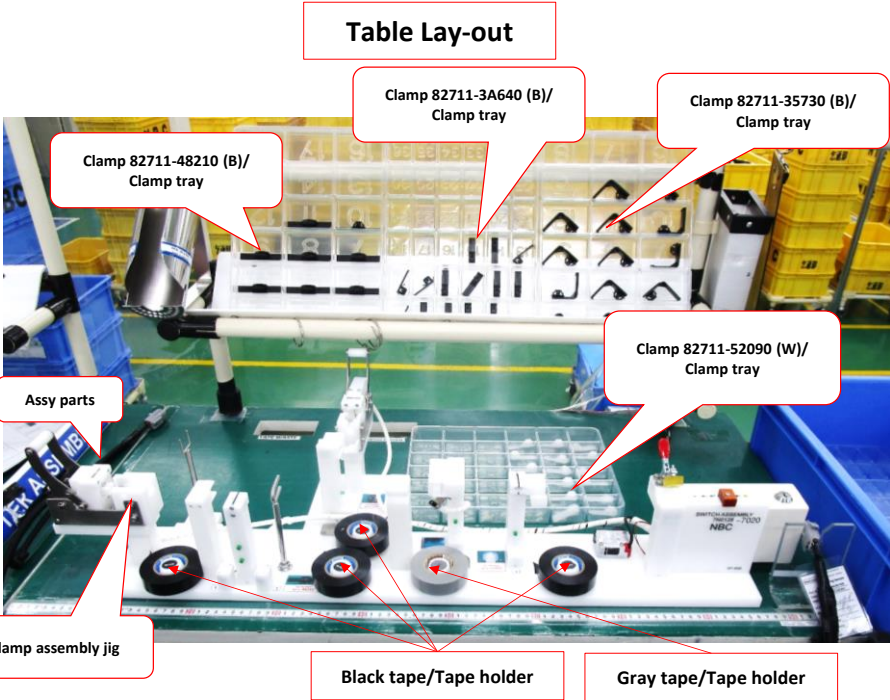



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS						Effectivity Date: May 10, 2023	
	Process Name/Title:						Validity Date: n/a	
	Model Code/Part Number: 177D / 7L0127-7020A				Customer: TRQSS		Document No.: WI-ENG-PDE-351C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.: 4 Page No.: 1 of 9	

PARTS:		1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [4pcs.]; Gray tape		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P3			<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>1. No missing parts/tools 2. No excess parts/tools</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-52090 (W) 82711-12A80 (W)</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-48210 (B) 82711-3F290 (B)</p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
05/10/23	4	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a		
08/31/22	3	Improve work procedure/illustration in process 4 and 5. Quality pointers and notes in pg. no 1, 2, 3, 4, 5, 6 and 8				M. Ariola	J. Loterte	C. Villanueva	A. Arañes						
01/19/22	2	Improve process illustration in clamp assembly jig				K. Doria	J. Loterte	C. Villanueva	A. Arañes						
01/17/22	1	Change from Pre-launch to Masspro. Additional Table Lay-out; Change part number from 7L0127-7020 to 7L0127-7020A due to change in COT length from Ø7 L=537±2mm to Ø7 L=532±2mm due to removal of tolerance from COT to MR SW.				K. Doria	J. Loterte	C. Villanueva	A. Arañes						
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 13, 2021				

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PARTS:

1. Clamp 82711-48210 (B)
2. Clamp 82711-3A640 (B)
3. Clamp 82711-35730 (B)

4. Clamp 82711-52090 (W)
5. Black tape [4pcs.]
6. Gray tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

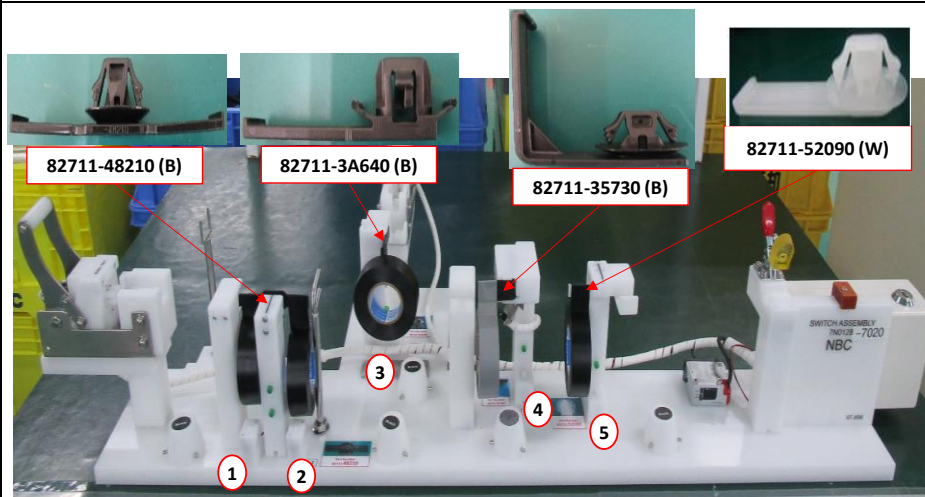
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp setting



1. Get 1 pc. of clamp **82711-48210 (B)** using right hand then insert to clamp location **1 and 2** using both hands.

2. Get 1 pc. of clamp **82711-3A640 (B)** using right hand then insert to clamp location **3** using both hands.

5. Get the **Black tape** then initially attach to clamp location **1, 2, 3, and 5** using both hands.

3. Get 1 pc. of clamp **82711-35730 (B)** using right hand then insert to clamp location **4** using both hands.

4. Get 1 pc of clamp **82711-52090 (W)** using right hand then insert to clamp location **5** using both hands.

6. Get the **Gray tape** then initially attach to clamp location **4** using both hands.

n/a

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position
5. No wrong use of clamp

Important reminders/Note/s:

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

STANDARD TAPING FOR CLAMP

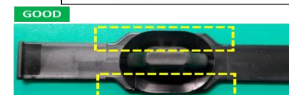
One side tape under clamp



CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



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PARTS:

1. Assy parts
2. Black tape [4pcs.]

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

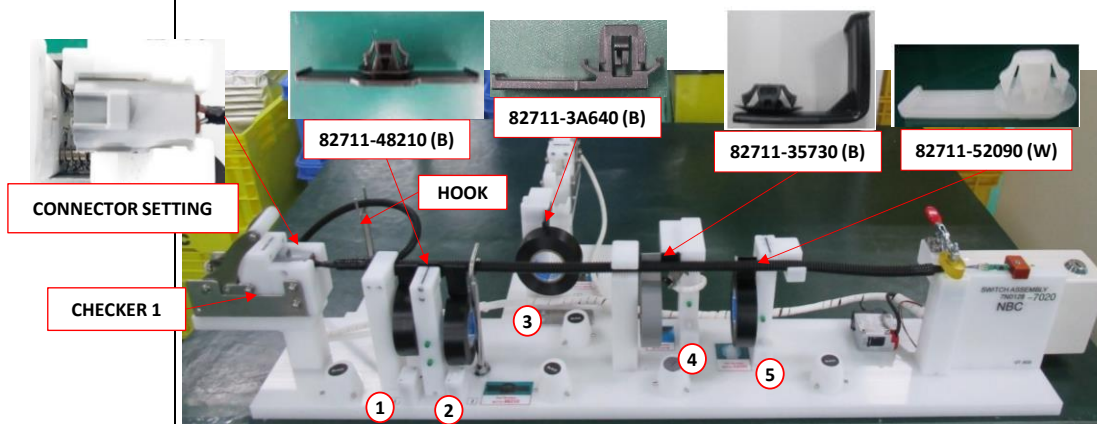
TOOLS/PPE

QUALITY POINTERS

3

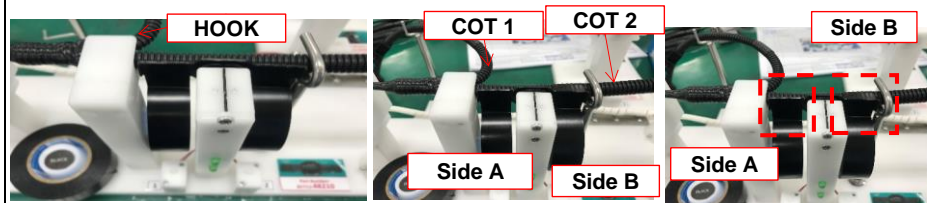
P3

Clamp assembly



1. Get the assy parts and set into jig. *(See above picture for correct setting of harness).* First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, put the assy parts with black connector **6189-1161 (B)** into **HOOK**. Continue to set the harness in jig. Last, set the PCB within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON**.

