



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number:

380D

/

7L0140-7020A

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 9, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-648B

Revision No.:

1

Page No.:

1 of 8

PARTS:

1. Assy parts; Label 7V8110-0020; Clamp 82711-52090 (W); Clamp 82711-16820 (BR); Black tape [2pcs]

JIG:

1. Clamp Assembly jig
2. Label dispenser

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

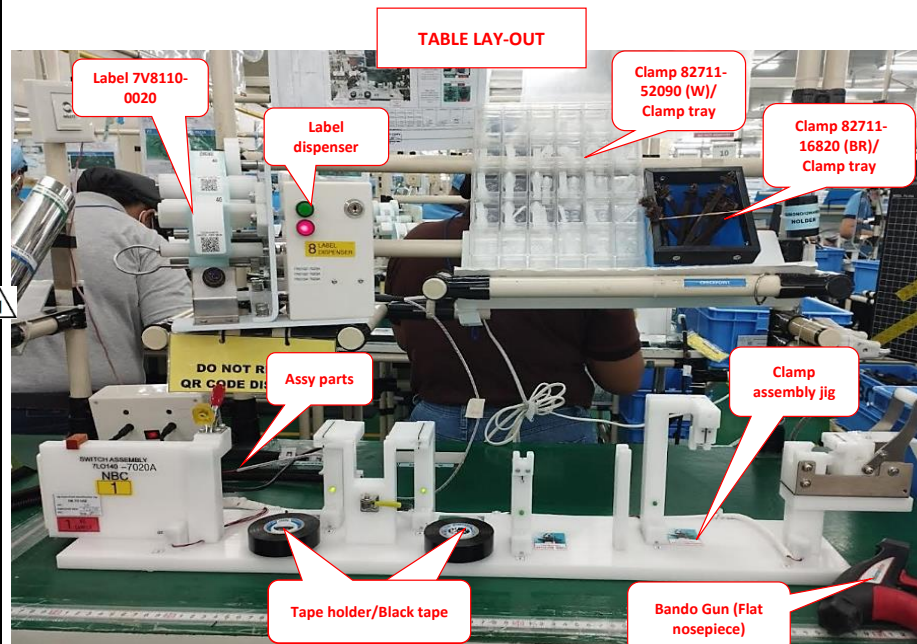
TOOLS/PPE

QUALITY POINTERS

1

P2

Table Lay-out



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.

1. No wrong use of parts
2. No deformed terminal

Document reference/s:

1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Please refer to WI-ENG-PDE- 669 for Offline Assembly Process

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/09/23	1	Change Purpose from Pre-launch to Masspro. Inclusion of Quality Checkpoints. Improve Work Procedure/Illustration on process no. 2, 3 and 4. Additional table lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
03/10/23	0	Initial issue. Change Wire color from Green (G) to Gray (GR).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Clamp 82711-16820 (BR)
2. Clamp 82711-52090 (W)

