



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 382D / 7N0175-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 18, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-680

Revision No.:

0

Page No.:

1 of 8

PARTS:

1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-52090 (W); Black tape [1pc]; White tape [2pcs]

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

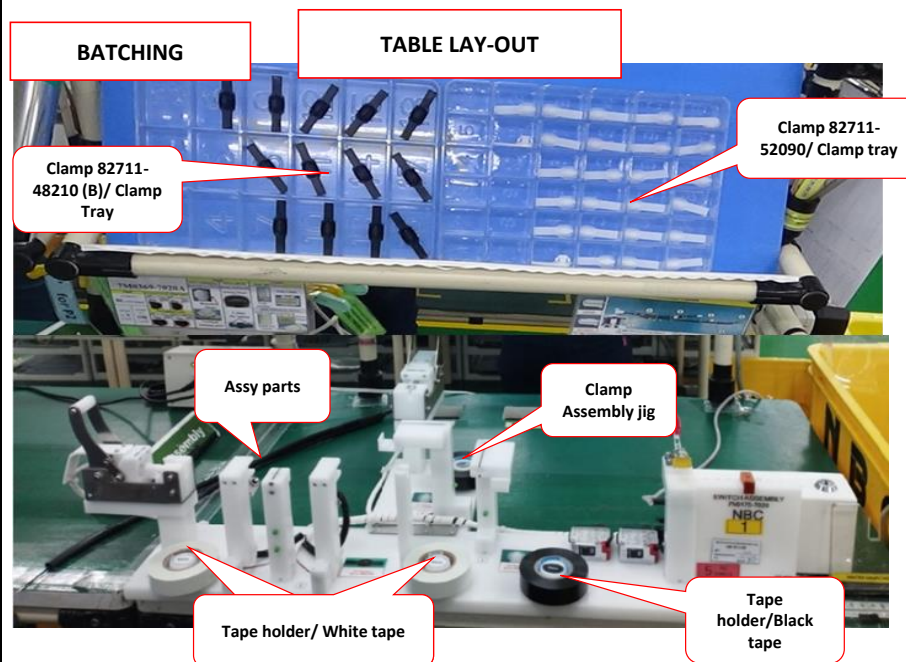
TOOLS/PPE

QUALITY POINTERS

1

n/a

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.

Important reminders/Note/s:

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

Revision History

| Eff. Date | Rev. No | Details of Change | Prepared | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|--|-----------|------------|---------------|-----------|-------------|-------------|-------------|----------|
| 05/18/23 | 0 | Initial issue. Change Process name/Title from "TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS"; Changed Document no. from WI-ENG-PDE-632 to WI-ENG-PDE-680 due to separation of process. Changed purpose from Pre-launch to Masspro. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes | | | | |

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DCC Stamp



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PARTS:

1. Clamp 82711-48210 (B)
2. Clamp 82711-52090 (W) [2pcs]

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

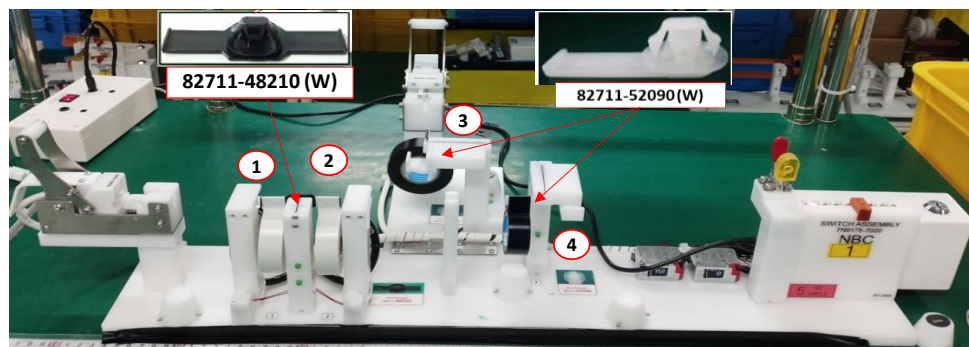
TOOLS/PPE

QUALITY POINTERS

2

n/a

Clamp setting



1. Get [1pc] of Clamp 82711-48210 (B) then set to location 1 using both hands.

2. Get the white tape then initially attach to location 1 and 2 using both hands

3. Get [2pcs.] of Clamp 82711-52090 (W) then set to location 2 using both hands.

4. Get the Black tape then initially attach to location 3 and 4 using both hands

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

Important reminders/Note/s:

