



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 15, 2023

Model Code/Part Number: 900B/910B / 7N0101-7020B

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-686

Revision No.:

0

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## PARTS:

1. Assy parts: Clamp 82711-33380 (B); Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Black tape [5pcs.]; Orange tape [2pcs.]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/15/23	0	Initial Issue. Excluded Process from WI-ENG-PDE-48C; Change process Name/Title from "TAPING ASSEMBLY PROCESS" to <b>CLAMP ASSEMBLY PROCESS</b> ; Change Document Control number from <b>WI-ENG-PDE-458C</b> to <b>WI-ENG-PDE-686</b> due to separation of process.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				

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DCC Stamp



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### PARTS:

1. Clamp 82711-48070 (GR)
2. Clamp 82711-52090 (W) [4pcs.]
3. Clamp 82711-33380 (B)

4. Black tape [5pcs.]
5. Orange tape [2pcs.]

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

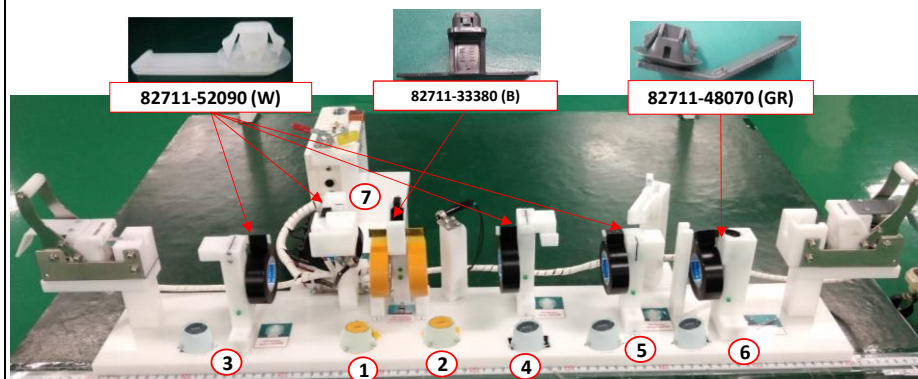
### TOOLS/PPE

### QUALITY POINTERS

2

n/a

Clamp setting



1. Get 1pc. of clamp **82711-33380 (B)** using right hand then set to clamp location **1** and **2** using both hands.

2. Get 1pc. of clamp **82711-48070 (W)** using right hand and set to clamp location **6** using both hands.

3. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **3** and **7** using both hands.

4. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **4** and **5** using both hands.

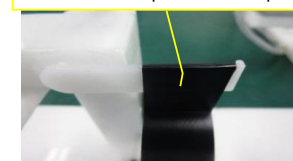
5. Initially attach **Orange tape** to clamp location **1** and **2** using both hands.

6. Initially attach **Black tape** to clamp location **3**, **4**, **5**, **6** and **7** using both hands.

n/a

### STANDARD TAPING FOR CLAMP

One side tape under clamp



### Important reminders/Note/s:

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

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

### CLAMP ILLUSTRATION



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### PARTS:

1. Assy parts
2. Black tape [5pcs]

3. Orange tape [2pcs]

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

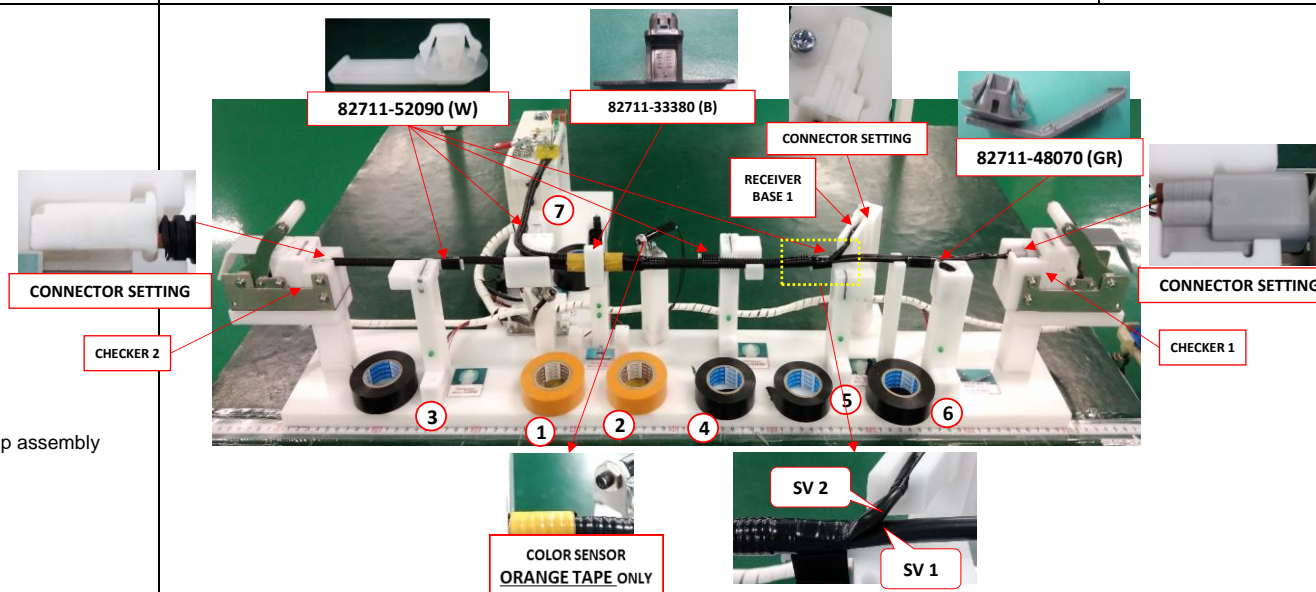
### TOOLS/PPE

### QUALITY POINTERS

3

n/a

Clamp assembly



1. Get the assy parts and set into jig. *(See above picture for correct setting of harness)*. First, set the connector 6188-0175 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the 6098-3810 (W) to Receiver base 1 then lock. Continue the harness in jig. Next, set the connector 6098-2220 (W) to Receiver base 2 the pull the checker fixture for continuity checking. Last, set the terminal and PCB end within the stopper jig then press by toggle clamp. Continue if 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 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location 2 was ON.



**Important reminders/Note/s:**  
**1. Make sure no gap between stopper and PCB**

1. No flip-out tape
2. No peel-off tape
3. No wrong use of tape
4. No damaged clamp
5. No wrong usage of parts
6. No missing clamp

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### PARTS:

1. Assy parts
2. Black tape [3pcs]

3. Orange tape [2pcs]

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

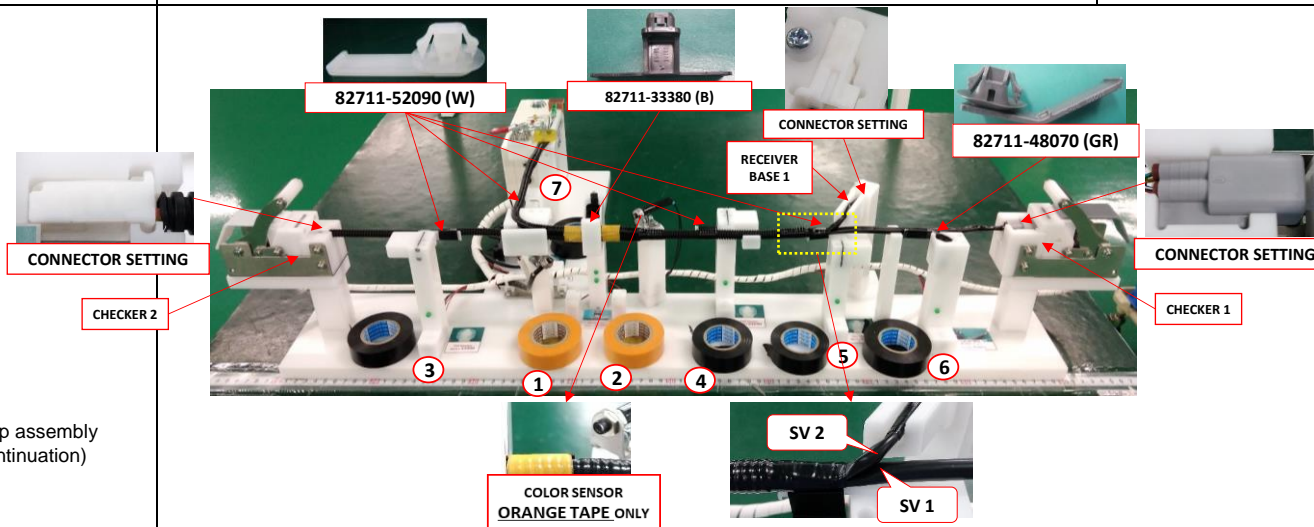
### TOOLS/PPE

### QUALITY POINTERS

3

n/a

Clamp assembly  
(Continuation)



4. Hold the tape on clamp location **2** then start taping using both hands. Make **3 windings** of tape then cut the tape. **Color sensor** light will beep/buzz if sensor detects **Orange tape**. Press the **SW button** after taping. Continue if sequence light in location **3** was **ON**.

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 sequence light in location **4** was **ON**.

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 sequence light in location **5** was **ON**.



**Important reminders/Note/s:**  
**1. Make sure no gap between stopper and PCB**

1. No flip-out tape
2. No peel-off tape
3. No wrong use of tape
4. No damaged clamp
5. No wrong usage of parts
6. No missing clamp

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

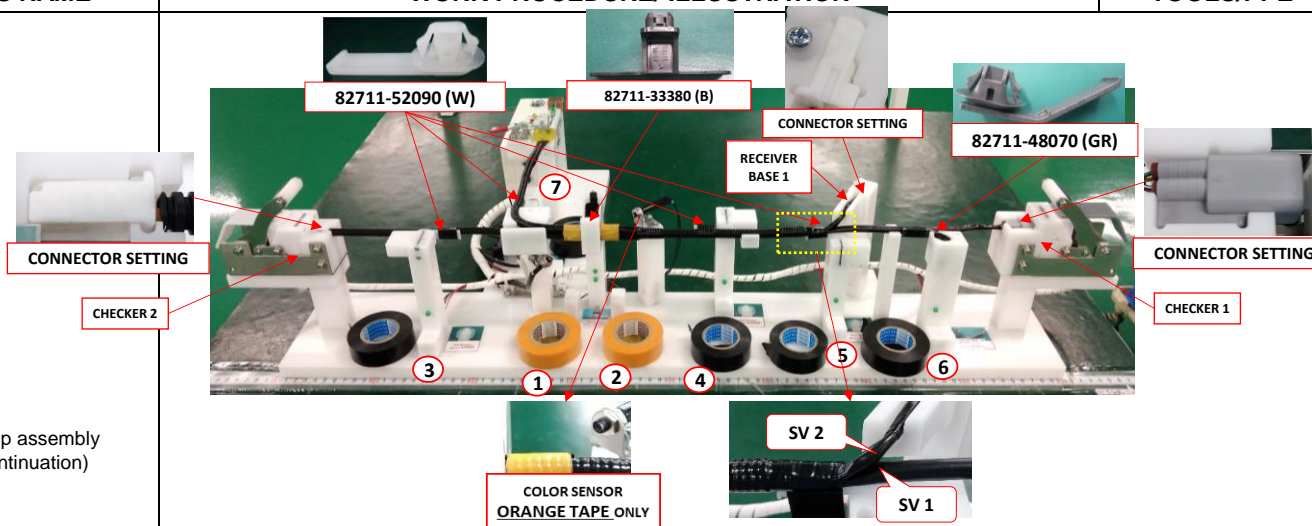
### TOOLS/PPE

### QUALITY POINTERS

3

n/a

Clamp assembly  
(Continuation)

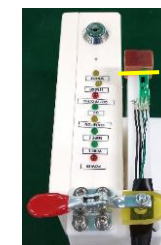


7. Hold the tape on clamp location **5** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location **6** was **ON**.

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. Continue if sequence light in location **7** was **ON**.

