

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 17, 2021

Product Name/Code:

780B / 1 7R0103-7021

Customer:

TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-206C

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. Assy parts
2. Clamp 82711-26380 (BR) [4pcs.]

JIG:

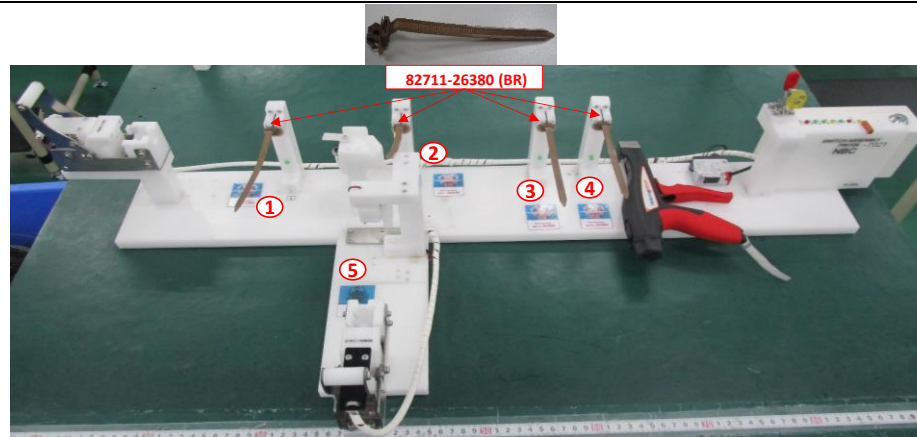
1. Clamp assembly jig

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

Clamp

P3

1
Clamp setting



1. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **1** using both hands.

2. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **2** using both hands.

3. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **3** using both hands.

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

4. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **4** using both hands.

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.

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

Prepared by

Reviewed by

Approved by

Noted by

04/17/21

1

Change part number from 7R0103-7020B to 7R0103-7021. Apply some improvements in every process.

D. Castillo

C. Villanueva

A. Shimamura

A. Arañes

12/07/20

0

Initial issue

D. Castillo

R. Peñaloza

A. Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Checked

Approved

Noted

Est. Date:

December 07, 2020

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DCC Stamp



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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts
2. Clamp 82711-16830 (B)

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

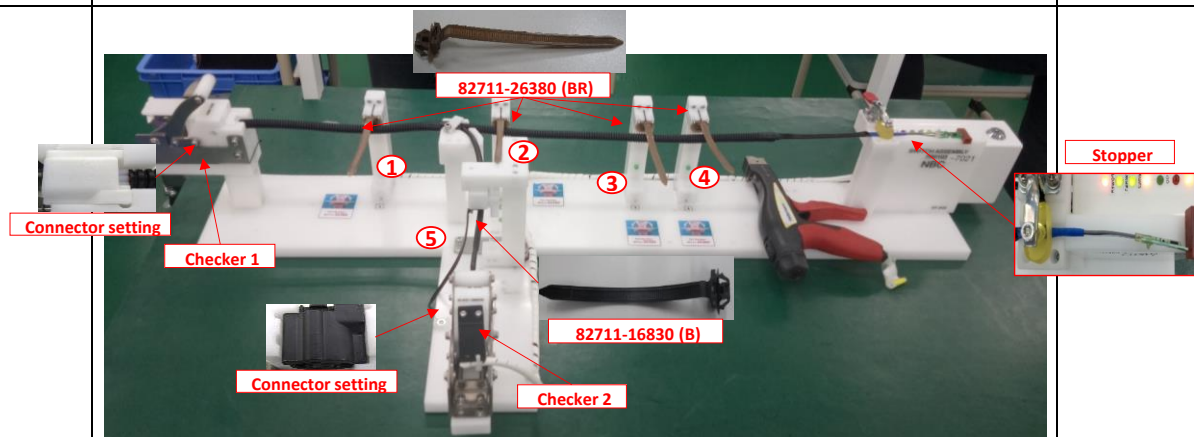
TOOLS/PPE

QUALITY POINTERS

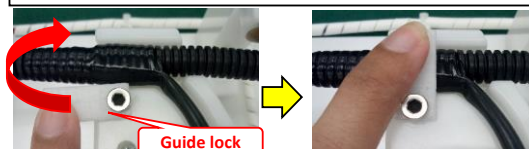
1

P3

1
Clamp setting
(Continuation)



5. Hold the assy parts and then set to jig. *(See above picture for correct setting).* First, set the connector **6189-1142 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. *(See below illustration for Y-Taping lock.)* Second, set the **PCB** to stopper jig and push down the toggle clamp. Last, set the connector **6189-1161 (B)** to **Checker 2** then push the checker fixture for continuity checking.



