

**WORK INSTRUCTION**

Effect: September 9, 2022

September 9, 2022

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

Validity Date:

n/a

Model Code/Part Number: **895B / 7N0091-7020**Customer: **TRJ**

Document No.:

WI-ENG-PDE-517BPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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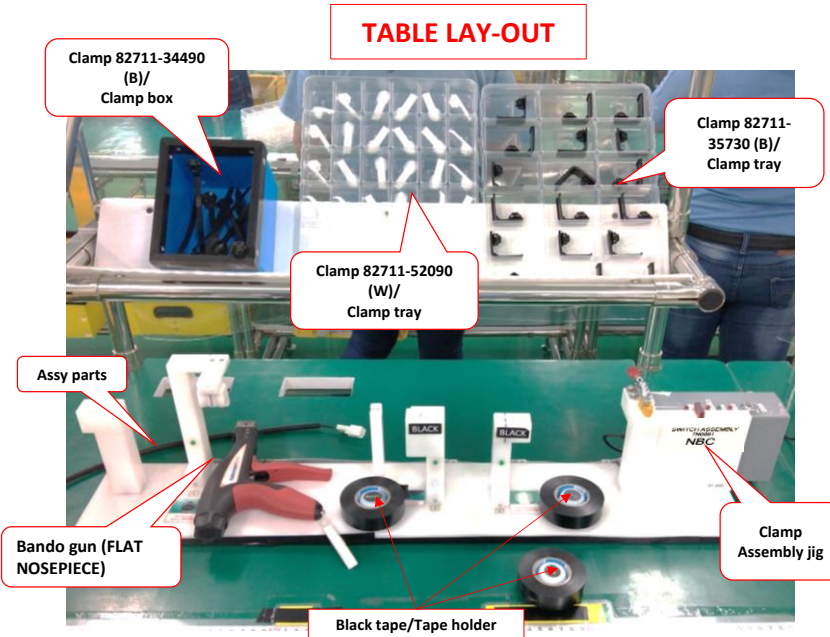


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PARTS:

1. Assy parts; Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clamp 82711-35730 (B); Black tape [3pcs]

JIG:

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div>TABLE LAY-OUT </div> <div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>CLAMP ILLUSTRATION 2 </div> <div>BAND CLAMP ILLUSTRATION 2 </div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</div>

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by:
09/09/2022	2	Improve Work procedure/Illustration on process no. 4,5 and 6; Quality pointers on pg. no. 1 to 10	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
06/10/2022	1	Change purpose from Pre-launch to Masspro. Additional table layout.	K. Doria	J. Loterte	C. Villanueva	A. Arañes
05/13/2022	0	Initial issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes
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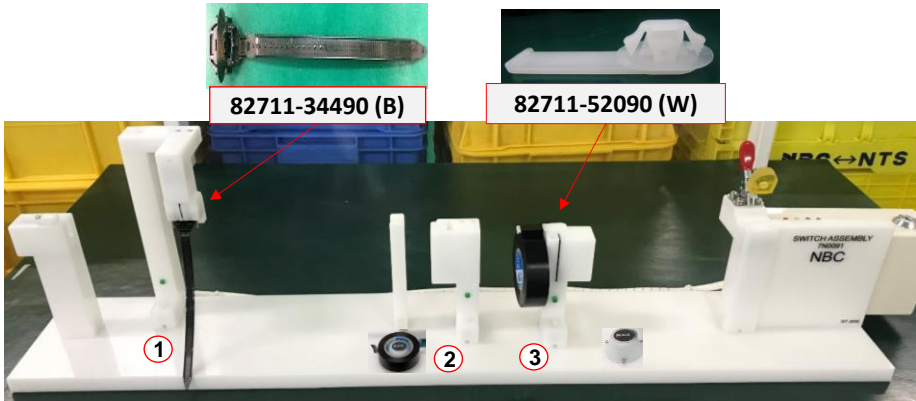





