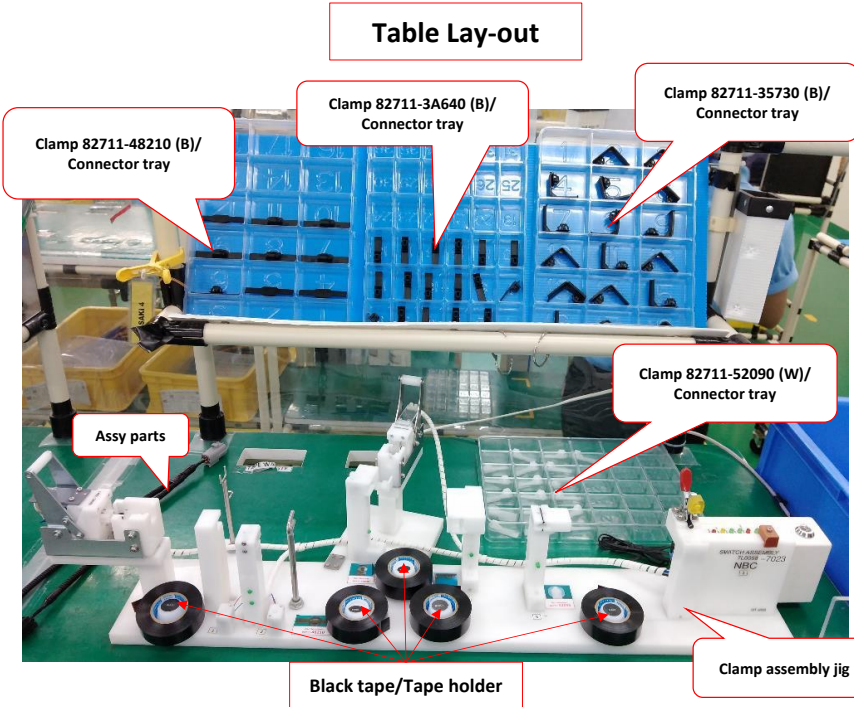




	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		March 10, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: 150B / 7L0058-7024		Customer: TRQSS		Document No.:		WI-ENG-PDE-400D	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 7

PARTS:		1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (b); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [5pcs.]		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P4	<p>Table Lay-out</p> 		<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by					
03/10/23	1	Inclusion of quality checkpoints. Improve quality pointers						M. Catapang	J. Loterte	C. Villanueva	A. Arañes								
02/12/22	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 12, 2022					

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PARTS:

1. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

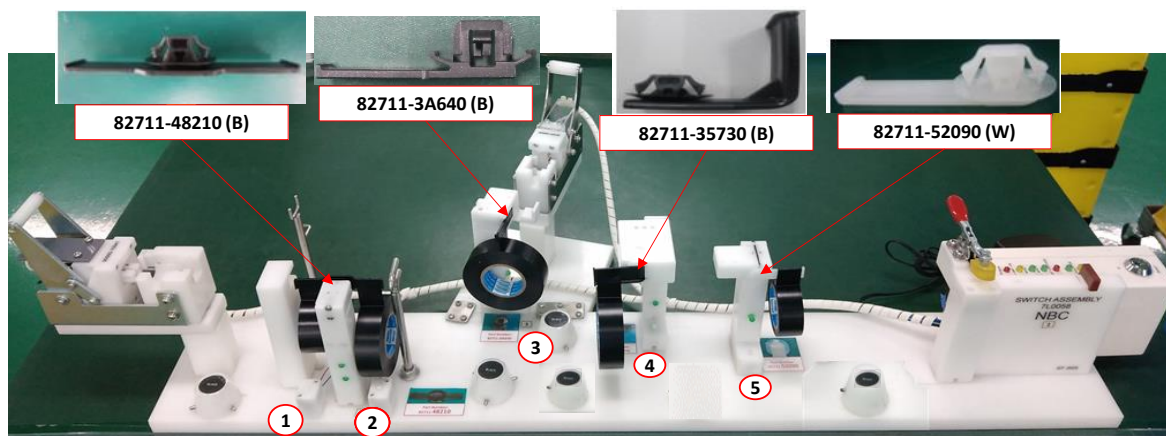
TOOLS/PPE

1 QUALITY POINTERS

2

P4

Clamp setting



Important reminders/Note/s:

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

1. Get 1 pc. of clamp **82711-48210 (B)** using right hand then insert to clamp location **1 and 2** using both hands.

2. Get 1 pc. of clamp **82711-3A640 (B)** using right hand then insert to clamp location **3** using both hands.

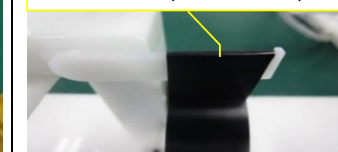
3. Get 1 pc. of clamp **82711-35730 (B)** using right hand then insert to clamp location **4** using both hands.

