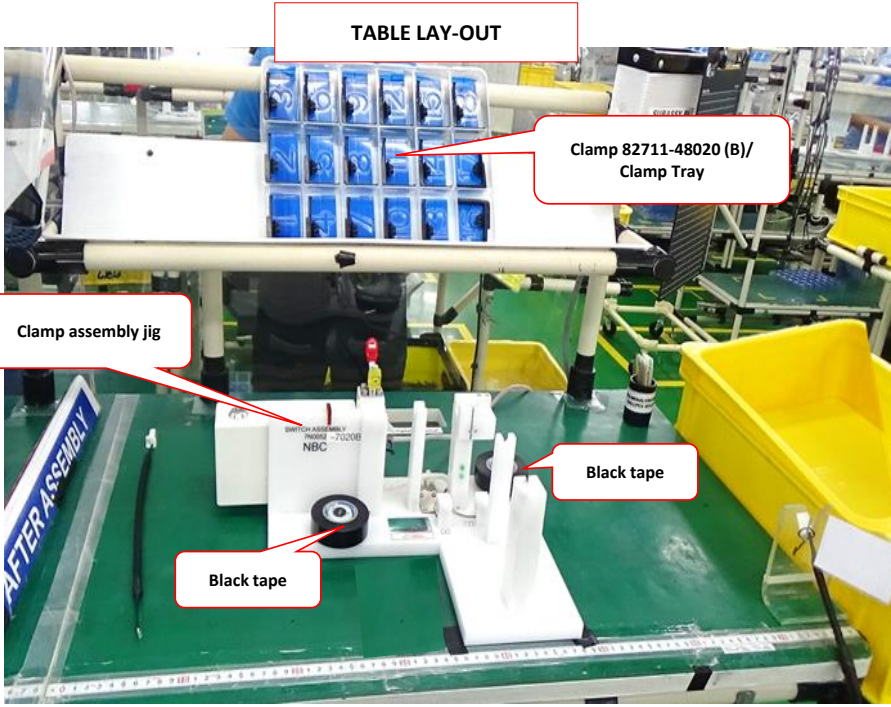
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		April 28, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: 817B / 7N0052-7020B		Customer: TRJ		Document No.:		WI-ENG-PDE-260B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:	1 of 6	

PARTS:		1. Assy parts 2. Clamp 82711-48020 (B) 3. Black tape [2pcs.]		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2			<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools	

04/28/23	5	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	Prepared by Reviewed by Approved by Noted by Est. Date: April 17, 2021	
09/20/22	4	Improve quality pointers: Reminders/notes and references in process no.2, 3,4 and 5 due to document improvement. Work procedure/illustration in process no.4 - visual/by two's inspection.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
01/03/22	3	Change COT length from L=245±3mm to L=243±2mm (Refer to WI-ENG-PDE-264). Change tolerance to range in taping process from L=53±3mm to L=55±1mm and from L=33±3mm to L=33±2mm/-1mm; from L=46±3mm to L=43-49mm due to encountered minimum dimension from end tape to terminal tip (Refer to WI-ENG-PDE-260A)	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
09/28/21	2	Add notes on clamp assembly; update the illustration	D. Castillo	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change		Revised	Checked	Approved	Noted	

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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817B**/****7N0052-7020B**

Customer:

TRJ

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Clamp 82711-48020 (B)
2. Black tape [2pcs.]

