



## WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

April 20, 2021

Product Name/Code: 310B / 7M0521-7020A

Customer: TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-164C

Revision No.:

4

Page No.:

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## PARTS:

1. Clamp 82711-48210 (B)  
2. Clamp 82711-3A640 (B)  
3. Clamp 82711-48070 (GR)

4. Clamp 82711-52090 (W)  
5. Black tape [7pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

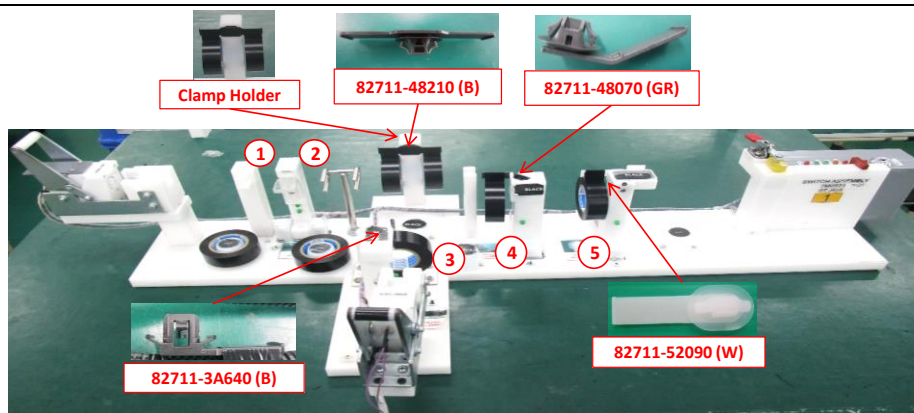
TOOLS/PPE

QUALITY POINTERS

1

P3

Clamp setting



1. Get the clamp **82711-3A640 (B)** using right hand and put to location **3** using both hands.

2. Get the clamp **82711-48070 (GR)** using right hand and put to location **4** using both hands.

3. Get the clamp **82711-52090 (W)** using right hand and put to location **5** using both hands.

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

4. Initially attach black tape to location **3, 4 and 5** using both hands.

5. Get the clamp **82711-48210 (B)** using right hand then put to clamp holder and initially attach black tape using both hands.

**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.

**STANDARD TAPING FOR CLAMP**

One side tape under clamp



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

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/20/21	4	Revise due to standardize the color of clamp in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/10/20	3	Changed effectivity and validity date. Remove cycle time	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
07/02/18	n/a	Initially established as Engineering instruction (EI-ENG-PDE-043) . Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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## PARTS:

1. Assy parts
2. Black tape

## JIG

1. Clamp Assembly Jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

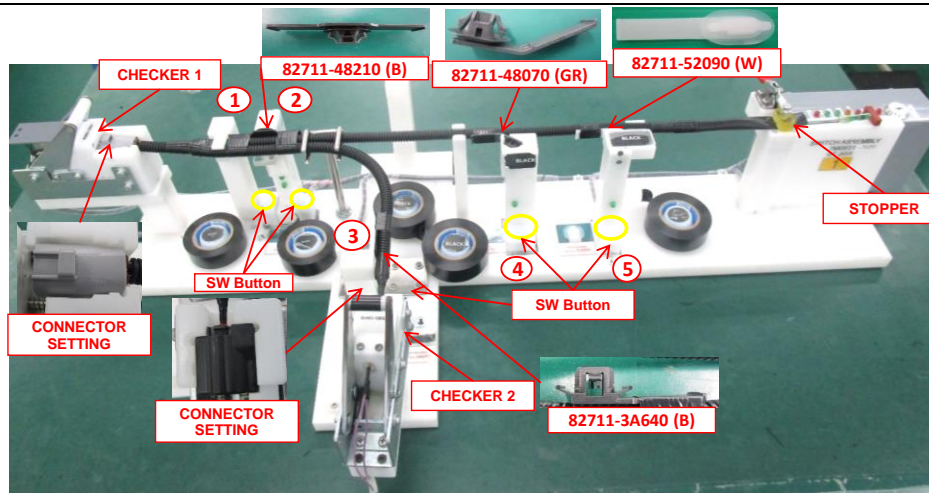
## QUALITY POINTERS

2

P3

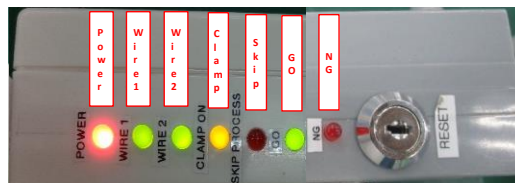
4

Clamp Assembly



1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the connector **(6189-1161)** to **Checker 2** then push the lock for continuity checking. Last, set the end of **GR/BW hotmelted wire** together 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, WIRE1, WIRE2 and CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.



n/a

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

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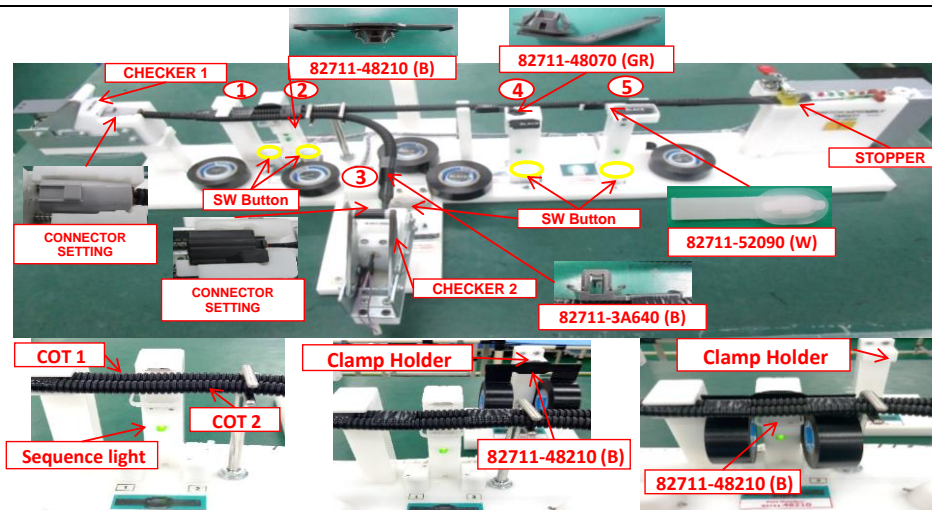
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly  
(Continuation)



3. Fix the 2 corrugated tube and **2 windings** of tape on both sides (**tape width**) using both hands then cut the tape.

4. Get the clamp in clamp holder (**82711-48210**) and set to location **1** and **2**.

5. Hold the tape on clamp location **1** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue if sequence light on location **2** was **ON**.

6. Hold the tape on clamp location **2** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue if sequence light on location **3** was **ON**.

7. Hold the tape on clamp location **3** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue if sequence light on location **4** was **ON**.

n/a



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

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

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1. Clamp Assembly Jig

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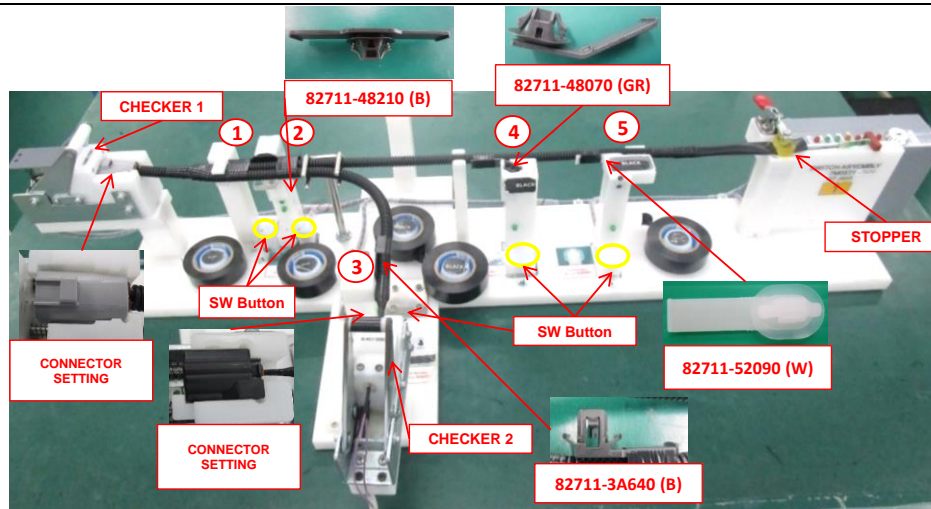
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly  
(Continuation)



8. 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. Continue if sequence light on location **5** was **ON**.