4. Get 1 pc of clamp **82711-52090 (W)** using right hand then insert to clamp location **5** using both hands.

5. Get the **Black tape** then initially attach to clamp location **1, 2, 3, 4 and 5** using both hands.

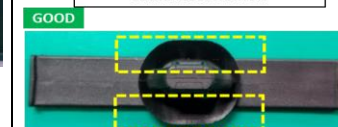
STANDARD TAPING FOR CLAMP

One side tape under clamp



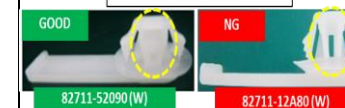
1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

CLAMP ILLUSTRATION



82711-48210 (B)

CLAMP ILLUSTRATION



82711-52090 (W)

82711-12A80 (W)

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

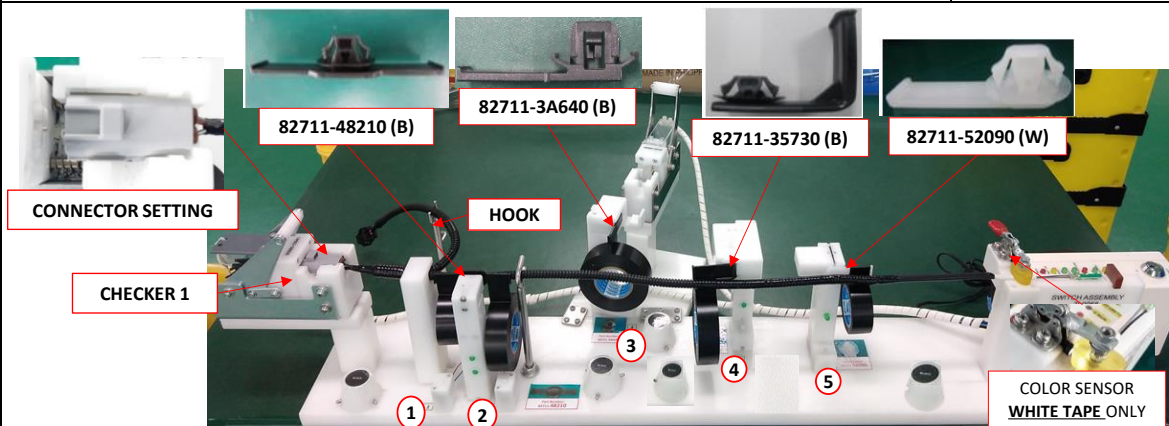
TOOLS/PPE

1 QUALITY POINTERS

3

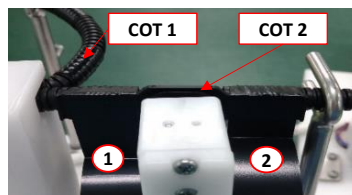
P4

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, put the assy parts with black connector 6189-1161 (B) into **HOOK**. Continue to set the harness in jig. Last, set the PCB within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON**.

2. 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.



3. On clamp location **1**, make **2 windings** of tape using both hands. Repeat the process on clamp location **2**.

Note: DO NOT CUT THE TAPE.



