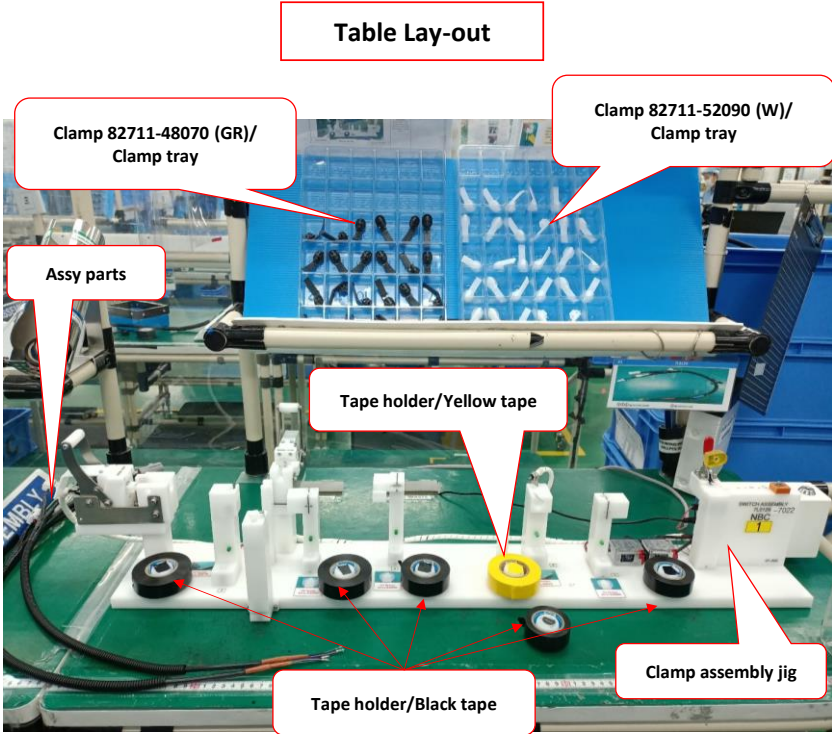
	<b>WORK INSTRUCTION</b>		Effectivity Date:	<b>October 22, 2021</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>		Validity Date:	<b>n/a</b>	
	Model code/Part number: <b>910B / 1 7L0126-7022</b>	Customer: <b>TRQSS</b>	Document No.:	<b>WI-ENG-PDE-272C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

<b>PARTS:</b>		1. All parts (Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape; Yellow tape)				<b>JIG</b>	1. Clamp assembly jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
1	P3					n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position		
Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/22/21	1	Change part number due to additional clamp quantity 82711-52090 (W). Change from pre-launch to masspro. Add table lay-out.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes
09/17/21	0	Initial issue.				D.Castillo	J.Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	September 13, 2021		

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

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n/a

Product Name/Code: 910B / 1 7L0126-7022

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## PARTS:



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

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

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

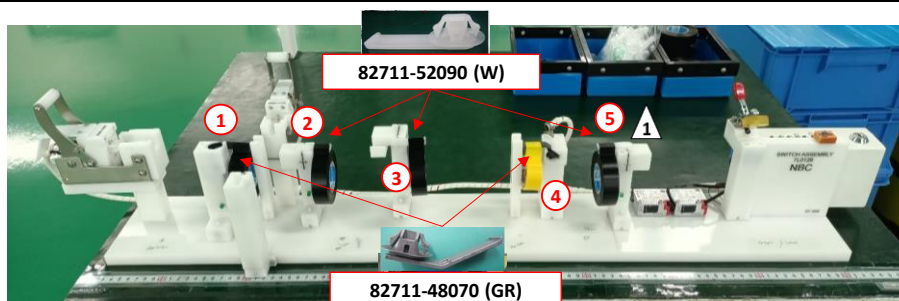
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

2

Clamp Setting



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

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

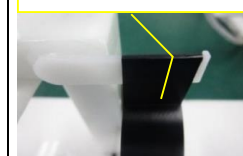


2. Get **3pcs.** of clamp **82711-52090 (W)** using right hand then set to clamp location **2, 3 and 5** using both hands.