JIG

1. Clamp Assembly jig
2. Label dispenser

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

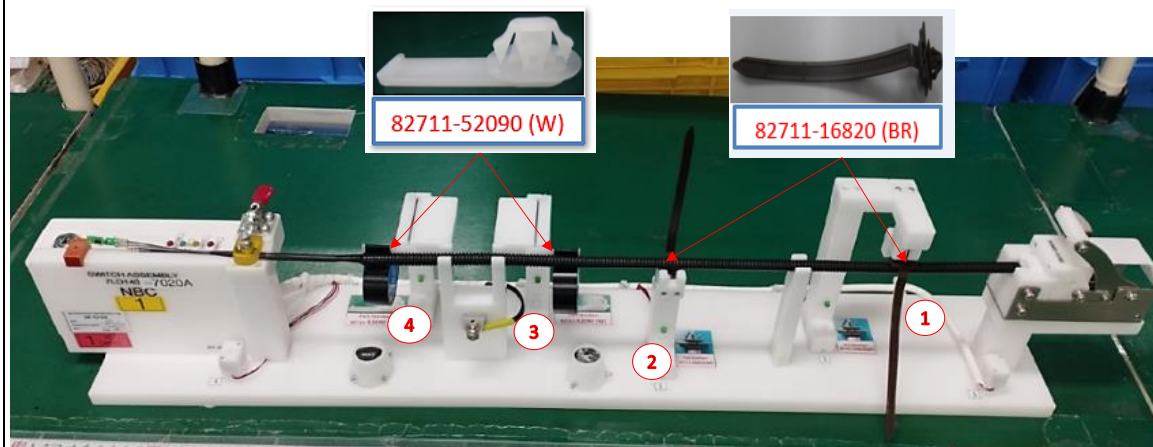
TOOLS/PPE

QUALITY POINTERS

2

P2

Clamp setting



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

2. Get 2pcs. of clamp **82711-16820 (BR)** using right hand and set to clamp location **2 and 1** using both hands.

3. Initially attach the black tape to **Location 4 and 3**.

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

STANDARD TAPING FOR CLAMP

One side tape under clamp



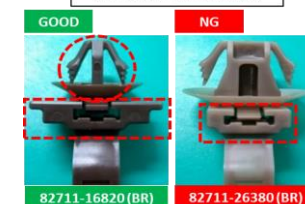
Important reminders/Note/s:

1. Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.

CLAMP ILLUSTRATION



BAND CLAMP ILLUSTRATION



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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig
2. Label dispenser

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

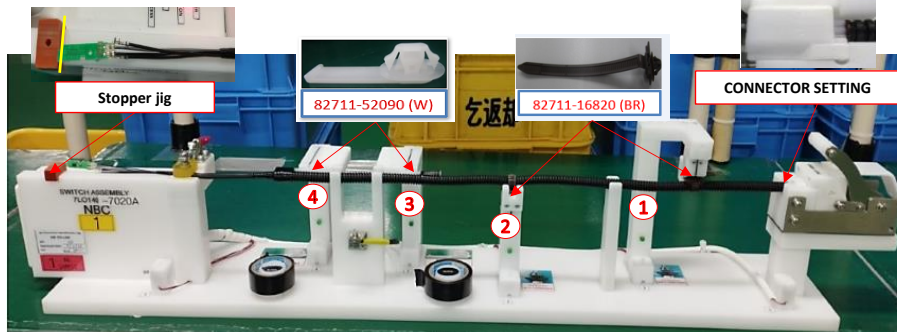
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp Assembly



1. Get the assy parts and then set into jig. (See above picture for correct setting). First, set the connector 6189-1142 (W) to Receiver base 1. Continue to set the harness in jig. last, set the PCB and B-B wires to stopper jig and push down the toggle clamp.

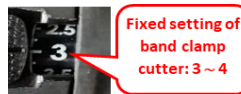
2. Initially tighten the band clamp on clamp location 1 and 2 using both hands.



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$

3. Get the bando gun using both hand and cut the band clamp on location 1 using both hands. Press the SW button after cut. Proceed to Clamp location 2 and continue the process.

4. Cut the band clamp on clamp location 2 using both hands. Press the SW button after cut. Proceed to Clamp location 3 and continue the process.



BANDO GUN ALIGNMENT



BANDO GUN

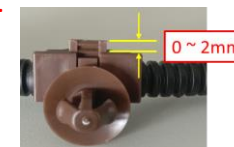


FLAT NOSEPIECE

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

Important reminders/Note/s:

1. Make sure no gap between stopper and terminals
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).



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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig
2. Label dispenser

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WORK PROCEDURE/ ILLUSTRATION

