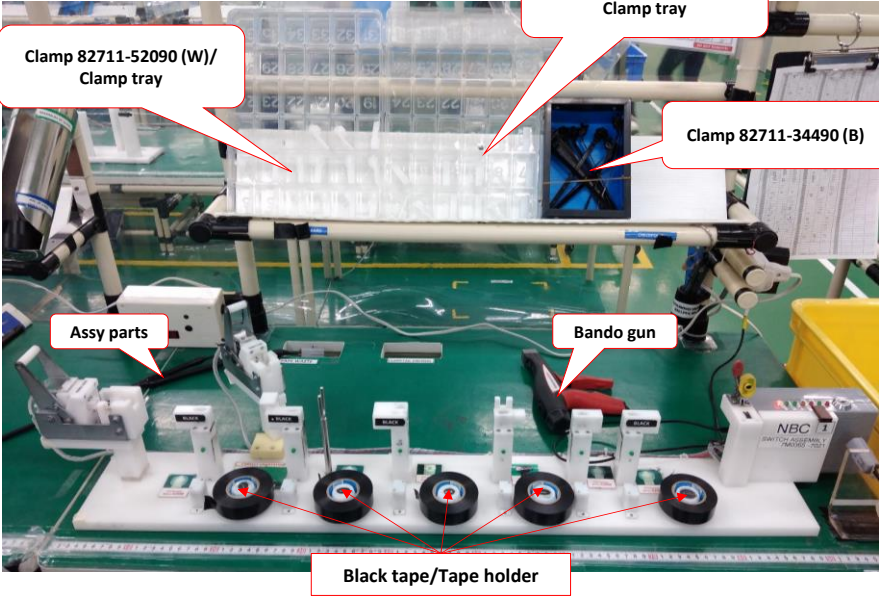




	WORK INSTRUCTION		Effectivity Date: April 24, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date: n/a	
	Model Code/Part Number: 011B / 7M0365-7021	Customer: TRJ	Document No.: WI-ENG-PDE-418C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3 Page No.: 1 of 9	

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [5pcs.]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	<div>Table Lay-out</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <ol style="list-style-type: none"> Maintain and always practice 5's. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <div>Bando Gun</div> 	<ol style="list-style-type: none"> No damaged clamp No wrong use of parts No wrong use of tape

Revision History							Prepared by	Reviewed by	Approved by	Noted by
04/24/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a
11/07/22	2	Improve quality pointers, notes reference in process no.2,3,4 and 5 as document improvement. Work procedure and illustration in process no.4 - visual/by two's inspection	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/31/22	1	Removal of spot taping process in clamp assembly on clamp location 2	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/22/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	February 22, 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 [5pcs.]

JIG

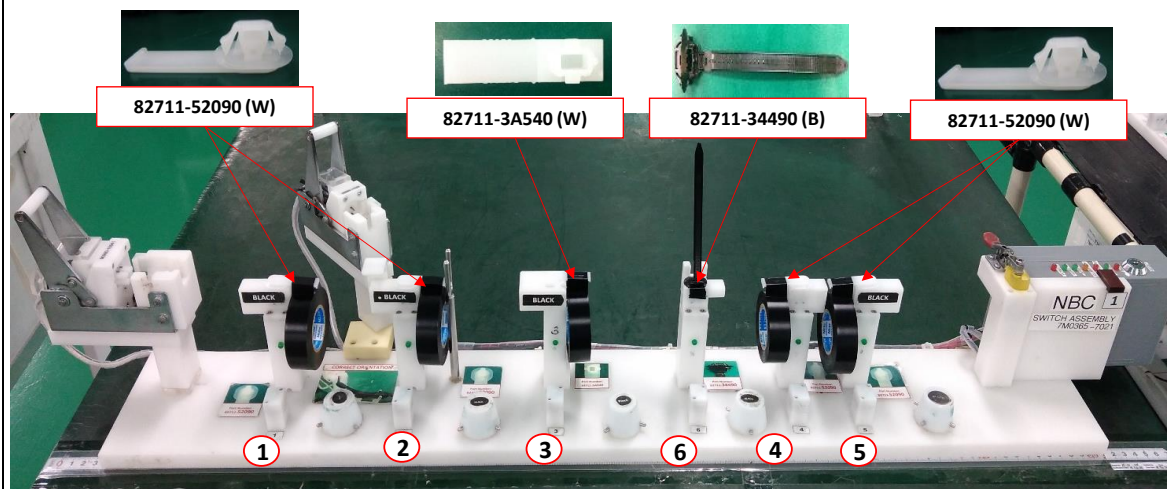
1. Clamp assembly jig

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

2

P3

Clamp setting



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

2. Get 2pcs. of clamp **82711-52090 (W)** using both hands and set to location **4** and **5** using both hands.

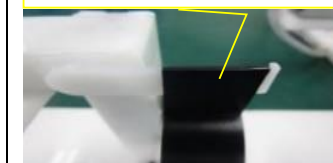
3. Get 1pc. of clamp **82711-3A540 (W)** using right hand then set to location **3** using both hands.