JIG

1. Clamp Assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P2

Clamp setting



1. Get 1pc. of clamp **82711-48020 (B)** using right hand then set to clamp location **1** and **2** using both hands.

2. Initially attach **Black tape** on clamp location **2** and **1** using both hands.

n/a

Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

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

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WORK INSTRUCTION

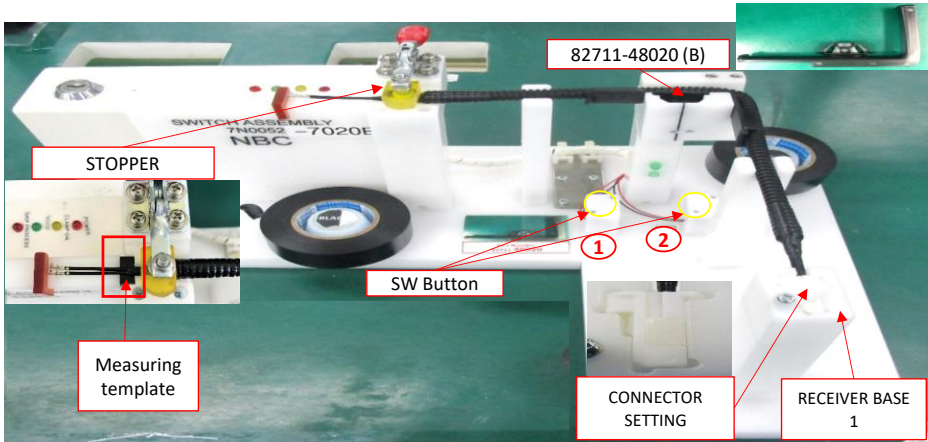
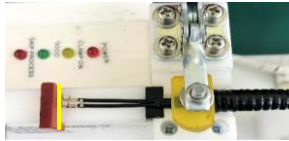
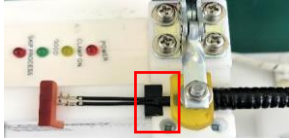
TAPING ASSEMBLY PROCESS

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

Model Code/Part Number: **817B / 7N0052-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp Assembly jig	<div></div> <div>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6098-3810 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Last, set the B-B wires together within stopper jig then press by toggle clamp. Continue if sequence light in location 1 was ON. Note: Check if the end tape is within the measuring template. If encountered outside the template, STOP the process, CALL the leader and WAIT for instruction.</div> <div>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, was On. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div> <div><div>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue if sequence light in clamp location 2 was ON.</div><div>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</div></div> <div>5. After taping, CONDUCT POINT CHECKING before removing the harness in jig.</div>		n/a	<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper jig and terminals</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div></div> <div>Important reminders/Note/s: 1. Make sure that the end tape on wire will not be exposed outside of measuring template.</div>

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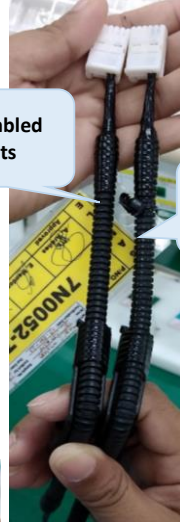


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TAPING ASSEMBLY PROCESS

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

Model Code/Part Number: **817B / 7N0052-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2	<p>ACTUAL PRODUCT</p>  <p>Assembled parts</p>  <p>Master sample</p>  <p>1. Conduct alignment of harness (Master sample vs. assembled parts) using both hands.</p> <p>2. Check the terminal, connector lock condition, insertion and taping condition.</p> <p>3. Check the presence of undertape, clamp and taping condition.</p> <p>4. Check the taping condition and terminal appearance. Must be no deformed terminal.</p>				<p>MASTER SAMPLE</p>  <p>1. No skip process</p>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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PARTS:

n/a

JIG

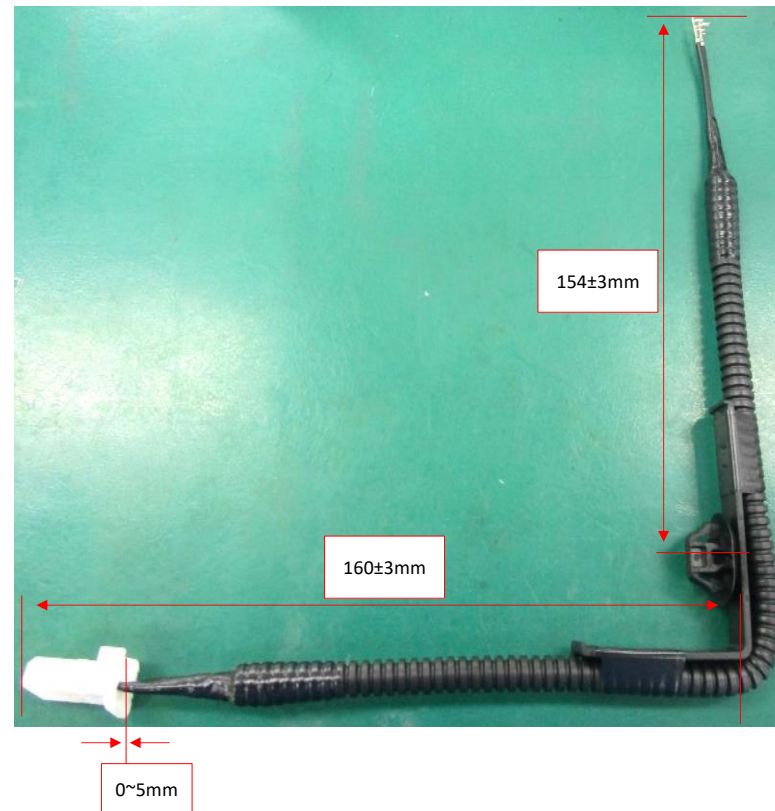
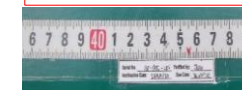
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P2

Measurement

**MEASURING TAPE****Note:**

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

Important reminders/Note/s:

1. FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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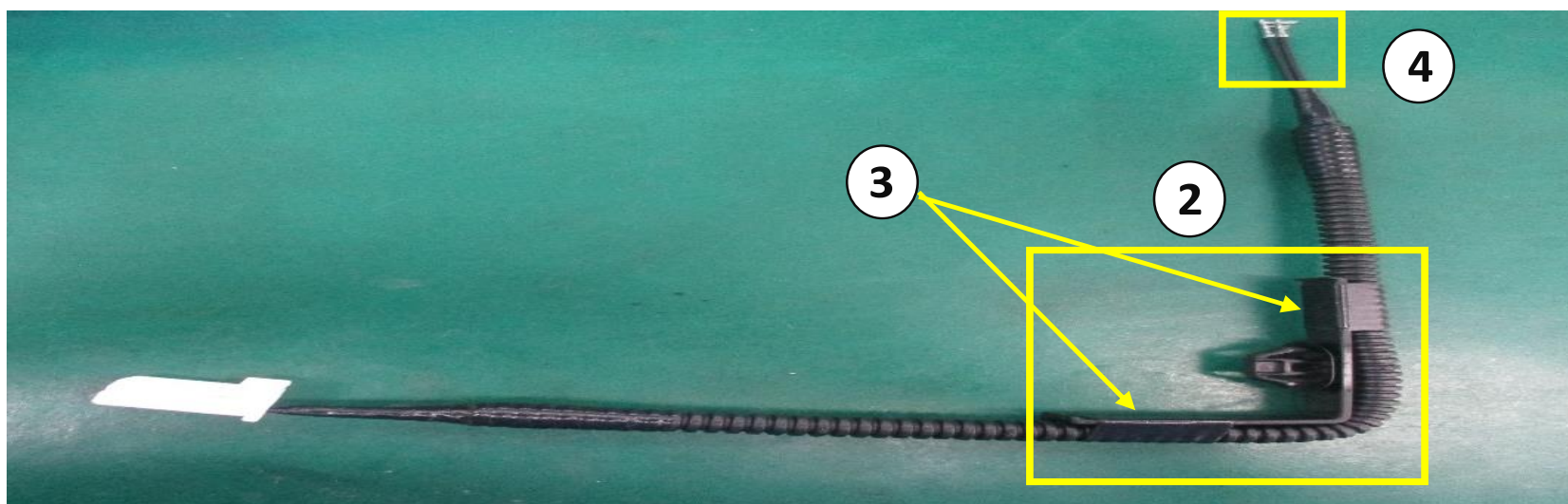
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PARTS:

1. Assy parts

JIG

n/a

**QUALITY CHECKPOINTS****P2****7N0052-7020B****GOOD****NO GOOD****1****No Unlock/
Halflocked
Connector****2 No Missing Clamp (1pc.)****3****No Missing Tape
(conduct BENDING of 2 sides of
wing clamp)****4****No
Deformed
Terminal**

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