9. Hold the tape on clamp location **7** 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.

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



### Important reminders/Note/s:

1. **Make sure no gap between stopper and PCB**

1. No flip-out tape
2. No peel-off tape
3. No wrong use of tape
4. No damaged clamp
5. No wrong usage of parts
6. No missing clamp

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PARTS:

1. Assy parts

JIG

n/a

NO.

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WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

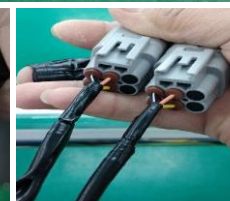
n/a

Visual/By Two's  
Inspection

ACTUAL PRODUCT

Assembled  
partsMaster  
sample

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



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



3. Check the **presence of  
clamp** attachment and  
taping condition.

MASTER SAMPLE



1. No skip checking during inspection

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PARTS:

1. Assy parts

JIG

n/a

NO.

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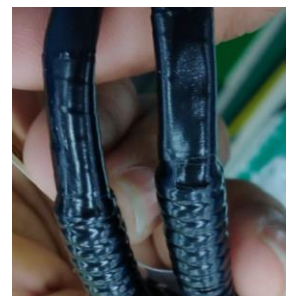
TOOLS/PPE

QUALITY POINTERS

4

n/a

Visual/By Two's  
Inspection  
(Continuation)



4. Check the **Y-TAPING** condition.



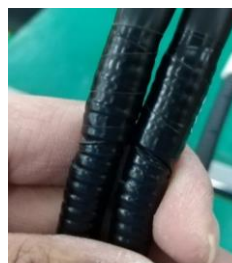
5. Check the **insertion, connector lock and taping condition.**



6. Check the **presence of clamp, Y-Taping and clamp attachment taping condition.**



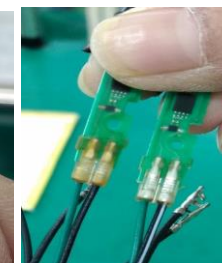
7. Check the **insertion and connector lock condition.**



8. Conduct **bending** and check the **taping condition of COT to VM tube (Sunprene).**



9. Check the **PCB and terminal appearance.**



MASTER SAMPLE



1. No skip checking during inspection

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PARTS:

n/a

JIG

n/a

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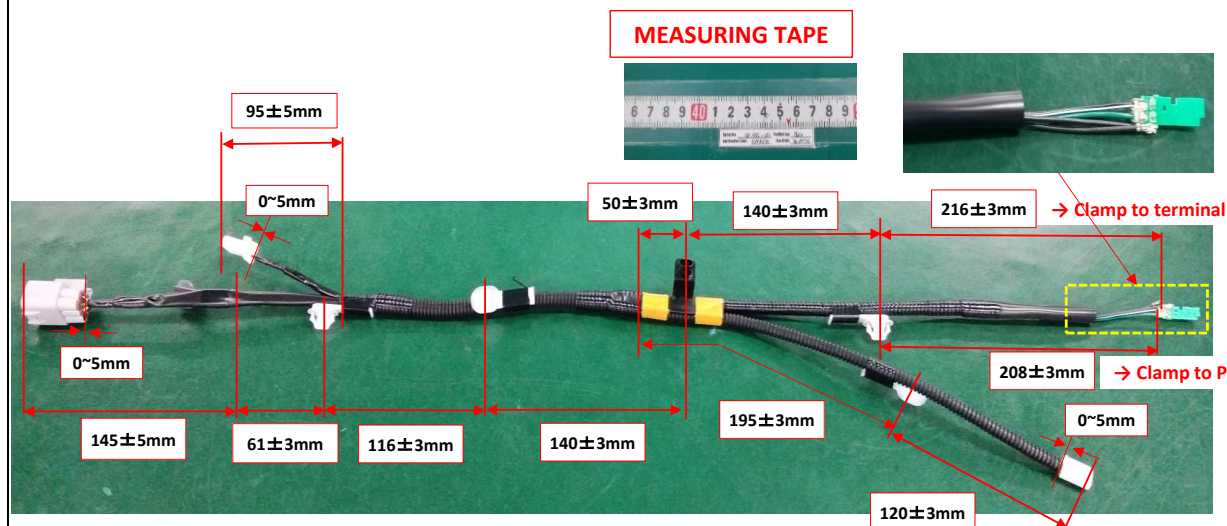
TOOLS/PPE

