



# WORK INSTRUCTION CLAMP ASSEMBLY PROCESS

|                   |                |
|-------------------|----------------|
| Effectivity Date: | April 4, 2023  |
| Validity Date:    | n/a            |
| Document No.:     | WI-ENG-PDE-663 |
| Revision No.:     | 1              |
| Page No.:         | 1 of 8         |

|                     |                                                                                                                    |                      |
|---------------------|--------------------------------------------------------------------------------------------------------------------|----------------------|
| Process Name/Title: | Model Code/Product Number: <b>895B / 7N0092-7020</b>                                                               | Customer: <b>TRJ</b> |
| Purpose:            | <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |                      |

|        |                                                                             |     |                       |
|--------|-----------------------------------------------------------------------------|-----|-----------------------|
| PARTS: | 1. Assy part; Clamp 82711-52090(W); Clamp 82711-48210(B); Black tape [4pcs] | JIG | 1. Clamp Assembly jig |
|--------|-----------------------------------------------------------------------------|-----|-----------------------|

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE                                                                                                                                                                                                                                                                                                                                                                                                                             | QUALITY POINTERS                                                                                                                                                                                                             |
|-----|--------------|------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1   | n/a          | Table Lay-out                | <p><b>Safety Instruction</b><br/>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b><br/>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b><br/>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> | <p>1. No missing parts/ tools.<br/>2. No excess part/ tools.</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-52090(W) 82711-12A80(W)</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-48210(B) 82711-3I290(B)</p> |

| Revision History |        |                                                                                                                                                             |          | Prepared by | Reviewed by  | Approved by | Noted by       |
|------------------|--------|-------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|-------------|--------------|-------------|----------------|
| 04/04/23         | 1      | Change document control no. from "WI-ENG-PDE-550D to WI-ENG-PDE-663" due to separation of process from "TAPING ASSEMBLY PROCESS to CLAMP ASSEMBLY PROCESS". | M.Ariola | J. Loterte  | C.Villanueva | A.Arañes    |                |
| 03/30/22         | 0      | Initial Issue.<br>Change from 3MP to 4MP; Excluded from P3 due to new process distribution                                                                  | M.Ariola | J. Loterte  | C.Villanueva | A.Arañes    |                |
| Eff.Date         | Rev.No | Details of Change                                                                                                                                           | Revised  | Reviewed    | Approved     | Noted       | Est. Date:     |
|                  |        |                                                                                                                                                             |          |             |              |             | March 30, 2023 |

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## WORK INSTRUCTION

Process Name/Title:



## CLAMP ASSEMBLY PROCESS

Model Code/Product Number:

895B

/

7N0092-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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## PARTS:

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

3. Black tape [4pcs.]

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

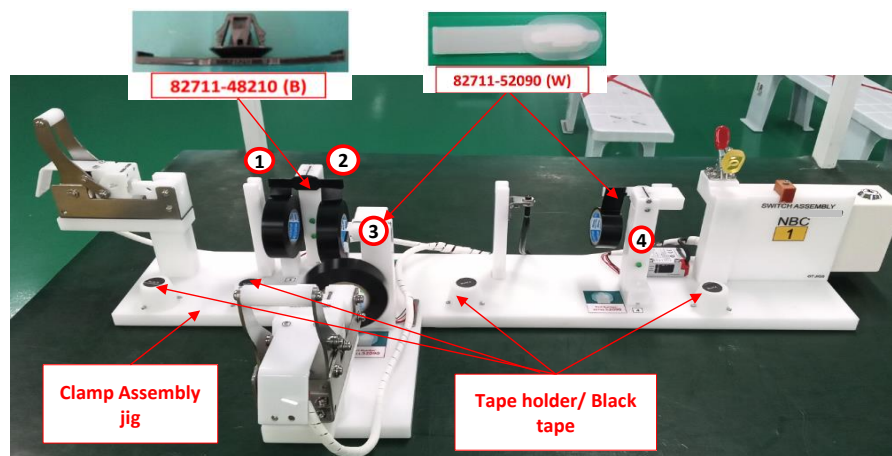
## TOOLS/PPE

## QUALITY POINTERS

2

n/a

Clamp Setting



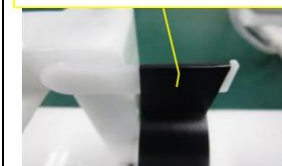
1. Get **1pc.** of clamp **82711-48210 (B)** using right hand then set to clamp location **1 and 2** using both hands.

