



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 05, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 740BW / 7H0423W7020

Customer:

NBS

Document No.:

WI-ENG-PDE-479B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

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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

Table Lay-out

Clamp 82711-34490 (B)/
Clamp boxClamp 82711-35730 (B)/
Clamp trayClamp 82711-52090 (W)/
Clamp tray

Assy parts

Bando gun

Black tape/Tape holder

Clamp Assembly jig

Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

BANDO
GUN

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by:
05/05/22	2	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
04/28/22	1	Removal of undertape in clamp 82711-35730 (B) during assembly/process	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
04/20/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				

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PARTS:	1. Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W) 3. Black tape [2pcs.]			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Setting	<p>1. Get 1 pc. of band clamp 82711-34490 (B) then set to clamp location 1 using both hands.</p> <p>2. Get 1 pc. of clamp 82711-52090 (W) then set to clamp location 3 using both hands.</p> <p>3. Initially attach Black tape on clamp location 3 using both hands.</p>		n/a	<p>STANDARD TAPING FOR CLAMP</p> <p>One side tape under clamp</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p>

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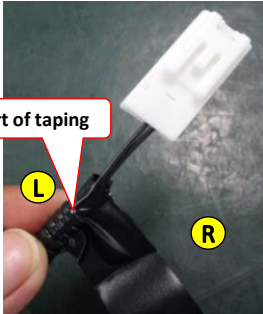
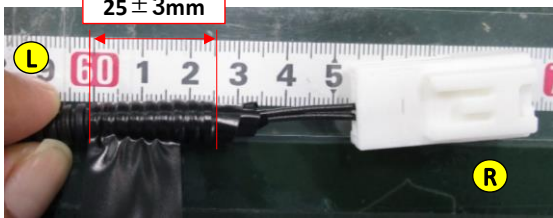
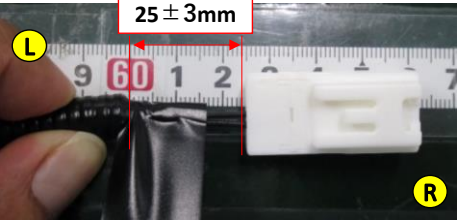
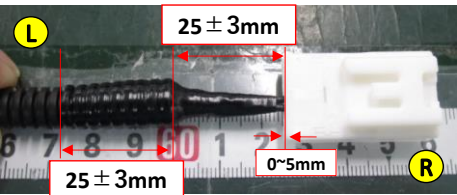

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PARTS:	1. Assy part 2. Black tape				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P2 Taping 1 Corrugated tube to wire near connector	<div data-bbox="600 427 954 874"><p>Start of taping</p><p>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</p></div> <div data-bbox="972 459 1523 802"><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 data-bbox="600 890 1055 1110"><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 <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div data-bbox="600 1134 1055 1329"><p>25 ± 3mm 0~5mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<p data-bbox="1556 751 1762 775">MEASURING TAPE</p>  <ul data-bbox="1785 802 2007 959" style="list-style-type: none">1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape	<p data-bbox="1800 587 2107 691"><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p>	

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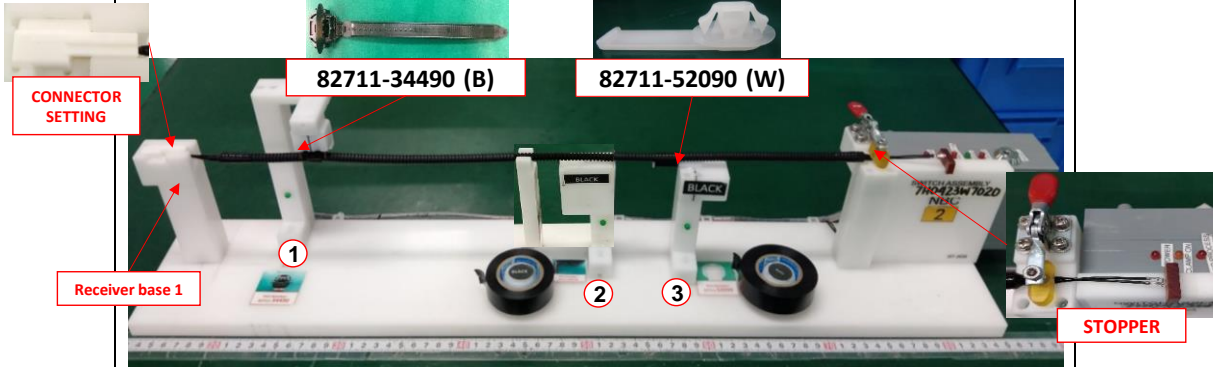
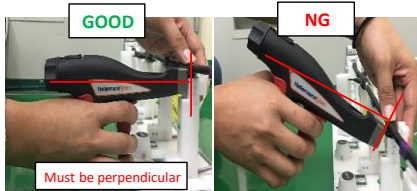
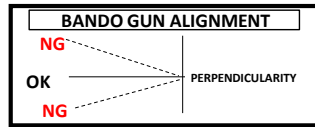