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. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

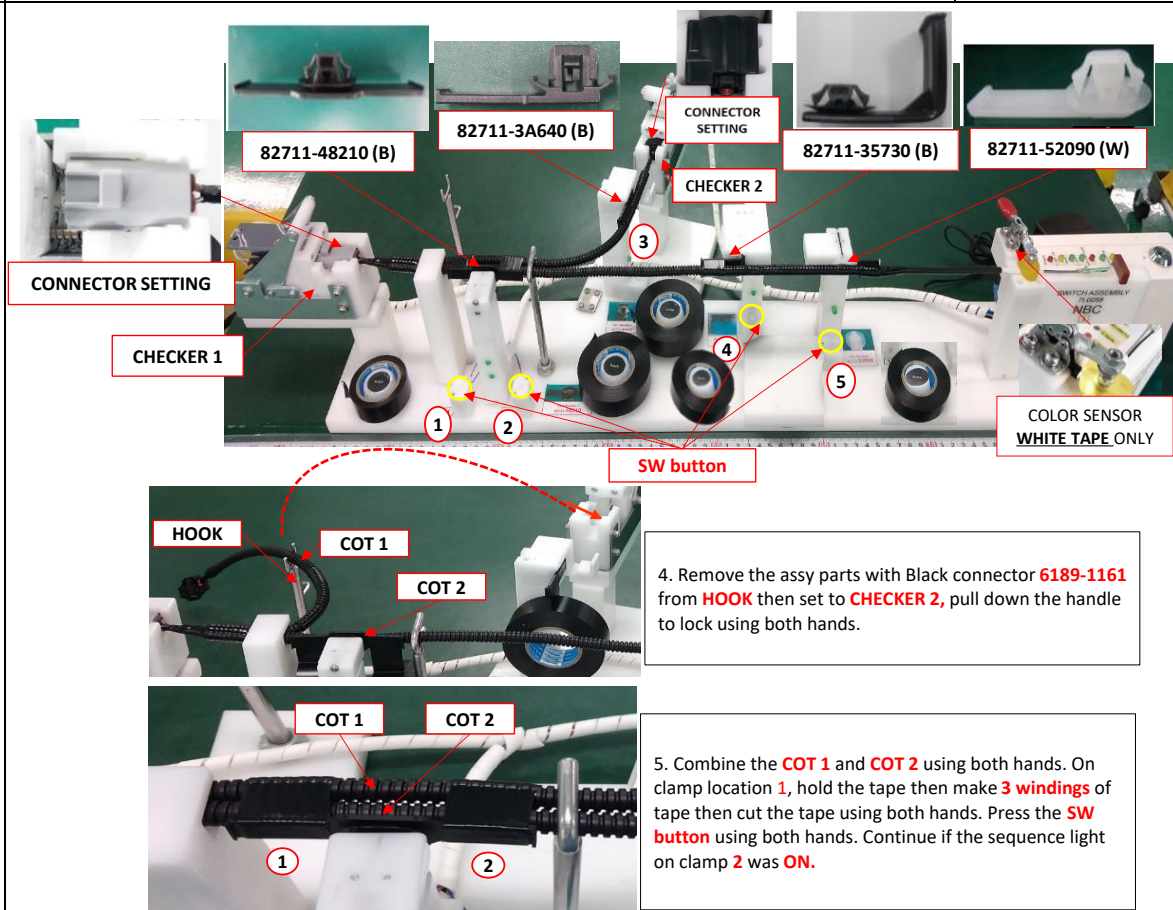
TOOLS/PPE

1 QUALITY POINTERS

3

P4

Clamp assembly
(Continuation)



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. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

3

P4

Clamp assembly
(Continuation)

82711-48210 (B)

82711-3A640 (B)

CONNECTOR SETTING

CHECKER 2

82711-35730 (B)

82711-52090 (W)

CHECKER 1

COLOR SENSOR
WHITE TAPE ONLY

COT 1

COT 2

SW button

6. On clamp location 2, hold the tape then make 3 windings of tape then cut the tape using both hands. Press the SW button using both hands. Continue if the sequence light on clamp 3 was ON.

7. 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 on clamp location 4 was ON.

8. 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 on clamp location 5 was ON.

9. 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.

10. 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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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Visual/By two's inspection

