



## WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

March 5, 2021

Product Name/Code: 780B / 7R0106-7020A

Customer: TRMX

Validity Date:

n/a

Purpose:

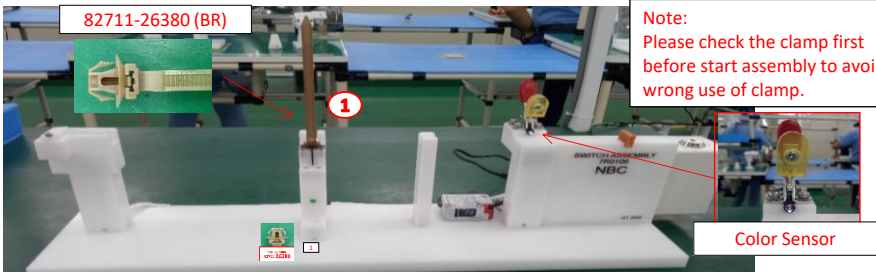

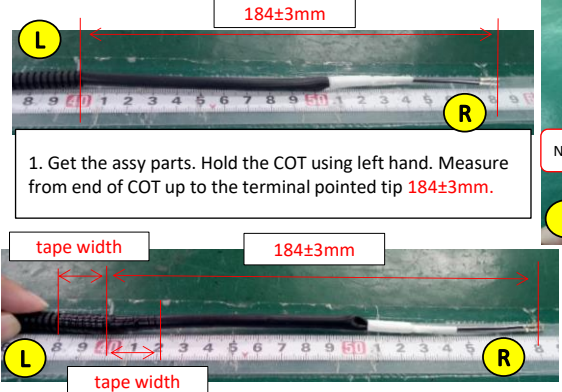
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assembly Setting	 <p>Get 1pc of Band clamp 82711-26380 (BR) using right hand and set to clamp location 1.</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p><b>Measuring tape</b></p> 	<p>1. No wrong use of clamp 2. No damaged clamp</p>
2	Taping COT to Sunprene tube near terminal	 <p>2. Hold the COT using left hand. Get Black tape using right hand and start taping using both hands. Make sure no gap between COT and Sunprene tube. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>3. After taping, check the measurement and taping condition.</p>	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>	<p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p>

Revision History				Prepared by:	Checked by:	Approve by:	Noted by:
3/5/21	1	Change from pre-launch to masspro.	D.Castillo	C.Villanueva	A.Shimamura	A.Arañes	
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date: November 27, 2020

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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

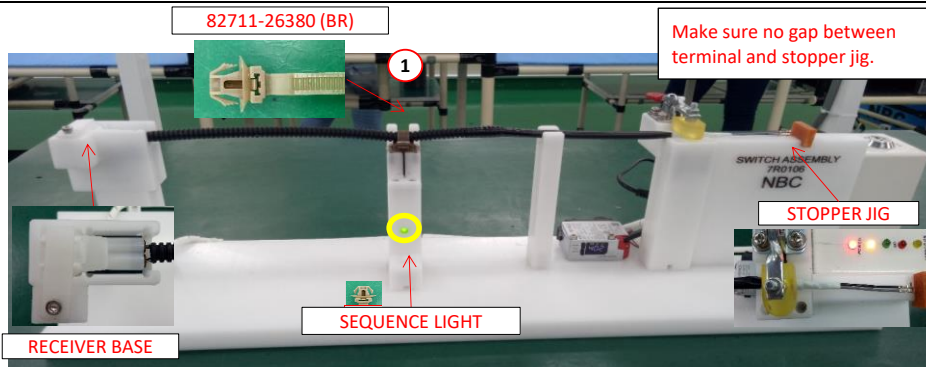
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp assembly jig



