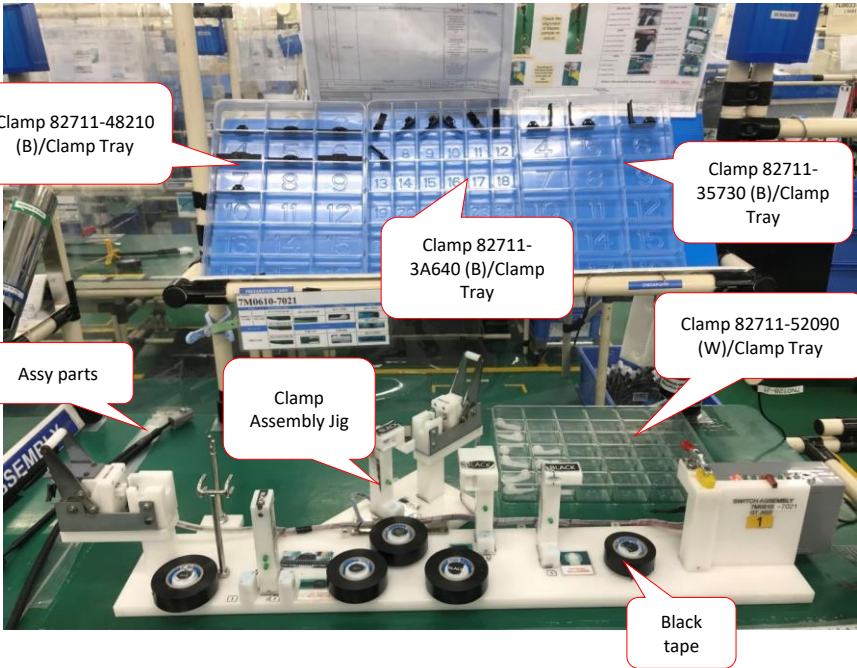
	WORK INSTRUCTION				Effectivity Date:		February 16, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model Code/Part Number: 164B / 7M0610-7021		Customer: TRJ		Document No.:		WI-ENG-PDE-398C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 7

PARTS:		1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [5pcs.]				JIG:		1. Clamp assembly jig		
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P3	Table Lay-out	<div>Table Lay-out</div>  <div>Clamp 82711-48210 (B)/Clamp Tray</div> <div>Clamp 82711-3A640 (B)/Clamp Tray</div> <div>Clamp 82711-35730 (B)/Clamp Tray</div> <div>Clamp 82711-52090 (W)/Clamp Tray</div> <div>Assy parts</div> <div>Clamp Assembly Jig</div> <div>Black tape</div>				n/a		1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools	

Revision History							Prepared by	Checked by	Approved by	Noted by
02/16/23	1	Work instruction improvement: Update Quality pointers. Inclusion of Quality checkpoint (Page 7).				D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
02/12/22	0	Initial Issue. PCB from 2 chips (61C619-0002) to 1 chip (7N0994-7060). Wire color from Gray (GR) to Green (G).				K. Doria	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date: February 12, 2022

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### PARTS:

1. Clamp 82711-48210 (B)  
2. Clamp 82711-3A640 (B)

3. Clamp 82711-35730 (B)  
4. Clamp 82711-52090 (W)

### JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

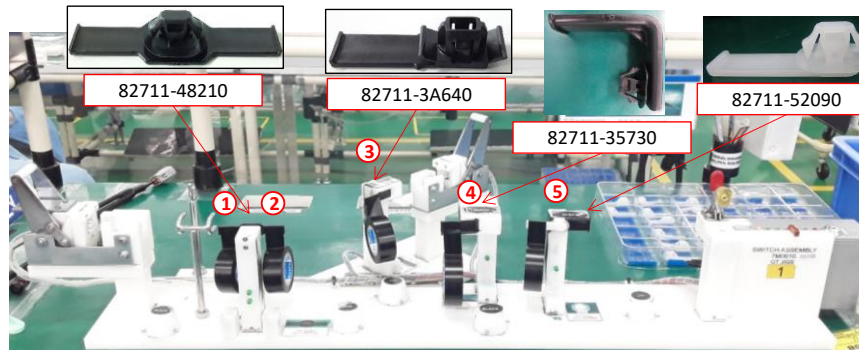
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Setting

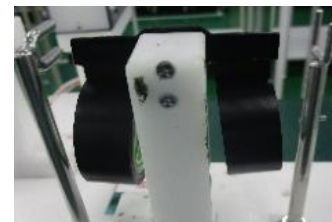
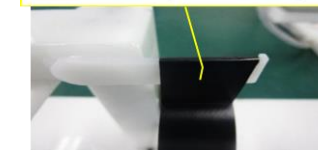


#### STANDARD TAPING FOR CLAMP

One side tape under clamp

1. Get the clamp 82711-48210 (B) using right hand and set to **location 1 and 2**, 82711-3A640 (B) set to **location 3**, 82711-35730 (B) set to **location 4** and 82711-52090 (W) set to **location 5** using right hand.