2. Get Black tape using right hand. Wrap the **COT2 & SIDE B** of the clamp (2 windings) using both hands.



n/a

Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB.

2. Do not cut the tape.



1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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PARTS:

1. Assy parts
2. Black tape [4pcs]

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

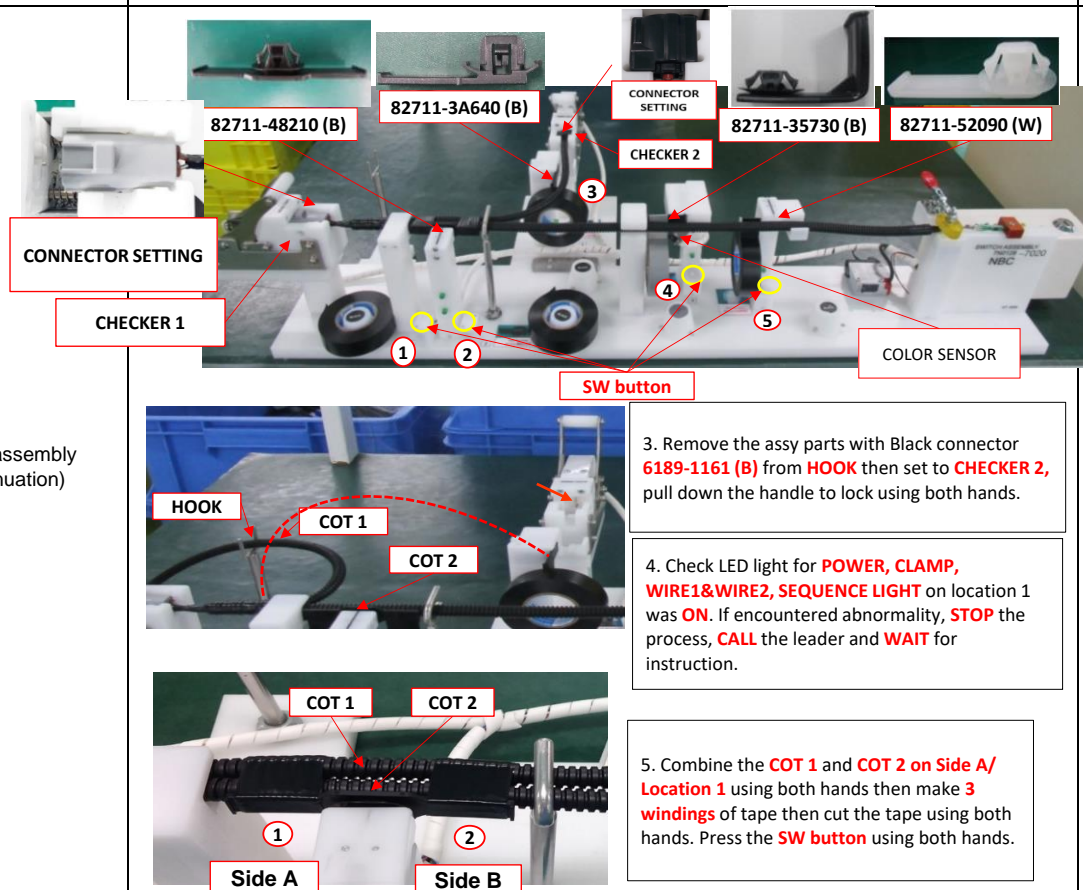
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp assembly
(Continuation)



