



## WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Model code/Part number: 890B / 7L0098-7020

Customer: TRQSS

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 28, 2023

Validity Date:

n/a

Document No.:

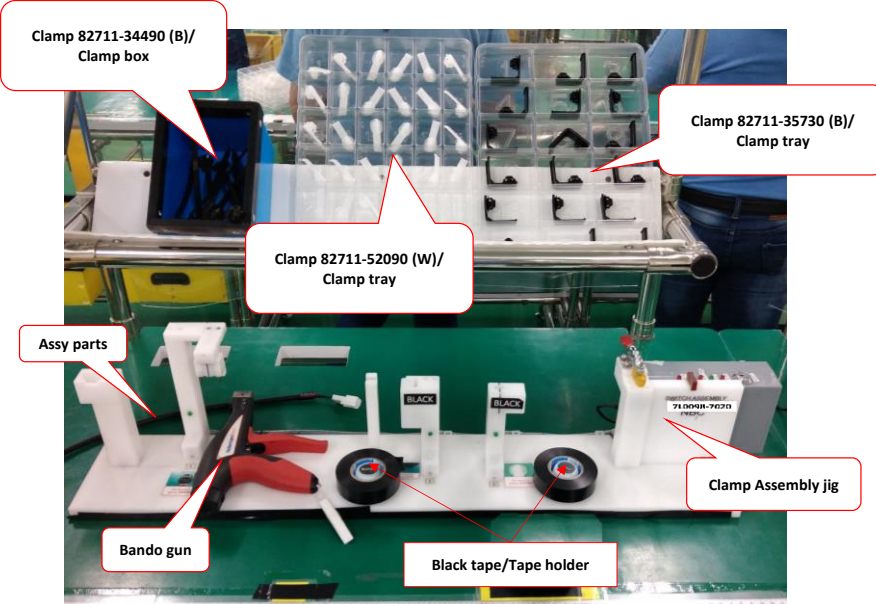




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PARTS:		1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-34490 (B); Clamp 82711-35730 (B); Black tape [2pcs.]				JIG:		1. Clamp Assembly jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	P2	<div>Table Lay-out</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 workplace 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 missing parts/tools 2. No excess parts/tools					
Revision History													
04/28/23	4	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a	Prepared by	Reviewed by	Approved by	Noted by
10/20/22	3	Additional table lay-out. Improve quality pointers, notes reference in process no.1,2,3,4 and 5 as document improvement. Work procedure and illustration in process no.4 - visual/by two's inspection				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	 J. Loterte	 C. Villanueva	 A. Arañes	n/a
05/28/21	2	Removal of validity date. Apply some improvements				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
11/28/21	1	Change connector color from Natural to White; Remove cycle time				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
08/24/20	0	Initial issue				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 24, 2020		

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## PARTS:

1. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

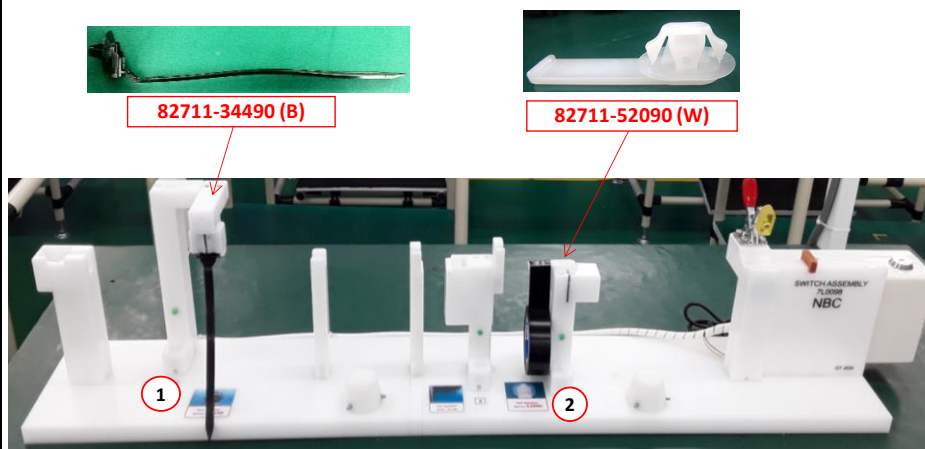
## TOOLS/PPE

## QUALITY POINTERS

2

P2

Clamp setting



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

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

3. Initially attach **Black tape** on clamp location **3** using both hands.

n/a

## STANDARD TAPING FOR CLAMP

One side tape under clamp

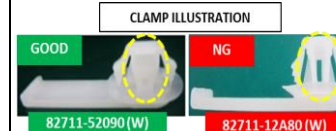


1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape
4. No missing clamp

**Important reminders/Note/s:**

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

## BAND CLAMP ILLUSTRATION



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## PARTS:

1. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

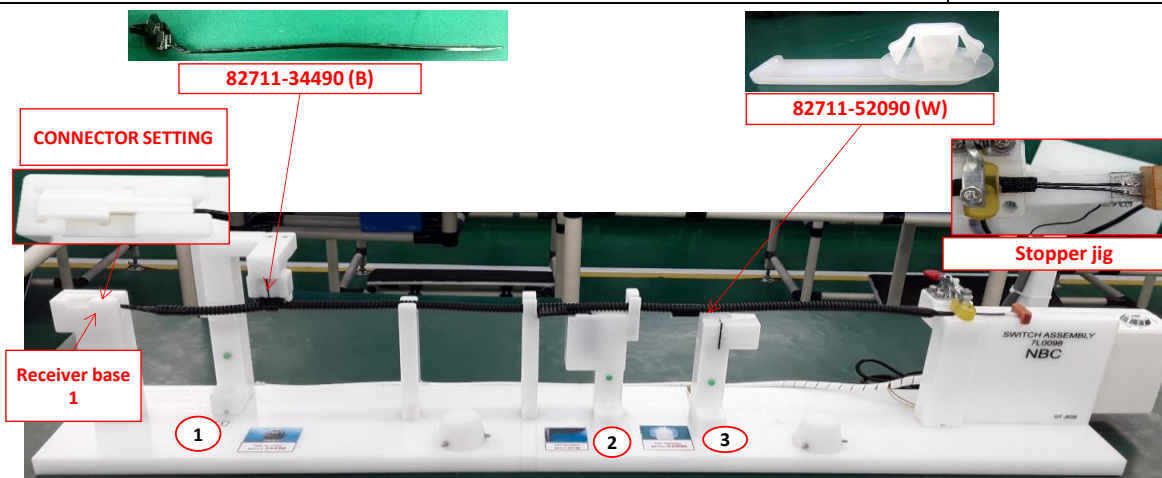
## TOOLS/PPE

## QUALITY POINTERS

3

P2

Clamp Assembly



1. Get the assy parts and set into jig. *(See above picture for correct setting of harness).* First, put the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness into jig. Last, set the terminal end together within the stopper then press by **Toggle clamp**. Continue if the sequence light in location **1** was **ON**.

2. Check if LED for **POWER**, **WIRE** and **CLAMP** is **ON** as well as the **SEQUENCE LIGHT**. If encountered abnormality **STOP** and immediately **CALL** the attention of the leader and **WAIT** for instruction.



## Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

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## PARTS:

1. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

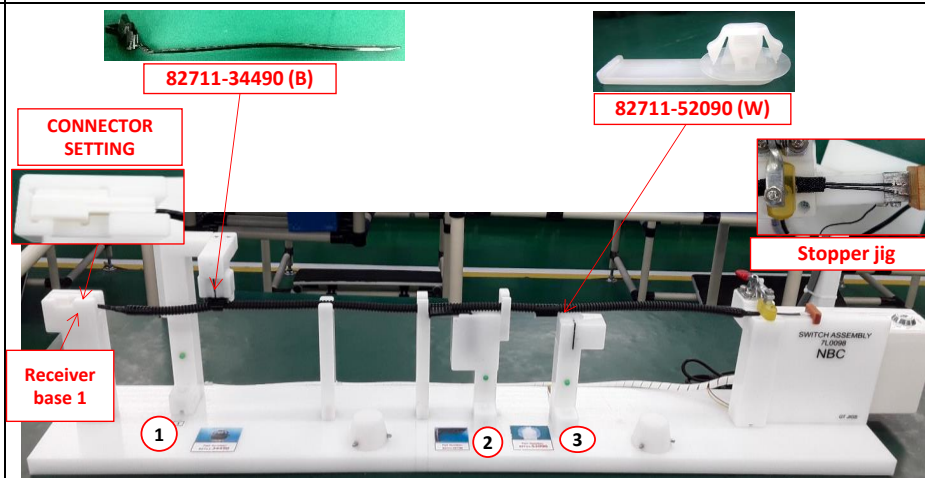
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

3

P2

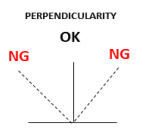
Clamp Assembly  
(Continuation)

3. Initially tighten the band clamp location **1** using both hands.

4. Get the Bando gun using right hand then cut the Band clamp on location **1**. Press the **SW** button after cutting.

**Note: Follow the sequence light for the next location.**

## BANDO GUN ALIGNMENT



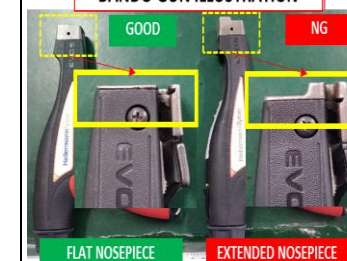
**Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.**  
For:  $\phi 5 - 1 \sim 2$ ,  $\phi 7 - 3 \sim 4$

## Bando gun



1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

## BANDO GUN ILLUSTRATION



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## PARTS:

1. Assy parts
2. Black tape
3. Clamp 82711- 35730 (B)

## JIG

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Clamp Assembly (continuation)	<p>5. Get Black tape using right hand and begin the spot taping of COT on clamp location <b>2</b>. <i>Make 2 windings then cut the tape.</i></p> <p>6. Get 1pc. of clamp <b>82711-35730 (B)</b> using right hand and insert to clamp location <b>2</b> using both hands. Get <b>Black tape</b> using right hand and conduct pre-taping.</p> <p>8. Hold the tape on clamp location <b>3</b>, make <b>3 windings</b> then cut the tape using both hands. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard.</p> <p>7. Continue taping of COT to clamp using both hands. Make <b>3 windings</b> then cut the tape. Press the <b>SW button</b> after taping.</p> <p>9. Conduct <b>POINT CHECKING</b> after assembly.</p> <p><i>COT location must be on this side while conducting taping to avoid wrong facing of clamp.</i></p>	n/a	<p><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between stopper and terminals</b></p> <ol style="list-style-type: none"><li>1. No wrong setting of clamp</li><li>2. No wrong use of clamp</li><li>3. No Loose attachment of clamp</li><li>4. No loose tape</li><li>5. No peel-off tape</li><li>6. No damaged clamp</li><li>7. No wrong use of tape</li><li>8. No missing clamp</li></ol>

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Visual/By two's inspection

**ACTUAL PRODUCT**



**Assembled parts**



**Master sample**



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



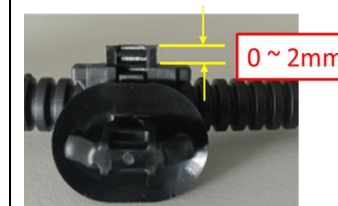
3. Check the **presence of all clamp attachment, taping condition and band clamp cut condition.**



