

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/ Product Number: **780B / 7R0104-7023A** Customer: **TRMX**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

**January 19, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-557D**

Revision No.:

**3**

Page No.:

**1 of 11****PARTS:**

1. Assy Parts; Clamp 82711-26380 (BR); Clamp 82711-16830 (B); Label 7V4030-0020

JIG:

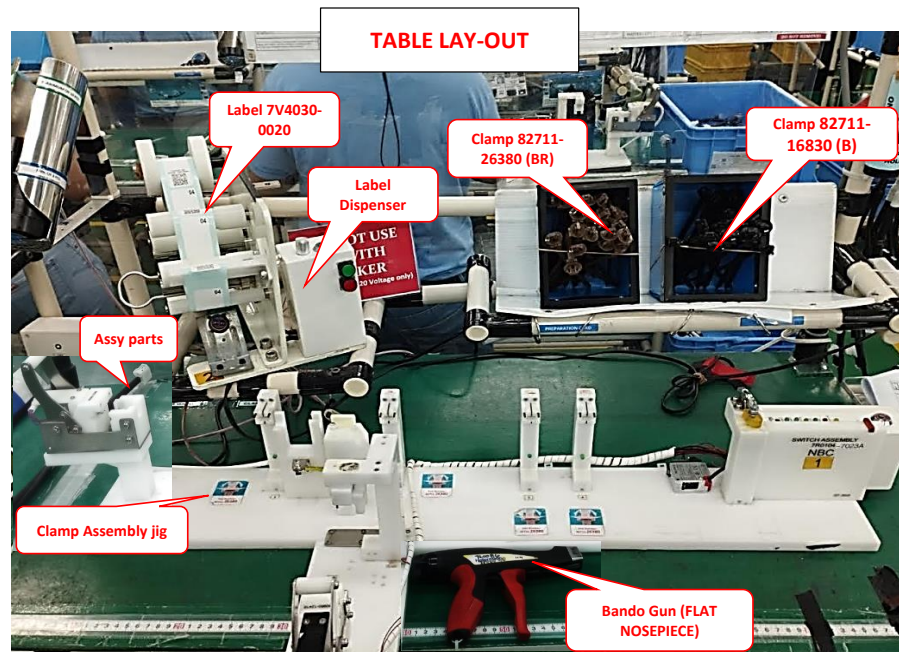
1. Clamp assembly jig
2. Label dispenser

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

1

P4

Table Lay-out

**Safety Instruction**

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

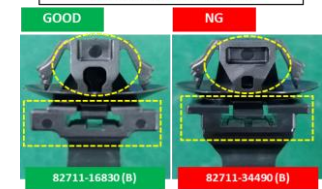
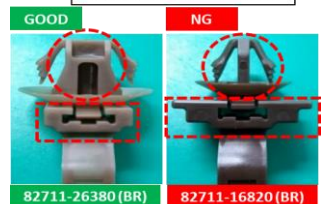
**Housekeeping**

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 missing parts/tools
2. No excess parts/tools

**BAND CLAMP ILLUSTRATION****BAND CLAMP ILLUSTRATION**

01/19/23 3 Inclusion of Quality Checkpoints.

M. Ariola J. Loterte C. Villanueva A. Arañes

11/10/22 2 Improve work procedure/illustration on process no.6-Visual/by two's inspection; Improve Quality pointers; Reminders/Notes and references on page no.1,2,3,4,5,8,9 and 10 due to process improvement.

M. Ariola J. Loterte C. Villanueva A. Arañes

07/22/22 1 Change from Pre-launch to Masspro.Changed table lay-out.

M. Ariola J. Loterte C. Villanueva A. Arañes

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Prepared by

Reviewed by

Approved by

Noted by

Est. Date:

December 04, 2020

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

2 of 11

**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
2	P4	Clamp setting	<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<ol style="list-style-type: none"><li>1. No wrong use of clamp</li><li>2. No damaged clamp</li><li>2. No wrong use of tape</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.</li></ol> <div><b>BAND CLAMP ILLUSTRATION</b></div> <div><div>GOOD</div><div>82711-26380 (BR)</div><div>NG</div><div>82711-16820 (BR)</div></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

