

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 8, 2021

Product Name/Code:

096D / 7L0119-7020

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-242C

Revision No.:

1

Page No.:

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PARTS:

1. Clamp 82711-48070 (GR)
2. Clamp 82711-52090 (W) [2pcs]
3. Clamp 82711-3A540 (W)

4. Clamp 82711-33380 (B)
5. Black tape [6pcs]

JIG:

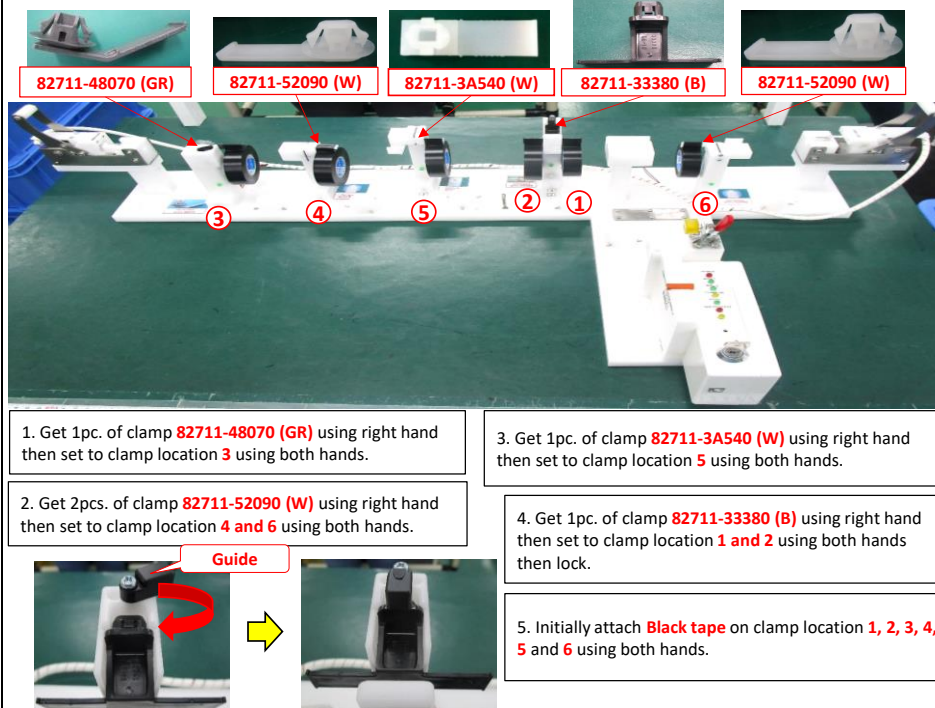
1. Clamp assembly jig

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

1

P3

Clamp Setting

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

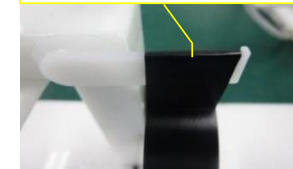
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

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

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/08/21	1	Change purpose from Pre-launch to Mass pro; Added Black tape on part section	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
02/27/21	0	Initial issue	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes

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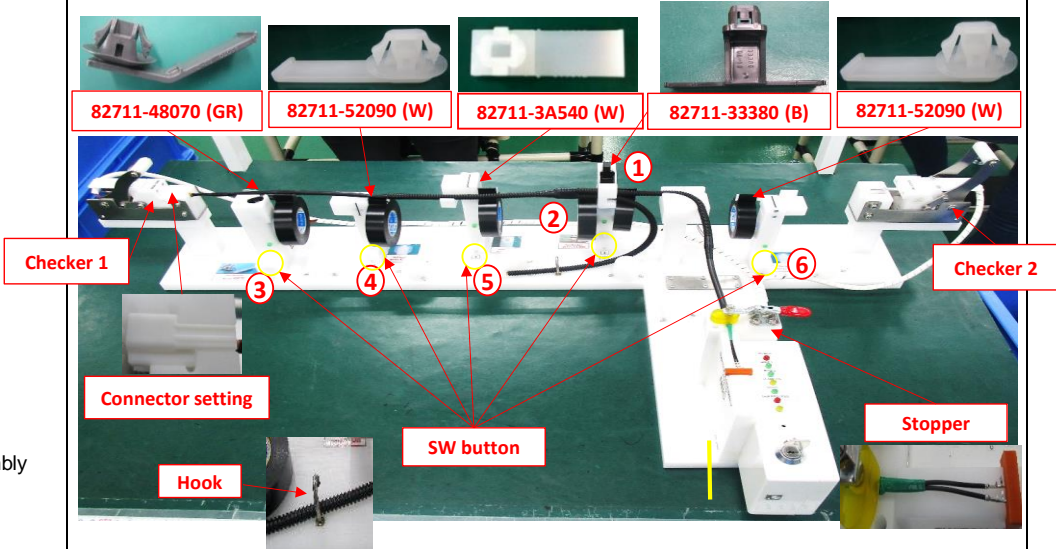
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PARTS:	1. Assy parts			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp Assembly		n/a	<div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>
		<div></div> <div>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6098-3802 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then press by Toggle clamp. Initially put the other side of harness (COT with connector 6098-2220 (W)) in Hook. Check if the sequence light of location 1 and 2 was on.</div> <div>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.</div>			

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1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

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QUALITY POINTERS

2

P3

Clamp Assembly
(Continuation)

3. Hold the tape on clamp location **1**, make **2 windings** of tape on **COT 1** using both hands and do not cut the tape.