4. Check the **taping condition and terminal appearance.** Must be **no deformed terminal.**

**MASTER SAMPLE**

1. No skip checking during inspection.

**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.

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

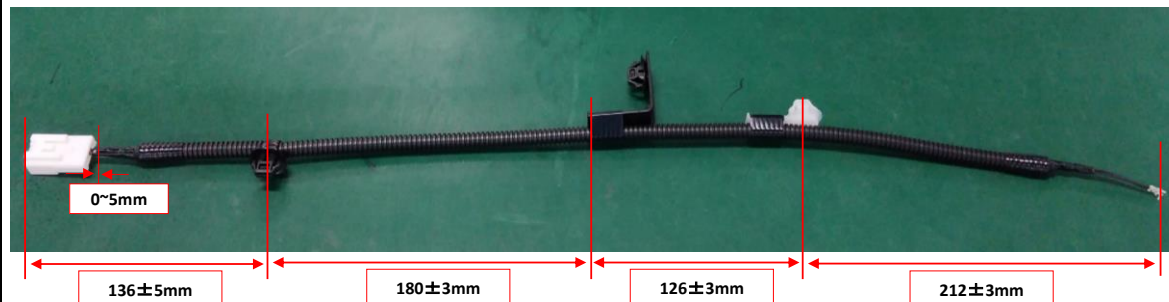
Measurement

## MEASURING TAPE



Note:

Please use calibrated/verified measuring tape when getting the 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



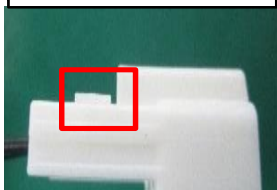
### QUALITY CHECKPOINTS

P2

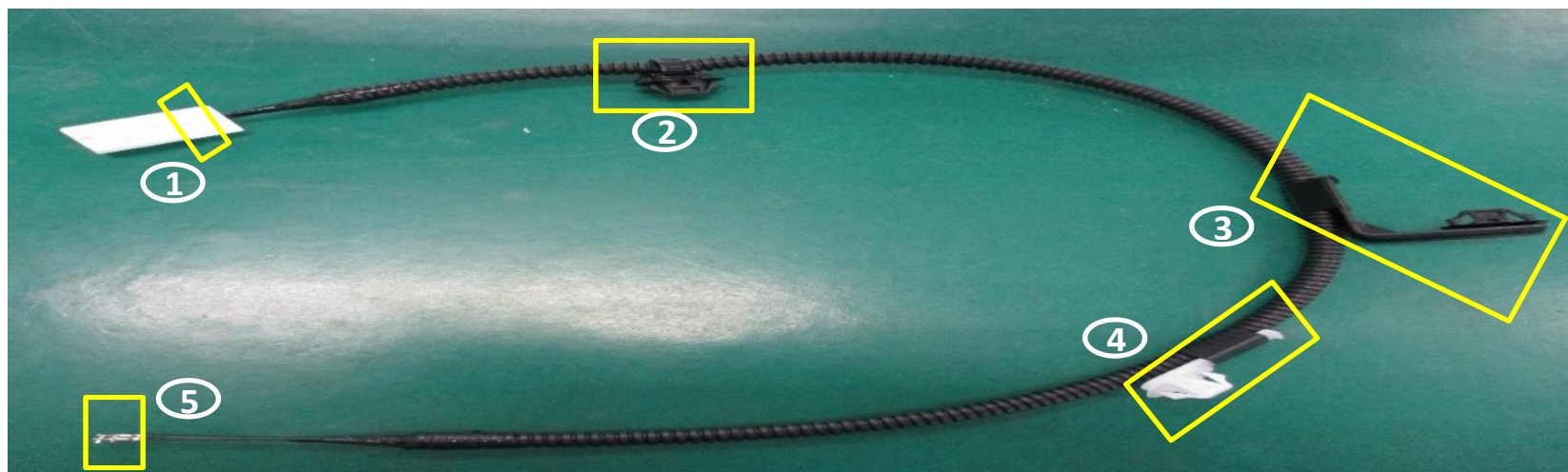
7L0098-7020



GOOD



NO GOOD



① No Unlocked/Half locked connector

⑤ No Deformed Terminal

② ③ ④ No Missing Clamp

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