



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number:

240B/ 7M0514-7020B

Customer:

TRJ

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

November 04, 2021

Validity Date:

n/a

Document No.:

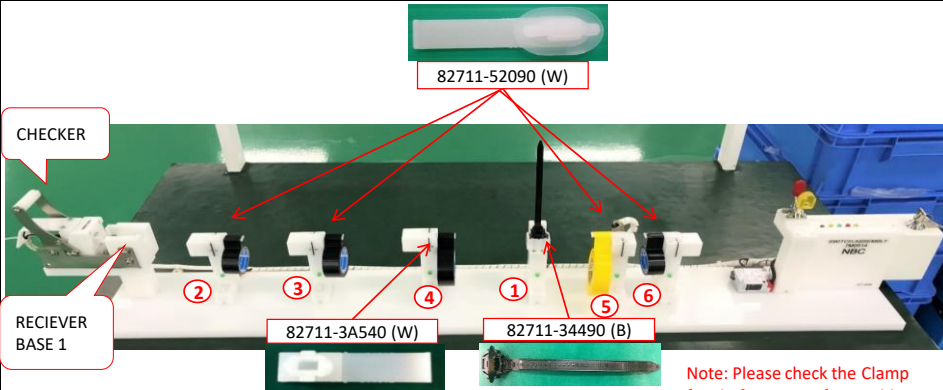
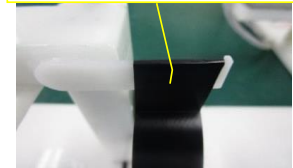
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PARTS:	1. Assy parts 2. Black tape [4pcs.]			3. Yellow tape	JIG:	Clamp Assembly Jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	P2	Clamp Setting	 <p>1. Get 1pc. of clamp 82711-34490 (B) using right hand then set to clamp location 1 using both hands.</p> <p>2. Get 4pc. of clamp 82711-52090 (W) using right hand then set to clamp location 2, 3, 5 and 6 using both hands.</p> <p>3. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to clamp location 4 using both hands.</p> <p>4. Initially attach the Yellow tape to location 5 using both hands.</p> <p>5. Initially attach the Black tape to location 2, 3, 4 and 6 using both hands.</p> <p>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p>			<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>STANDARD TAPING FOR CLAMP</p> <p>One side tape under clamp</p>  <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>	
Revision History					Prepared by	Reviewed by	Approved by	Noted by
					K. Doria	J. Loterte	C. Villanueva	A. Arañes
11/04/21	0	Initial issue			K. Doria	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change			Prepared	Checked	Approved	Noted
					Est. Date:	November 04, 2021		

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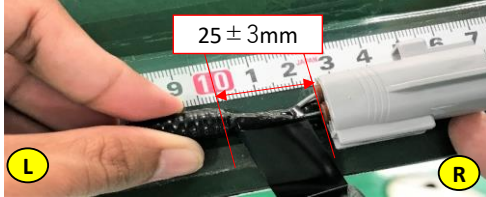
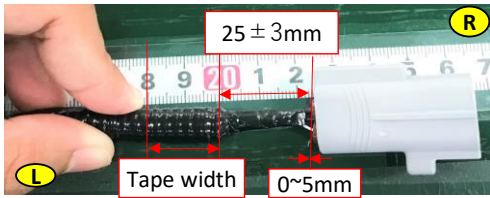

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 3 Black Corrugated tube to wire near connector 6188-0066 (GR)	<div><p>Start of taping</p></div> <div><p>25 ± 3mm</p></div> <div><p>25 ± 3mm Tape width 0~5mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p><p>2. Measure from end of COT up to edge of connector 25±3mm using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div>	<p>MEASURING TAPE</p> 	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:

1. Assy parts
2. Black tape [4pcs.]

3. Yellow tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

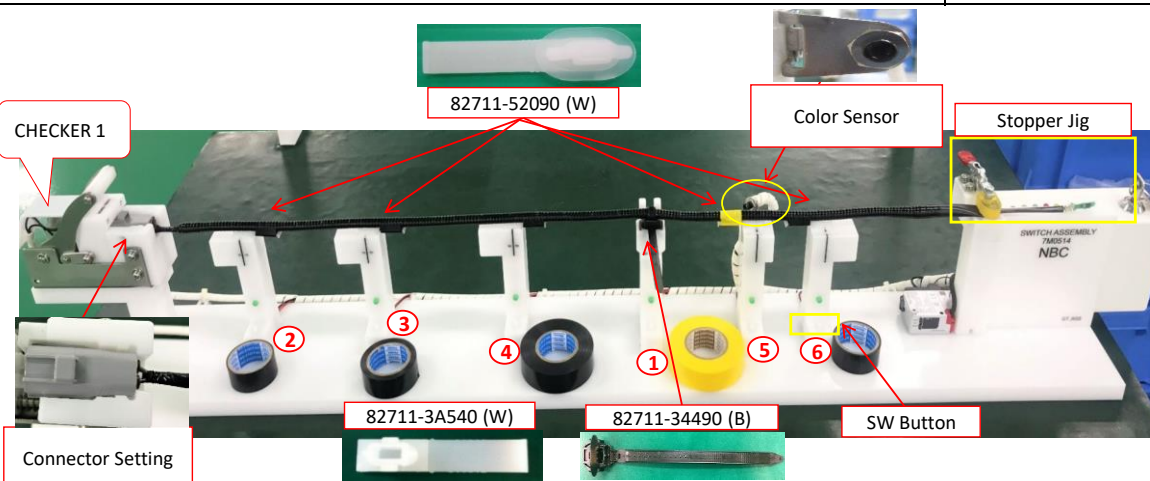
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp assembly



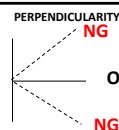
1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6188-0066 (GR) to Receiver base 1. Continue to set the harness in the jig up to the end of B/B wires and GR/BW hotmelted wires within the stopper, then pull down the Toggle clamp.

