



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

January 25, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

300D / 7N0123-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-602B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

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PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490(B); Black tape [4pcs]; Violet tape				JIG:	1. Clamp Assembly jig						
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
1		P2		Table Lay-out				<div><div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div>1. No missing parts/tools. 2. No excess parts/tools.</div> <div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-16B30 (B)</div></div></div></div>			
Revision History													
01/25/23	2	Change work Illustration of Measurement on pg.8; Quality checkpoints on pg. 9.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	<div>Prepared by M. Ariola</div>	<div>Reviewed by J. Loterte</div>	<div>Approved by C. Villanueva</div>	<div>Noted by A. Arañes</div>
01/13/23	1	Change document purpose from pre-launch to masspro. Additional table layout. Improve work procedure and illustration; quality pointers in all process. Inclusion of quality checkpoints.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
12/02/22	0	Initial issue.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	December 2, 2022		

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PARTS:

1. Clamp 82711-52090 (W) [4pcs]
2. Clamp 82711-3A540 (W)

3. Clamp 82711-34490 (B)
4. Black tape [4pcs]
5. Violet tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

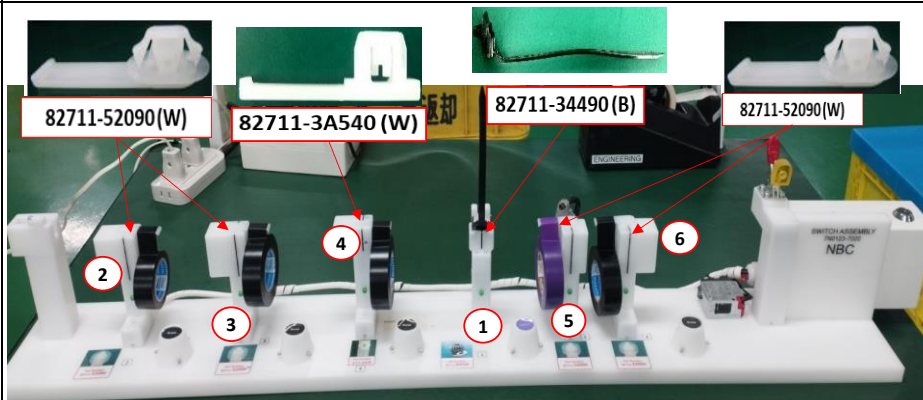
TOOLS/PPE

QUALITY POINTERS

2

P2

Clamp setting



1. Get 2pcs. of clamp **82711-52090 (W)** then set to clamp location **2 and 3** using both hands.

2. Get 2pcs. of clamp **82711-52090 (W)** then set to clamp location **5 and 6** using both hands.

3. Get 1pc. of clamp **82711-3A540 (W)** then set to clamp location **3** using both hands.

4. Get 1pc. of band clamp **82711-34490 (B)** then set to clamp location **1** using both hands.

5. Get the **Violet tape** then initially attach to clamp location **5** using both hands.

6. Get the **Black tape** then initially attach to clamp location **2, 3, 4, and 6** using both hands.

n/a

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

Important reminders/Note/s:

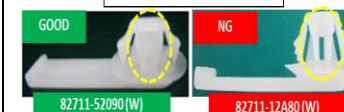
1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

STANDARD TAPING FOR CLAMP

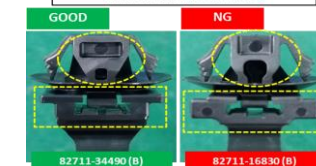
One side tape under clamp



CLAMP ILLUSTRATION



BAND CLAMP ILLUSTRATION



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PARTS:

1. Assy parts
2. Black tape

3. Black sunprene tube $\varnothing 9$ L=112 \pm 3mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

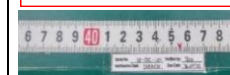
3

Wire insertion to Black sunprene tube $\varnothing 9$ L=112 \pm 3mm



1. Get the Black Sunprene tube $\varnothing 9$ L=112 \pm 3mm using right hand then insert the assy parts using left hand.

MEASURING TAPE



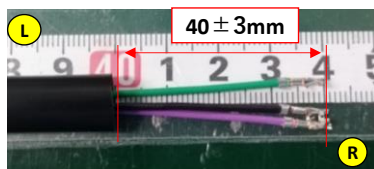
Important reminders/Note/s:

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

4

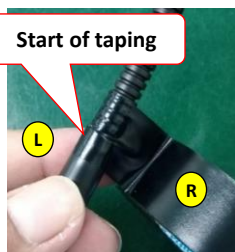
P2

Taping 3 Black COT to Black sunprene tube near terminal



1. Measure from end of tube up to terminal pointed tip 40 \pm 3mm using both hands.

Start of taping



2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.