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PARTS:		1. Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W)	3. Black tape	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp Setting	<div></div> <div>1. Get 1 pc. of band clamp 82711-34490 (B) then set to clamp location 1 using both hands.</div> <div>2. Get 1 pc. of clamp 82711-52090 (W) then set to clamp location 3 using both hands.</div> <div>3. Initially attach Black tape on clamp location 3 using both hands.</div>	n/a	<div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</div> <div>2. Important reminders/Note/s 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div></div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>NG</div><div></div><div></div><div>82711-52090 (W)</div><div>82711-12A80 (W)</div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>82711-34490 (B)</div><div>82711-16830 (B)</div></div></div>

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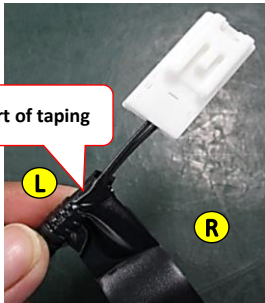
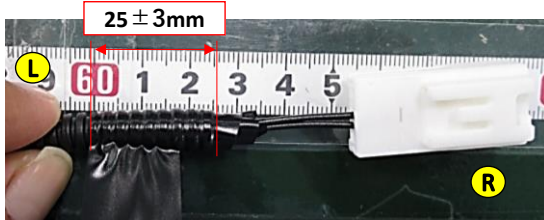
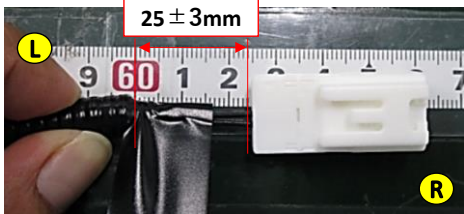
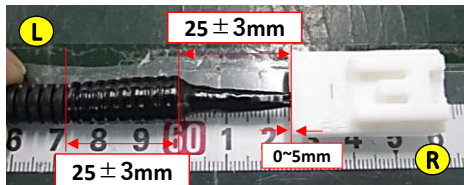

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PARTS:		1. Assy part 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 Corrugated tube to wire near connector	<div><p>Start of taping</p><p>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</p></div> <div><p>25 ± 3mm</p><p>2. Confirm measurement of 25±3mm from end of tape up to COT then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm</p><p>3. Measure from end of corrugated tube up to the edge of connector 25±3mm then continue the taping process using both hands</p></div> <div><p>25 ± 3mm</p><p>0~5mm</p><p>4. After taping, check the measurement and taping condition.</p></div>	 <p>MEASURING TAPE</p>	<p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <p>Important reminders/Note/s</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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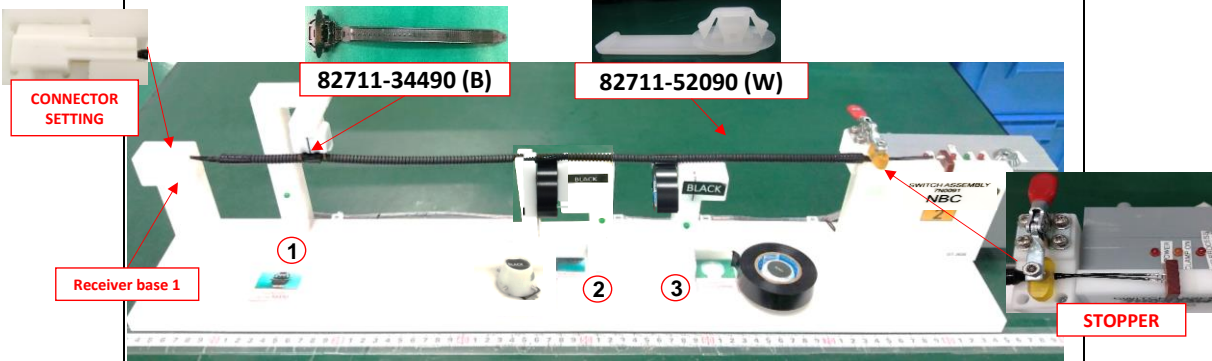
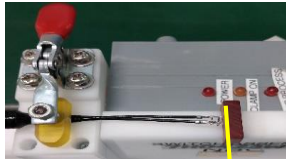
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PARTS:	1. Assy parts 2. Black tape			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P2 Clamp Assembly	 <p>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.</p> <p>2. Check if all LED light for POWER ON, 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.</p> <p>3. Get the black tape and hang to COT on location 2, for spot taping.</p>	n/a	 <p>2 Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper jig and terminals.</p>	