1. Check the connector lock.

2. Check the Y-taping, spot taping and clamp attachment condition.

3. Conduct bending of clamp with 2 sides taping.

GOOD**NG**

4. Check the alignment of COT, spot taping on two sides taping and half-wrap taping.

5. Compare to Master sample. *Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.***MASTER SAMPLE**

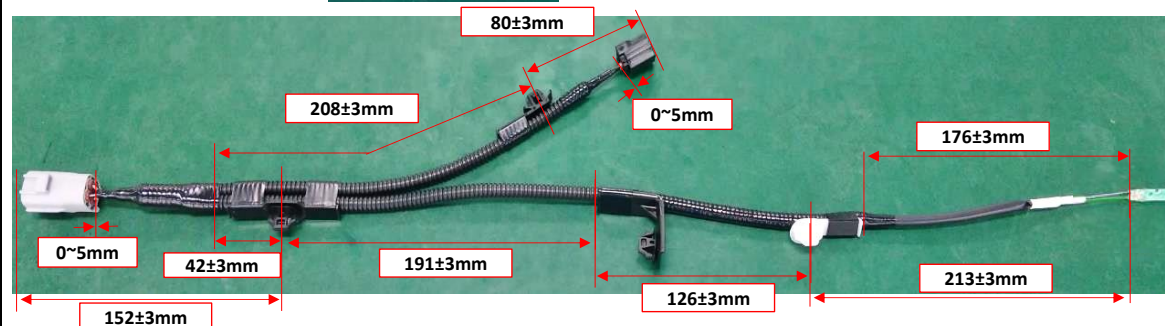
P4

5

Measurement

MEASURING TAPE**Note:**

Please use calibrated/verified measuring tape when getting the measurement.

**NOTE: FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS

P4

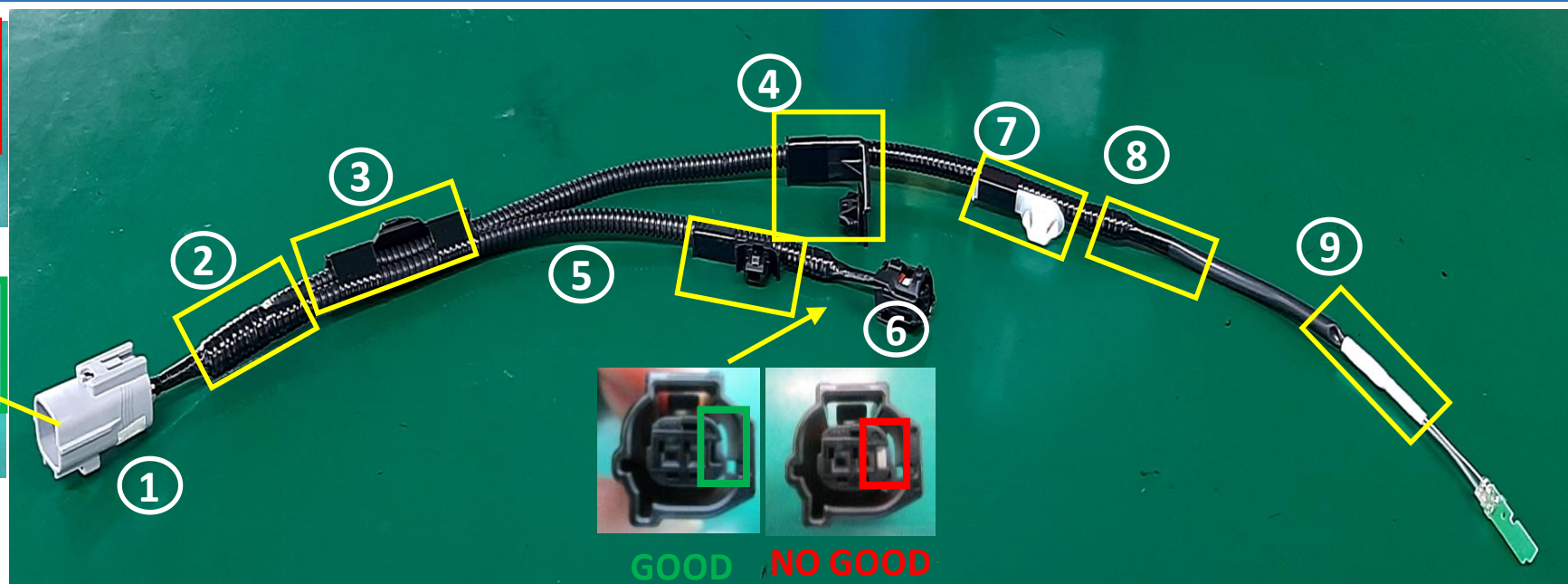
7L0058-7024



NO GOOD



GOOD



① ⑥ No **UNLOCKED/HALFLOCKED CONNECTOR**

② ⑧ ⑨ No **MISSING TAPE**

③ ④ ⑤ ⑦ No **MISSING CLAMP**

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