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

## STANDARD TAPING FOR CLAMP

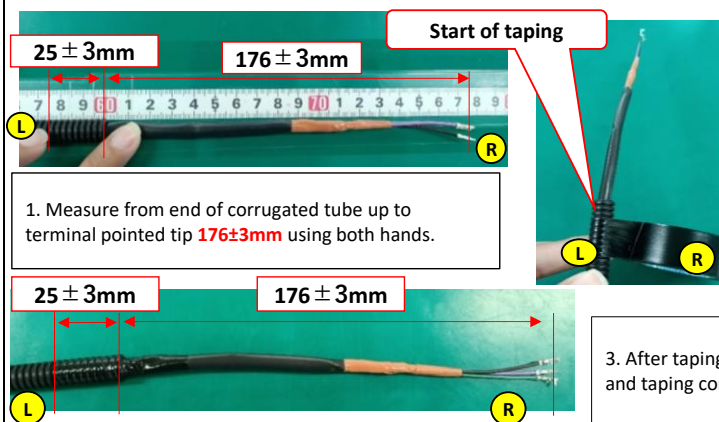
One side tape under clamp



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

**Note:** Please check the Clamp first before start of assembly to avoid wrong use of clamp.

3

Taping 5  
Black corrugated tube to  
Black sunprene tube

1. Measure from end of corrugated tube up to terminal pointed tip **176±3mm** using both hands.

2. Get the **Black tape** using right hand then start taping process using both hands.

**Note:** Please refer to **WI-PRO-ASY-001** for taping procedure.

3. After taping, check the measurement and taping condition.

## Measuring Tape



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

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

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## WORK INSTRUCTION

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910B

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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1

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## PARTS:

1. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

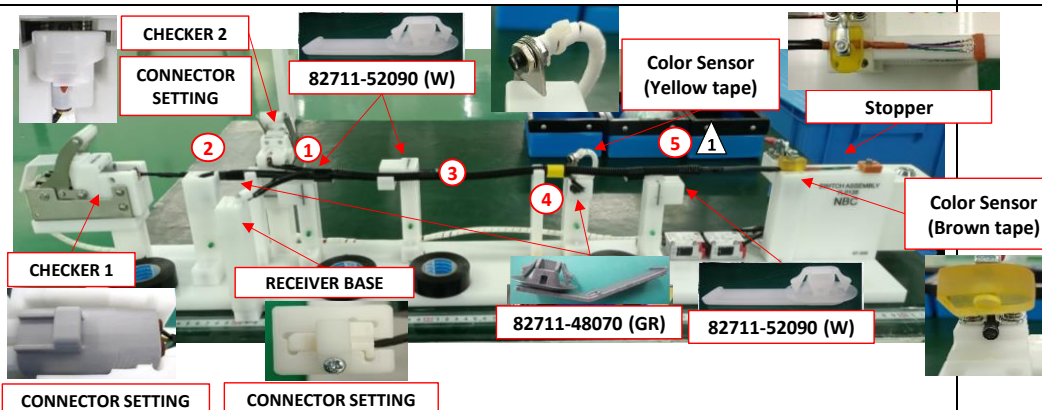
## TOOLS/PPE

## QUALITY POINTERS

3

P3

Clamp Assembly



n/a

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. Last, set the terminals end together within the stopper then press by **Toggle clamp**.

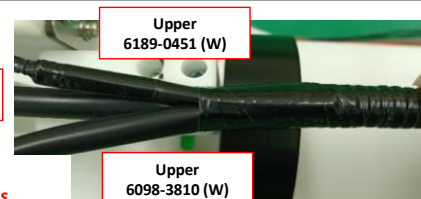
2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Check if the sequence light of location **1** was **ON**.

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**.



Bottom  
6188-0066 (GR)

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



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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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: 910B / 1 7L0126-7022

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

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## PARTS:

1. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

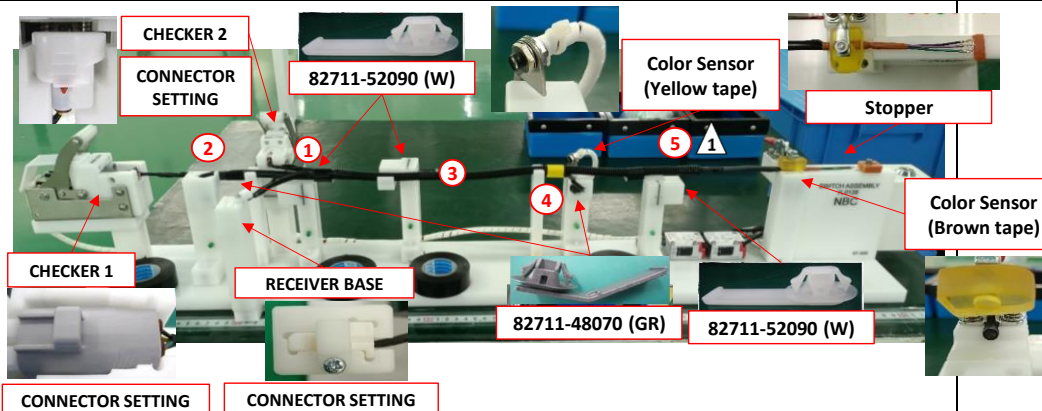
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

