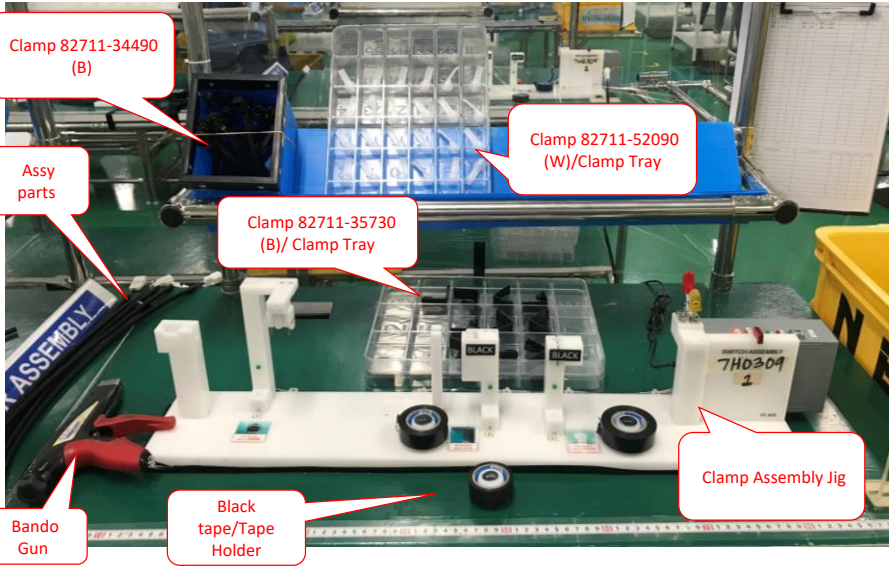





	WORK INSTRUCTION				Effectivity Date:		May 20, 2022	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model Code/Part Number: 666W / 7H0309W7020D		Customer: NBS		Document No.:		WI-ENG-PDE-524B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 7

PARTS:	1. Assy parts; Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clamp 82711-35730 (B); Black tape [3pcs.]			JIG:	1. Clamp Assembly Jig
---------------	--	--	--	------	-----------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>BANDO GUN</p> 	1. No missing parts/tools. 2. No excess parts/tools.

Revision History								Prepared by	Reviewed by	Reviewed by	Approved by
05/20/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
05/13/22	0	Initial issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Est. Date:	May 13, 2022			

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2 of 7**PARTS:**

1. Clamp 82711-34490 (B)
2. Clamp 82711-52090 (W)

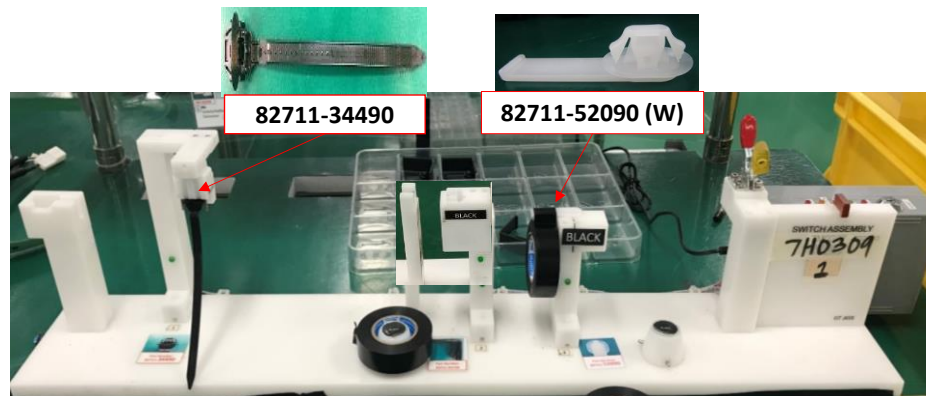
3. Black tape

JIG

1. Clamp Assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2****P2**

Clamp Setting



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

1. Get 1 pc. of band clamp **82711-34490 (B)** then set to clamp location **1** using both hands.

2. Get 1 pc. of clamp **82711-52090 (W)** then set to clamp location **3** using both hands.

3. Initially attach **Black tape** on clamp location **3** using both hands.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp