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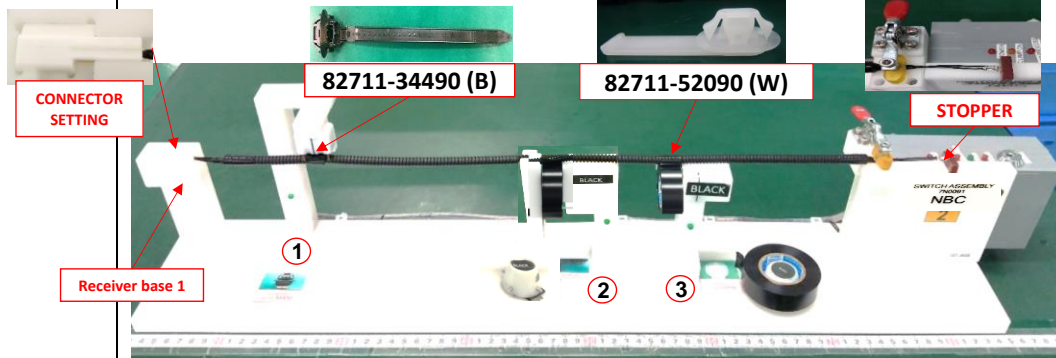
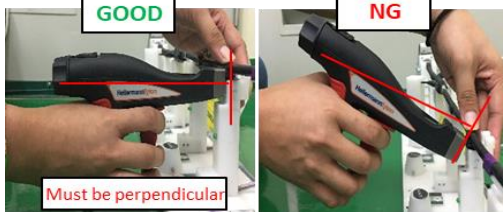



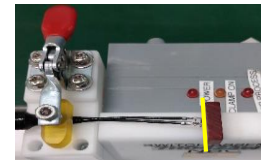
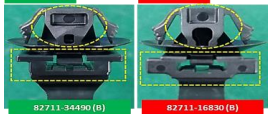

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PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly (Continuation)	<div></div> <div><p>4. Initially tighten the band clamp on location 1 using both hands.</p><p>5. Get the bando gun using right hand then cut the band clamp on location 2. Continue the process if sequence light button on location 2 was on.</p></div> <div><div><p>Must be perpendicular</p></div><div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p></div><div><p>Fixed setting of band clamp cutter: 1 ~ 2</p></div></div> <div></div>		<div><p>1. No wrong use of tape</p><p>2. No missing tape</p><p>3. No damage clamp</p><p>4. No missing clamp</p><p>5. No skip process</p></div> <div><p>2. Important reminders/ Note/s:</p><p>1. Make sure no gap between the stopper jig and terminals.</p><p>2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p></div> <div><p>BAND CLAMP ILLUSTRATION</p><div><p>GOOD NG</p></div><p>82711-34490 (B) 82711-16830 (B)</p><div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p></div><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div>	

