


	<b>WORK INSTRUCTION</b>				Effectivity Date:		March 1, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		-	
	Process Name/Title:		Product Name/Code: <b>D01L / 7M0646-7020A</b>		Customer: <b>TRJ</b>		Document No.: <b>WI-ENG-PDE-070B</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.: 1 of 3

PARTS:	△ 5	1. Clamp 82711-52070 (W) [2pcs]	△ 6	JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2  △  Clamp Assembly Setting	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>1. Get the two band clamp 82711-52070 using right hand then attach to location 1 and 2 using both hands.  <i>Note: Please check the clamp first before start of assembly to avoid wrong use of clamp.</i></p> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. No wrong use of clamp 2. No wrong clamp position</p>

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
03/01/21	5	Remove cycle time; Change clamp colors in accordance with color standardization for plastic parts (Please refer to GL-COM-003); Put assy parts on pg. 2 parts section Add measuring tape illustration and instruction on measurement process	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes									
08/01/20	4	Update the effective and validity date; Update cycle time; Improve some process on Page 2.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes									
01/31/20	3	Changed process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-037B to WI-ENG-PDE-070B. Add cycle time per process.	M. Catapang	J. Loterte	A. Shimamura	n/a									
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date: June 23, 2018								

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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Product Name/Code: D01L / 7M0646-7020A

Customer: TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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## PARTS:

5

1. Purple tape
2. Assy parts

## JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

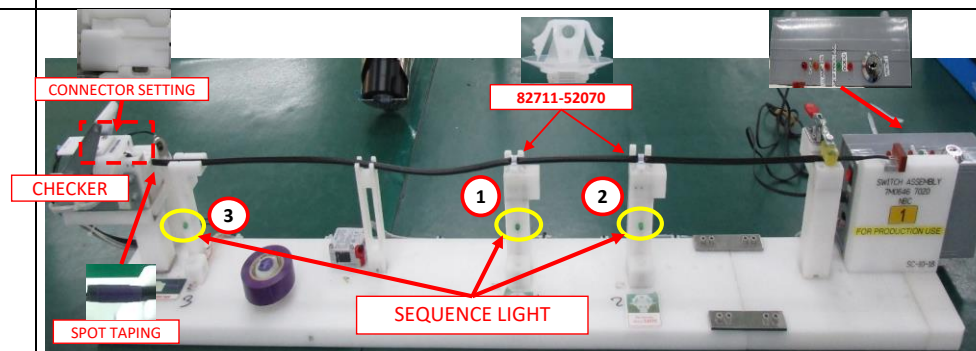
TOOLS/PPE

QUALITY POINTERS

2

P1

Clamp Assembly

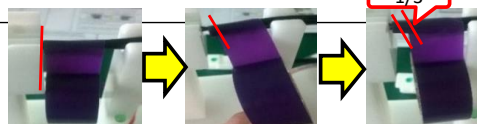


1. Get the assy parts and set to jig using both hands. Put the connector to Checker then lock, set the wires within the stoper and press the toggle clamp. Continue if the sequence light of location 1 was on.

3. Initially tighten the band clamp on location ① ② using right hand.

4. Get the bando gun using right hand then cut the band clamp location. Press the SW button after cutting the 2 band clamp ① ②.

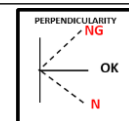
5. Get **Purple Tape** using right hand and start the spot taping on location ③ **25mm**. Wind the tape **2 times** before shifting. Make **1/3 shifting** and then wind the tape **3 times** then cut the tape. Press the SW button after taping. (go sound will be heard)



2. Check if all LED light for Power and wires are **ON**. If encountered abnormality, **STOP** the process, **CALL** the immediate superior and **WAIT** for instructions.



BANDO GUN ALIGNMENT



Fixed setting of band clamp cutter: 3~4

6. **CONDUCT POINT CHECKING** before removing from jig.

BANDO GUN



Terminal stopper jig



*Note: Make sure no gap between stopper jig and terminals.*

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp

**NOTE:**  
**GO buzzer will be heard once the tape color is detected by the Color sensor.**

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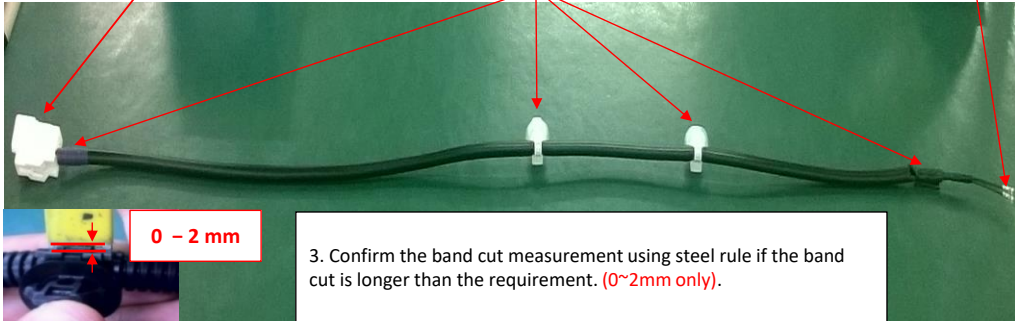



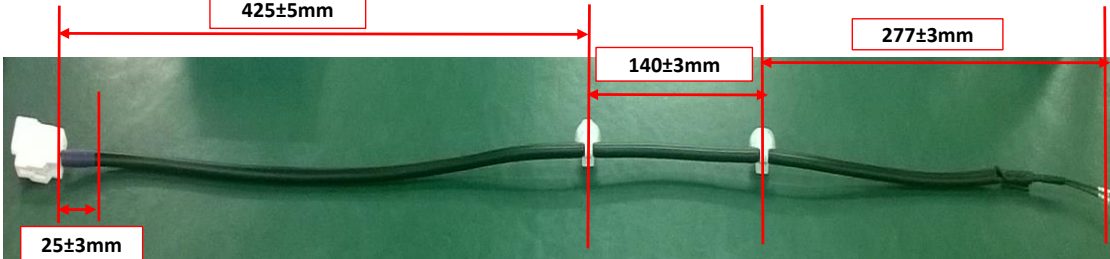
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PARTS:	N/A			JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Visual/By Two's Inspection	<div>1. Check the connector lock.</div> <div>2. Check the taping condition, clamp attachment and alignment.</div> <div>4. Check the terminal appearance.</div> <div><div>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div><div><div>0 - 2 mm</div><div>3. Confirm the band cut measurement using steel rule if the band cut is longer than the requirement. (0~2mm only).</div></div></div>			<div>MASTER SAMPLE</div> <div></div>
		P2			
4	Measurement	<div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div><div>425±5mm</div><div>140±3mm</div><div>277±3mm</div><div>25±3mm</div></div>			<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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