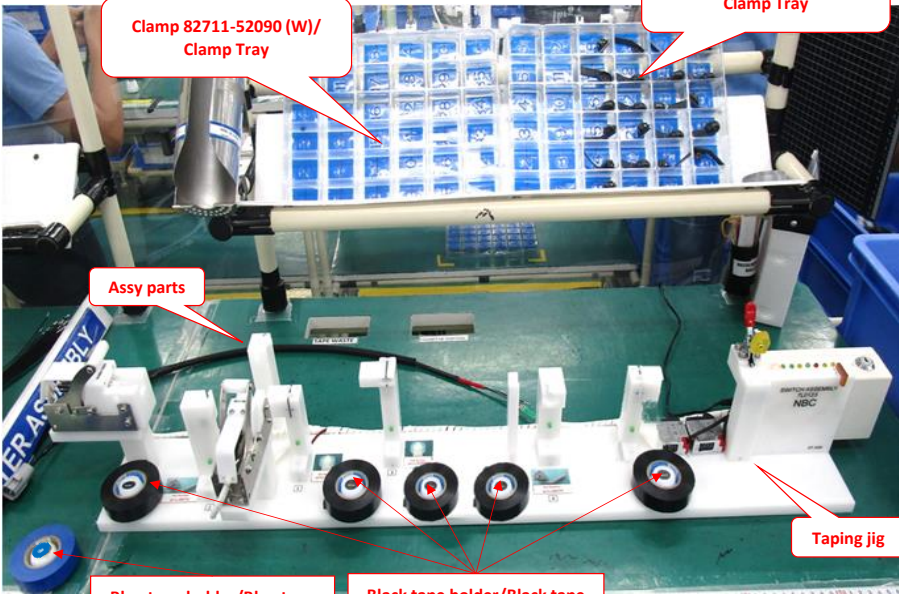




	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		March 07, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model code/Part number: 922B / 7L0123-7022		Customer: TRQSS		Document No.:		WI-ENG-PDE-429C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 10

PARTS: 1. Assy parts 2. Clamp 82711-52090 (W) 3. Clamp 82711-48070 (GR) 4. Black tape [5pcs.] 5. Blue tape [1pc.]		JIG: 1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P3 Table Lay-out	<div style="text-align: center;"> TABLE LAY-OUT </div> 	<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear required 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>
		QUALITY POINTERS 1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
03/07/23	1	Inclusion of quality checkpoints. Improve quality pointers	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
02/19/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 19, 2022			

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Effectivity Date:

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PARTS:

1. Assy parts
2. Clamp 82711-52090 (W) [3pcs.]
3. Clamp 82711-48070 (GR) [2pcs.]

4. Black tape [5pcs.]

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

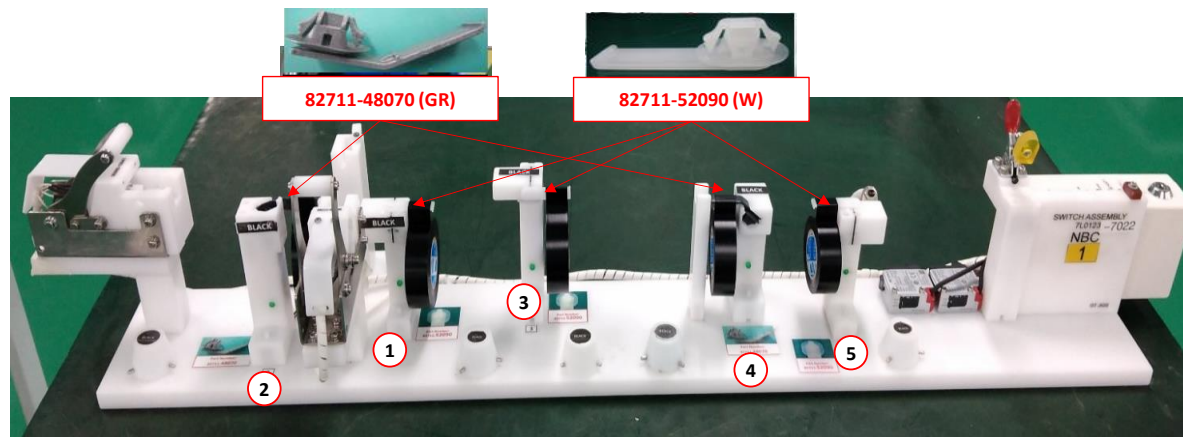
TOOLS/PPE

1 QUALITY POINTERS

2

P3

Clamp setting



1. Get **3pcs.** of clamp **82711-52090 (W)** using right hand then set to clamp location **1, 3 and 5** using both hands.

2. Get **2pcs.** of clamp **82711-48070 (GR)** using right hand then set to clamp location **2 and 4** using both hands.

3. Initially attach Black tape to clamp location **1, 2, 3, 4 and 5** using both hands.

STANDARD TAPING FOR CLAMP

One side tape under clamp



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

Important reminders/Note/s:

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

CLAMP ILLUSTRATION



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PARTS:

1. Assy parts
2. Blue tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

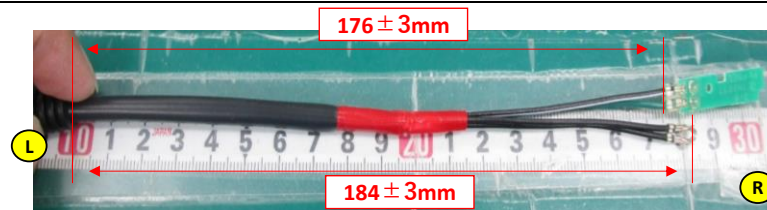
TOOLS/PPE

1 QUALITY POINTERS

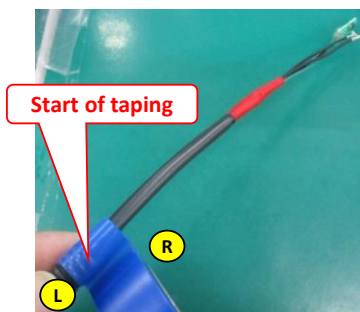
3

P3

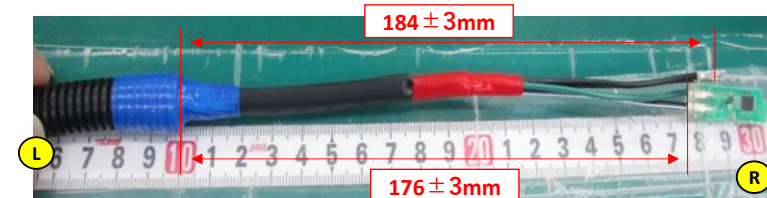
Taping 1
Black corrugated tube to
Black VM tube
(Sunprene)



1. Measure from end of sunprene tube up to edge of hotmelted wire $176 \pm 3\text{mm}$ and up to terminal pointed tip $184 \pm 3\text{mm}$ using both hands.



2. Get the **Blue tape** using right hand then start taping process using both hands.



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

MEASURING TAPE



Important reminders/Note/s:
1. Use **BLUE TAPE** only
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