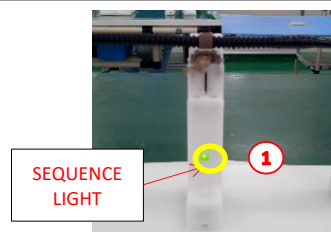
1. Get the assy parts using both hands. First, put the connector into receiver base then lock. Second, put the terminal to stopper jig. Color sensor will beep/buzz if detected White tape. Pull down the toggle clamp using right hand. Continue if the sequence light of location 1 was on.  
*Refer to above illustration for the correct setting.*

2. Check if LED light for **POWER**, **CLAMP**, **COLOR SENSOR** and **SEQUENCE LIGHT** is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

3. Initially tighten the clamp on location 1 using both hands.

4. Get the bando gun and cut the clamp on location 1. Press the switch button after cutting. **Go** buzzer will be heard.

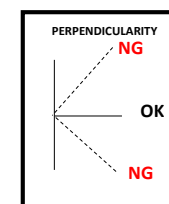
5. Conduct **POINT CHECKING** before removal from jig.



N/A

Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For: ø5 - 1~2, ø7 - 3~4

BANDO GUN ALIGNMENT



**NOTE: YOU WILL HEAR THE NG BUZZER IF THE SENSOR DETECT WRONG USE OF TAPE AND MISSING TAPE.**

1. No wrong use of clamp
2. No damaged clamp
3. No wrong setting of bando gun
4. No loose/tight clamp attachment

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PARTS:

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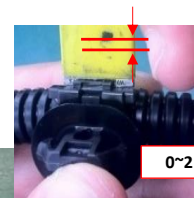
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Visual/By two's inspection

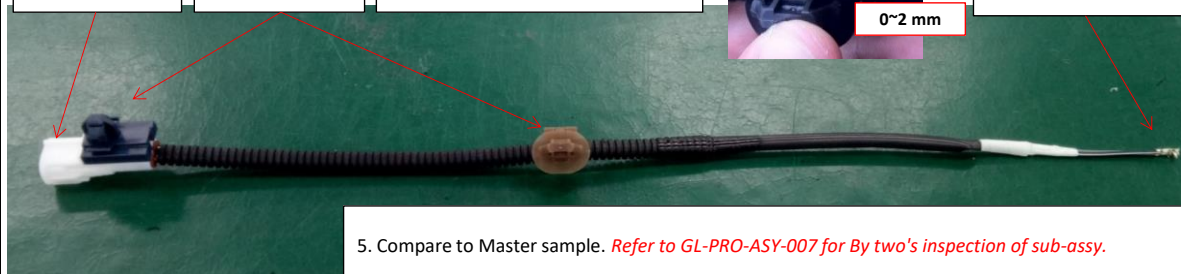
1. Check if the connector was properly locked.

2. Check the clamp attachment.

3. Confirm the band cut measurement using steel rule. If the band cut is longer than the requirement (**0~2mm only**)



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



Master Sample



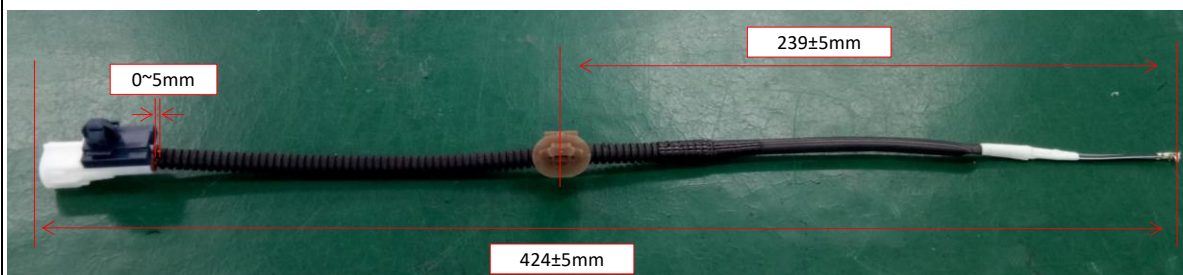
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P2

Measurement



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



For Hastumono and Owarimono

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