6. Using left index finger, push the guide lock to lock the Y-taping portion.

7. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **5** using both hands.

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

n/a

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

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JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

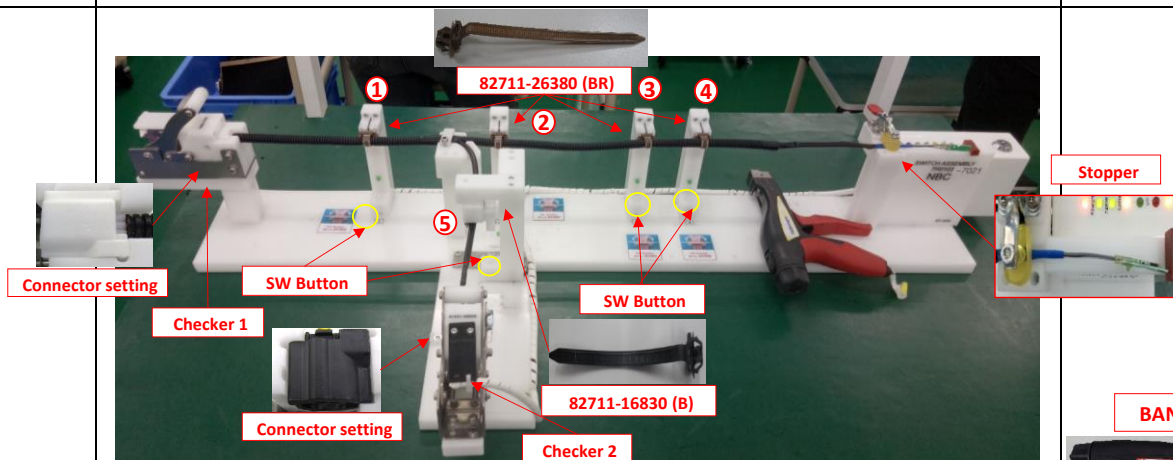
TOOLS/PPE

QUALITY POINTERS

2

P3

1
Clamp assembly

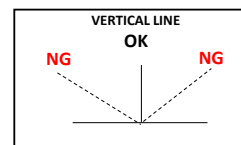


1. Initially tighten the band clamp on clamp location **1, 2, 3, 4, and 5** using both hands.

2. Get the Bando Gun using right hand and cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was **ON**.

3. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was **ON**.

4. Cut the band clamp on clamp location **3** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **4** was **ON**.



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5$ - 1~2, $\phi 7$ - 3~4



BANDO GUN



Note: Make sure no clearance between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

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1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

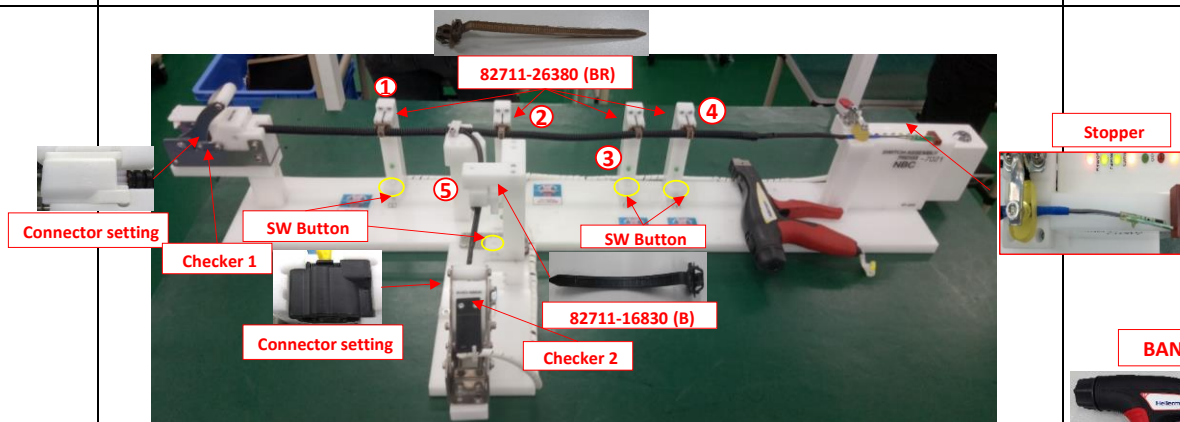
TOOLS/PPE

QUALITY POINTERS

2

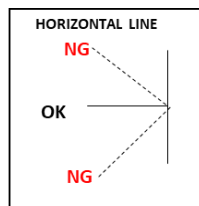
P3

1
Clamp assembly
(Continuation)



5. Cut the band clamp on clamp location 4 using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location 5 was **ON**.