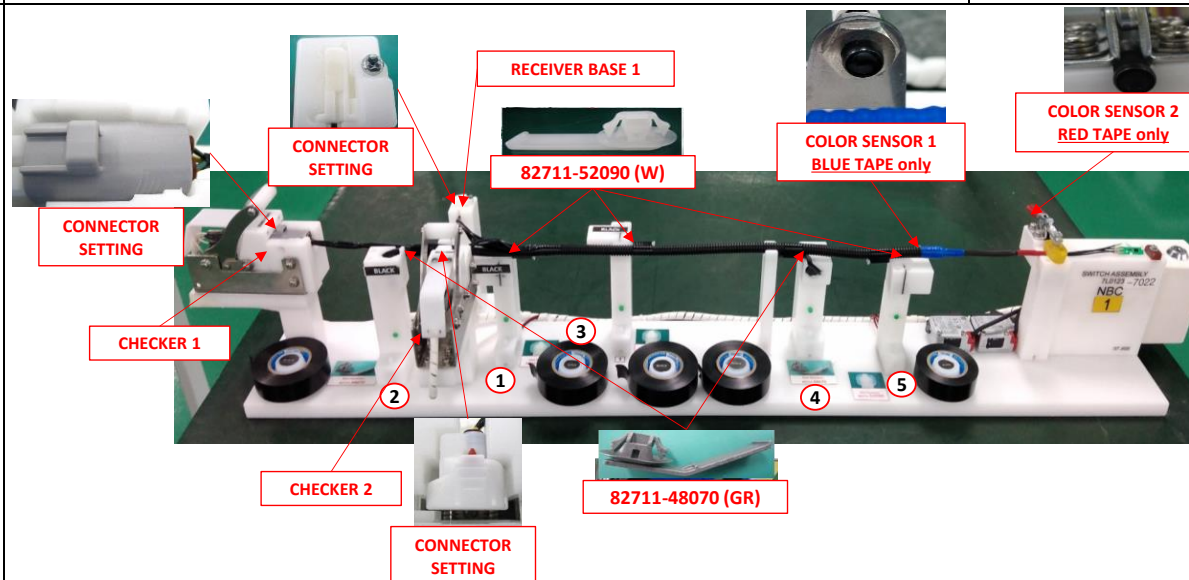
TOOLS/PPE

1 QUALITY POINTERS

4

P3

Clamp Assembly



1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Third, set the connector **6098-3810 (W)** to **Receiver base 1** then lock. Continue to set the harness in jig. **Color sensor 1** will beep/buzz if sensor detects **Blue tape**. **Color sensor 2** will beep/buzz if sensor detects **Red tape**. Last, set the hotmelted wires and terminal end together within the stopper then press by **Toggle clamp**. Check if the sequence light of location **1** was **ON**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.



Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB

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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PARTS:

1. Black tape
2. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

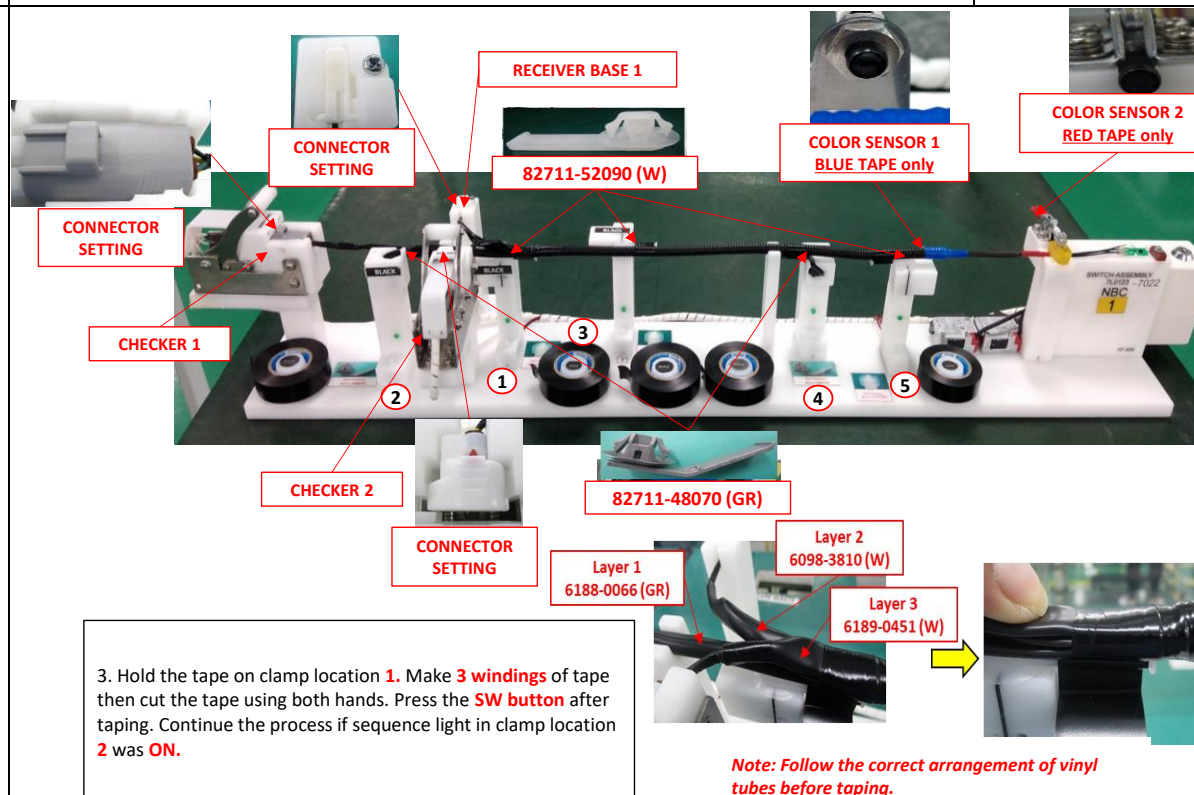
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

