

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

Effectivity Date:

February 18, 2021Product Name/Code: **946B / 2 7N0074-7020A**Customer: **TRJ**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-122B

Revision No.:

2

Page No.:

1 of 3**PARTS:****2**

1. Clamp 82711-52090 (W)
2. Black tape

2

JIG:

1. Clamp Assembly jig

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

1

P2

Clamp setting

**82711-52090 (W)**

2

1

1. Get 1pc. of clamp **82711-52090 (W)** using right hand then set to clamp location **2**.2. Get the Black tape and initially attach on clamp location **2**.**Safety Instruction**

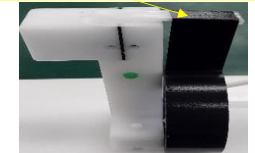
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

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 damaged 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:
02/18/21	2	Changed part number from 7N0074-7020 to 7N0074-7020A due to removal of taping from COT to wire near connector. Standardize the color of clamp in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Removal of cycle time	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
09/0120	1	Changed effectivity and validity date. Update cycle time in every process. Changed cycle time from 67 sec's to 45.4 sec's	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

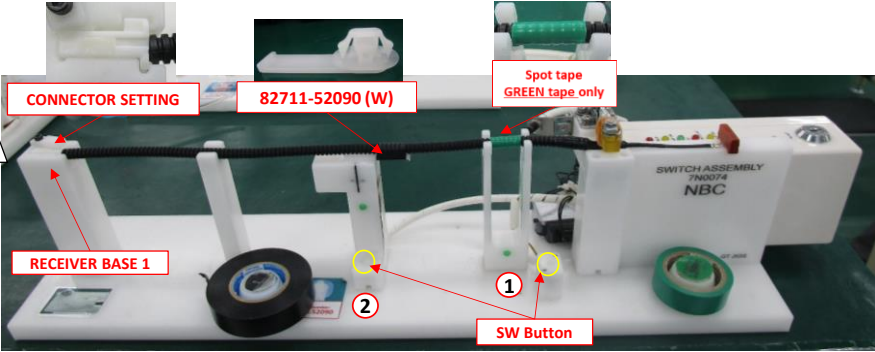

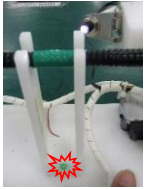

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DCC Stamp

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	2 of 3	



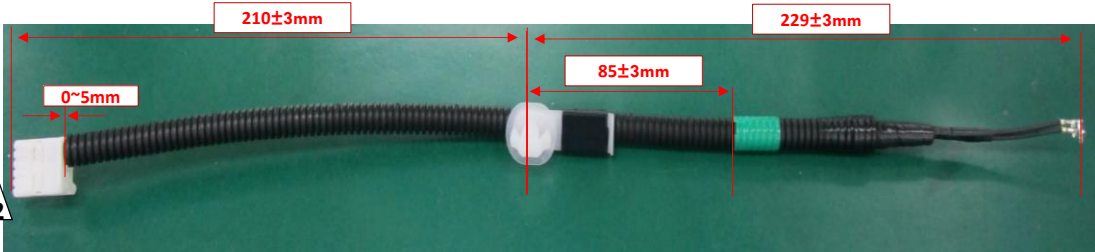
PARTS:	1. Assy parts 2. Green tape 2. Black tape		JIG	1. Clamp Assembly Jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Assembly	 <p>CONNECTOR SETTING</p> <p>82711-52090 (W)</p> <p>Spot tape GREEN tape only</p> <p>RECEIVER BASE 1</p> <p>2</p> <p>1</p> <p>SW Button</p> <p>1. Get the assy parts (<i>see above picture for correct setting</i>) and then put it on jig using both hands. Set the B/B wires ith terminal end together within the stopper then pressby Toggle clamp. Continue if the sequence light was on.</p> <p>2. Check if all LED light for POWER ON, WIRE1 and WIRE2, CLAMP, and SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>3. Get the GREEN tape and conduct spot taping (2~3 winds) on location 1 using both hands. You will heard a buzz if the tape detected by the color sensor. Press the switch button after taping.</p> <p>4. Hold the tape on clamp location 2 using right hand. Make 3 windings on clamp then cut the tape. Press the switch button after taping.</p> <p>5. Conduct POINT CHCKING before removing the harness from jig</p>  <p>Color sensor light will on if tape was detected</p> 	n/a	 <p>Note: Make sure no gap between stopper jig and terminal tip</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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PARTS:	n/a	JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	2 Visual/By two's inspection	<div> <div>1. Check the connector lock.</div> <div>2. Check the clamp attachment and taping condition.</div> <div>4. Check the terminal appearance. Make sure no deformed terminal.</div> <div>3. Check the presence of spot tape.</div> <div>5. Compare to Master sample. <i>Note: Refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div> </div> 		<div>MASTER SAMPLE</div> 
4	P2 Measurement	<div> <div>2 MEASURING TAPE</div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div>  </div>		<div>FOR HATSUMONO AND OWARIMONO ONLY</div> <div>1. No wrong dimension</div>

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