

	<b>WORK INSTRUCTION</b>				Effectivity Date:		November 12, 2022	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: <b>310B / 7M0555-7020A</b>		Customer: <b>TRJ</b>		Document No.: <b>WI-ENG-PDE-116C</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.: 1 of 7

<b>PARTS:</b>	1. Clamp 82711-48210 (B); Clamp 82711-52090 (W); Black tape [3pcs.]; Orange tape; Assy parts				<b>JIG:</b>	1. Clamp Assembly jig			
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Table Lay-out	<div style="text-align: center;"> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear required 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>	1. No missing parts/tools. 2. No excess parts/ tools.  <div style="text-align: center;"> </div> <div style="text-align: center; margin-top: 10px;"> </div>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/12/22	7	Improve Quality pointers; Reminders/Notes and references on page no.2,3,4,5,6 and 7; Improve Work procedure/Illustration on process no.4- Visual/ By two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
07/13/22	6	Apply additional Work Procedure/Illustration in Visual/By two's inspection due to process improvements.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
06/02/22	5	Additional Table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2018			

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☐ PROTOTYPE

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### PARTS:

1. Clamp 82711-48210 (B)
2. Clamp 82711-52090 (W) [2pcs.]

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

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

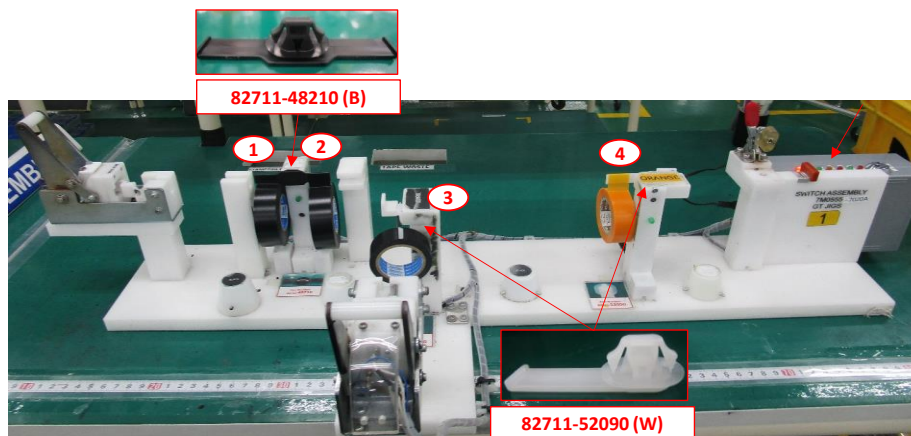
### TOOLS/PPE

### QUALITY POINTERS

2

P3

Clamp Setting



1. Get 1pc. of clamp **82711-48210 (B)** then attach to location **1 and 2**

2. Get 2pcs. of clamp **82711-52090 (W)** then attach to location **3 and 4** on jig.

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

n/a

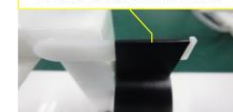
1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position
5. No wrong use of clamp

### Important reminders/Note/s:

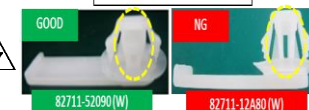
1. Please use calibrated/verified measuring tape when getting the measurement.

#### STANDARD TAPING FOR CLAMP

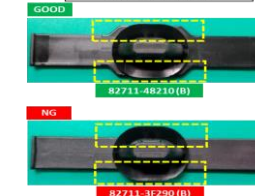
One side tape under clamp



#### CLAMP ILLUSTRATION



#### CLAMP ILLUSTRATION



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## PARTS:

1. Assy parts

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

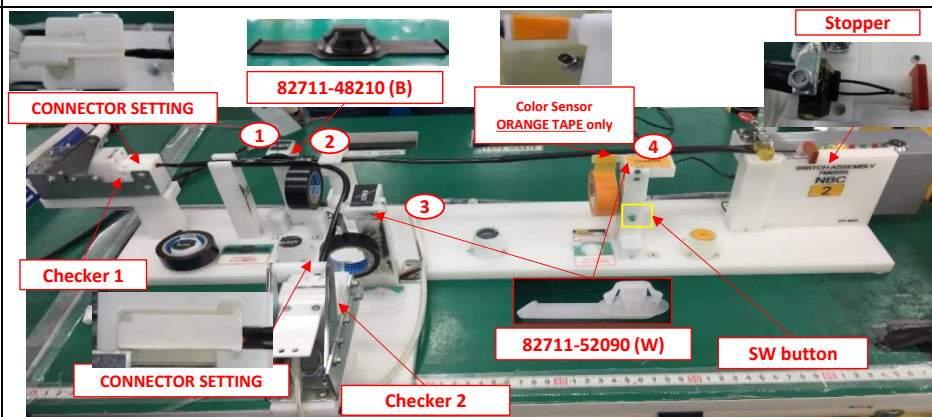
## TOOLS/PPE

## QUALITY POINTERS

3

P3

Clamp Assembly



1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector **6098-3802 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6098-2220 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Last, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then press by **Toggle clamp**. Continue if the sequence light in 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.



n/a

## Important reminders/Note/s:

1. Make sure no gap between the terminals and stopper jig.



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Purpose:

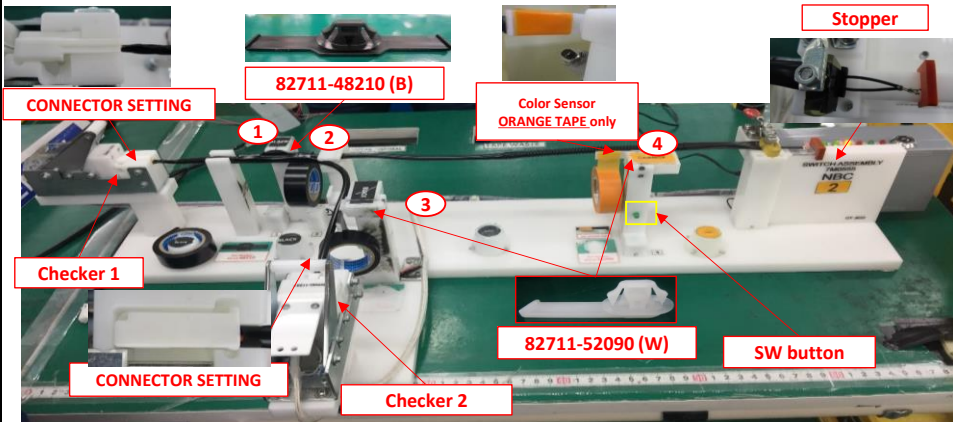

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly (Continuation)	<div></div> <div><div>3. Hold the tape on clamp location <b>1</b> then start taping using both hands. Make <b>3 windings</b> of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location <b>2</b> was on.</div><div>4. Hold the tape on clamp location <b>2</b> then start taping using both hands. Make <b>3 windings</b> of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location <b>3</b> was on.</div><div>5. Hold the tape on clamp location <b>3</b> then start taping using both hands. Make <b>3 windings</b> of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location <b>4</b> was on.</div><div>6. Hold the tape on clamp location <b>4</b> then start taping using both hands. Make <b>3 windings</b> of tape then cut the tape. <i>(Note: Color sensor light will beep/buzz if sensor detects Orange tape on the first winding of tape).</i> Press the SW button after taping. Go sound will be heard.</div><div>7. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</div></div>	n/a	<div>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp</div> <div><div>7</div><b>Important reminders/Note/s:</b>  1. Make sure no gap between the terminals and stopper jig.</div> <div></div>

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

Model Code/Part Number: **310B / 7M0555-7020A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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Validity Date:

**n/a**

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## PARTS:

1. Assembled parts
2. Master sample

**JIG**

n/a

**NO.**

**PROCESS NAME**



**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

4

P3

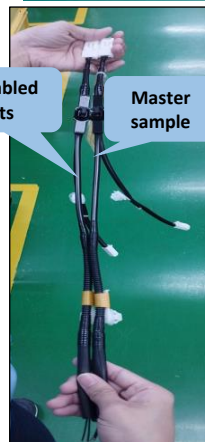
Visual/By Two's Inspection



**ACTUAL SAMPLE**

Assembled parts

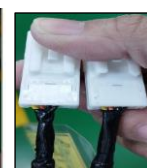
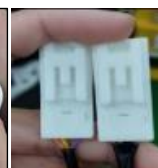
Master sample



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



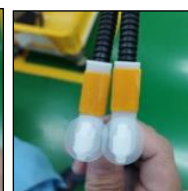
2. Check the **terminal appearance**, and **wire insertion**.