MEASURING TAPE



1. No wrong use of parts
2. No deformed terminal

Important reminders/Note/s:

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

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PARTS:

1. Assy parts
2. Black tape

JIG

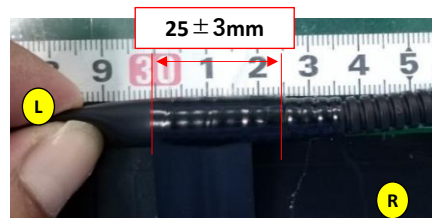
n/a

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

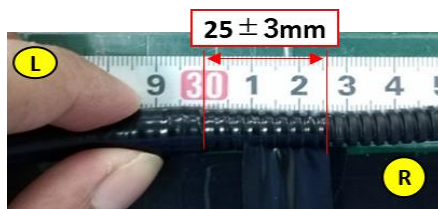
4

P2

Taping 3
Black COT to Black
sunprene tube near
terminal (Continuation)



3. Confirm measurement of **25±3mm** from end of tape up to end of tube then continue the taping process using both hands.



4. Confirm measurement of **25±3mm** from end of tube up to end of tape then continue the taping process using both hands.



5. After taping, check the measurement, terminal appearance and taping condition.

MEASURING TAPE**Important reminders/Note/s:**

1. 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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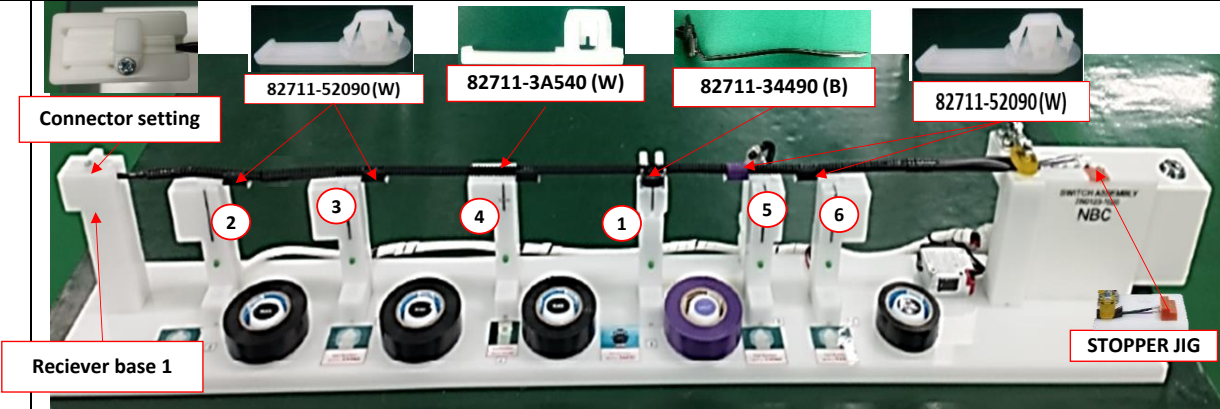
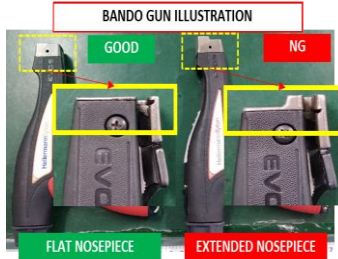
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Process Name/Title:
Model Code/Part Number: **300D / 7N0123-7020** Customer: **TRJ**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Clamp Assembly	<div><p>1. Get the assy parts and set into jig using both hands. <i>(See above picture for correct setting)</i>. First, set the connector 6098-3802 (W) to Receiver base 1 then lock. Continue to set the harness then last, set the B-G-V wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was on.</p><p>2. Check if all LED light for POWER ON, WIRE 1 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p><p>3. Initially tighten the band clamp on location 1 using both hands.</p></div>		<p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</p> <p>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals 2. Setting of Band clamp cutter depends on the size of COT/Viny tube. For $\phi 5$- 1~2, $\phi 7$- 3~4</p> <div></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy part

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Clamp Assembly
(Continuation)



4. Hold the tape on clamp location **2** then start taping using both hands. Make **3 windings** of tape then cut the tape. Continue in clamp location **3**.

5. Hold the tape on clamp location **3** then start taping using both hands. Make **3 windings** of tape then cut the tape. Continue in clamp location **4**.

6. Hold the tape on clamp location **4** then start taping using both hands. Make **3 windings** of tape then cut the tape. Continue in clamp location **5**.

7. Hold the tape on clamp location **5** then start taping using both hands. Make **3 windings** of tape then cut the tape. Continue in clamp location **6**.

8. Hold the tape on clamp location **6** then start taping using both hands. Make **3 windings** of tape then cut the tape.

9. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

Important reminders/Note/s:

1. Make sure no gap between stopper and terminals



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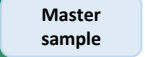



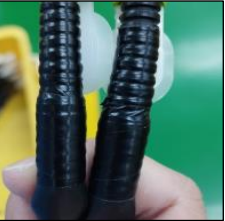






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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assembled parts 2. Master sample		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Visual/By two's inspection	<div><div>ACTUAL PRODUCT</div></div> <div><div>Assembled parts</div></div> <div><div>Master sample</div></div> <div><div>2. Check the connector lock, terminal, insertion and taping condition.</div></div> <div><div>3. Check the presence of all clamp attachment, taping condition, color of tape and band clamp cut condition.</div></div> <div><div>5. Check the terminal appearance. Must be no deformed terminal.</div></div> <div><div>4. Check the taping condition of COT to sunprene tube. Conduct slightly bending.</div></div>		<div>1. No skip checking during inspection</div> <div>MASTER SAMPLE</div> <div></div> <div>Important reminders/Note/s: 1. 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><div>0 ~ 2mm</div></div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-34890 (B)</div></div></div>

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PARTS:

n/a

JIG

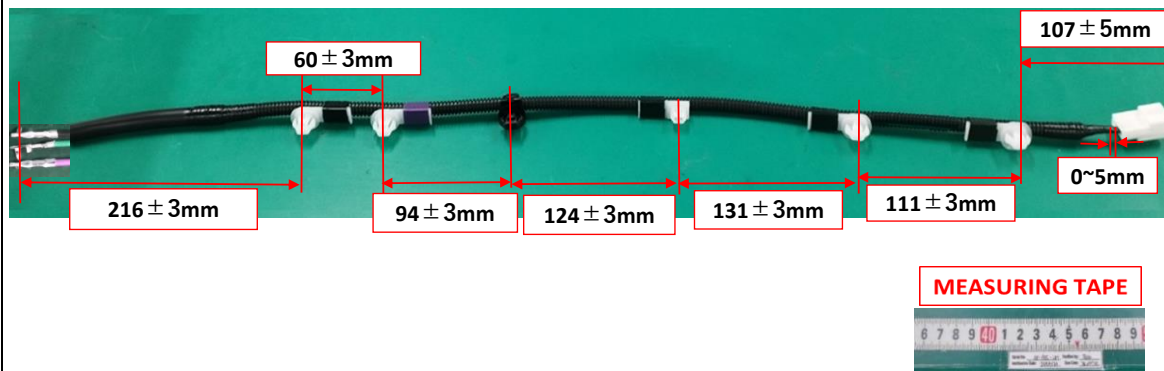
n/a

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

7

P2

Measurement

**Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

1. No wrong dimension

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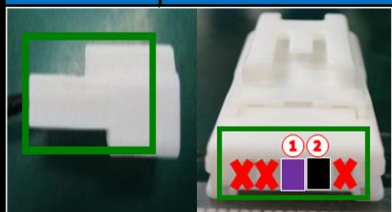
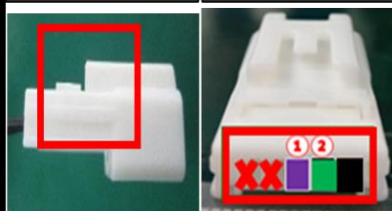
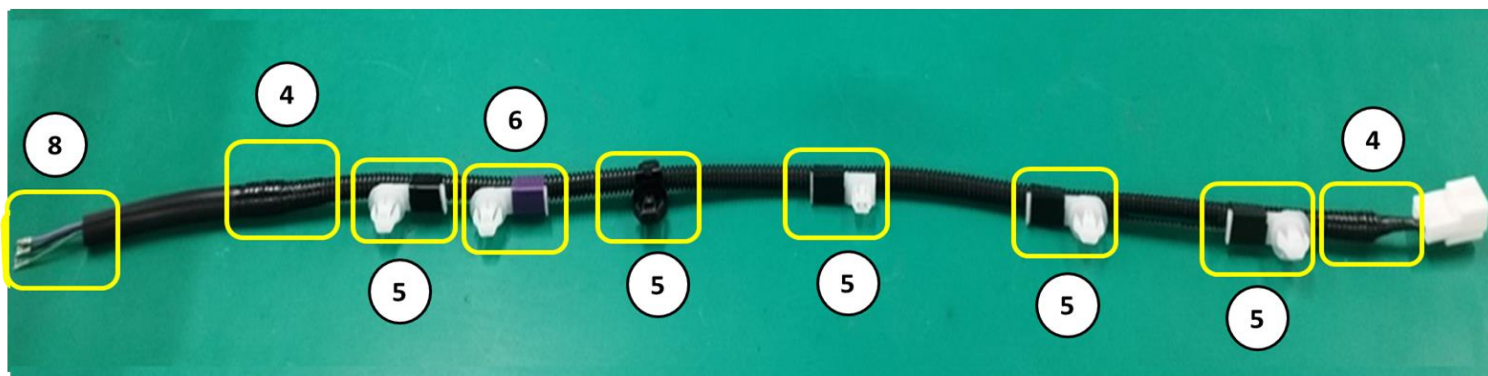
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PARTS:

n/a

JIG

n/a

2 QUALITY CHECKPOINTS**P2****7N0123-7020****GOOD****GOOD****NO GOOD****NO GOOD****1** No Unlock/Halflock Connector**2** No Wrong Insert**3** No Terminal Backing Out**4** No Missing Tape**5** No Missing Clamp(6pcs.)**6** No Wrong Used of Tape (Violet tape)**7** Checking of Clamp Alignment**8** No Deformed Terminal

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