

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 17, 2023Model Code/Part Number: **910B / 7L0126-7023**Customer: **TRQSS**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-636D

Revision No.:

1

Page No.:

1 of 8**PARTS:**

1. Assy parts
2. Clamp 82711-52090 (W)
3. Clamp 82711-48070 (GR)

4. Black tape [4pcs.]
5. Yellow tape [1pc.]

JIG:

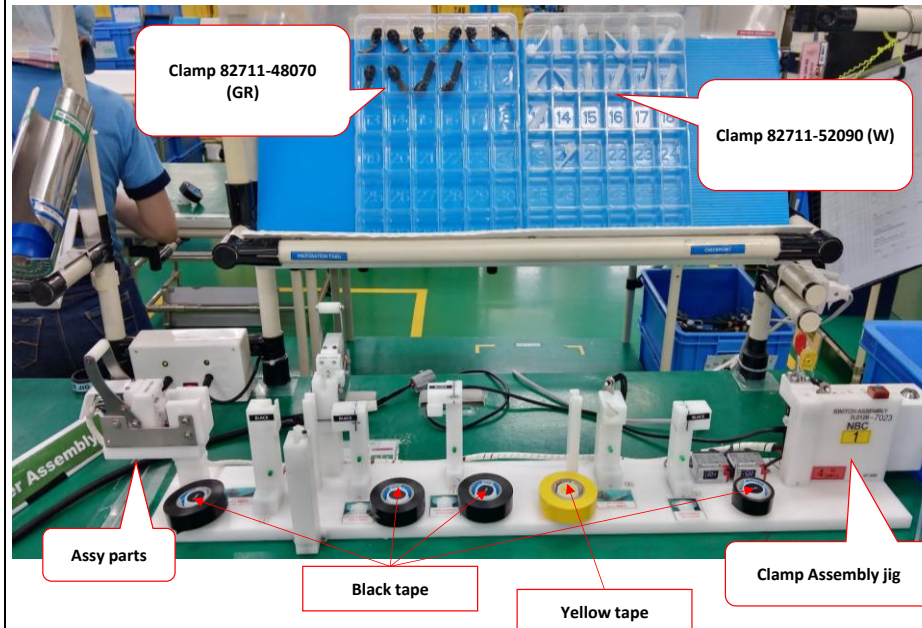
1. Clamp assembly jig

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

1

P4

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 missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

04/17/23

1

Document purpose from prelaunch to masspro. Change taping: From VM tube sunprene to wire near terminal to Spot taping (Brown tape). Additional table layout. Improve work procedure due to improvement. Align quality checkpoints on finished assy parts.

M. Catapang

J. Loterte

C. Villanueva

A. Arañes

03/02/23

0

Initial issue

M. Catapang

J. Loterte

C. Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

March 02, 2023

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☐ PROTOTYPE

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PARTS:

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

3. Black tape [4pcs.]
4. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

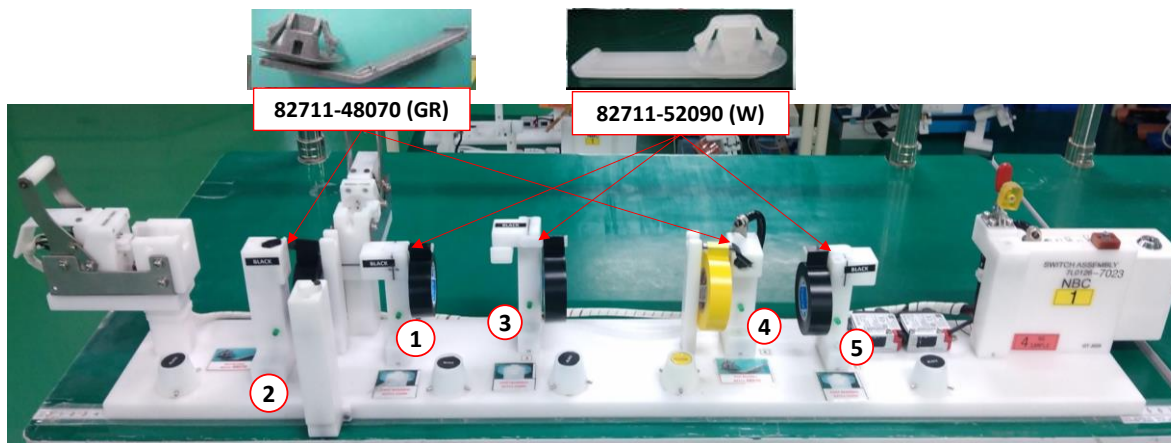
TOOLS/PPE

QUALITY POINTERS

2

P4

Clamp setting



1. Get **2pcs.** of clamp **82711-48070 (GR)** using right hand then set to clamp location **2 and 4** using both hands.

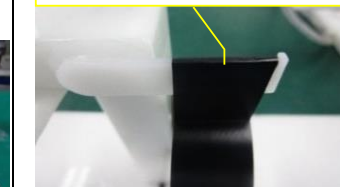
3. Initially attach **Yellow tape** to clamp location **4** using both hands.

2. Get **3pcs.** of clamp **82711-52090 (W)** using right hand then set to clamp location **1, 3 and 5** using both hands.

4. Initially attach **Black tape** to clamp location **2, 1, 3, and 5** using both hands.

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

Important reminders/Note/s:

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

CLAMP ILLUSTRATION



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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

3

P4

Clamp Assembly

CHECKER 2
CONNECTOR SETTING
82711-48070 (GR)
82711-52090 (W)
Color Sensor YELLOW TAPE only
CHECKER 1
1
2
3
4
5
RECEIVER BASE 1
CONNECTOR SETTING
CONNECTOR SETTING

1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Third, set the connector **6098-3810 (W)** to **Receiver base** then lock. Continue to set the harness in jig. **Color sensor light** will beep/buzz if sensor detects **Brown tape**. Last, set the terminals end together within the stopper then press by **Toggle clamp**. Continue if the sequence light on clamp location **1** was **ON**.

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.

3. Hold the tape on clamp location **1**. 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 **2** was **ON**.

Upper Connector 6189-0451 (W)
Bottom Connector 6188-0066 (GR)
Upper Connector 6098-3810 (W)

Note: Follow the correct arrangement of vinyl tubes before taping.



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

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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3. Yellow tape

JIG

1. Clamp assembly jig

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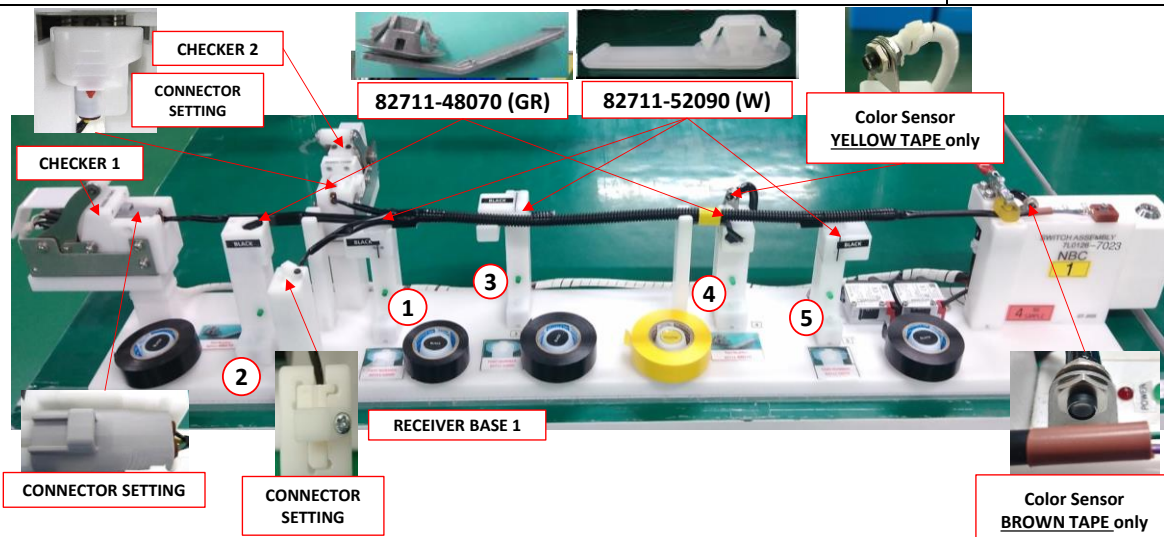
TOOLS/PPE

QUALITY POINTERS

3

P4

Clamp Assembly
(Continuation)



4. 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 in clamp location **3** was **ON**.

