



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Model code/Part number:

YKC / 7N0033-7020

Customer:

TRJ

Car Model:

SUZUKI SOLIO

Document No.:

WI-ENG-PDE-961

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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## PARTS:

1. Assy parts; White tape

JIG:

1. Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

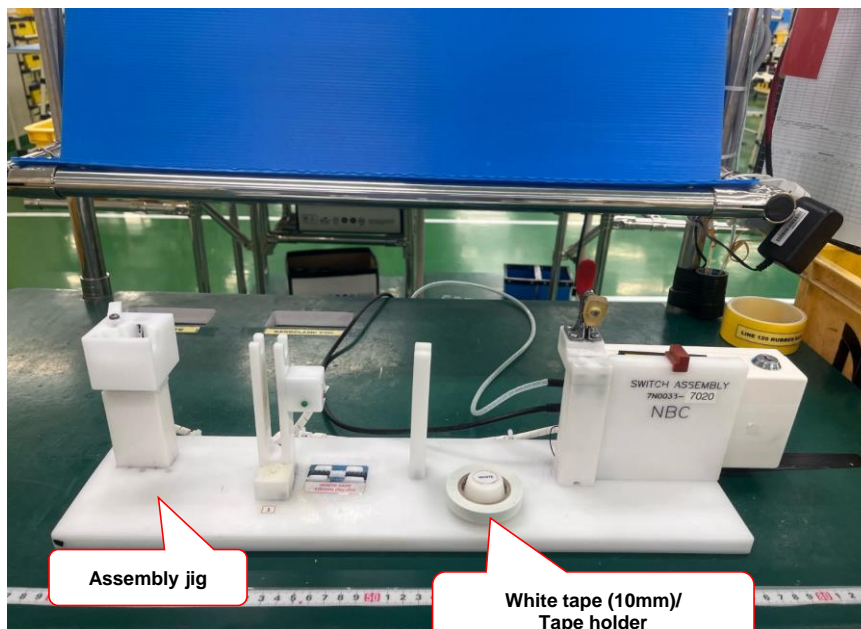
## QUALITY POINTERS

1

Clamp  
Assy

Table Lay-out

## TABLE LAY-OUT

**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.

**Document reference/s:**

1. Refer to **WI-ENG-PDE-296** for Taping assembly process

1. No missing parts/tools
2. no excess parts/tools
3. No wrong position of parts/tools

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/31/24

0

Initial issue.  
Separate assembly process from Taping assembly process.

D. Castillo

C.  
Villanueva

A. Arañes

n/a

D. Castillo

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted


Est. Date:

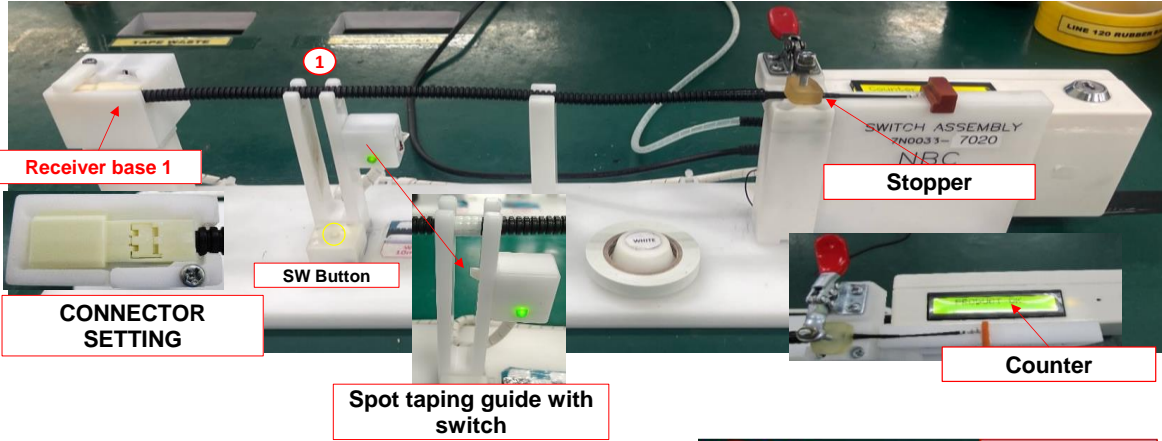
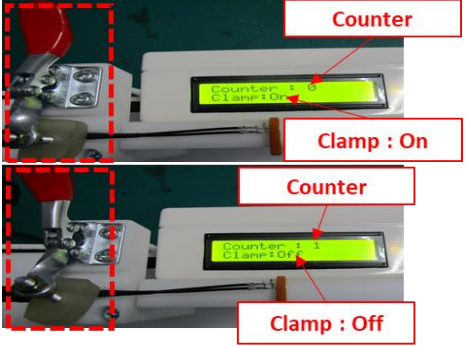
July 31, 2024

