



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 26, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code: 370B / 7L0045-7022

Customer:

TRQSS

Document No.:

WI-ENG-PDE-158B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

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PARTS:

3

1. Clamp 82711-52090 (W)
2. Black tape

3

JIG:

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

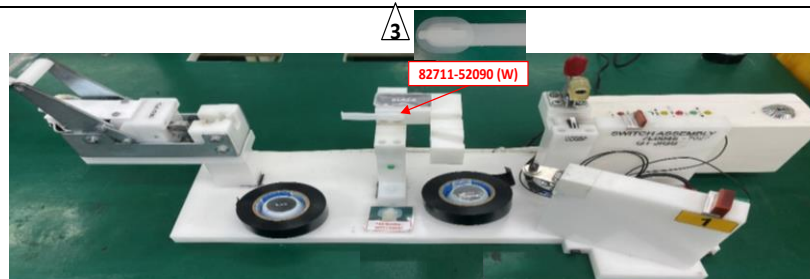
TOOLS/PPE

QUALITY POINTERS

1

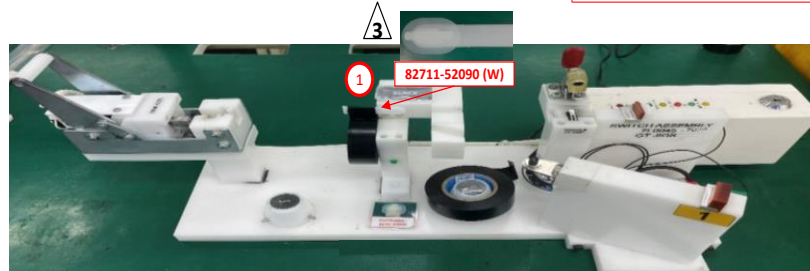
P2

Clamp setting



1. Get the clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.

**Note:** Please check all clamp and band clamp before start of assembly to avoid wrong use of parts.



2. Get the black tape then initially attach the tape on clamp location 1.

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

**Housekeeping**

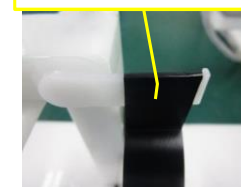
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

**STANDARD TAPING FOR CLAMP**

One side tape under clamp



1. No wrong use of parts
2. No damaged clamp

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

02/26/21	3	Revise due to standardize the color of connector in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color standardization of plastic parts). Apply some improvements. Removal of cycle time.
08/12/20	2	Transferred process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-072B to WI-ENG-PDE-158B. Changed part number from 7L0045-7021A to 7L0045-7022 due to removal of vinyl tube Ø4 L=25mm and changed vinyl tube dimension from Ø4 L=65mm to Ø4 L=45mm. Include cycle time per process.
12/06/19	1	Remove marking/include refer to Guideline's for By Two's inspection/Changed sequence of process (include clamp attachment/process distribution)

M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes
A. Roxas	A. Morcozo	O. Merin	

M. Catapang

C. Villanueva

A. Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Checked

Approved

Noted

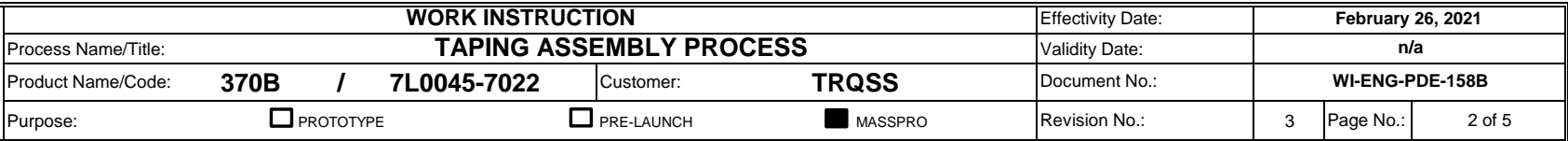
Est. Date:

April 14, 2018

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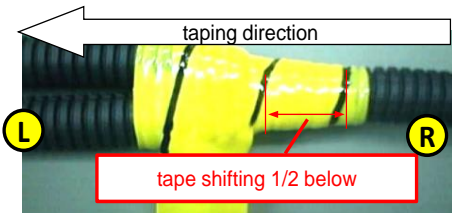
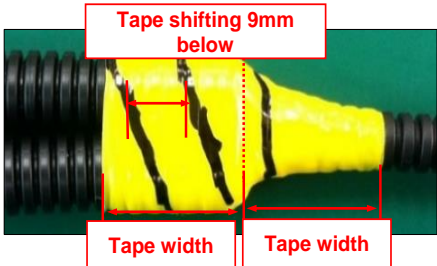
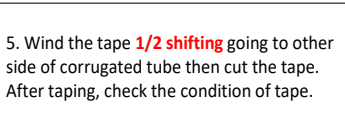
3 of 5

**PARTS:**

1. Assy parts
2. Black tape

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Y-Taping (Continuation)	  	n/a	<div>Note: Used <b>YELLOW</b> tape for easy visualization of shifting lines , but actual should be <b>BLACK</b>.</div> <ol style="list-style-type: none"><li>1. No peel-off tape</li><li>2. No flip out tape</li><li>3. No loose tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension</li></ol>

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**PARTS:**

1. Assy parts
2. Black tape

**JIG**

1. Clamp Assembly jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

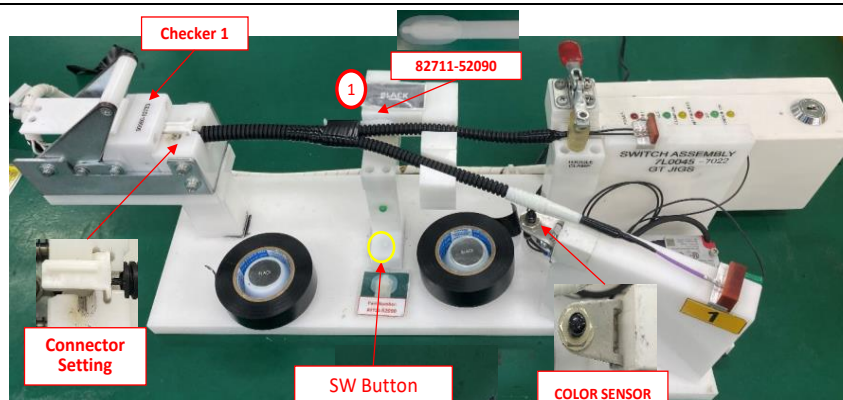
**TOOLS/PPE**

**QUALITY POINTERS**

3

P2

Clamp Assembly



1. Get the assy parts then set into jig. (*See above picture for the correct setting*). First, set the connector **6098-5577 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the **B/B wires** together within the stopper then press by toggle clamp. Last, set the **V/V wires** together within the stopper then press by toggle clamp. **Color sensor** light will beep/buzz if sensor detects **White tape**. Continue the process if clamp location **1** was on.

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.

4. Conduct **POINT CHECKING** on clamp attachment and taping before removing on jig.



3. Tape the clamp on clamp location **1** using both hands. Make **3 windings** on clamp then cut tape. Press the SW button after taping. **Go** sound will be heard.

n/a



Make sure **no gap** between terminal and stopper jig

*Note: Terminals should touch the aluminum to check the continuity*

1. No damage clamp
2. No missed tape
3. No missing parts

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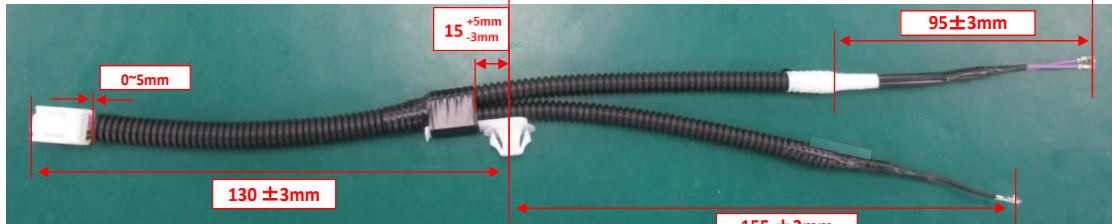
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	n/a		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	<div>3</div> <div>3</div> Visual Inspection  P2	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment and taping condition</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div>  <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div>		<div>MASTER SAMPLE</div> 
		<div>3</div> <div>MEASURING TAPE</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> 		<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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