6. Cut the band clamp on clamp location 5 using both hands. (See below illustration). Press the **SW button** after cutting of band clamp. **Go** sound will be heard.



BAND CLAMP CUT POSITION FOR 82711-16830 (B)



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$

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



Note: Make sure no clearance between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

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n/a

JIG

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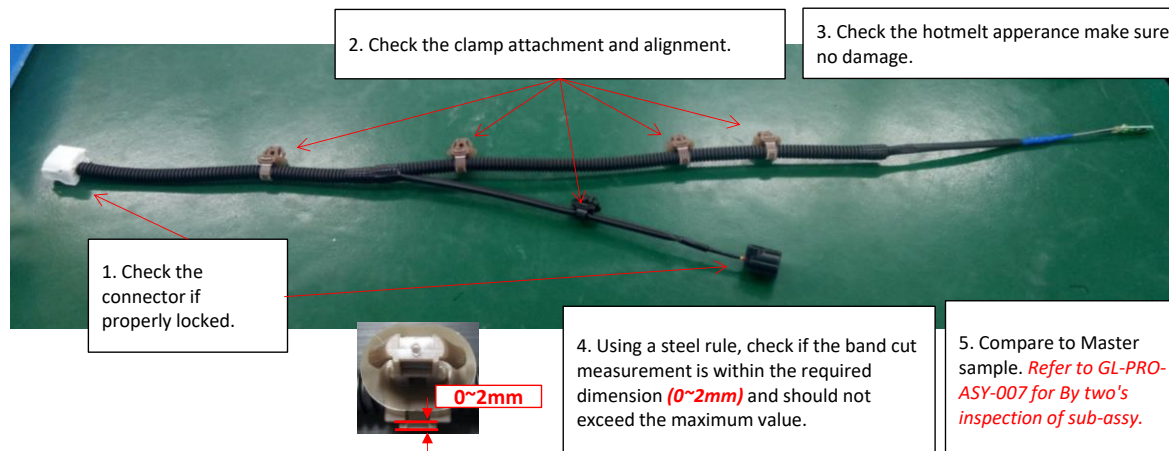
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Visual/By two's inspection



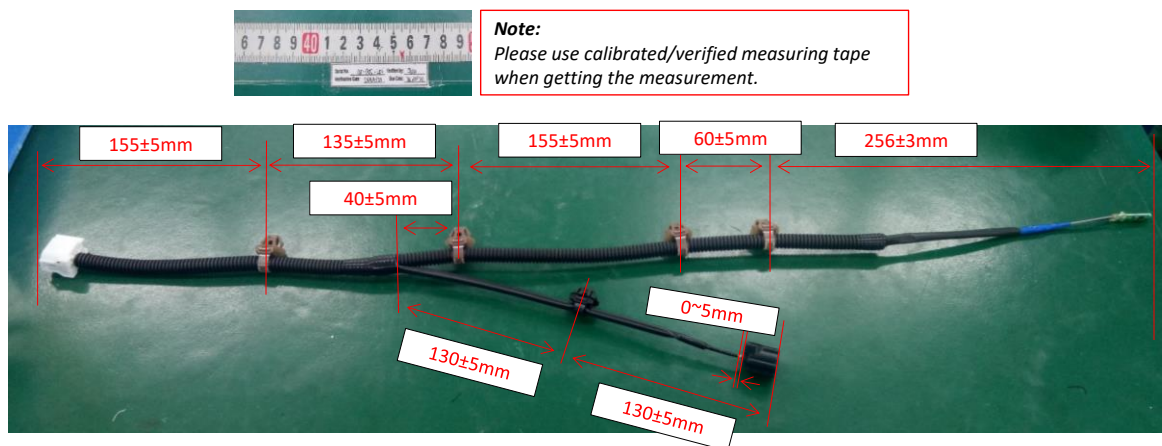
MASTER SAMPLE



P3

4

Measurement



NOTE: For HATSUMONO AND OWARIMONO

1. No wrong dimension

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