2. Get **2 pcs.** of clamp **82711-52090 (W)** using right hand then set to clamp location **3 and 4** using both hands.

3. Initially attach **BLACK TAPE** to location **1, 2, 3 and 4** using both hands

## STANDARD TAPING FOR CLAMP

One side tape under clamp

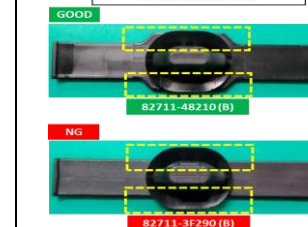


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

## CLAMP ILLUSTRATION



## CLAMP ILLUSTRATION



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## PARTS:

1. Assy parts
2. Black tape [4pcs]

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

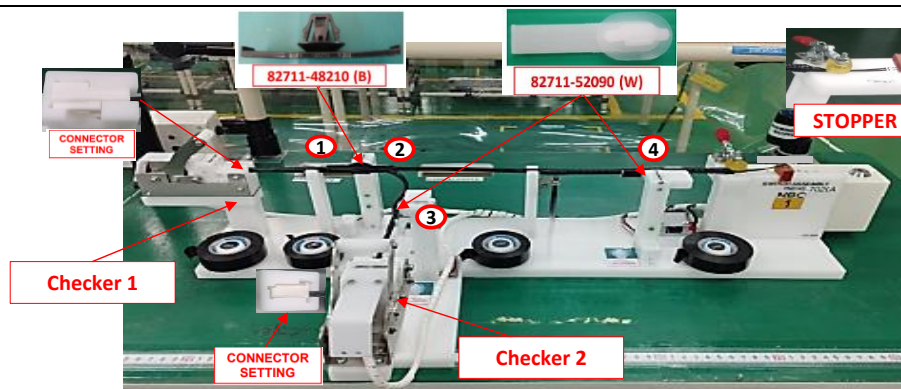
## TOOLS/PPE

## QUALITY POINTERS

3

n/a

Clamp Assembly



1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Checker 1. Then, set the connector 6098-2220 (W) to Checker 2 Continue to set the harness in jig. Last, set the end of B-B wire together within the stopper then press by Toggle clamp.

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

3. Combine the Vinyl 1 and Vinyl 2 using both hands. On clamp location 1 and 2, hold the tape then make 3 windings of tape then cut the tape. Press the SW button using both hands. Continue if the sequence light on clamp Location 3 was ON.

n/a

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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## WORK INSTRUCTION

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1

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## PARTS:

1. Assy parts
2. Black tape [4pcs]

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

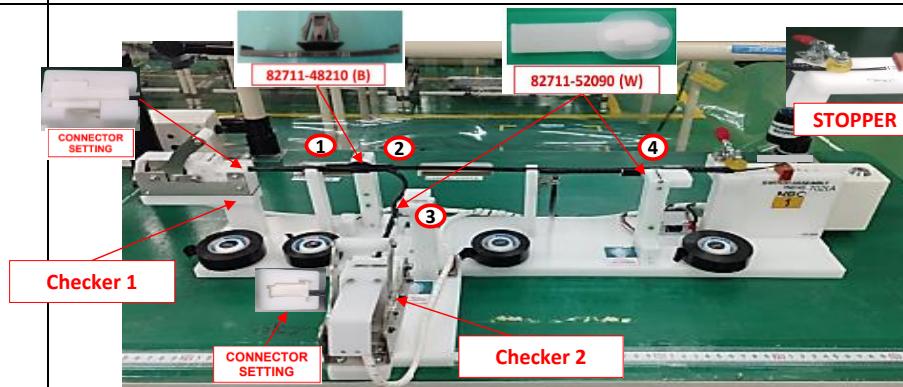
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

3

n/a

Clamp Assembly  
(Continuation)

4. On clamp location **3**, hold the tape then start taping using both hands. Make **3** windings of tape then cut the tape. Press the **SW button** after taping. Proceed to location **4** after taping.

