



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 16, 2021

Model Code/Part Number: 102D

/ 2 7L0121-7023

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-244B

Revision No.:

2

Page No.:

1 of 5

PARTS:

2

1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [4pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

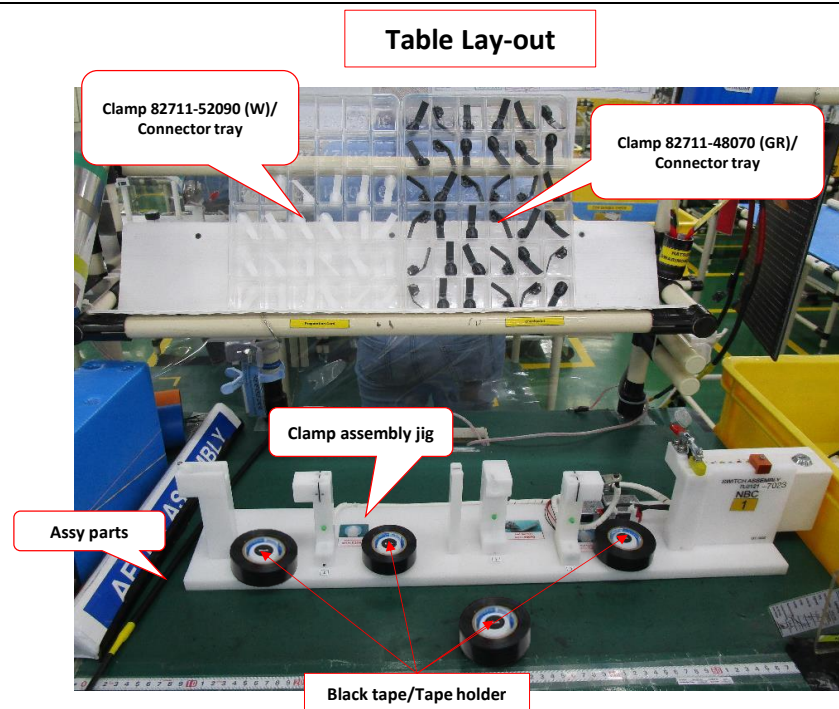
TOOLS/PPE

QUALITY POINTERS

1

P2

2 Table Lay-out



Safety Instruction

Be sure to wear required 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.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/16/21	2	Change part number from 7L0121-7022 to 7L0121-7023 due to additional quantity of clamp (82711-52090 (W)). Improve work procedure and illustration in all process. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/31/21	1	Change part number from 7L0121-7021A to 7L0121-7022 due to change of wire insertion sequence.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
03/08/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
							M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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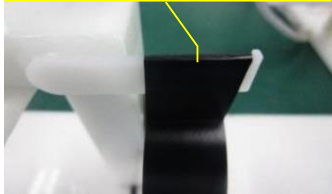
☒ MASSPRO

Revision No.:

2

Page No.:

2 of 5

PARTS:	1. Clamp 82711-52090 (W) [2pcs.] 2. Clamp 82711-48070 (GR) 3. Black tape [3pcs.]			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp setting	<div data-bbox="555 451 1523 810"></div> <div data-bbox="622 834 1088 975">1. Get 2pcs. of clamp 82711-52090 (W) using right hand then set to clamp location 1 and 3 using both hands.</div> <div data-bbox="622 991 1088 1117">2. Get 1pc. of clamp 82711-48070 (GR) using right hand then set to clamp location 2 using both hands.</div> <div data-bbox="896 1126 1368 1220">3. Initially attach Black tape on clamp location 1, 2, and 3 using both hands.</div>		n/a	<div data-bbox="1800 432 2130 549">STANDARD TAPING FOR CLAMP One side tape under clamp</div>  <div data-bbox="1785 810 2130 946">1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</div>

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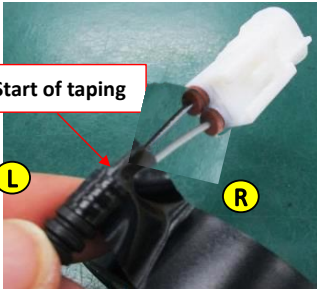
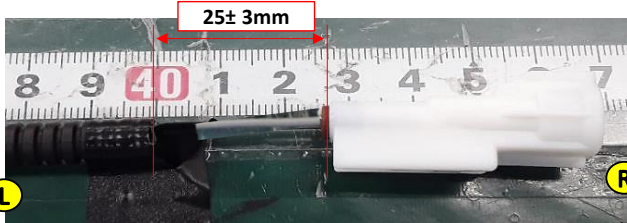
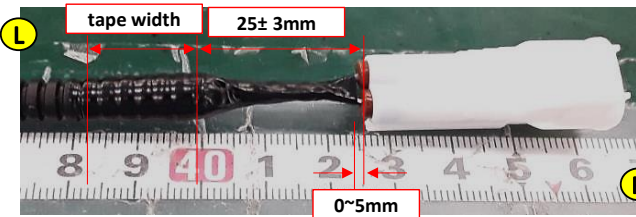

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Revision No.:

2

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 Black corrugated tube to wire near connector	<div><p>Start of taping</p></div> <div><p>25± 3mm</p></div> <div><p>tape width 25± 3mm 0~5mm</p></div> <div><p>1. Hold the corrugated tube using left hand, get the Black tape then start pre-taping at the middle of COT and wires using both hands.</p><p>2. Measure from end of corrugated tube up to end of connector 25mm then continue the taping process using both hands. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure</i></p><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>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</p><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div>

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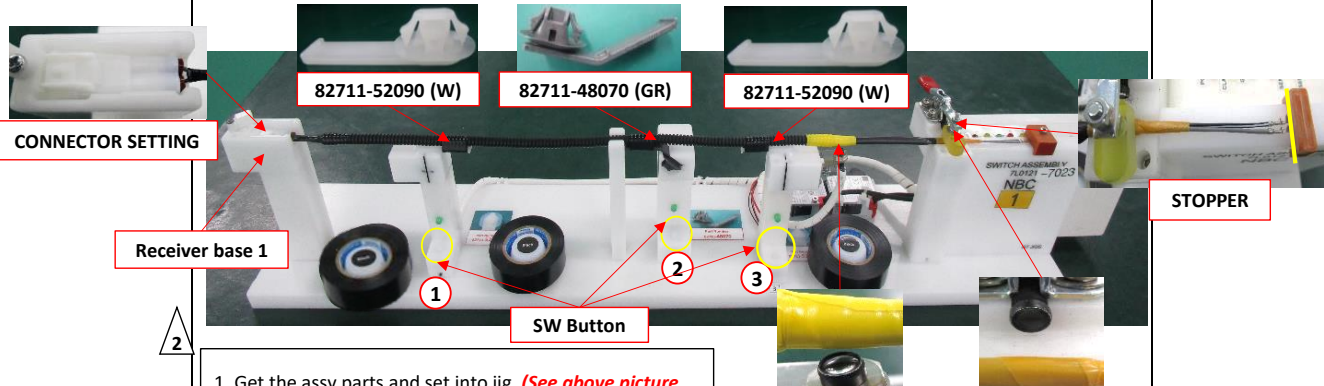

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

4 of 5

PARTS:	1. Assy parts 2. Black tape			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp assembly	 <p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig, Color sensor light will beep/buzz if detects Yellow tape. Color sensor light will beep/buzz if sensor detects Orange tape. Last, set the GR-B/W wires together within stopper jig then press by toggle clamp. Continue if sequence light in location 1 was ON.</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, Sensor ON was On. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>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.</p> <p>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.</p> <p>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. Go sound will be heard.</p> <p>6. After taping, CONDUCT POINT CHECKING before removing the harness in jig.</p>		n/a	 <p>Note: Make sure no gap between stopper jig and terminals.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>

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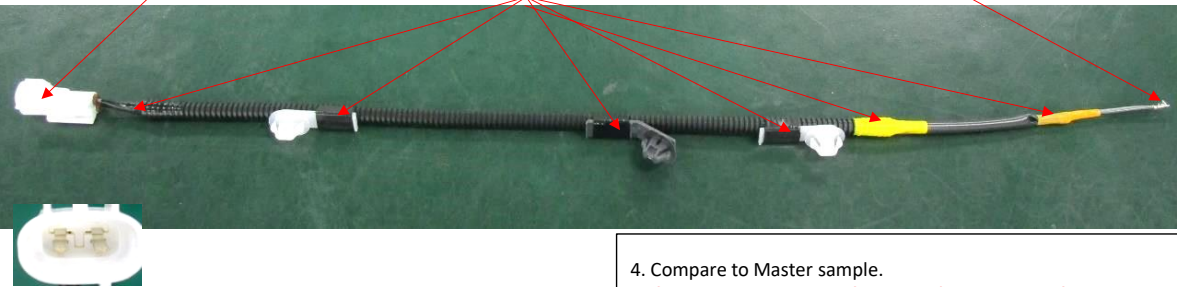


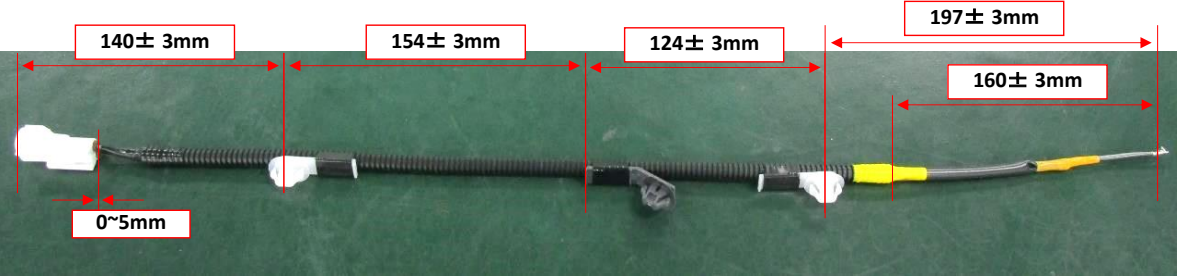
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Page No.:

5 of 5

PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	Visual/By two's inspection	<div>2</div> <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></div> <div>4. Compare to Master sample. <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></div>		<div>MASTER SAMPLE</div> <div></div>	
6	Measurement	<div>2</div> <div><div>MEASURING TAPE</div><div></div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div></div>		<div>FOR HATSUMONO AND OWARIMONO ONLY</div> <div>1. No wrong measurement</div>	

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