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

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PROTOTYPE



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PARTS:

1. Assy part
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

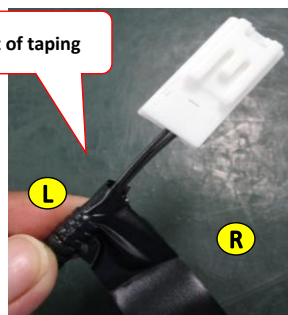
QUALITY POINTERS

3

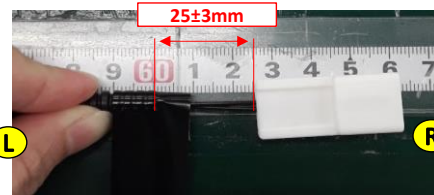
P2

Taping 1
Corrugated tube to wire
near connector

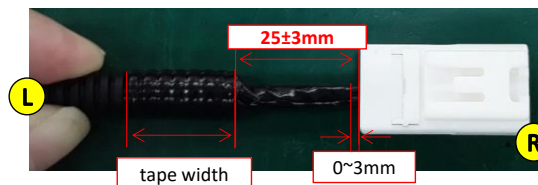
Start of taping



1. Hold the corrugated tube using left hand, get **Black tape** and start pre-taping using right hand.



2. Hold the corrugated tube using left hand, measure from end of corrugated tube up to the edge of connector **25mm**.
Note: Please refer to WI-PRO-ASY-001 for taping procedure.



3. After taping, check the measurement and tape condition.

MEASURING TAPE



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

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

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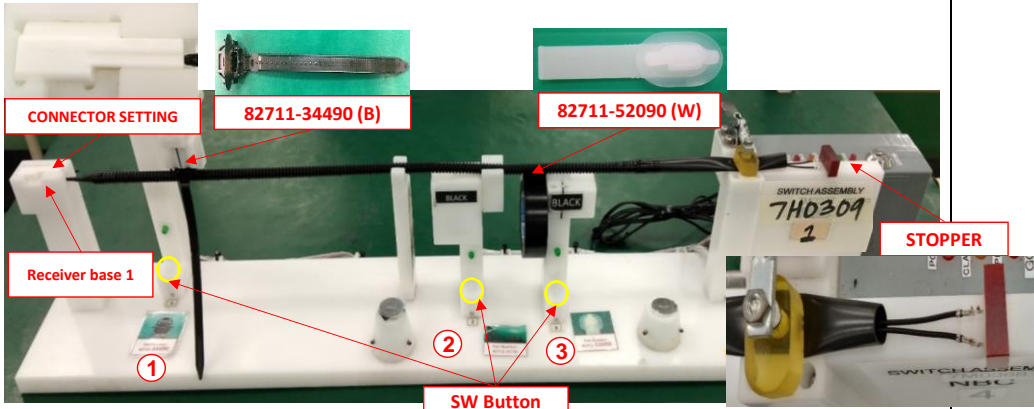
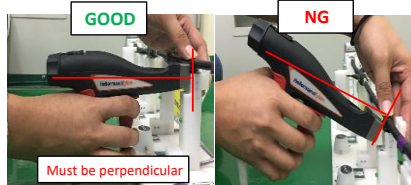
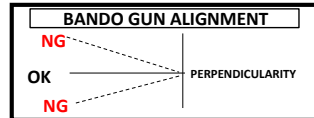

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PARTS:		1. Assy parts		JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.</p><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p><p>3. Initially tighten the band clamp on location 1 using both hands.</p><p>4. Get the bando gun using right hand then cut the band clamp on location 1. Continue the process if sequence light button on location 2 was on.</p></div> <div></div> <div></div>	<div>BANDO GUN</div> 	<p>Note: Make sure no gap between stopper jig and terminals.</p> <p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape 5. No loose/tight clamp attachment</p> <p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p>

