

	<b>WORK INSTRUCTION</b>				Effectivity Date: <b>July 19, 2021</b>	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date: <b>n/a</b>	
	Process Name/Title:		Product Name/Code: <b>310B / 7M0522-7020C</b>		Customer: <b>TRJ</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-166C</b>		Revision No.: <b>4</b>	
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<b>PARTS:</b>	<div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div>	1. Black tape [5 pcs] 2. Clamp 82711-52090 (W) [3pcs] 3. Clamp 82711-48070 (GR) [2pcs]	JIG:	1. Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp Assembly setting	<div style="text-align: center;"> </div> <div style="margin-top: 10px; border: 1px solid black; padding: 5px; text-align: center;"> <b>Sequence light</b> </div> <div style="margin-top: 10px; border: 1px solid black; padding: 5px;"> <p>1. Get 2pcs. of clamp (82711-48070) using right hand then set to location 1 &amp; 4 using both hands.</p> <p>2. Get 3pcs. of clamp (82711-52090) using right hand then set to location 2, 3 &amp; 5 using both hands.</p> <p>3. Get Black tape using right hand and conduct pre-taping from location 1,2,3,4,5 using both hands.</p> </div> <div style="margin-top: 10px; border: 1px solid black; padding: 5px;"> <p><b>Note:</b> Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>          Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)       </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <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 style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>	<div style="border: 1px solid black; padding: 5px; text-align: center; margin-bottom: 10px;"> <b>STANDARD TAPING FOR CLAMP</b> </div> <div style="text-align: center;"> </div> <div style="margin-top: 10px;">         1. No loose tape          2. No flip-out tape          3. No peel-off tape          4. No wrong use of tape          5. No wrong use of clamp          6. No missing clamp       </div>

Revision History					Prepared by:	Checked by:	Approved by:	Noted by:
07/19/21	4	Remove validity date and add tape quantity.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes		
01/20/21	3	Change part number due to change clamp from 82711-3A540 to 82711-52090 and change facing of clamp 82711-48070 and 82711-52090. Change clamp color in accordance with color standardization for plastic parts. Remove cycle time.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes		
09/08/20	2	Change Process owner from Production to Engineering. Improved process and add cycle time. Updated pictures. Change part number.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes		
07/12/18	n/a	Previously established Engineering Instruction (EI-ENG-PDE-051). Initial issue.	D. Castillo	R. Alcantara	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	October 18, 2018

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**PARTS:**

1. Assy parts

**JIG**

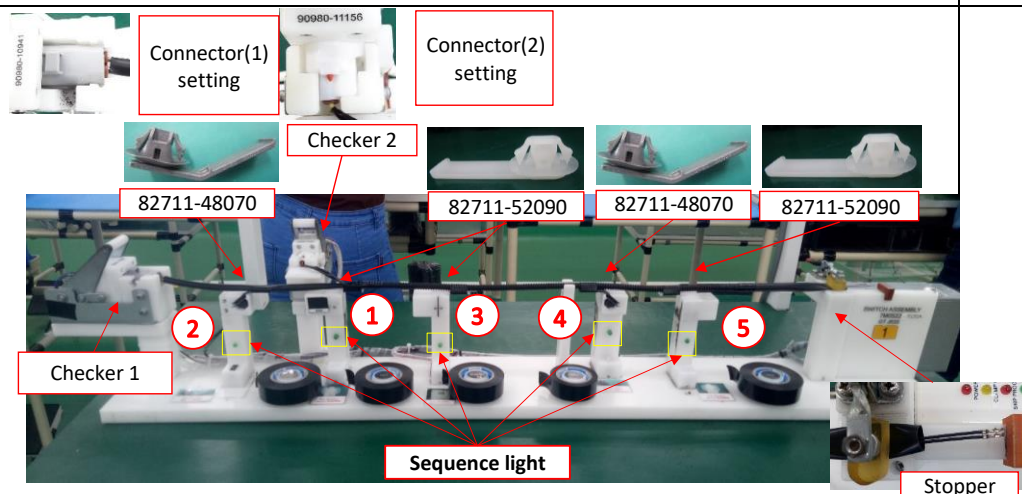
1. Assembly jig

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

2

P3

Clamp Assembly



N/A

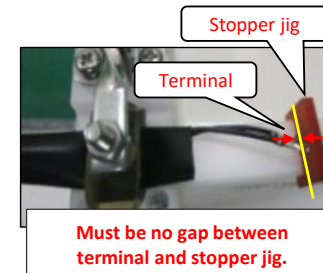
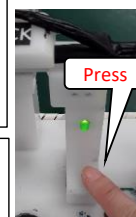
1. Get the assy parts and set to jig using both hands. First, put the Gray connector to **Checker 1** then pull the checker fixture. Second, put the White connector to **Checker 2** then pull the checker fixture. Last, set the terminal to stopper jig then pull down the toggle clamp. **Refer to the above illustration for the correct setting.**