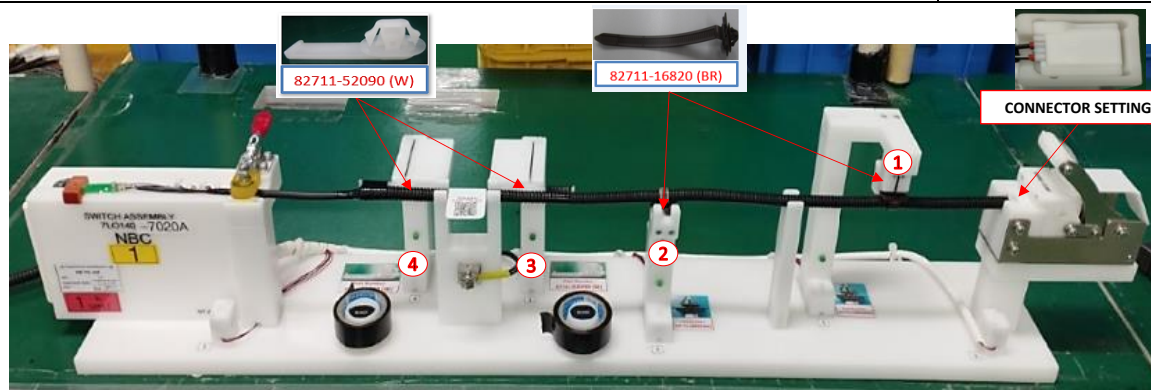
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp Assembly
(Continuation)



5. Hold the tape on clamp location **3**. Make **3 windings** of tape then cut the tape using both hands. Continue the process on clamp location **4**.

6. Hold the tape on clamp location **4**. Make **3 windings** of tape then cut the tape using both hands. Continue the process on label attachment

7. For label attachment, get the QR code label then attach using both hands. (Refer to the next page for label attachment).

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



QR Code label facing

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

Important reminders/Note/s:
1. Make sure no gap between stopper and terminals



STOPPER JIG



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PARTS:

1. Assy parts
2. Label 7V8110-0020

JIG

1. Clamp Assembly jig
2. Label dispenser

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

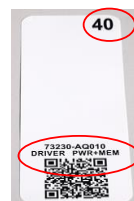
QUALITY POINTERS

4

P2

Label Attachment

Model Code	Item No.	Item Name
7L0139-7020	73230-AQ040	Driver Manual
7L0140-7020	73230-AQ010	Driver PWR+MEM
7L0141-7020	73230-AQ020	Driver Power



Model code

1. Get the label.

Note: Check the model code, item

Item no. & name

2. Align the end part of label in the jig.

3. Fold the center part of the label

4. Align both end part of label .

5. After alignment , Press the label with both fingers .

6. Press the label upside down using finger.

Acceptable overlap
0~1mm

GOOD

NG

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



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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

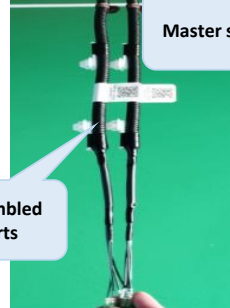
Visual/By two's inspection



ACTUAL PRODUCT

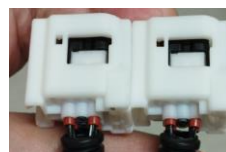


Master sample



Assembled parts

1. Conduct **alignment of harness (Engineering sample vs. assembled parts)** using both hands.



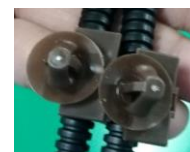
2. Check the **connector lock condition, insertion and terminal.**