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PARTS:		1. Assy parts 2. Clamp 82711-35730 (B)	3. Black tape	JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly (Continuation)	<p>5. Conduct spot taping on COT on clamp location 2 using both hands. Make 2 windings of tape and do not cut.</p> <p>6. Get 1 pc. of clamp 82711-35730 (B) then set to clamp location 2 using left hand.</p>		n/a	<p><i>Note: Make sure no gap between stopper jig and terminals.</i></p> <ol style="list-style-type: none">1. No damaged clamp2. No wrong usage of parts3. No missing clamp4. No missing tape

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

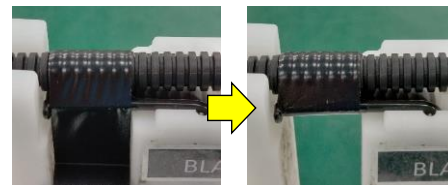
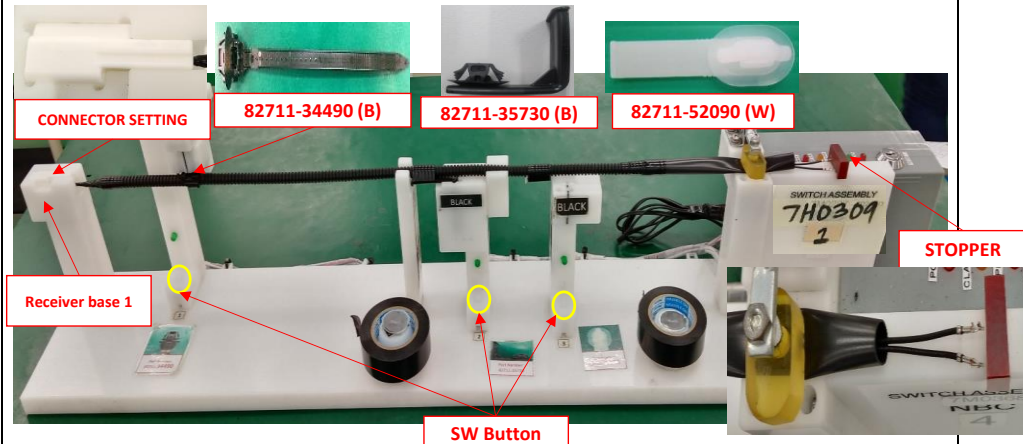
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly
(Continuation)



7. Conduct clamp attachment on clamp location **2** using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue the process if sequence light in location **3** was **on**.

8. Tape the clamp on location **3** using both hands. Make **3 winds** then cut the tape. Press the **SW button** after taping. **Go** sound will be heard .

9. Conduct **POINT CHECKING** before removing the harness from jig.

n/a

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape

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n/a

JIG

n/a

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

5

Visual/By Two's Inspection

P2

1. Check connector lock.

3. Check the clamp attachment and taping condition.

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

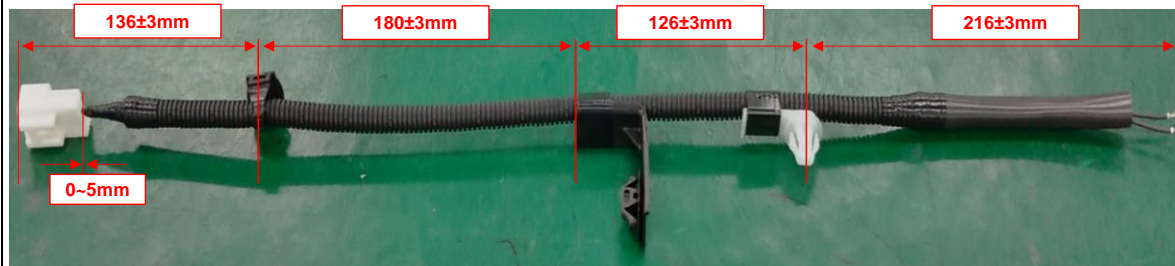
**0~2 mm**

2. Using 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
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy.***MASTER SAMPLE**

6

Measurement

MEASURING TAPE*Note: Please use calibrated/verified measuring tape when getting the measurement.***136±3mm****180±3mm****126±3mm****216±3mm****0~5mm****NOTE: FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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