3 of 11

### PARTS:

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

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

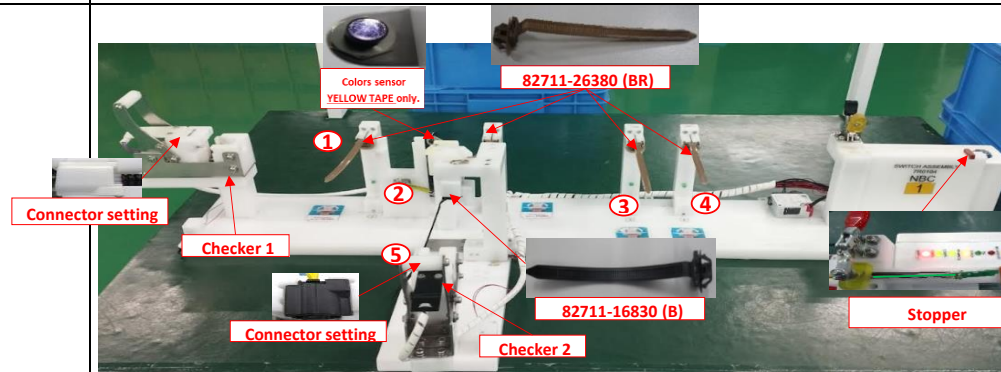
### TOOLS/PPE

### QUALITY POINTERS

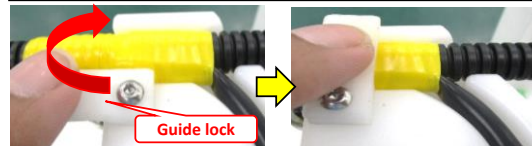
3

P4

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. **Color sensor** light will be beep/buzz if sensor detects **Yellow tape**. (*See below illustration for Y-Taping lock.*) Second, set the **PCB** and **B-B wires** 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**, **Sensor ON** was On. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

n/a

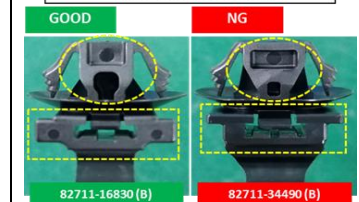
1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

#### Important reminders/Note/s:

1. Make sure no gap between the PCB and stopper jig.



#### BAND CLAMP ILLUSTRATION



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☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

4 of 11

### PARTS:

1. Assy parts

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

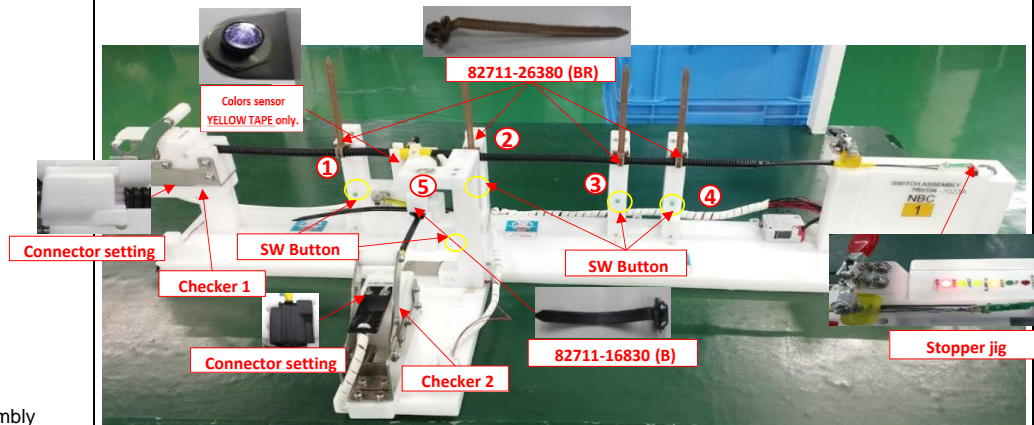
### TOOLS/PPE

### QUALITY POINTERS

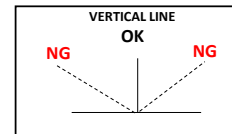
4

P4

Clamp assembly



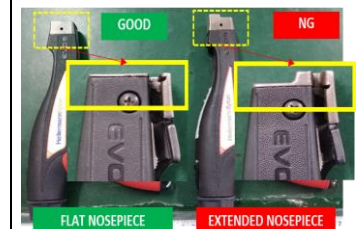
- Initially tighten the band clamp on clamp location **1, 2, 3, 4, and 5** using both hands.
- Get the Bando Gun using right hand and cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was on.
- Cut 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.
- 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.