4. Check the **taping condition.**



5. Check the **QR Code label and correct facing.**



3. Check the **Y-Taping condition, presence of all clamp attachment, taping condition and band clamp cut condition.**



6. Check the **Terminal and PCB appearance and taping condition, Must be no deformed terminal.**

1. No skip checking during inspection

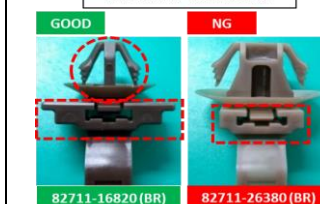
MASTER SAMPLE



CLAMP ILLUSTRATION



BAND CLAMP ILLUSTRATION



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n/a

JIG

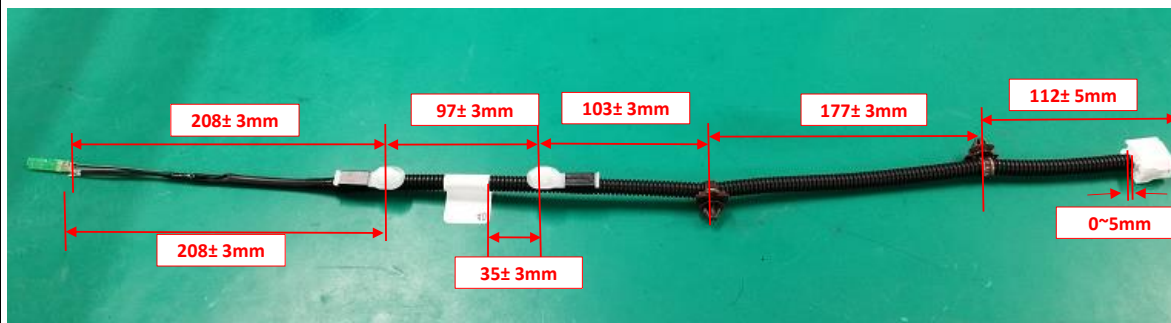
n/a

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

6

P2

Measurement

**MEASURING TAPE****Important reminders/Note/s:**

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

1. No wrong dimension

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PARTS:

n/a

JIG

n/a



QUALITY CHECKPOINTS

P2

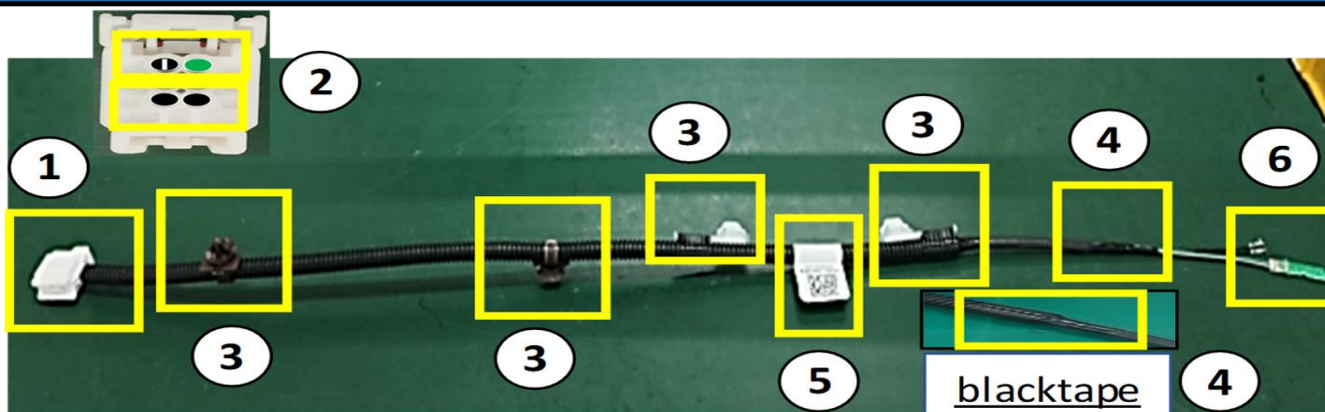
7L0140-7020A



GOOD



NO GOOD



① **NO UNLOCKED/ HALF LOCKED CONNECTOR**

② **No WRONG INSERT
No Terminal Backing Out**

③ **No MISSING CLAMP [4pcs]**

③ **Checking of Clamp attachment**

④ **No Missing tape**

⑤ **NO MISSING QR CODE
No wrong facing of QR CODE**

⑥ **NO Deformed terminal**

Proper alignment of B-B wires and hotmelt

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