3

P3

Clamp Assembly  
(Continuation)

n/a

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

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 buzzer once the color sensor detect the Yellow tape.*

1 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.

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code:

910B

/

7L0126-7022

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

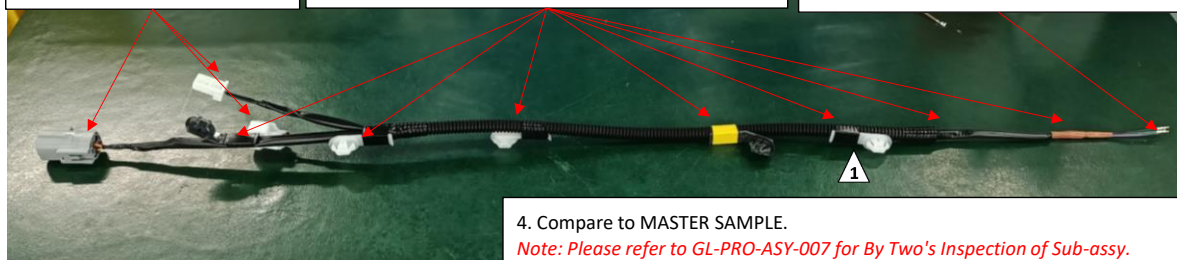
4

Visual Inspection/By Two's inspection

1. Check the connector lock.

2. Check the clamp attachment and taping condition.

3. Check the terminals appearance. Make sure no deformed terminal.



4. Compare to MASTER SAMPLE.

Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.

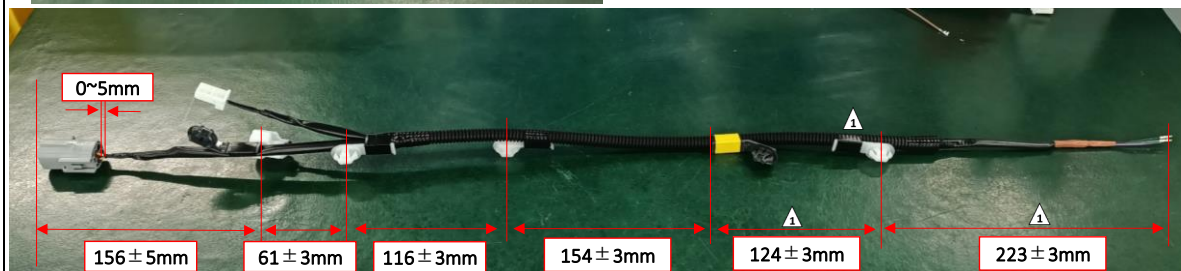
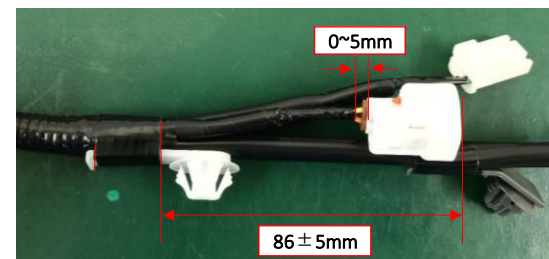
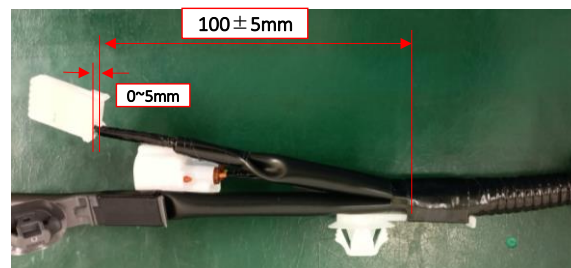
Master Sample



5

P3

Measurement



NOTE: HATSUMONO AND OWARIMONO

1. No wrong dimension

Measuring Tape



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

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