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

6. After taping, conduct **POINT CHECKING** before removing the harness from jig.

n/a

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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## PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

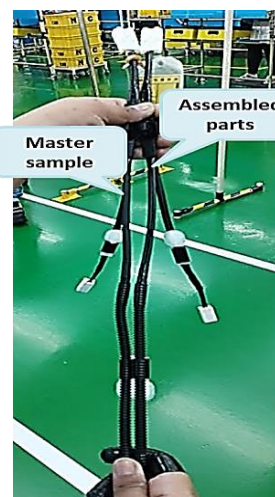
QUALITY POINTERS

4

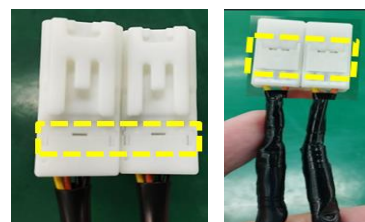
n/a

Visual/By two's  
Inspection

ACTUAL PRODUCT



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



1. Check the **connector lock, wire insertion** and **taping condition**.



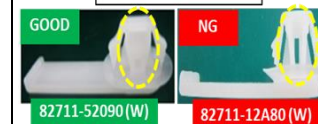
2. Check the **presence of wing type clamp** and **taping condition**. Conduct **bending of clamp** with 2 sides taping.

## MASTER SAMPLE

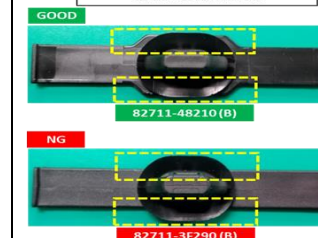


1. No skip checking during inspection.

## CLAMP ILLUSTRATION



## CLAMP ILLUSTRATION



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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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## PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

n/a

Visual/By two's  
Inspection  
(continuation)

3. Check the **presence of clamp attachment** and the **taping condition**.



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



5. Check the **taping condition** and **terminal appearance**. Must be **no deformed terminal**.

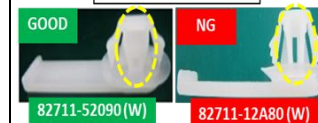
n/a

## MASTER SAMPLE

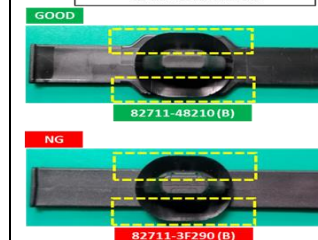


1. No skip checking during inspection.

## CLAMP ILLUSTRATION



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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

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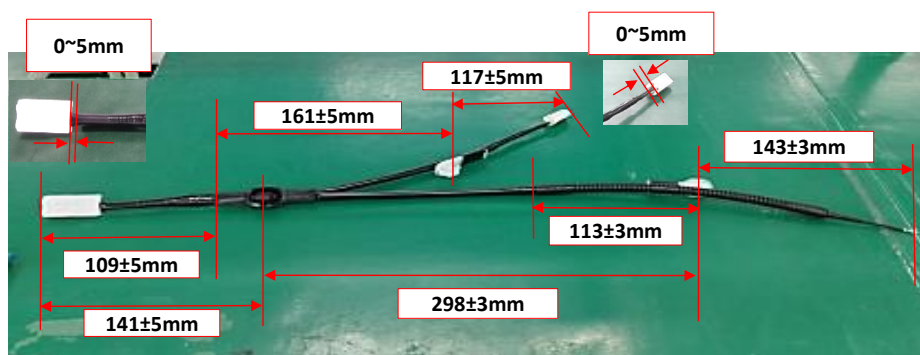
TOOLS/PPE

QUALITY POINTERS

5

n/a

Measurement



MEASURING TAPE



1. No wrong Dimension

**Important reminders/Note/s:****1. For Hatsumono and owarimono.****2. Please use calibrated/verified measuring tape when getting the measurement.**

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|        |     |     |     |
|--------|-----|-----|-----|
| PARTS: | n/a | JIG | n/a |
|--------|-----|-----|-----|

### QUALITY CHECKPOINTS

**Clamp Assembly**

**7N0092-7020**

**1**  
  
**GOOD**

**NO GOOD**

**1 2** No **Unlock/Halflocked** Connector

**3 4** No **Wrong Insert**

**5 6 7 8** No **Missing Tape**

**9 10 11** No **Missing Clamp**

**12** No **Deformed Terminal**

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