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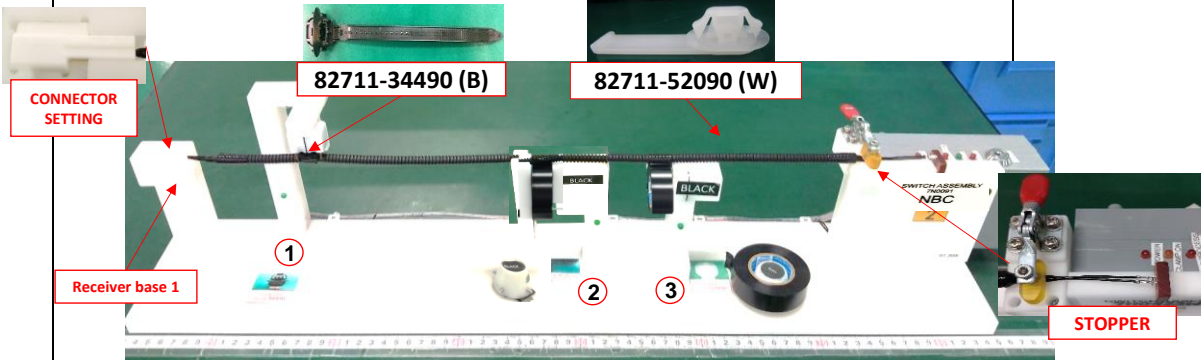
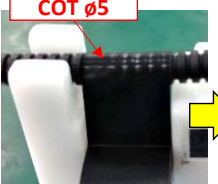
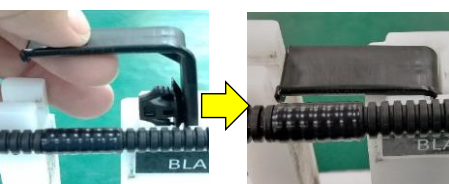
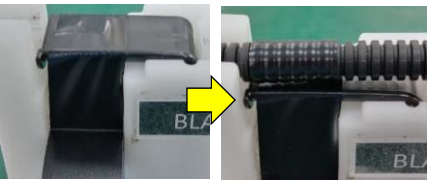

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PARTS:	1. Assy parts 2. Black tape 3. Clamp 82711-35730 (B)			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly (Continuation)	    <p>5. Conduct spot taping on COT in clamp location 2. Make 2 winds then cut the tape.</p> <p>6. Get 1 pc. of clamp 82711-35730 (B) then set to clamp location 2 using left hand.</p> <p>7. Initially attach Black tape on clamp location 2 using both hands then set the COT to clamp location 2 using left hand.</p>		n/a	<p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</p>  <p>2. Important reminders/Note/s: 1. Make sure no gap between stopper jig and terminals.</p>

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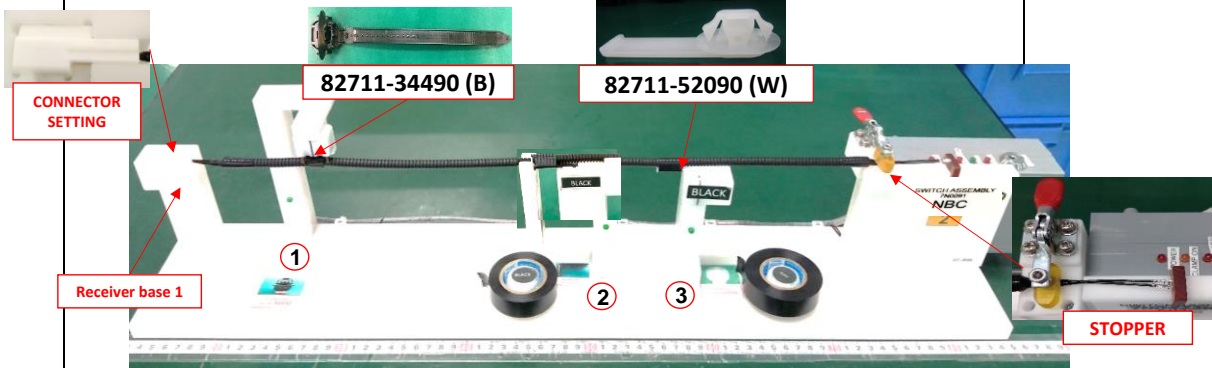
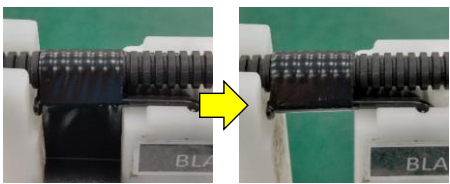