### BANDO GUN (FLAT NOSEPIECE)



### BANDO GUN ILLUSTRATION



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Document No.:

WI-ENG-PDE-557D

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

5 of 11

### PARTS:

1. Assy parts

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

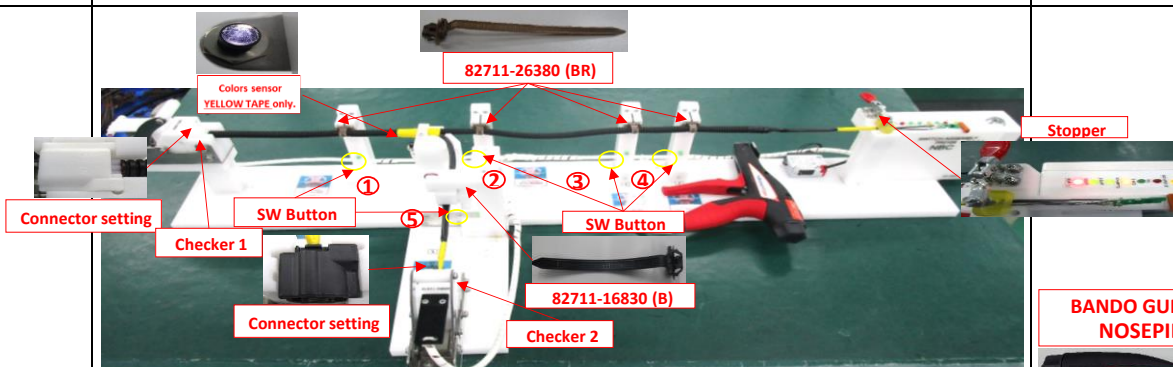
### TOOLS/PPE

### QUALITY POINTERS

4

P4

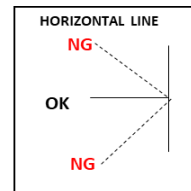
Clamp assembly  
(Continuation)



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. Continue on label Attachment.

#### BAND CLAMP CUT POSITION FOR 82711-16830 (B)



Fixed setting of  
band clamp  
cutter: 1 ~ 3

#### BANDO GUN (FLAT NOSEPIECE)

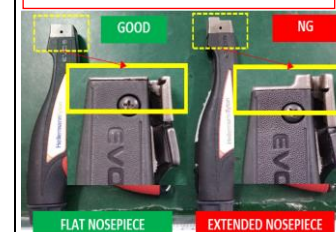


#### Important reminders/Note/s:

1. Make sure no gap between the PCB and stopper jig.
2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For:  $\phi 5 - 1 \sim 2$ ,  $\phi 7 - 3 \sim 4$



#### BANDO GUN ILLUSTRATION



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Document No.:

**WI-ENG-PDE-557D**

Revision No.:

3

Page No.:

6 of 11

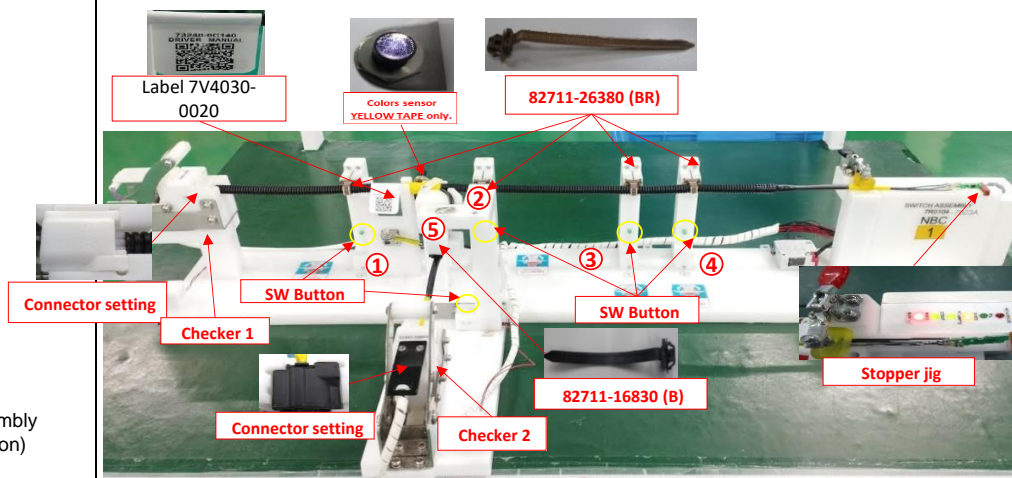
**PARTS:**

1. Assy parts

**JIG**1. Clamp assembly jig  
2. Label Dispenser**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P4

Clamp assembly  
(Continuation)

n/a

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

7. For label attachment, **color sensor** will light if detects the **label code**. After attachment, press the **SW button** using both index finger (**same timing**). **Go** sound will be heard. (*Refer to the next page for label attachment*).

