

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

Effectivity Date:

May 20, 2021

Product Name/Code: **550B / 4 7L0081-7022**Customer: **TRQSS**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-018B

Revision No.:

4

Page No.:

1 of 4

PARTS:

1. Clamp 82711-34490 (B)
2. Clamp 82711-48070 (GR)
3. Black tape [1pc.]

JIG:

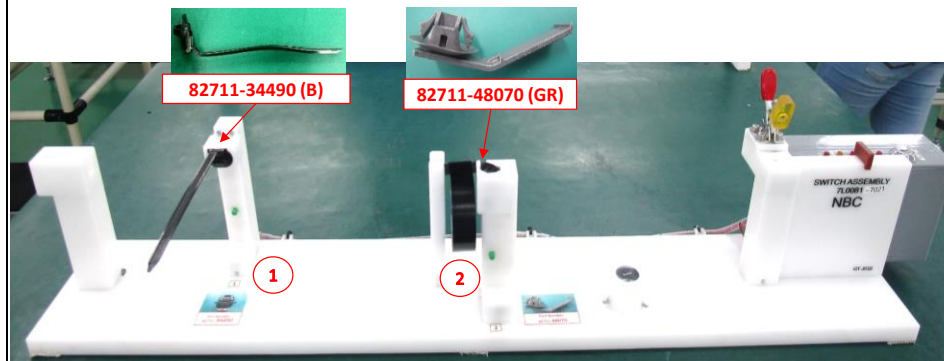
1. Clamp Assembly jig

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

1

P2

Clamp setting



1. Get 1 pc. of clamp **82711-34490 (B)** using right hand then set to clamp location 1 using both hands.

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

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

3. Initially attach **Black tape** to clamp location **2**.

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.

STANDARD TAPING FOR CLAMP

One side tape under clamp



1. No loose attachment of clamp
2. No wrong use of clamp
3. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/20/21	4	Revise due to change part number from 7L0081-7021 to 7L0081-7022 due to removal of taping from COT to wire near connector.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
05/01/21	3	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
06/10/19	0	Previously established as Engineering Instruction (EI-ENG-PDE-093). Initial issue.	J. Loterte	A. Shimamura	A. Arañes		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Product Name/Code:

550B

/ 4 7L0081-7022

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 20, 2021

Validity Date:

n/a

Document No.:

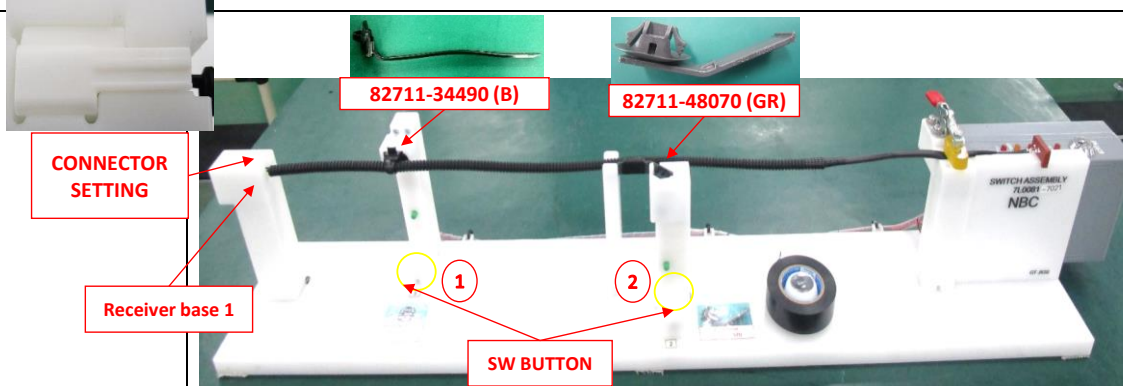
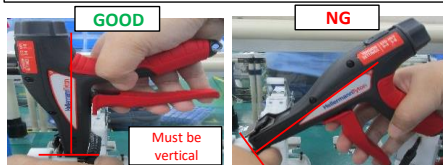


WI-ENG-PDE-018B

Revision No.:

4

Page No.:

2 of 4

PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp Assembly	<div><div></div><div><p>1. Get the assy parts and then put into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the B/B wires together within the stopper jig and then press by toggle clamp. Continue the process if sequence light in location 1 was ON.</p><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 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><div></div><div><p>BANDO GUN ALIGNMENT</p><p>VERTICAL</p><p>NG OK NG</p></div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div></div></div> <div><div></div><p>Bando Gun</p></div> <div><div></div><p>Make sure no gap between terminal and stopper jig.</p><div><ol style="list-style-type: none">1. No missing tape2. No damaged clamp3. No missing clamp4. No loose/tight clamp5. No wrong attachment of clamp6. No wrong use of clamp</div></div>		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

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

Product Name/Code: **550B / 4 7L0081-7022**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 20, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-018B

Revision No.:

4

Page No.:

3 of 4

PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

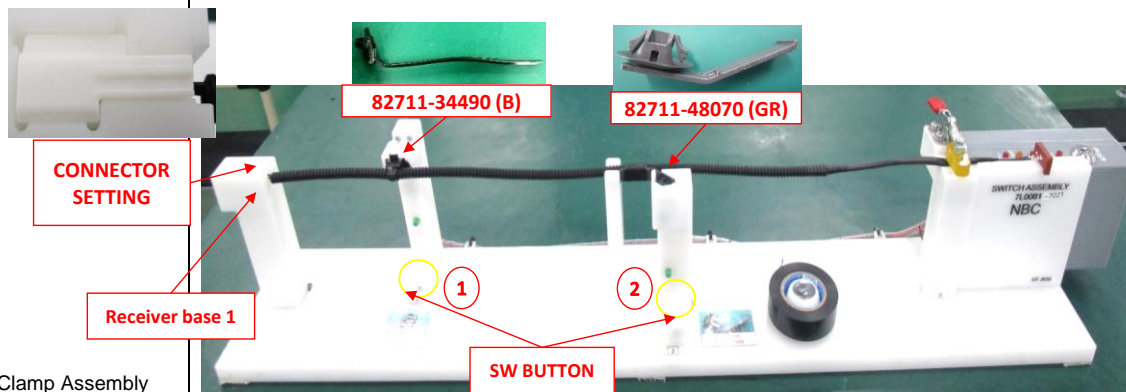
TOOLS/PPE

QUALITY POINTERS

2

P2

Clamp Assembly
(Continuation)



5. Hold the tape on clamp location **2**. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. **Go** sound will be heard.

6. Conduct **POINT CHECKING** before removing the harness from jig.

n/a



Make sure no gap between terminal and stopper jig.

1. No missing tape
2. No damaged clamp
3. No missing clamp
4. No loose/tight clamp
5. No wrong attachment of clamp
6. No wrong use of clamp

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 20, 2021

Product Name/Code:

550B

/ 4 7L0081-7022

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-018B

Revision No.:

4

Page No.:

4 of 4

PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Visual/By Two's Inspection	<div> <div>1. Check the connector lock.</div> <div>2. 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>3. Check the clamp attachment and taping condition.</div> <div>4. Check 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> </div>		<div>MASTER SAMPLE</div>
4	Measurement	<div> <div>MEASURING TAPE</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div>141±3mm</div> <div>188±3mm</div> <div>350±3mm</div> <div>185±3mm</div> <div>0~5mm</div> </div>		<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp