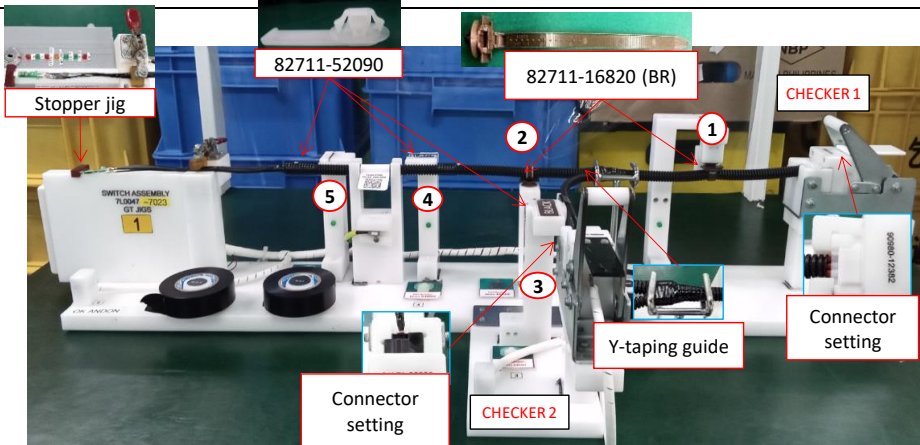



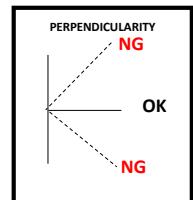
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PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp Assembly	<div><p>1. Get the assy parts using right hand and set to jig. Put the White connector on checker 1, Black connector on checker 2 and put the wires on toggle clamp using both hands.</p><p>2. Check the LED light for <b>POWER</b>, <b>CLAMP</b>, <b>WIRE 1</b> and <b>WIRE 2</b> and <b>SEQUENCE LIGHT</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the leader and <b>WAIT</b> for instruction.</p><p>3. Initially tighten the band clamp on location <b>1</b> and <b>2</b> using both hands.</p><p>4. Get the Bando gun using right hand and cut the band clamp on location <b>1</b> and <b>2</b>. Press the SW button after every cutting.</p><p>5. Tape the clamp on location <b>3</b> using both hands. Make <b>3 winds</b> and cut the tape. Press the SW button after taping. Repeat the process for location <b>4</b> and <b>5</b>. Proceed to attachment of label.</p></div> <div><p><b>BANDO GUN</b></p></div>	<p>Note: Make sure no clearance between PCB and stopper jig</p>  <ol style="list-style-type: none"><li>1. No wrong setting of clamp</li><li>2. No wrong use of clamp</li><li>3. No Loose attachment of clamp</li><li>4. No wrong setting of Bando gun</li><li>5. No wrong use of tape</li><li>6. No peel off tape</li><li>7. No missing tape</li></ol> <div><p>Fixed setting of band clamp cutter: 3 ~ 4</p></div> <p><b>BANDO GUN ALIGNMENT</b></p> 	

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Visual/By two's inspection

1. Check the connector lock

2. Check the clamp attachment, alignment and tape condition,

3. Check the presence of label and terminal appearance.

4 Using a steel rule check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.



5. Compare to Master sample.  
*Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.*

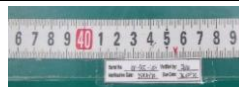
MASTER SAMPLE



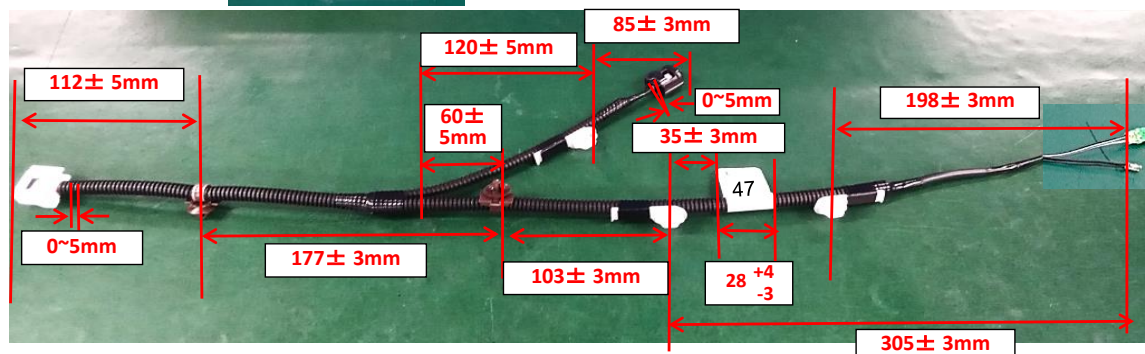
P3

5

Measurement



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



FOR HATSUMONO AND  
OWARIMONO ONLY

1. No wrong measurement

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### PARTS:

1. Label 7V2200-0020 (73230-07060 Driver PWR+MEM)

### JIG

1. Clamp Assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

3

P2

Clamp assembly  
Label Attachment

**Model Code** 47

**Item no. & name** 73230-07060 DRIVER PWR+MEM

1. Get the label.  
**Check the model code, item no. & name**

2. Align the end part of label in the jig.

3. Fold the center part of the label

4. Align both end part of label .

5. After alignment , Press the label with both fingers.  
**Make sure it was attach properly.**

6. Press the label upside down using finger.

7. Press the SW button after label attachment. Conduct **POINT CHECKING** and remove the harness from jig.

**GOOD**

Acceptable overlap 0~1mm



Label Dispenser

1. No bubbles
- 2.No damage
- 3.No peel off
- 4.No wrong use of label
5. No missing parts
6. No loose attachment



NG

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