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

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**3**

Page No.:

**7 of 11****PARTS:**

1. Assy parts
2. Label 7V4030-0020

**JIG**

1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																	
5	P4	Label attachment	<table><tr><th>Model</th><th>Item No</th><th>Item Name</th></tr><tr><td>7R0102</td><td>73240-0C140</td><td>Driver Manual</td></tr><tr><td>7R0103</td><td>73240-0C150</td><td>Driver Power</td></tr><tr><td>7R0104</td><td>73240-0C160</td><td>Driver PWR-MEM</td></tr><tr><td>7R0105</td><td>73230-0C170</td><td>Passenger Manual</td></tr><tr><td>7R0106</td><td>73230-0C180</td><td>Passenger Manual</td></tr></table> <p>04 Model code</p> <p>1. Get the label. <b>Note: Check the model code, item no. &amp; name</b></p> <p>Item no. &amp; name</p> <p>2. Align the end part of label in the jig.</p> <p>3. Fold the center part of the label</p> <p>4. Align both end part of label .</p> <p>5. After alignment , Press the label with both fingers .</p> <p>6. Press the label upside down using finger.</p> <p>Acceptable overlap 0~1mm</p> <p><b>GOOD</b></p> <p><b>NG</b></p>	Model	Item No	Item Name	7R0102	73240-0C140	Driver Manual	7R0103	73240-0C150	Driver Power	7R0104	73240-0C160	Driver PWR-MEM	7R0105	73230-0C170	Passenger Manual	7R0106	73230-0C180	Passenger Manual	n/a	<div>1. No bubbles 2. No damage 3. No peel off 4. No wrong use of label 5. No missing parts 6. No loose attachment 7. No wrong usage of label</div>
Model	Item No	Item Name																					
7R0102	73240-0C140	Driver Manual																					
7R0103	73240-0C150	Driver Power																					
7R0104	73240-0C160	Driver PWR-MEM																					
7R0105	73230-0C170	Passenger Manual																					
7R0106	73230-0C180	Passenger Manual																					

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WI-ENG-PDE-557D

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

8 of 11

### PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P4

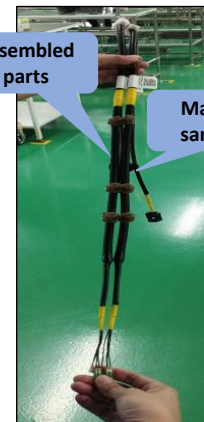
Visual/By two's inspection



ACTUAL PRODUCT

Assembled parts

Master sample



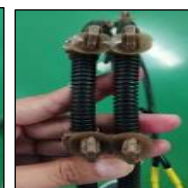
1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **connector lock, terminal and insertion.**



3. Check the **presence of all clamp attachment and band clamp cut.**



5. Check the **presence of clamp attachment and band clamp cut.**



4. Check the **presence and condition of QR code label attachment.**



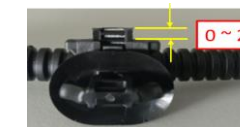
### MASTER SAMPLE



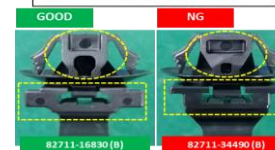
1. No skip checking during inspection.

### Important reminders/Note/s:

1. Using steel rule, check if the **band cut measurement is within the required dimension and should not exceed the allowable range**



BAND CLAMP ILLUSTRATION



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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

9 of 11

**PARTS:**

1. Assembled parts
2. Master sample

**JIG**

n/a

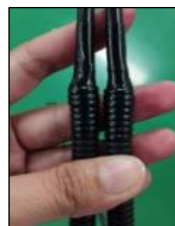
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P4

Visual/By two's inspection  
(Continuation)**ACTUAL PRODUCT**

6. Check the **connector lock, terminal and insertion.**



8. Check the **Taping condition of COT to sunprene tube. Conduct slightly bending.**



9. Check the **Taping condition and color of tape (Yellow tape only)**



7. Check the **Y-Taping condition and color of tape (Yellow tape only).**



10. Check the **terminal and PCB appearance. Must be no deformed terminal.**

**MASTER SAMPLE**

1. No skip checking during inspection.

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Document No.:

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Revision No.:

**3**

Page No.:

**10 of 11****PARTS:**

n/a

**JIG**

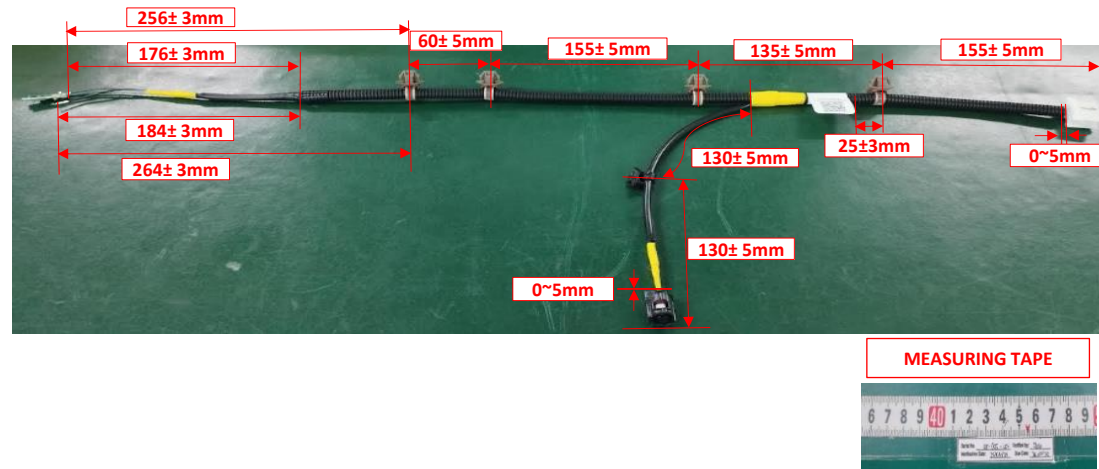
n/a

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

7

P4

Measurement



1. No wrong dimension

**Important reminders/Note/s:**

1. Please use calibrated/ verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono

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Revision No.:

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Page No.:

**11 of 11**

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n/a

**JIG**

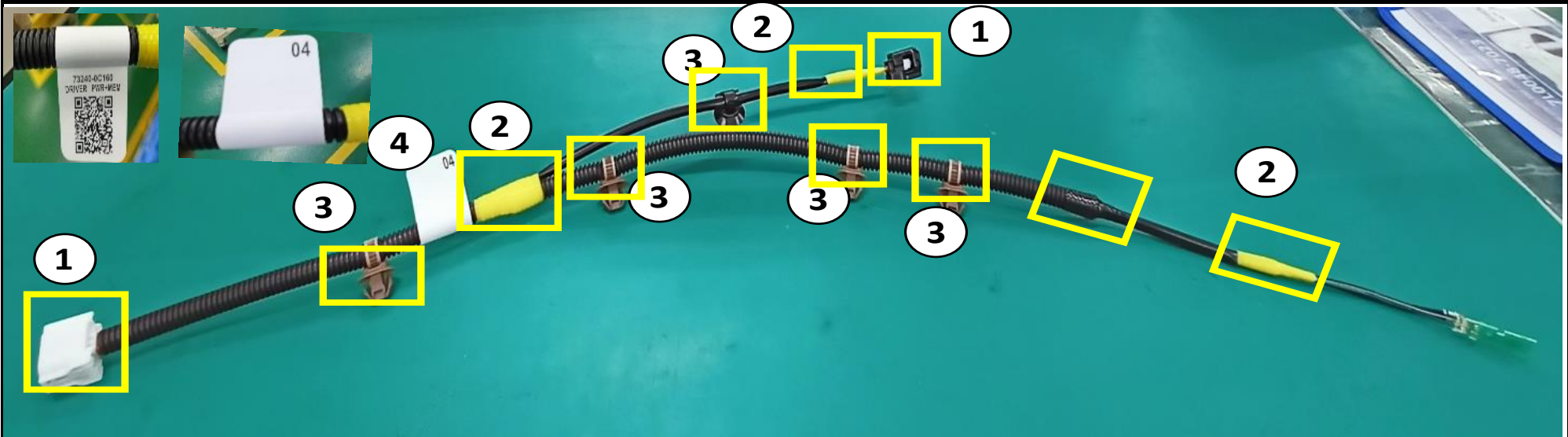
n/a



## QUALITY CHECKPOINTS

**P4**

**7R0104-7023A**



**1 NO UNLOCKED/ HALF LOCKED CONNECTOR**

**2 No MISSING TAPE**

**3 No MISSING CLAMP**

**4 NO MISSING QR CODE  
No wrong facing of QR CODE**

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