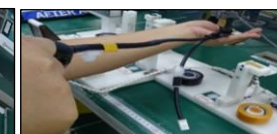
3. Check the **presence of clamp attachment**. Conduct **slightly bending of part with wing-type clamp**.



4. Check the **presence of all clamp attachment**, **taping condition** and **color of tape**.



5. Check the **correct facing of clamp**.



**MASTER SAMPLE**



1. No skip checking during inspection

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### PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

7

WORK PROCEDURE/ ILLUSTRATION

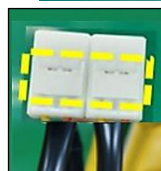
TOOLS/PPE

QUALITY POINTERS

4

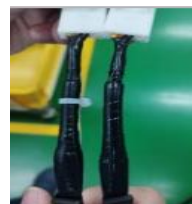
P3

Visual/By Two's  
Inspection (Continuation)

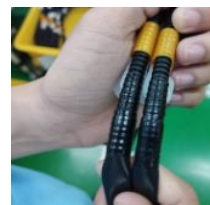


7. Check the **taping condition**.  
Conduct **slight pulling of VT**  
during bending of part with COT  
to VT taping to **avoid overlook of  
missing tape**.

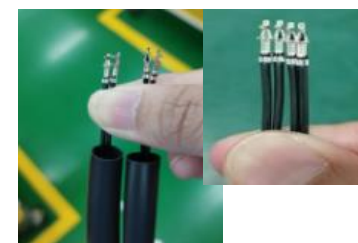
6. Check the **terminal appearance**, and **wire  
insertion**.



8. Check the **Y-Taping  
condition**.



9. Check the **taping  
condition of COT to  
Sunprene**. Conduct  
**slightly bending of parts**.



10. Check the **terminal appearance**. Must be  
**no deformed terminal**.

MASTER SAMPLE



1. No missing tape
2. No wrong facing of clamp

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n/a

**JIG**

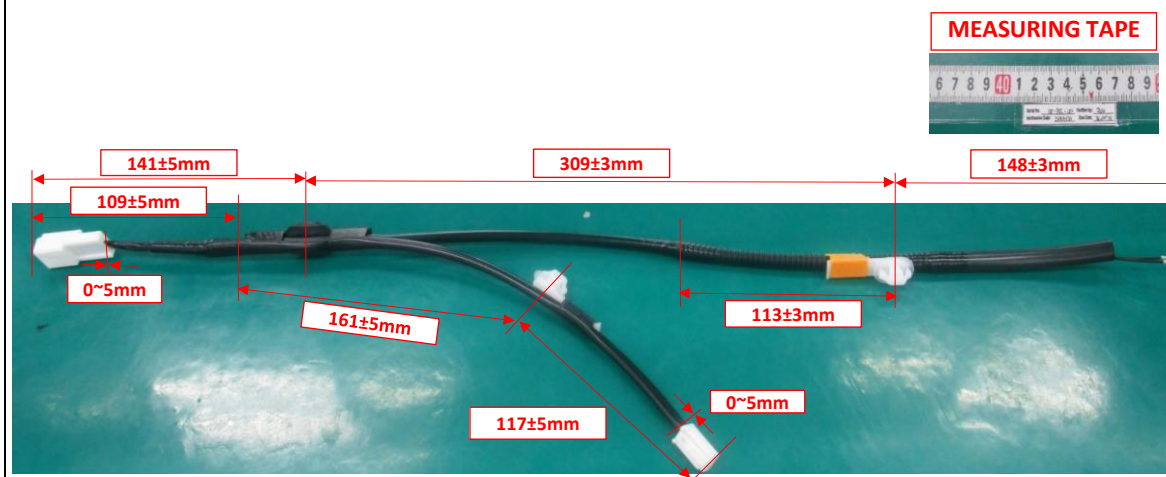
n/a

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

5

P3

Measurement



1. No wong dimension

**Important reminders/Note/s:**

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

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