QUALITY POINTERS

5

n/a

Measurement



Important reminders/Note/s:

1. FOR HATSUMONO AND OWARIMONO
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No wrong dimension

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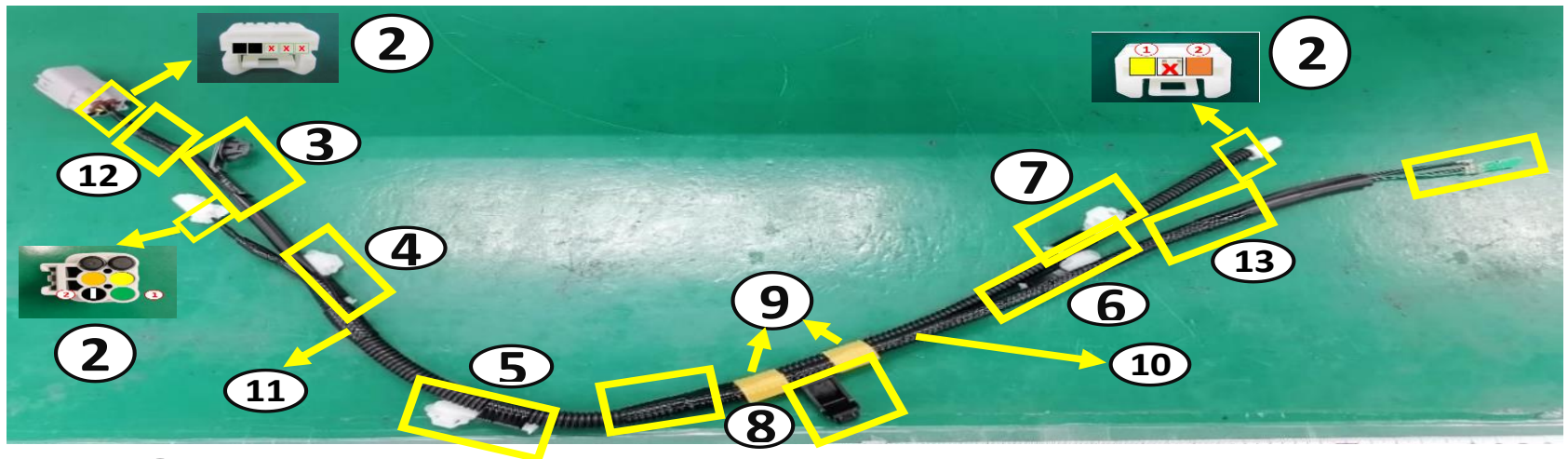
JIG

n/a

### QUALITY CHECKPOINTS

P3

# 7N0101-7020B



① No UNLOCKED/HALFLOCKED

⑨ No Missing tape (Orange)

② No Wrong Insert

⑩ ⑪ ⑫ ⑬ No Missing tape

③ ④ ⑤ ⑥ ⑦ ⑧ No Missing Clamp

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