2. On clamp location 1, Initially tighten the band clamp using both hands. Continue if the sequence light in location 1 was ON.

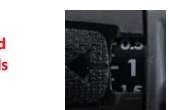
3. Get the bando gun using right hand then cut the band clamp. Press the SW button after cut. Continue if the sequence light on clamp location 2 was ON.



BANDO GUN



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: ø5 - 1~2, ø7 - 3~4



Fixed setting of band clamp cutter: 1~ 2

1. No loose clamp attached
2. No damage clamp
3. No flip-out tape
4. No peel-off tape
5. No loose tape
6. No wrong use of tape

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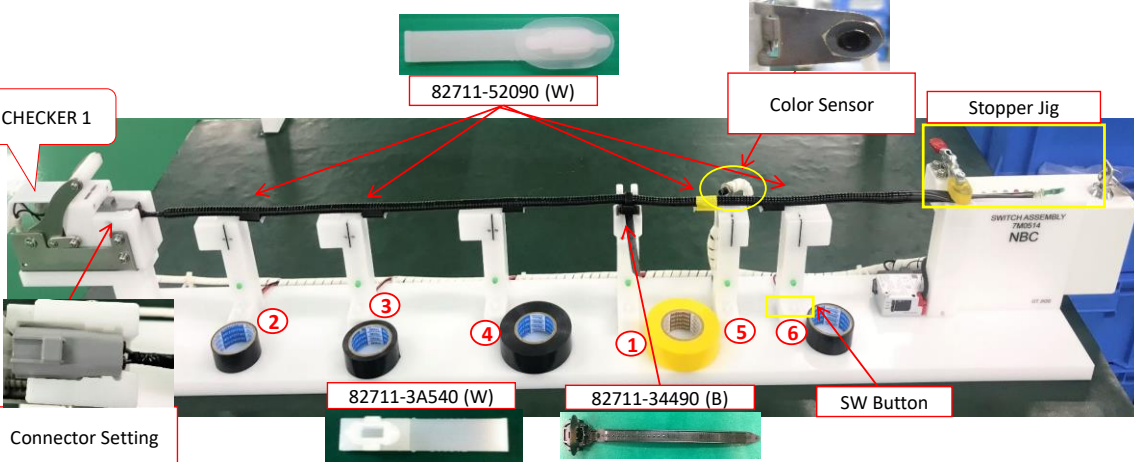
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P2 Clamp assembly Continuation	 <p>4. Hold the tape on clamp location 2 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in location 3 was ON.</p> <p>5. 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 the sequence light in location 4 was ON.</p> <p>6. 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 the sequence light in location 5 was ON.</p> <p>7. Hold the yellow 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. Continue if the sequence light in location 6 was ON.</p> <p>8. Hold the tape on clamp location 6 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.</p> <p>9. Conduct POINT CHECKING before removal from jig.</p>		4	

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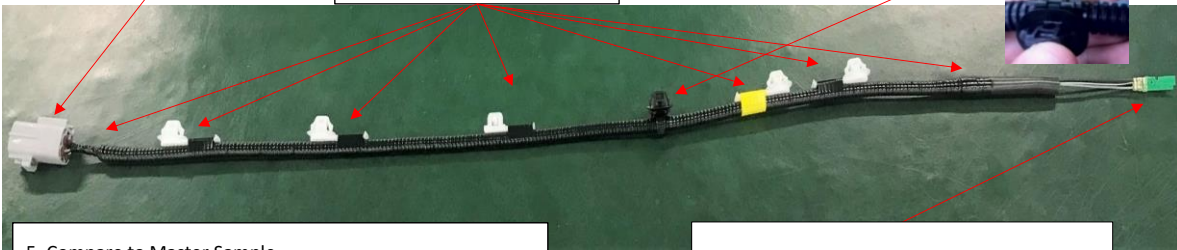
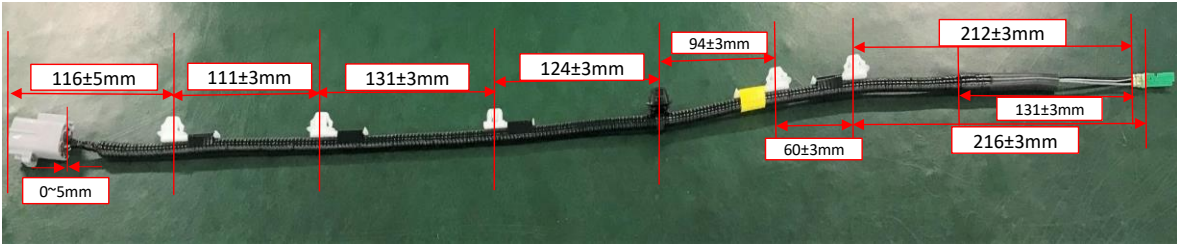
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PARTS:		n/a	JIG		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Visual/By Two's Inspection	<div>1. Check the connector lock</div> <div>2. Check the presence of all clamp attachment and taping condition.</div> <div>3. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div> <div>4. Check the hotmelt and terminal appearance, make sure no deformed terminal.</div> <div>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div> 			MASTER SAMPLE
5	Measurement	<div>MEASURING TAPE</div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> 			FOR HATSUMONO AND OWARIMONO 1. No wrong dimension

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