2. Get Black tape using right hand and conduct pre-taping on **location 1~5** using both hands.



n/a

1

#### CLAMP ILLUSTRATION

GOOD



82711-48210 (B)

NG



82711-3F290 (B)

#### CLAMP ILLUSTRATION

GOOD



82711-52090 (W)

NG



82711-12A80 (W)

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## PARTS:

1. Assy parts

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

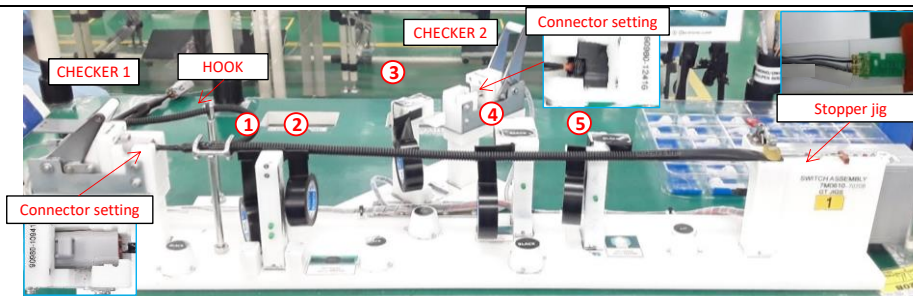
## TOOLS/PPE

## QUALITY POINTERS

3

P3

Clamp assembly



1. Get the assy parts and set to jig. Put first the Gray connector to checker 1. Secondly, put the checker 2 to hook beside the checker 1. Lastly, put the hotmelted wire into stopper jig.



2. Tape the clamp in location 1 & 2 to COT 1 (make 2 winds).



3. Remove the harness part from hook and then set to checker 2. Push both checker to lock. Same timing. Check the LED light for **POWER ON, CLAMP ON, WIRE1 and WIRE 2, SEQUENCE LIGHT is ON**. If encountered abnormality, apply **STOP** the process, **CALL** the leader and **WAIT** for instruction

4. Attach the COT 2 to the COT 1 (make 3 winds) then cut. Press the SW button after taping.

5. Hold the clamp in location 3 using left hand and begin taping using right hand. Press the SW button after taping. Repeat the process for location 4 and 5 press the switch button after taping. Go sound will be heard.

6. Conduct **POINT CHECKING** before removing from jig.

n/a

**Important reminders/Note/s:**

1. Make sure no gap between stopper jig and PCB

1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Visual/By Two's Inspection

1

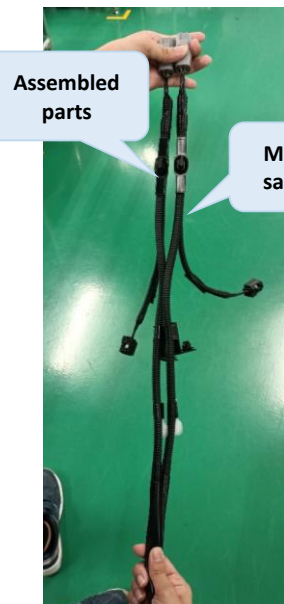


ACTUAL PRODUCT

MASTER SAMPLE

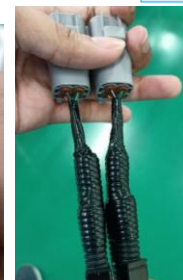
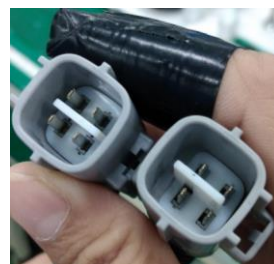


1. No skip inspection process



Assembled parts

Master sample



2. Check the **terminal, connector lock condition, insertion and Y-taping condition.**

1. Conduct alignment of harness (**Master sample vs. assembled parts**) using both hands.



3. Check the **presence of clamp and taping condition.** Conduct **bending of clamp with 2 sides taping.**

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/

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

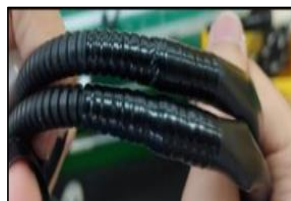
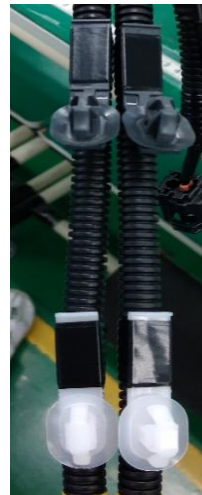
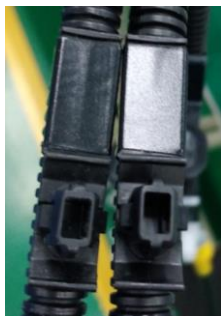
QUALITY POINTERS

