

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

Effectivity Date:

May 16, 2022Model Code/Product Number: **749W / 7H0336W7020D**Customer: **NBS**

Validity Date:

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

Document No.:

WI-ENG-PDE-525B

Revision No.:

1

Page No.:

1 of 5**PARTS:**

1. All parts; (Assy parts; Clamp 82711-52090 (W); Black tape; White tape (10mm))

JIG

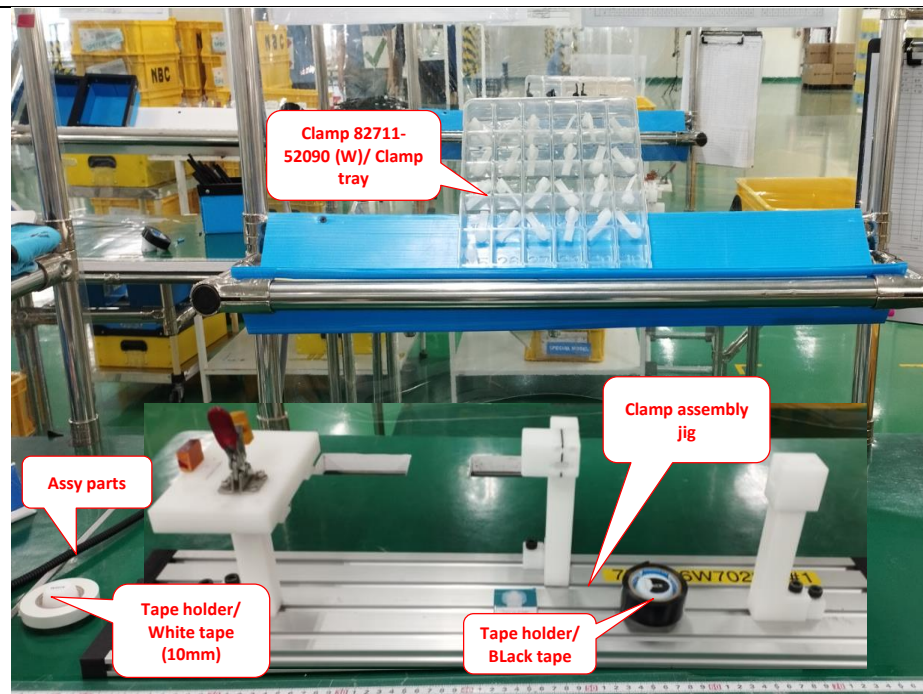
1. Temporary Clamp Assembly jig

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

1

P2

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.

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

05/16/22 1 Change from Pre-launch to Masspro. Additional Table Lay-out

M.Ariola J. Loterte C.Villanueva A.Arañes

05/11/22 0 Initial Issue.

M.Ariola J. Loterte C.Villanueva A.Arañes

Eff.Date Rev.No Details of Change

Revised Reviewed Approved Noted

Est. Date:

May 11, 2022

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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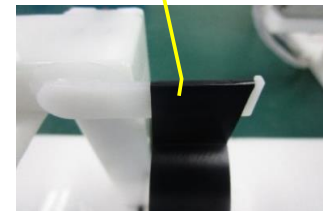
Page No.:

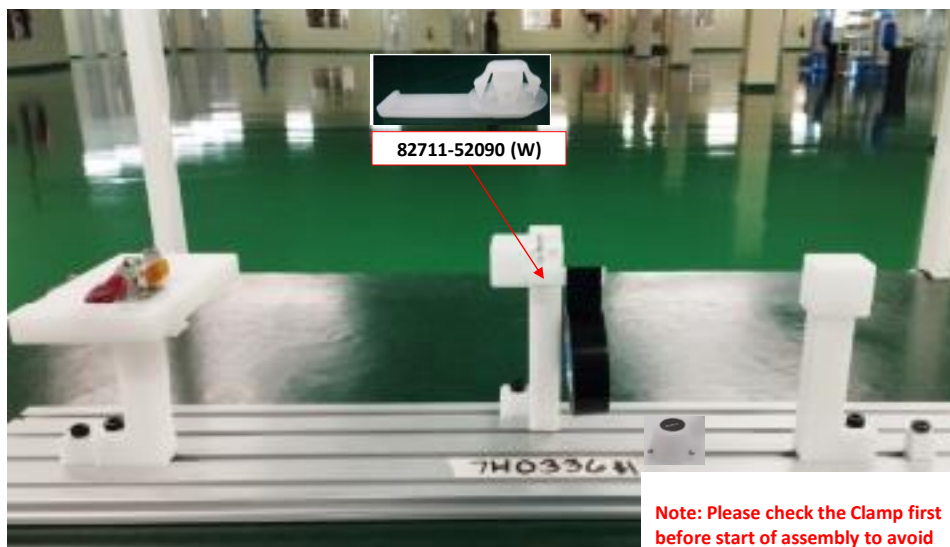
2 of 5**PARTS:**

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

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp setting	n/a	<div>One side tape under clamp</div>  <ol style="list-style-type: none">1. No wrong use of parts2. No wrong use of tape3. No damaged clamp4. No wrong clamp position



1. Get 1pc. of clamp **82711-52090 (W)** using right hand and set to clamp location **1** using both hands.

2. Initially attach **Black tape** to clamp location **1** using both hands.

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3 of 5**PARTS:**

1. Assy parts
2. White Tape (10mm)

JIG

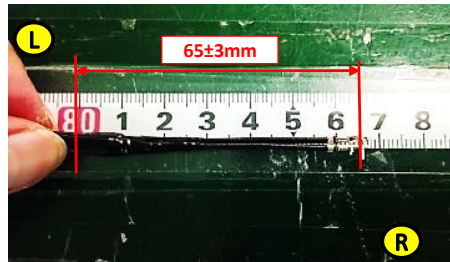
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

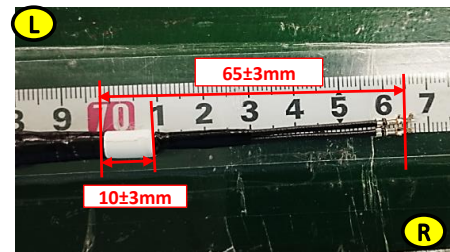
P2

Spot Taping



1. Measure from Vinyl tube up to terminal pointed tip **65mm** using both hands.

NOTE: This dimension is for internal control only. Not specified in the drawing.



3. After spot taping, check the measurement, alignment and tape condition.

Start of taping



2. Get the **White tape (10mm)** using right hand, begin taping process, conduct **2 windings** using both hands.

MEASURING TAPE**Note:**

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

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

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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Page No.:

4 of 5

PARTS:

1. Assy parts.
2. Black tape

JIG

1. Temporary Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

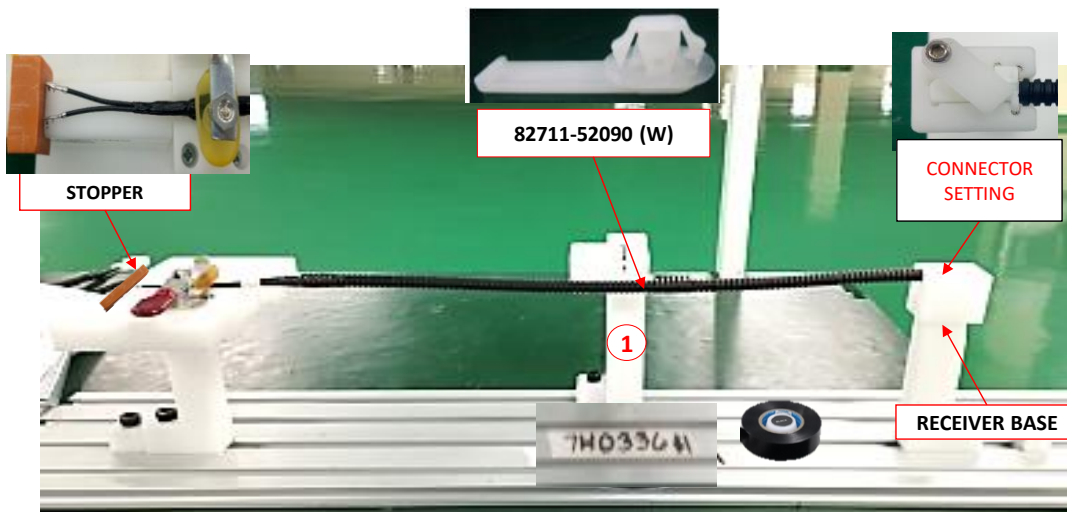
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly



1. Hold the tape on clamp location **1**, make **3 windings** of tape then cut the tape using both hands.

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



NOTE: Make sure NO GAP BETWEEN TERMINALS AND STOPPER JIG

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

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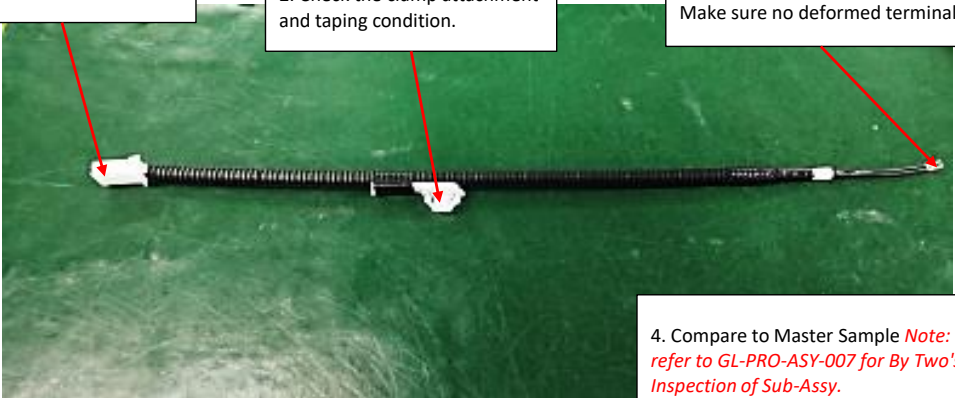

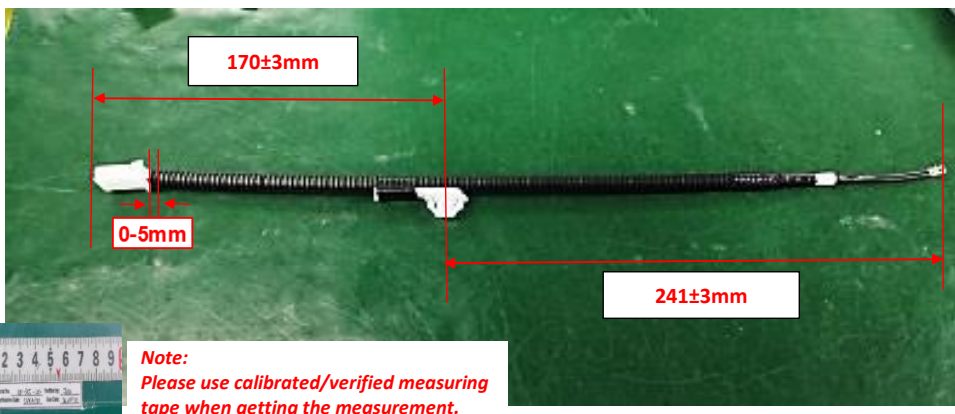
MASSPRO

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Page No.:

5 of 5

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 connector lock.</div> <div>2. Check the clamp attachment and taping condition.</div> <div>3. Check the terminal condition. Make sure no deformed terminal.</div>  <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy.</i></div>		<div>MASTER SAMPLE</div> 
6		Measurement	 <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div>		<div>NOTE: FOR HATSUNOMO OWARIMONO</div> <div>1. No wrong Dimension</div>

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