4. Remove COT 2 on hook and place under COT 1 then set connector **6098-2220 (W)** pull the checker fixture for continuity checking. *(See illustration.)*

5. Hold the tape on clamp location **1**, make **3 windings** of tape on combined **COT 1 and COT 2** then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **2** was on.

6. Hold the tape on clamp location **2**, 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 **3** was on.

n/a

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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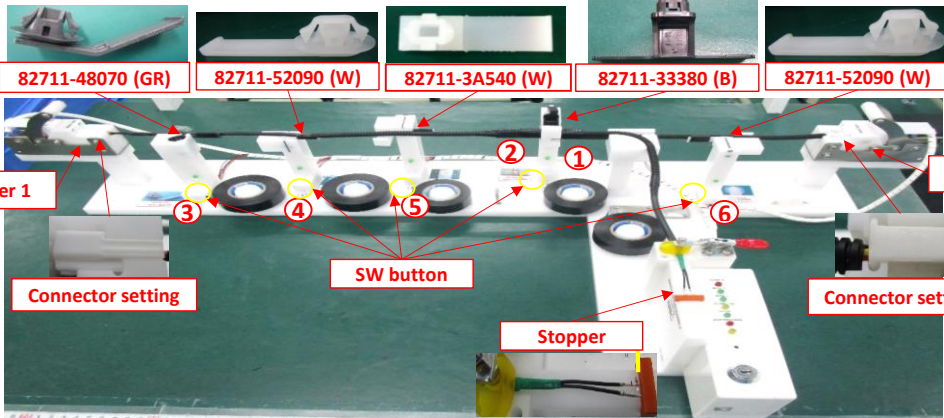

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2	P3	<div><div><div>82711-48070 (GR)</div><div>82711-52090 (W)</div><div>82711-3A540 (W)</div><div>82711-33380 (B)</div><div>82711-52090 (W)</div></div><div><div>Checker 1</div><div>3</div><div>4</div><div>5</div><div>2</div><div>1</div><div>6</div><div>Checker 2</div><div>Connector setting</div><div>SW button</div><div>Stopper</div><div>Connector setting</div></div></div> <div><div><div>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 in clamp location 4 was on.</div><div>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 in clamp location 5 was on.</div><div>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. Continue the process if sequence light in clamp location 6 was on.</div><div>10. Hold the tape on clamp location 6. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</div><div>11. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div></div></div> <div>n/a</div> <div><div><p>Note: Make sure no gap between stopper jig and terminals.</p></div><div><div>1. No wrong use of parts</div><div>2. No wrong use of tape</div><div>3. No damaged clamp</div><div>4. No wrong clamp position</div></div></div>			

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n/a

JIG

n/a

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QUALITY POINTERS

3

Visual/By Two's Inspection

P3

2. Check the clamp attachment and taping condition.

3. Check the terminal appearance. Make sure no deformed terminal.

4. Check the Y-taping condition.

1. Check the connector lock.

5. Compare to Master Sample

Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

MASTER SAMPLE



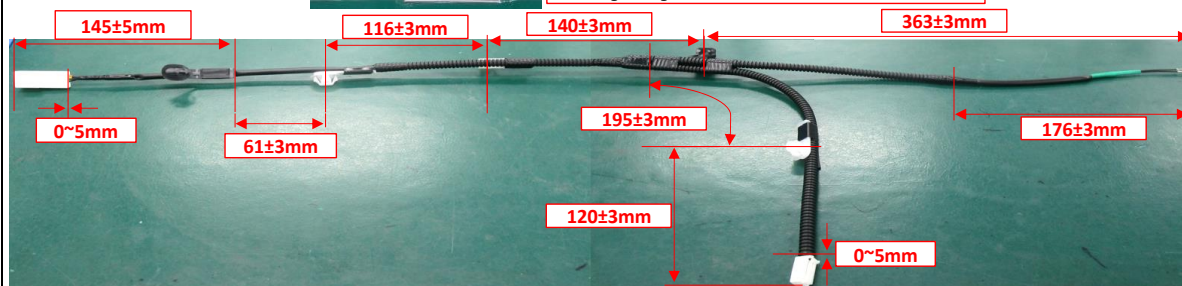
4

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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