5. 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**.

6. 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**.

*Note: Color sensor will beep/buzz once the color sensor detect the **Yellow tape**.*

7. 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. **Go** sound will be heard.

8. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminal

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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PARTS:

1. Assy parts

JIG

n/a

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4

P4

Visual/By Two's Inspection

Assembled parts

Master sample

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

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

3. Check the **connector lock, terminal, insertion** and **taping condition.**

4. Check the **connector lock, terminal, insertion** and **taping condition.**

ACTUAL PRODUCTS**MASTER SAMPLE**

1. No skip checking during inspection

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PARTS:

1. Assy parts

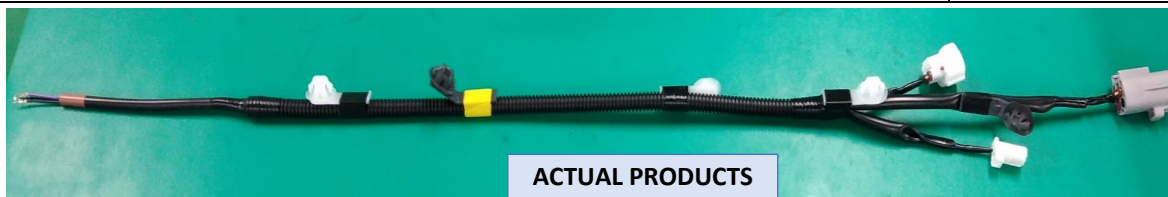
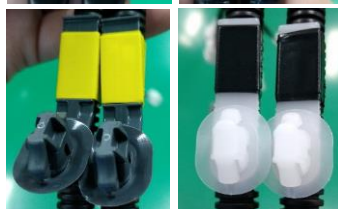
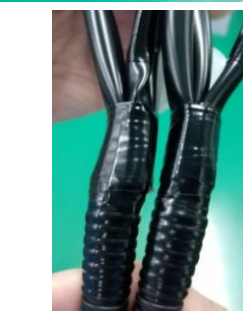
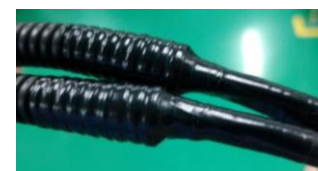
JIG

n/a

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

4

P4

Visual/By Two's Inspection
(Continuation)**ACTUAL PRODUCTS**5. Check the
**presence of clamp
and taping
condition.**6. Check the **Y-Taping
condition and alignment**7. Conduct **bending of COT
and tube** then check the
taping condition.8. Check the presence of spot
taping on tube (Brown tape)9. Check the **terminal appearance.**
Must be **no deformed terminal.****MASTER SAMPLE**

1. No skip checking during inspection

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PARTS:

1. Assy parts

JIG

n/a

NO.