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DCC Stamp

	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>July 31, 2024</b>		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>YKC / 7N0033-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI SOLIO</b>	Document No.: <b>WI-ENG-PDE-961</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 4

<b>PARTS:</b>	1. Assy part 2. White tape 10mm (No slit)			JIG:	1. Assembly jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	Clamp Assy  Assembly (Spot Taping )	<div></div> <div><p>1. Get the assy parts and set to taping jig using both hands. <i>(See above picture for correct setting).</i> First, set the <b>7282-1020 (W)</b> to <b>Receiver base 1</b> then lock. Continue to set the harness, last set the <b>B-B wires</b> together within the stopper jig then press by toggle clamp. Continue if the sequence light in location <b>1</b> was <b>ON</b>. <b>Note: Limit switch was applied for the detection of clamp.</b></p><p>2. Check if the Clamp is <b>ON</b>. Check if location <b>1</b> sequence light was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</p><p>3. Get the <b>White tape 10mm (no slit)</b> using right hand then conduct spot taping using both hands on location <b>1</b>. Make <b>3 windings only</b> then cut the tape. Press the <b>SW button</b> using right index finger. <b>Go</b> sound will be heard. <b>Note: Jig will alarm for excessive taping and skipped process.</b></p><p>4. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</p></div> <div></div>				<div><b>Important reminders/Note/s:</b> <b>1.</b> Make sure no gap between stopper and terminals. <b>2.</b> Counter will be the basis of quantity of harness per box. Only <b>LEADER</b> are allowed to reset the counter.</div> <div><p>1. No wrong insert 2. Make sure no gap between the terminal and stopper jig 3. No wrong use of tape 4. No excess windings 5. No missed tape</p></div>	

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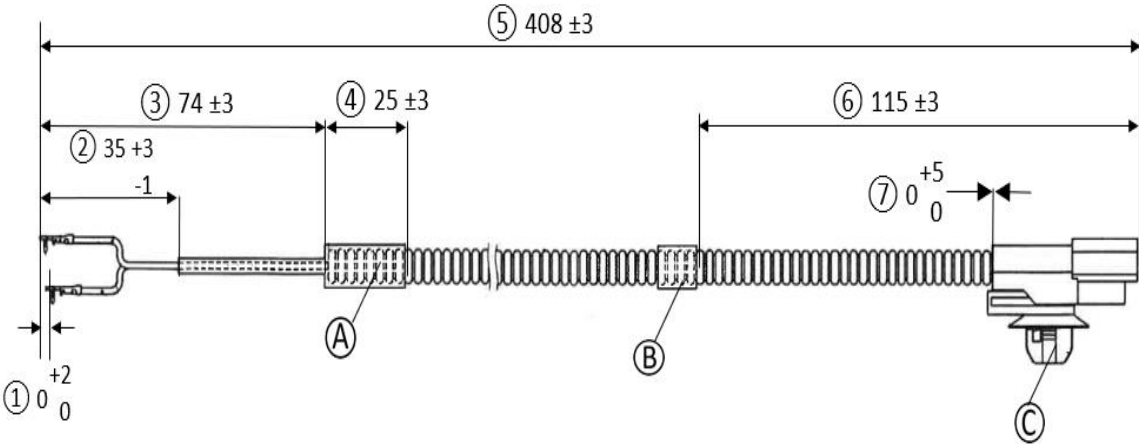

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy part		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div>Measurement</div> <div></div> <div><div>NOTE:</div><div>Ⓐ - Taping (B)</div><div>Ⓑ - Taping (W)</div><div>Ⓒ - Clamp (W)</div></div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			1. No wrong dimension	

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**PARTS:**

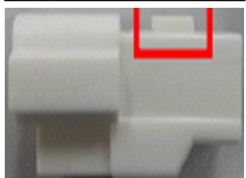
1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0033-7020**

①

**GOOD****NO GOOD**

②

③

①

**No Unlocked/ Half-locked Connector**

③

**No Missing Tape (Black Tape)**

②

**No Missing Spot Tape( White Tape)**

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