4

P3

Clamp Assembly
(Continuation)

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 the process if sequence light in clamp location **2** was **ON**.

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. Continue the process if sequence light in clamp location **3** was **ON**.



Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB

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

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PARTS:

1. Black tape
2. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

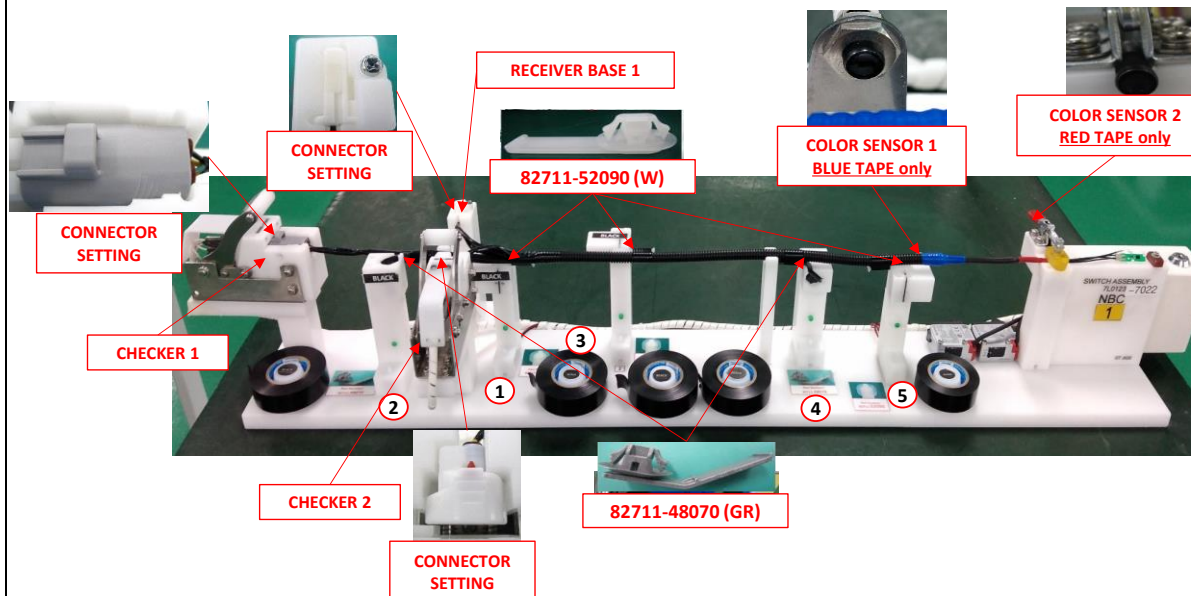
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