n/a



Important reminders/Note/s
1. Make sure no gap between stopper jig and PCB

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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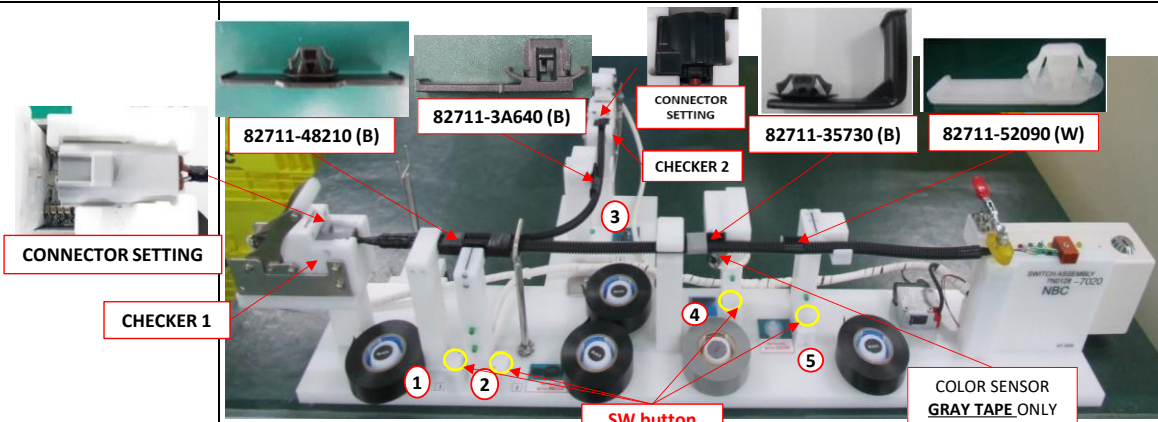
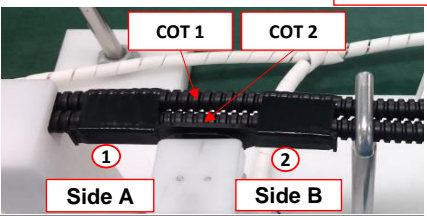

PARTS:

1. Assy parts
2. Black tape [4pcs.]

3. Gray tape

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Clamp assembly (Continuation)	  <p>6. Combine the COT 1 and COT 2 on Side B/ Location 2 using both hands then make 3 windings of tape then cut the tape using both hands. Press the SW button using both hands.</p> <p>7. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 4 was ON.</p> <p>8. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Color sensor light will beep/buzz if sensor detects Gray tape. Press the SW button after taping. Continue the process if sequence light on clamp location 5 was ON.</p> <p>9. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</p> <p>10. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p>	n/a	 Important reminders/Note/s 1. Make sure no gap between stopper jig and PCB 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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PARTS:

n/a

JIG

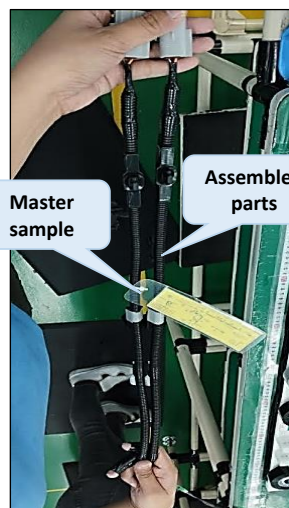
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

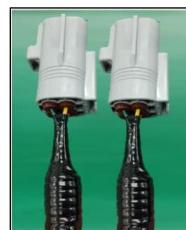
4

P3

Visual/By two's inspection

**ACTUAL PRODUCT****Master sample****Assembled parts**

1. Conduct **alignment of harness (Master sample vs. assembled parts)** using both hands.



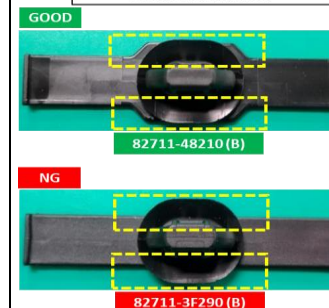
2. Check the **connector lock, wire insertion** and **taping condition**.



3. Check the **presence of wing type clamp** and **taping condition**. Conduct **bending of clamp** with 2 sides taping.

MASTER SAMPLE

1. No skip checking during inspection

CLAMP ILLUSTRATION**CLAMP ILLUSTRATION**

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

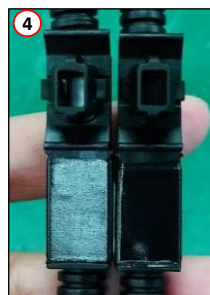
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Visual/By two's Inspection
(Continuation)4. Check the **presence of all clamp attachment** and **taping condition**.5. Check the **Y-Taping** condition.6. Check the **PCB and hot melted wires appearance****MASTER SAMPLE**