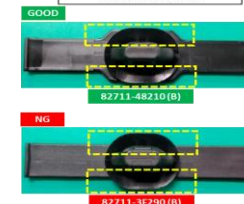
1. Please check the clamp before start of assembly to avoid wrong use of clamp



CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



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PARTS:

1. Assy parts

JIG

1. Temporary Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

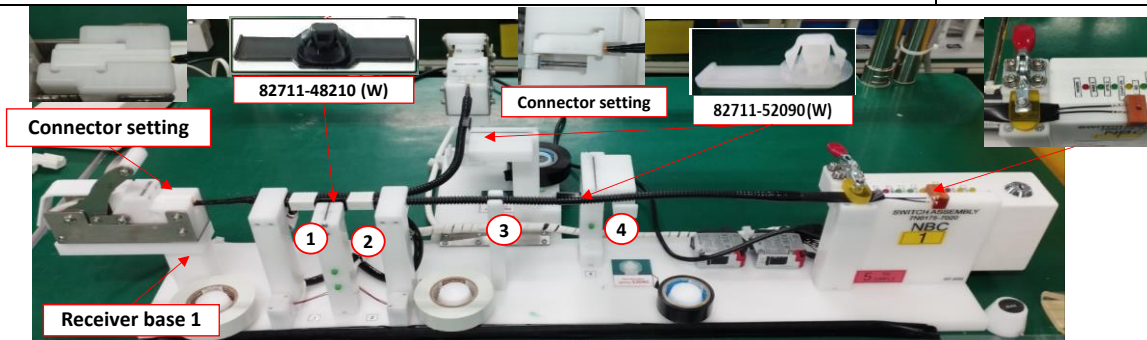
TOOLS/PPE

QUALITY POINTERS

4

n/a

Clamp Assembly

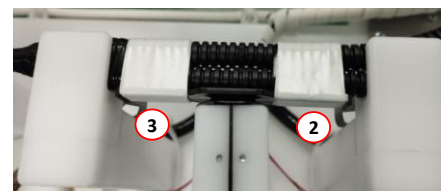


1. Get the assy parts and set into jig. *(See above picture for correct setting of harness).* First, set the connector 6098-3802 (W) to checker 1 then pull the checker fixture for continuity checking. Second, set the connector to checker 2 then pull the checker fixture for continuity checking, Last set the terminal into stopper jig then pull the toggle clamp using right hand.

2. Check all the LED light for Power ON, clamp ON, Wire 1 and Wire 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for the further instruction then continue the process. Continue if the sequence light in location 1 was ON.



3. Hold the tape on location 1 then start taping using both hands. Make 3 windings of tape and then cut the tape. Press the SW button after taping. Continue if the sequence light on location 2 was ON



4. Hold the White tape on location 2 then start taping using both hands. Make 3 windings of tape and then cut the tape. Press the SW button after taping. Continue if the sequence light on location 3 was ON

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

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PARTS:

1. Assy parts

JIG

1. Temporary Clamp assembly jig

NO.