4

P3

Clamp Assembly
(Continuation)

5. Hold the tape on clamp location **3**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **4** was **ON**.

6. Hold the tape on clamp location **4**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **5** was **ON**.

7. Hold the tape on clamp location **5**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard.

8. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB

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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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE



QUALITY POINTERS

5

P3



Visual/By Two's Inspection



ACTUAL PRODUCTS



Assembled parts

Master sample

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



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



4. Check the **connector lock, terminal, insertion and taping condition.**

MASTER SAMPLE



1. No skip checking during inspection

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME



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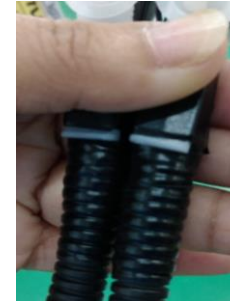
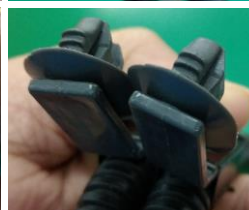
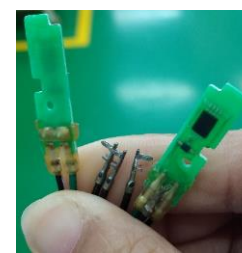
TOOLS/PPE



QUALITY POINTERS

5

P3

Visual/By Two's
Inspection
(Continuation)5. Check the **presence of clamp, under taping and taping condition.**6. Check the **Y-Taping condition and alignment**7. Conduct **bending of COT and tube** then check the **colored tape and taping condition.**8. Check the **colored tape and taping condition.**9. Check the **terminal and PCB appearance.** Must be **no deformed terminal.**

MASTER SAMPLE



1. No skip checking during inspection

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☐ PRE-LAUNCH

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PARTS:

n/a

JIG

n/a

NO.

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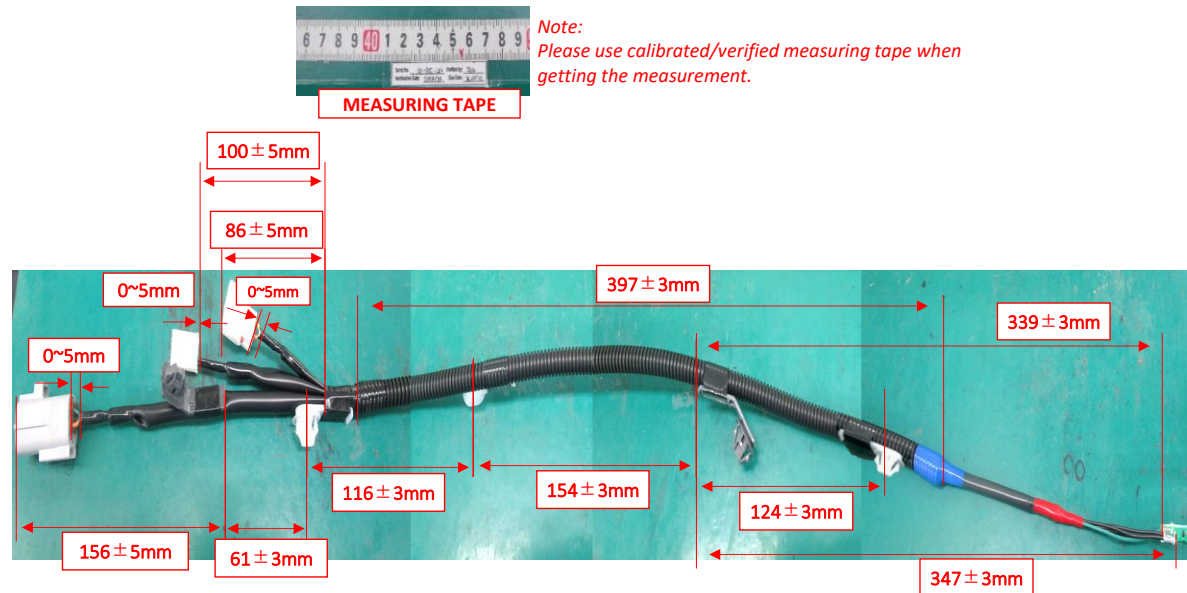
TOOLS/PPE