1. No skip checking during inspection

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

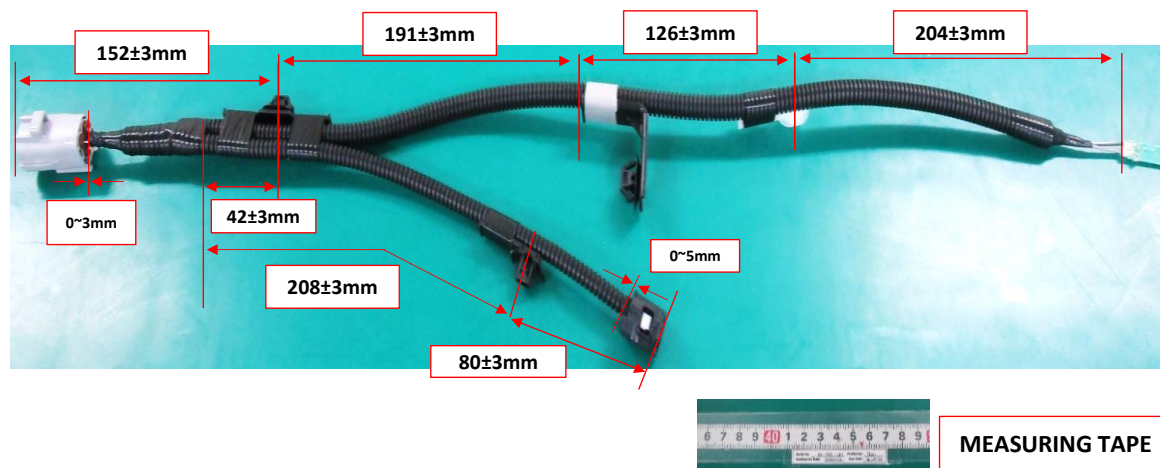
TOOLS/PPE

QUALITY POINTERS

5

P3

Measurement



Important reminders/Note/s:

**1. FOR HATSUMONO AND
OWARIMONO**

1. No wrong dimension

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PARTS:

1. Assy parts

JIG

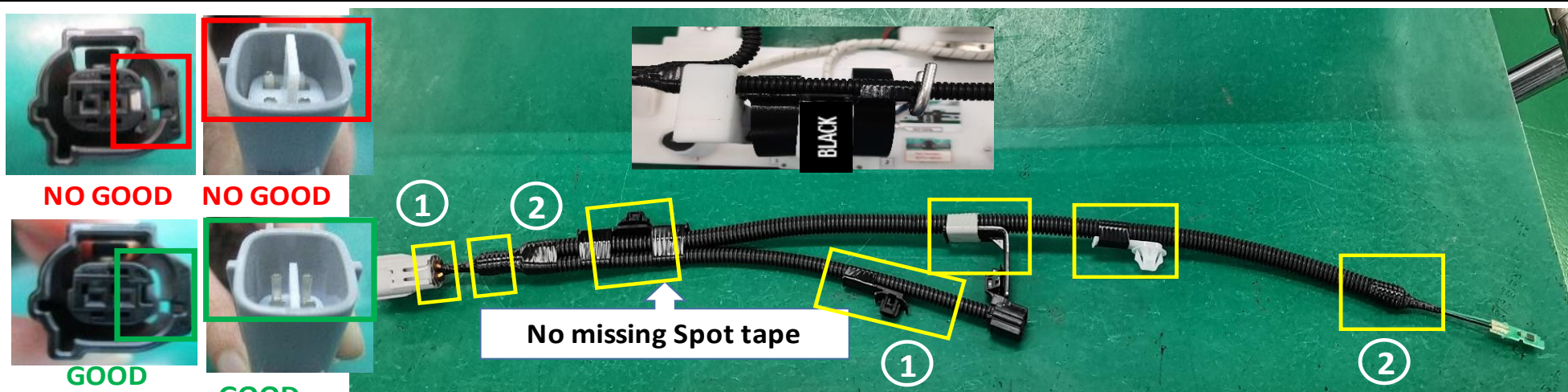
n/a



QUALITY CHECKPOINTS

P3

7L0127-7020A



- ① No **WRONG INSERT**
No **Unlocked / halflocked connector**
No **TBO**

- ② No **MISSING TAPE**
③ No **MISSING Clamp**

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