4

P3

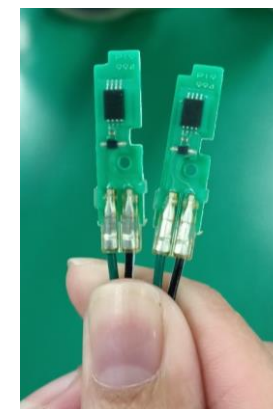
1

Visual/By Two's Inspection  
(Continuation)



4. Check the **presence of clamp, taping condition, connector lock and insertion.**

5. Check the **taping condition of COT to VM tube. Conduct bending to avoid missing tape.**



6. Check the **appearance of PCB.**

MASTER SAMPLE



1. No skip inspection process

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Purpose:

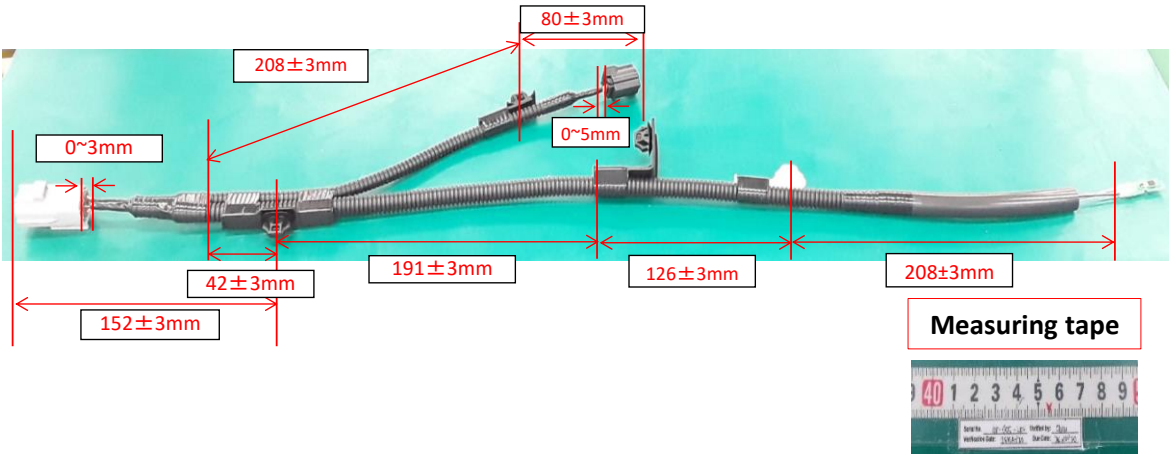
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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<b>PARTS:</b>	n/a			<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P3 Measurement				1. No wrong dimension  <b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono

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PARTS:

1. Assy parts

JIG

n/a

### 1 QUALITY CHECKPOINTS

P3

7M0610-7021



GOOD



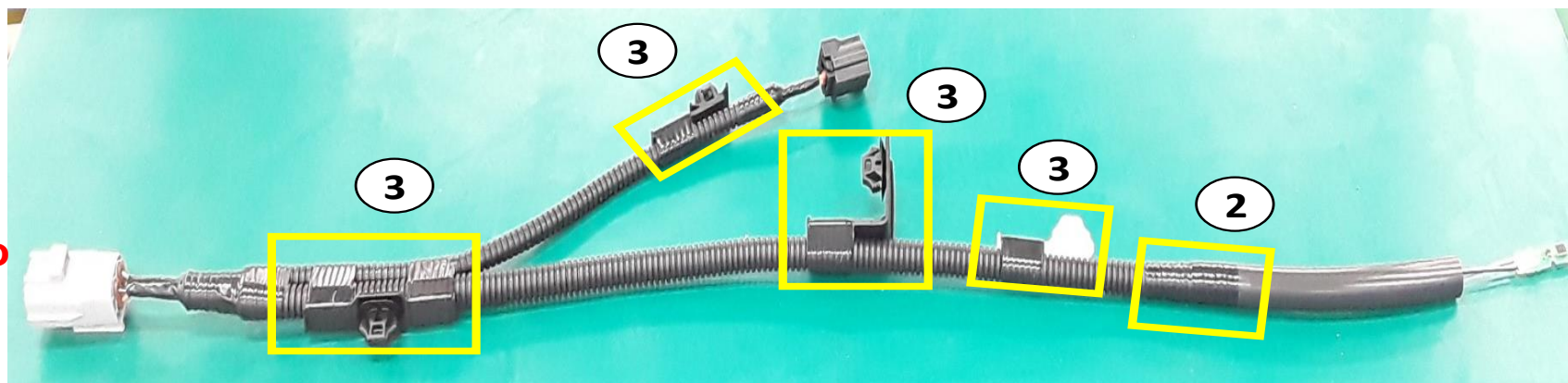
NO GOOD



NO GOOD



GOOD



1 No **WRONG INSERT**  
No **UNLOCKED/HALFLOCKED**  
NO **TBO**

2 No **Missing tape**

3 No **Missing CLAMP**

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