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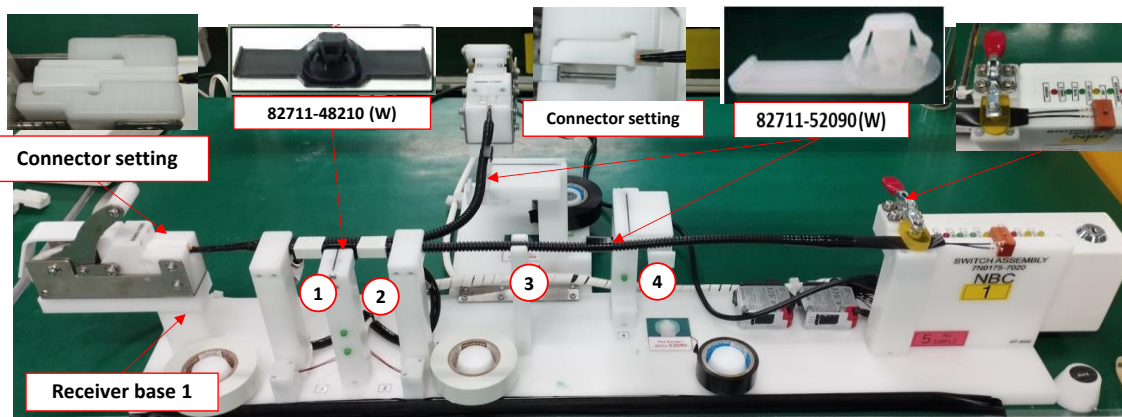
TOOLS/PPE

QUALITY POINTERS

4

n/a

Clamp Assembly
(Continuation)



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

6. Hold the tape on **location 4** then start taping using both hands. Make 3 windings of tape then cut the tape. Press SW button after taping.

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

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

n/a

Visual/By two's inspection



Assembled parts

Master sample

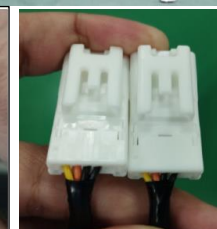
1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



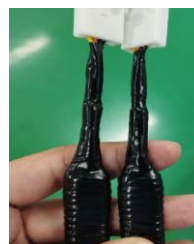
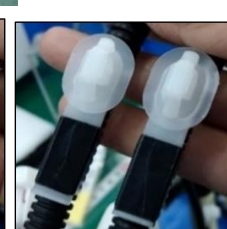
ACTUAL PRODUCT



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



3. Check the **presence of all clamp attachment, taping condition, color of tape condition.**



4. Check the **Y-Taping condition.**

1. No skip checking during inspection

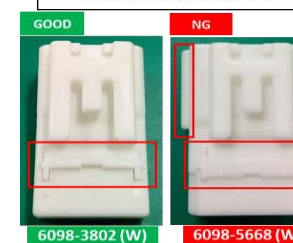
MASTER SAMPLE



CLAMP ILLUSTRATION



CONNECTOR ILLUSTRATION



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PARTS:

1. Assembled parts
2. Master sample

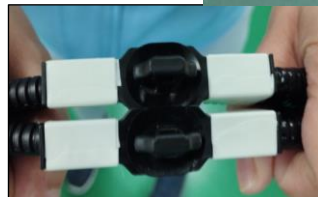
JIG

n/a

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

5

n/a

Visual/By two's inspection
(Continuation)**ACTUAL PRODUCT**

5. Check the **presence of clamp attachment, taping condition, color of tape** (Must be **white tape**). Conduct **slightly bending of parts with wing type-clamp**. Check the **inside spot taping**.

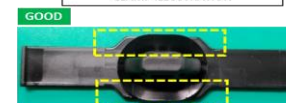


6. Check the **taping condition** of COT to sunprene tube. Conduct **slightly bending**.

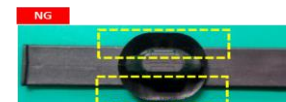


7. Check the terminal appearance

1. No skip checking during inspection

MASTER SAMPLE**CLAMP ILLUSTRATION**

82711-48210 (B)



82711-3F290 (B)

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PARTS:

n/a

JIG

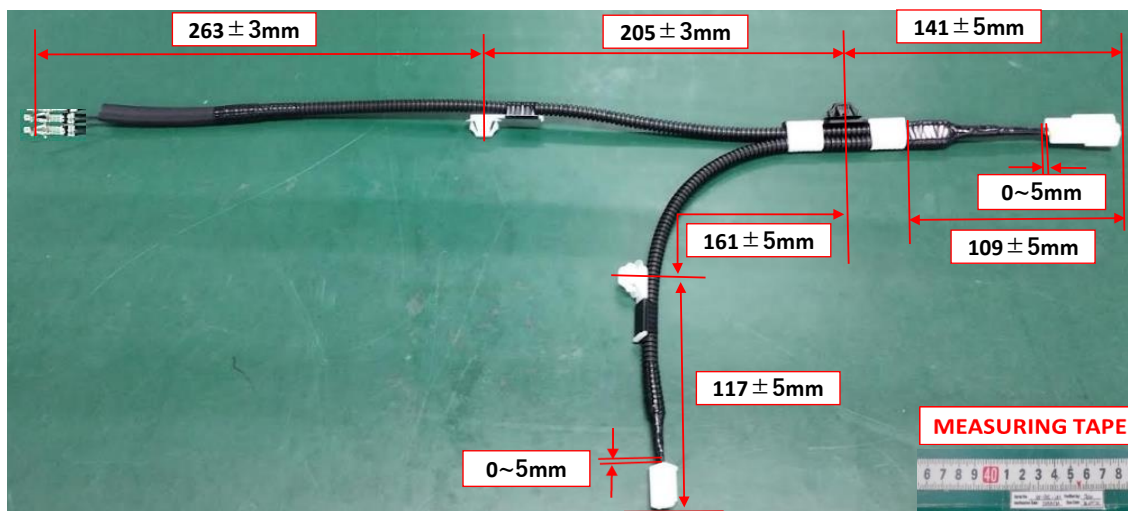
n/a

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

6

n/a

Measurement



1. No wrong dimension.

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

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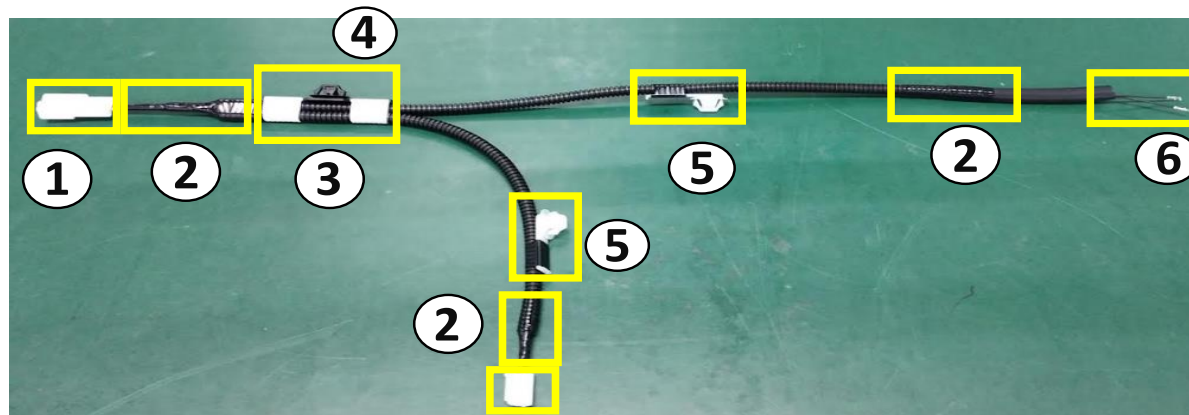
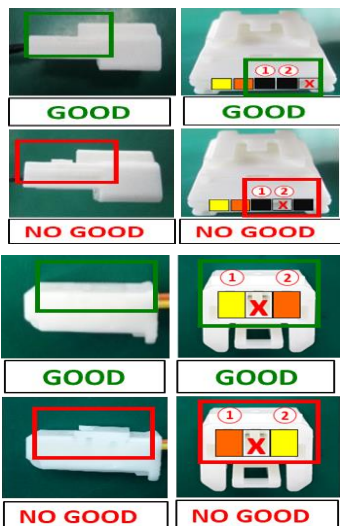
JIG

n/a

QUALITY CHECKPOINTS

n/a

7N0175-7020



**① No Unlock/
Halflocked Connector**
**No Wrong Insert (no wrong
slot)**

② No Missing Tape
**③ No Missing Clamp and
BENDING of 2 sides of
wing clamp**
**④ No wrong color of tape
(White tape)**

⑤ No Missing Common Clamp [2pcs]
⑥ No deformed terminal
⑦ Checking of clamp alignment.

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