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PARTS:		1. Assy parts 2. Black tape	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly (Continuation)	<div>  </div> <div>8. Conduct taping on clamp location 2 using both hands. Make 3 winds then cut the tape. Press the SW button after taping. Continue the process if sequence light in location 3 was on.</div> <div>9. Tape the clamp on location 3 using both hands. Make 3 winds then cut the tape. Press the SW button after taping. GO sound will be heard.</div> <div>10. Conduct POINT CHECKING before removing the harness from jig.</div>	n/a	<div>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</div> <div></div> <div>2 Important reminders/Note/s: 1. Make sure no gap between the stopper jig and terminals.</div>

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PARTS:		n/a		JIG	n/a
NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By two's inspection	<div><p>ACTUAL PRODUCT</p></div> <div><p>Master sample</p></div> <div><p>Assembled parts</p></div> <div></div> <div></div> <div><p>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</p><p>2. Check the connector lock condition, wire insertion</p><p>3. Check the taping condition.</p></div>	2 MASTER SAMPLE	<div><p>MASTER SAMPLE</p></div> <p>1. No skip checking during inspection</p>

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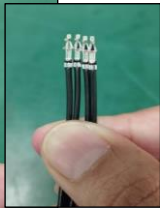







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PARTS:		n/a			JIG	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
5	P2	Visual/By two's inspection	<div><div><p>ACTUAL PRODUCT</p></div><div></div><div></div></div> <div>4. Check the presence of all clamp attachment and taping condition.</div> <div>5. Check the taping condition and terminal appearance. Must be no deformed terminal.</div>				<div>MASTER SAMPLE</div> <div><p>MASTER SAMPLE</p></div> <div><div>2</div><div>Important reminders/Note/s:</div><div>1. Using a steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</div><div><p>0 ~ 2mm</p></div><div><div>2</div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div><p>82711-52090 (W)</p></div><div>NG</div><div><p>82711-12A80 (W)</p></div></div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div><p>82711-34490 (B)</p></div><div>NG</div><div><p>82711-16830 (B)</p></div></div></div></div></div>

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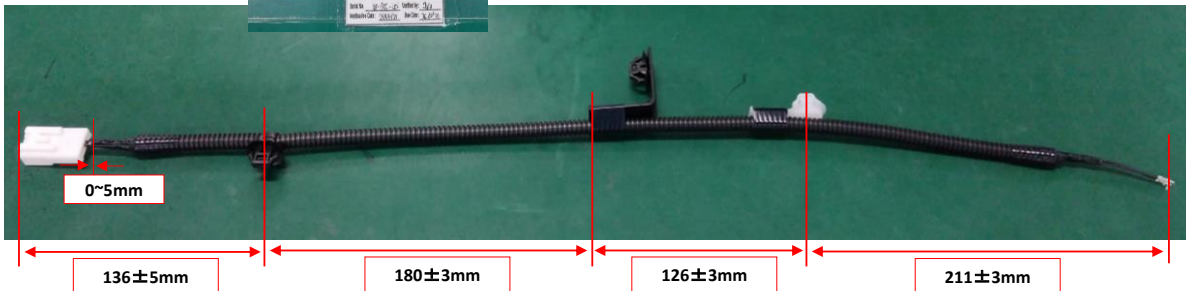
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PARTS:		n/a			JIG	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P2 Measurement	<div><div>MEASURING TAPE</div></div>				<div>1. No wrong measurement.</div> <div>2. Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono only</div>

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