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TOOLS/PPE

QUALITY POINTERS

5

P4

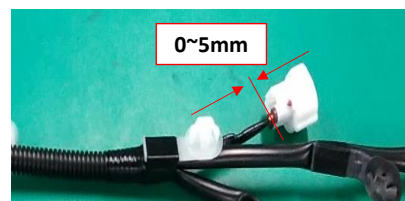
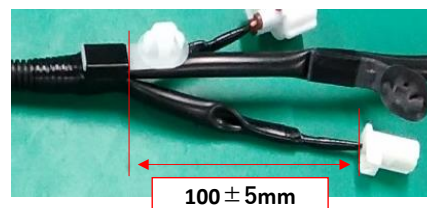
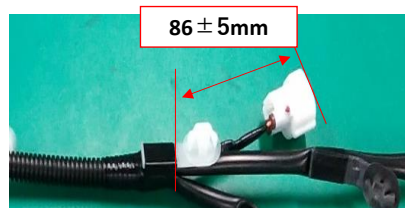
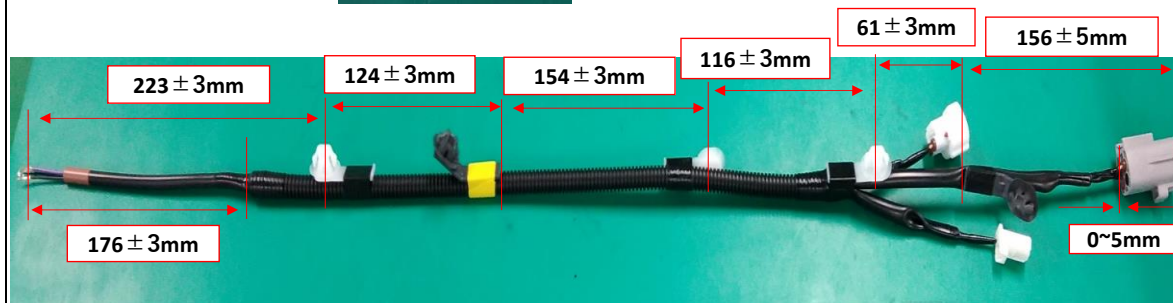
Measurement

MEASURING TAPE



Note:

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

Important reminders/Note/s:
1. FOR HATSUMONO AND
OWARIMONO

1. No wrong dimension

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JIG

n/a

QUALITY CHECKPOINTS

P4

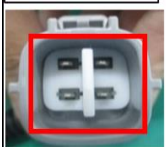
7L0126-7023



GOOD



GOOD



NO GOOD



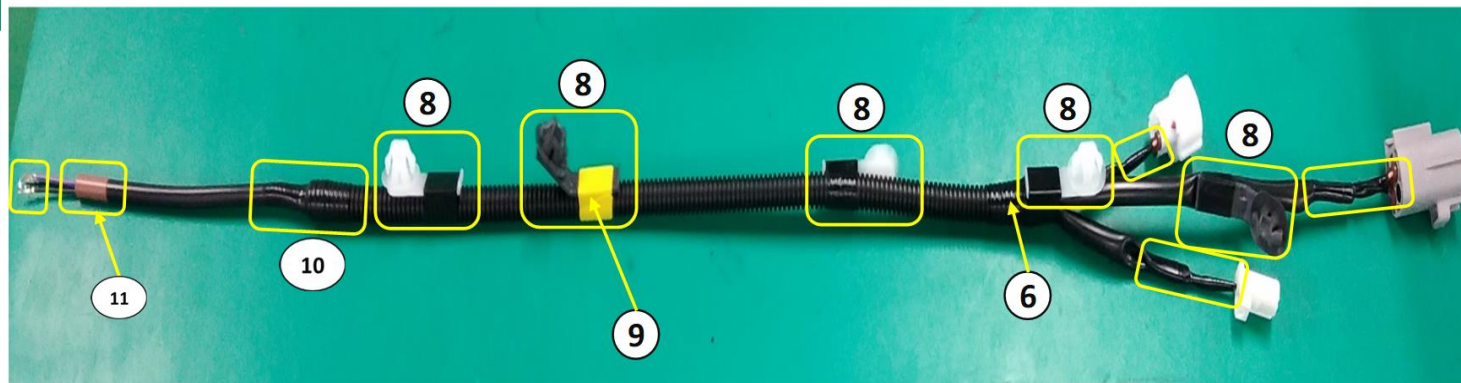
NO GOOD



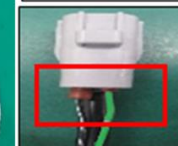
GOOD



NO GOOD



GOOD



NO GOOD

① No Unlock/Halflock Connector (on 3 connector)

② No Wrong Insert (on 3 connector)

③ No Missing Dummy Seal

④ No Missing Tape

⑤ No Terminal Backing Out

⑥ No Missing Tape and Wrong Used of tape (Y-taping)

⑦ Correct facing of Y-taping

⑧ No Missing Clamp (5pcs.)

⑨ No Wrong used of tape(yellow)

⑩ No Missing Tape(bending of COT to Sunprene)

⑪ No Missing spot tape (Brown tape on Tube)

⑫ No Deformed Terminal

⑬ Checking of Clamp Alignment

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