4. Get 1pc. of clamp **82711-34490 (B)** using right hand and set to location **6** using both hands.

5. Initially attach **Black tape** on clamp location **1, 2, 3, 4, and 5** using both hands.

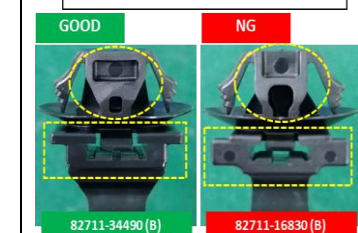
STANDARD TAPING FOR CLAMP

One side tape under clamp

**Important reminders/Note/s:**

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

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

CLAMP ILLUSTRATION**BAND CLAMP ILLUSTRATION**

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

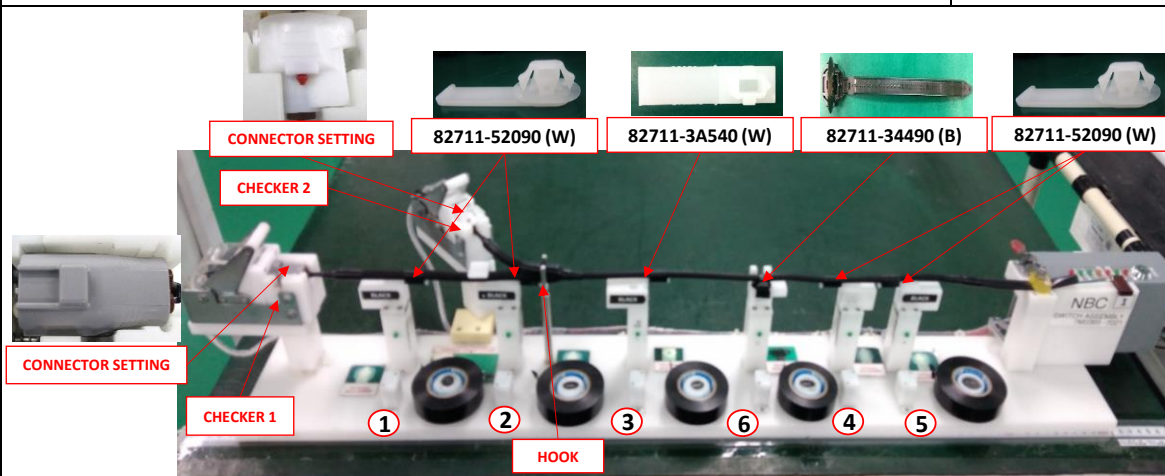
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly



1. Get the assy parts and set into jig. *(See above picture for the correct setting).* First, set the connector **6188-0066 (GR)** to **Checker 1** and then pull the checker fixture for continuity checking. Continue to set the Y-taping in Hook. Then, set the connector **6189-0451 (W)** to **Checker 2** and then pull the checker fixture for continuity checking. Last, set the **G-B/W wires** together within the stopper then press by toggle clamp. Continue the process if sequence light in **location 1** was **ON**.

2. Check if all **LED light** for **POWER ON, WIRE1, WIRE2 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.

3. Hold the tape on clamp location **1** and start taping using both hands. Make **3 windings** then cut the tape. Press the **SW button** after taping. Continue the process if sequence light on location **2** was **ON**.



Important reminders/Note/s:
1. Make sure no gap between stopper and terminals.

1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

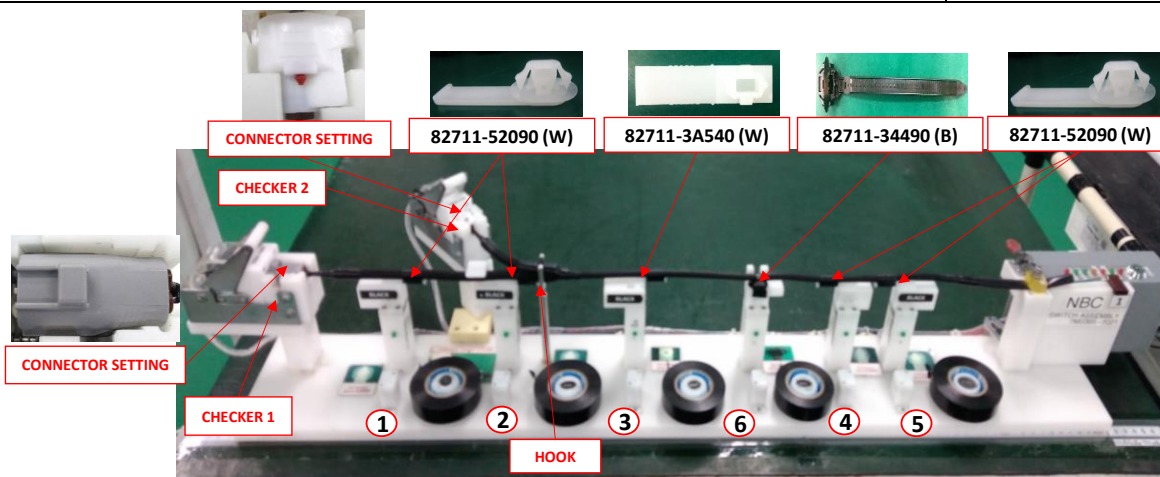
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly
(Continuation)