9. Hold the tape on clamp location **5** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. **Go** sound will be heard.

10. After taping, **CONDUCT POINT CHECKING** before removing of harness from jig.

11. First, pull the **2 checker fixture** (same timing) then remove the toggle clamp. Last, remove the harness from COT up to clamp.

n/a



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

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

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QUALITY POINTERS

3

4

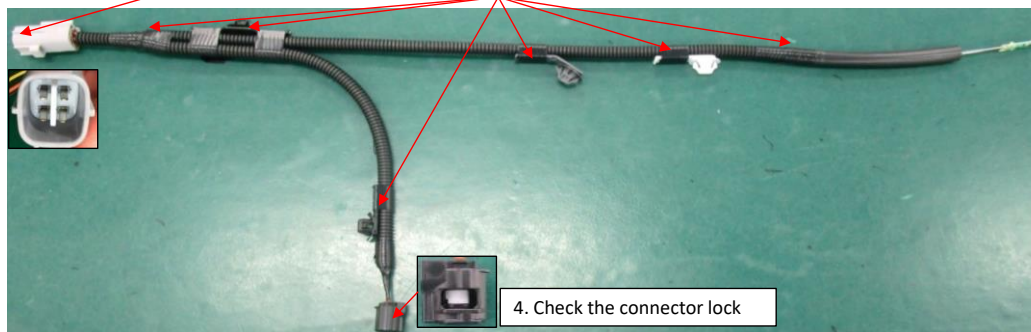
Visual/By Two's Inspection

P3

1. Check the connector lock

2. Check the presence of all clamp attachment and taping condition.

3. Check the Y taping condition and orientation.



4. Check the connector lock

5. Compare to Master Sample

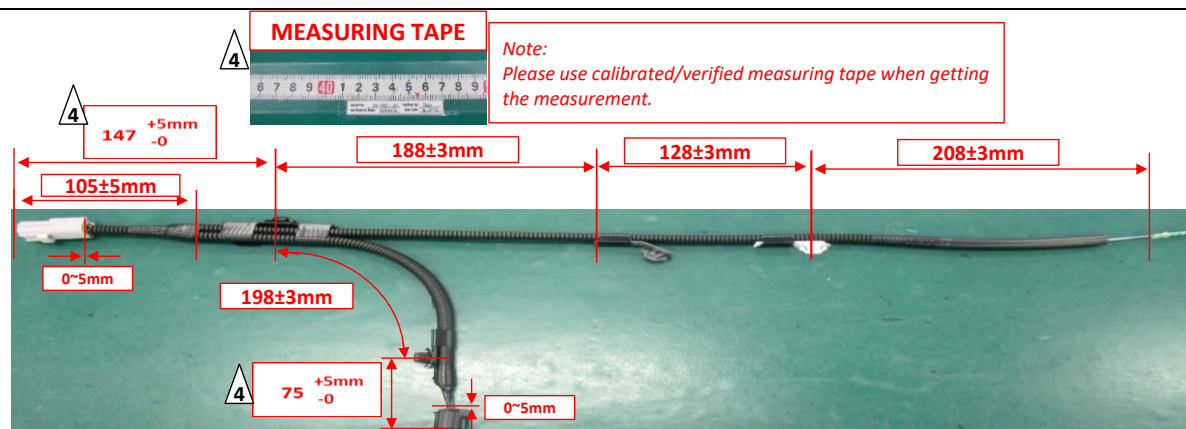
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy*

**MASTER SAMPLE**



4

Measurement



**MEASURING TAPE**

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

**Note: FOR HATSUMONO ANG OWARIMONO**

1. No wrong dimension

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