

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

Effectivity Date:

February 18, 2022

Model Code/Part Number: **780B / 7R0105-7022**Customer: **TRMX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

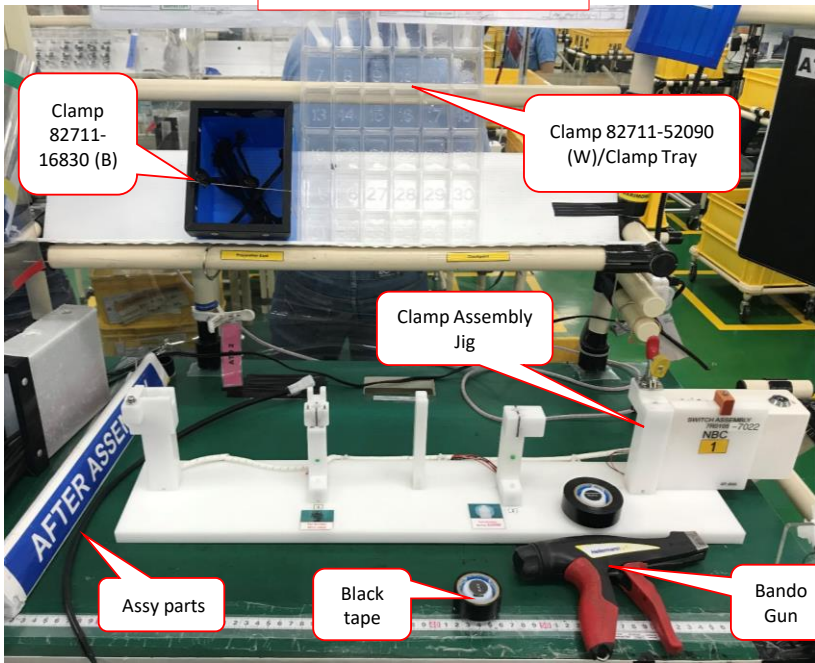
WI-ENG-PDE-404B

Revision No.:

0

Page No.:

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PARTS:		1. Assy parts; Clamp 82711-16830 (B); Clamp 82711-52090 (W); Black tape			JIG		1. Clamp assembly jig						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS						
1	P2	<div>Table Lay-out</div> 				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No wrong use of clamp 2. No damaged clamp					
Revision History													
02/18/22	0	Initial Issue.				K. Doria	J. Loterte	C. Villanueva	A. Arañes	Prepared by K. Doria	Reviewed by J. Loterte	Approved by C. Villanueva	Noted by A. Arañes
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Est. Date:	February 18, 2022		

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**PARTS:**

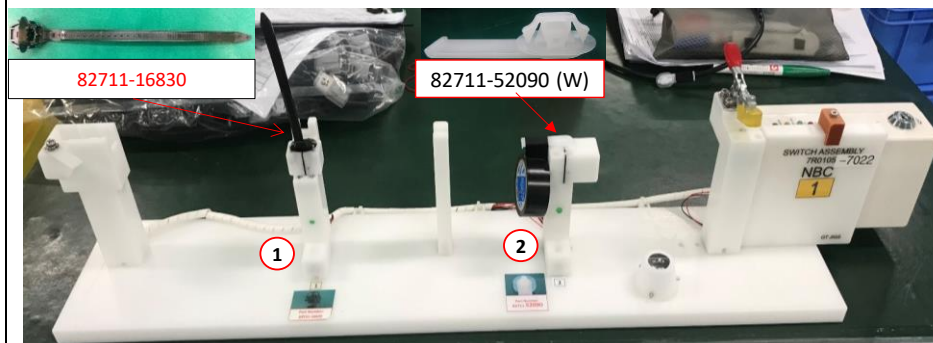
1. Clamp 82711-16830 (B)
2. Clamp 82711-52090 (W)

**JIG**

1. Clamp Assembly Jig

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

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



1. Get 1pc of Band clamp **82711-16830 (B)** using right hand and set to clamp location **1**.

1. Get 1pc of clamp **82711-52090(W)** using right hand and set to clamp location **2**. Initially attached black tape on clamp location **2**.

n/a

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

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

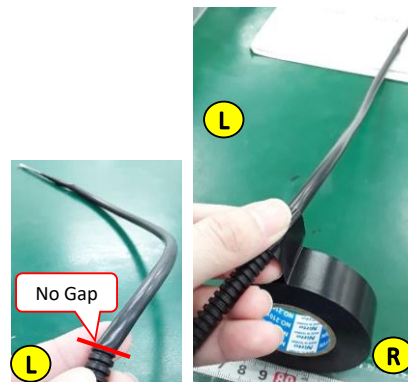
TOOLS/PPE

QUALITY POINTERS

3

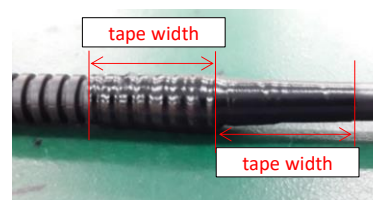
P2

Taping  
COT to Sunprene



1. Hold the COT using left hand. Get Black tape using right hand and start taping using both hands. Make sure no gap between COT and Sunprene tube.

*Refer to WI-PRO-ASY-001 for taping procedure.*



2. After taping, check the measurement and taping condition.

MEASURING TAPE



1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape

### Note:

*Please use calibrated/verified measuring tape when getting the measurement.*

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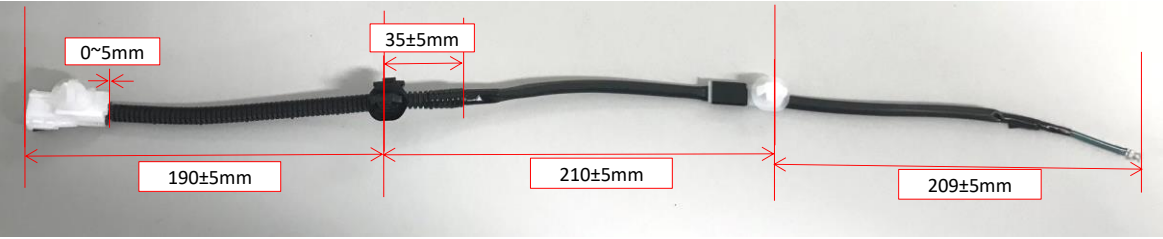
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PARTS:	n/a			JIG	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	Visual/By two's inspection	<div>1. Check if the connector was properly locked.</div> <div>2. Check the clamp attachment, alignment and tape condition.</div> <div>3. Check the terminal condition. Make sure no deformed terminal.</div> <div></div> <div><b>0 - 2 mm</b></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>			<b>MASTER SAMPLE</b>	
6	Meaasurement	<div></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div></div>			<b>For Hastumono and Owarimono</b>	

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