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PARTS:	1. Assy parts 2. Black tape			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly	<div data-bbox="465 422 1675 790"></div> <div data-bbox="593 798 1120 997"><p>1. Get the assy 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></div> <div data-bbox="1120 798 1523 997"><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></div> <div data-bbox="593 1005 1086 1093"><p>3. Initially tighten the band clamp on location 1 using both hands.</p></div> <div data-bbox="1086 1005 1523 1149"><p>4. Get the bando gun using right hand then cut the band clamp on location 1. Continue the process if sequence light button on location 2 was on.</p></div> <div data-bbox="649 1117 1064 1308"></div> <div data-bbox="1086 1165 1400 1292"></div>		<div data-bbox="1825 422 2094 590"></div> <div data-bbox="1803 598 2116 694"><p>Note: Make sure no gap between stopper jig and terminals.</p></div> <div data-bbox="1534 821 1780 973"></div> <div data-bbox="1579 981 1736 1021"><p>BANDO GUN</p></div>	<div data-bbox="1780 805 2016 949"><p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</p></div>

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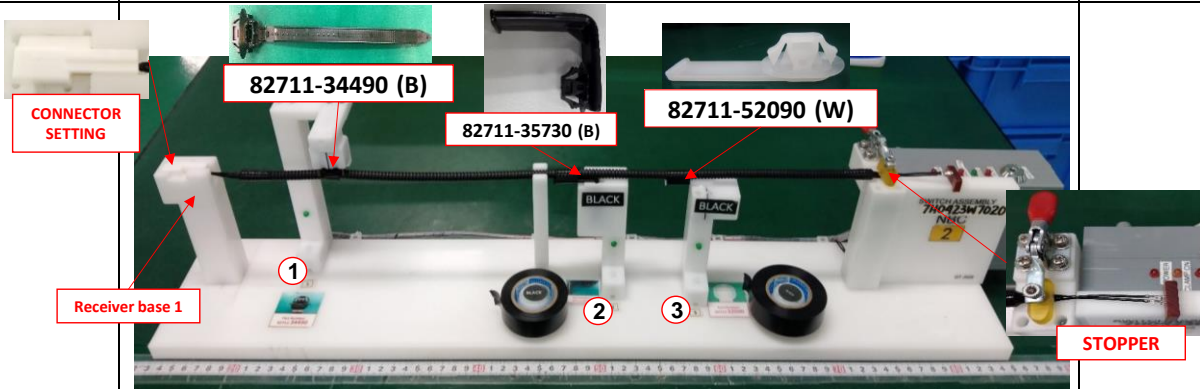
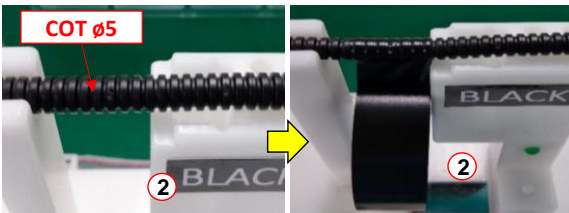
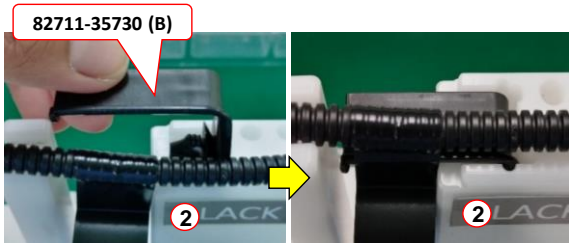
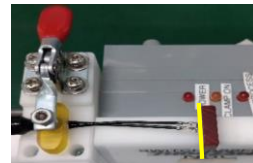
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PARTS:		1. Assy parts 2. Clamp 82711-35730 (B) 3. Black tape	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly (Continuation)	   <p>5. Conduct spot taping on COT on clamp location 2 using both hands. Make 2 windings of tape and do not cut.</p> <p>6. Get 1 pc. of clamp 82711-35730 (B) then set to clamp location 2 using left hand.</p>	n/a	 <p>Note: Make sure no gap between stopper jig and terminals.</p> <ol style="list-style-type: none">1. No wrong use of tape2. No missing tape3. No damage clamp4. No missing clamp5. No skip process