1. QUALITY POINTERS

6

P3

Measurement



Important reminders/Note/s:
1. FOR HATSUMONO AND
OWARIMONO

1. No wrong dimension

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PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS

P3

7L0123-7022



GOOD



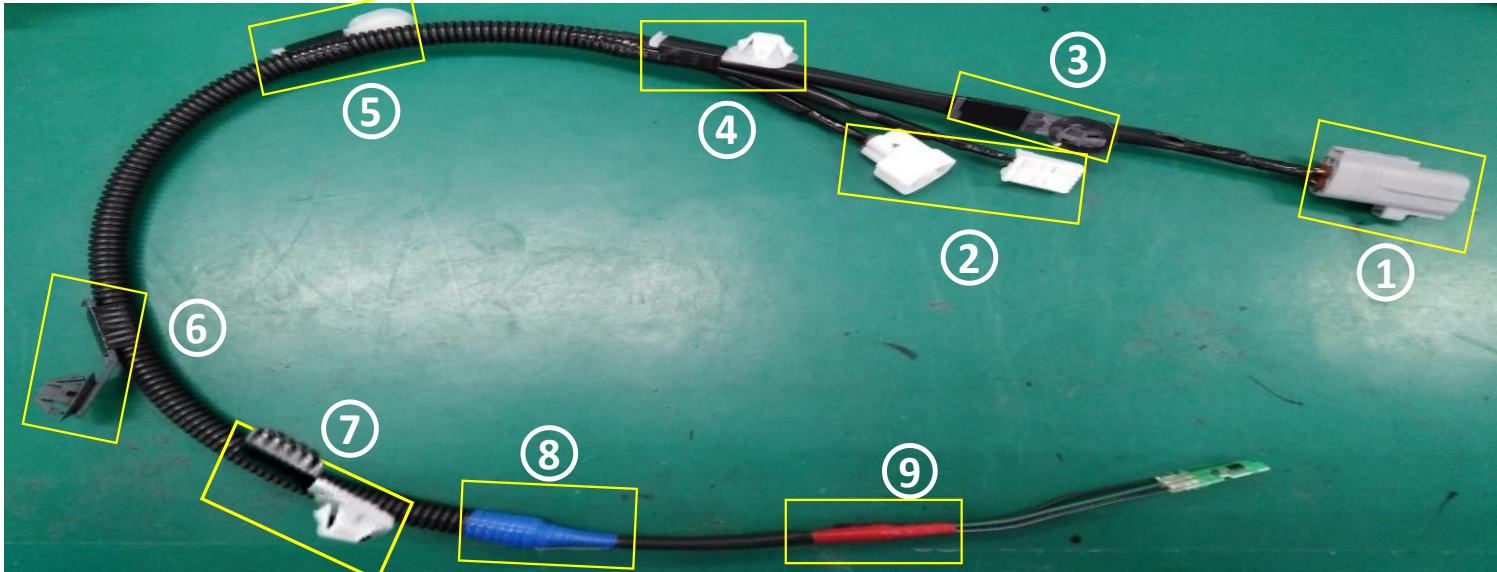
NO GOOD



NO GOOD



GOOD



① ② No UNLOCKED/ HALFLOCKED

⑧ ⑨ No MISSING TAPE

③ ④ ⑤ ⑥ ⑦ No MISSING CLAMP



NO GOOD



GOOD

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