2. Check if all LED light for **POWER ON**, **WIRE1** and **WIRE2** and **CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Continue if the sequence light of **Location 1** is **ON**.

3. Start the taping process (3 windings) on clamp **location 1** using both hands. Press the switch button after taping. Sequence light will **ON** to the next process.

4. Continue the taping process until you finished the **location 2,3,4 & 5**. Press the SW button after taping. Go sound will be heard.

5. Conduct **Point Checking** using right hand and slowly remove the harness from jig.



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

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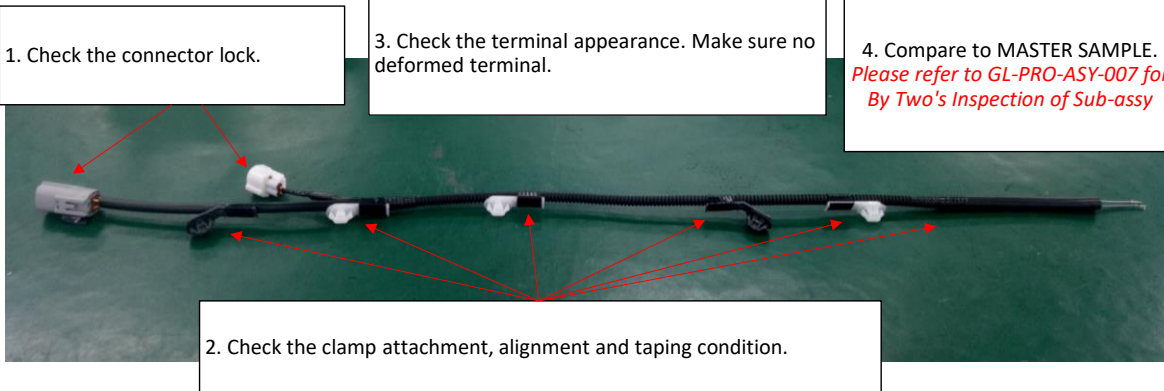

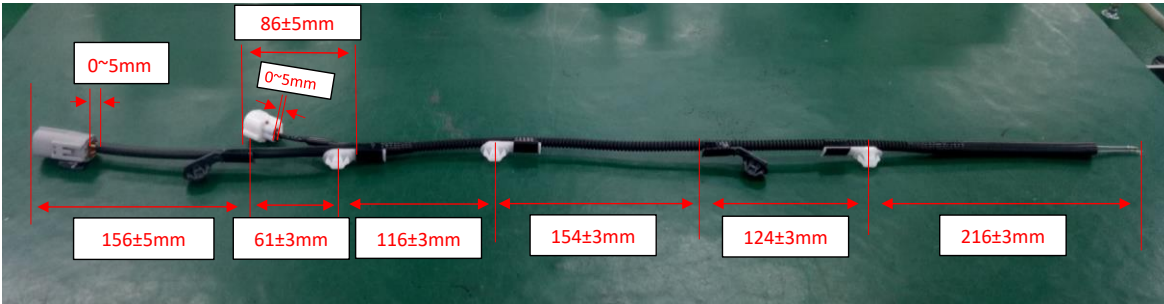
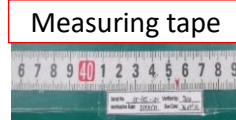
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<b>PARTS:</b>	N/A			<b>JIG</b>	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Visual/By two's inspection	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment, alignment and taping condition.</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div> <div>4. Compare to MASTER SAMPLE. <i>Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy</i></div> 			<b>Master Sample</b> 
4	P3 Measurement	 <div>Measuring tape</div> 			<div>NOT: FOR HATSUMONO AND OWARIMONO.</div> <div>1. No wrong dimension</div> <div><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div>

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