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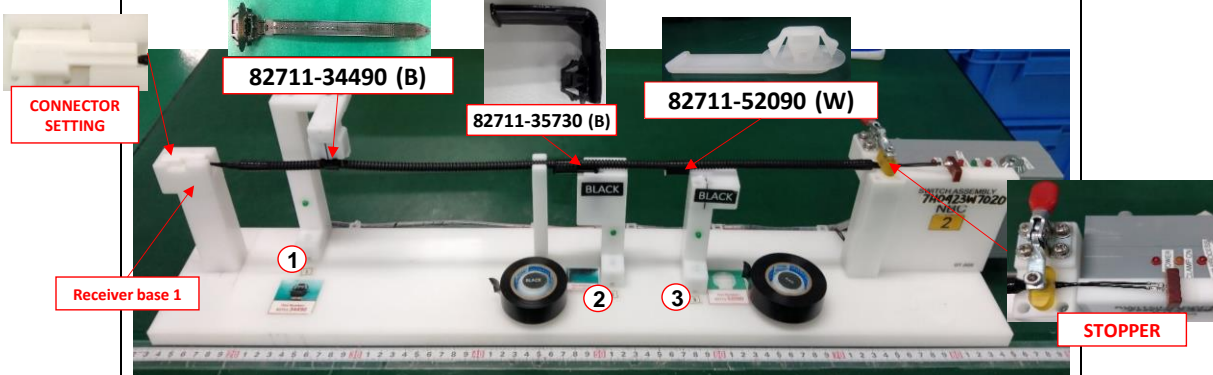


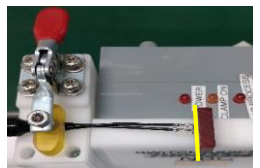
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PARTS:	1. Assy parts 2. Black tape			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly (Continuation)	   <p>7. Conduct clamp attachment on clamp location 2 using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if sequence light in location 3 was on.</p> <p>8. 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 .</p> <p>9. Conduct POINT CHECKING before removing the harness from jig.</p>		n/a	 <p>Note: Make sure no gap between stopper jig and terminals.</p> <p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</p>

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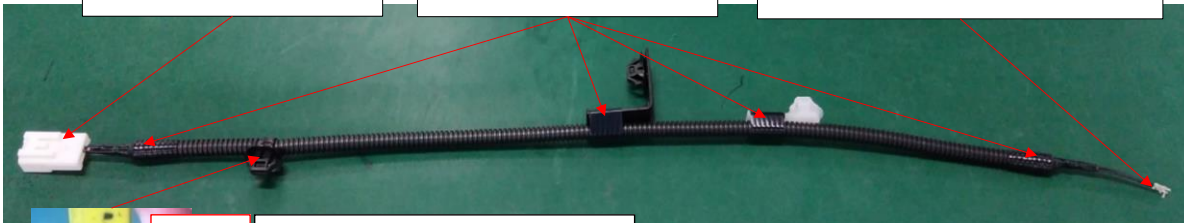



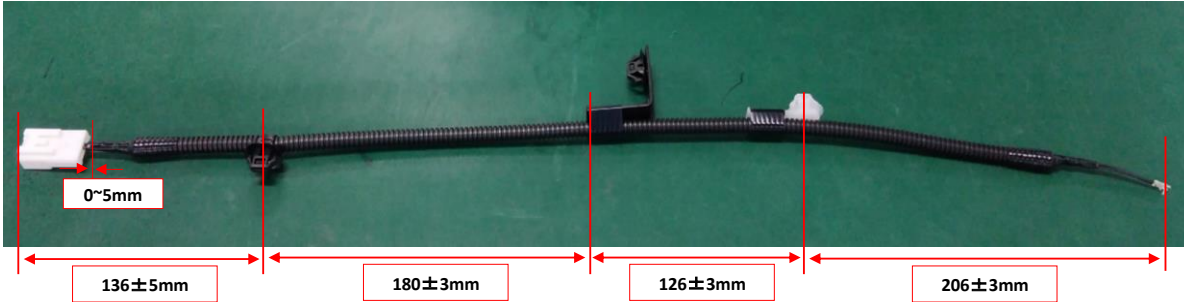
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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By two's inspection	<div>1. Check the double lock.</div> <div>2. Check the taping condition and clamp attachment.</div> <div>3. Check the terminal appearance, make sure no deformed terminal.</div> <div></div> <div></div> <div>4. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</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 
6		Measurement	<div></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div></div>		FOR HATSUMONO AND OWARIMONO ONLY 1. No wrong measurement

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