4. Hold the tape on clamp location **2** and start taping using both hands. Make **3 windings** then cut the tape. Press the **SW button** after taping. Continue the process if sequence light on location **3** was **ON**.

5. Hold the tape on clamp location **3** and start taping using both hands. Make **3 windings** then cut the tape. Press the **SW button** after taping. Continue the process if sequence light on location **4** was **ON**.

6. Hold the tape on clamp location **4** and start taping using both hands. Make **3 windings** then cut the tape. Press the **SW button** after taping. Continue the process if sequence light on location **5** was **ON**.

7. Hold the tape on clamp location **5** and start taping using both hands. Make **3 windings** then cut the tape. Press the **SW button** after taping. Continue the process if sequence light on location **6** was **ON**.



Important reminders/Note/s:
1. Make sure no gap between stopper and terminals.

1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly
(Continuation)

CONNECTOR SETTING

CHECKER 1

CHECKER 2

CONNECTOR SETTING

82711-52090 (W)

82711-3A540 (W)

82711-34490 (B)

82711-52090 (W)

①

②

③

⑥

④

⑤

HOOK

8. Initially tighten the band clamp on clamp location **6** using both hands.

9. Get the bando gun using right hand then cut the band clamp on location **6** using both hands. Press the **SW** button after cut. **GO** sound will be heard.

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

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

GOOD

NG

Must be perpendicular

BANDO GUN ALIGNMENT

NG

OK

NG

PERPENDICULARITY

BANDO GUN

1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

BANDO GUN ILLUSTRATION

GOOD

NG

FLAT NOSEPIECE

EXTENDED NOSEPIECE

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PARTS:

1. Assy parts

JIG

n/a

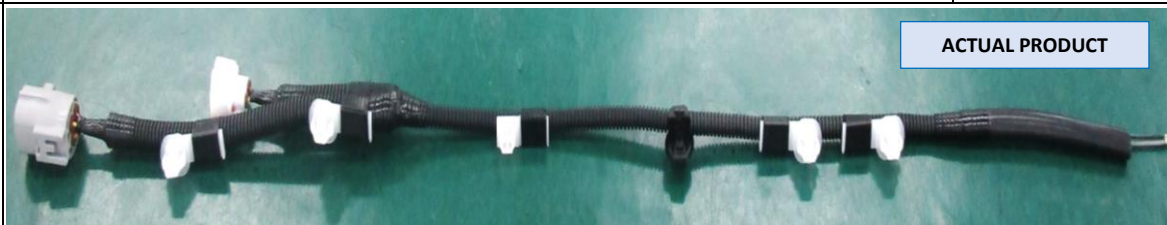
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

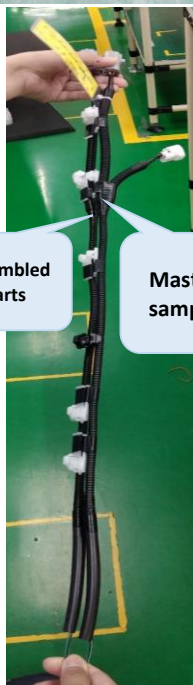
P3

Visual/By two's inspection

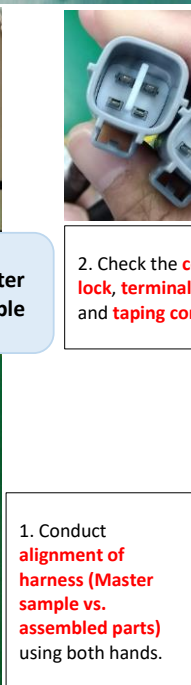
ACTUAL PRODUCT



Assembled parts



Master sample



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

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

3. Check the **presence of clamp tube and taping condition.**

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

MASTER SAMPLE

1. No skip checking during inspection

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PARTS:

1. Assy parts

JIG

n/a

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

4

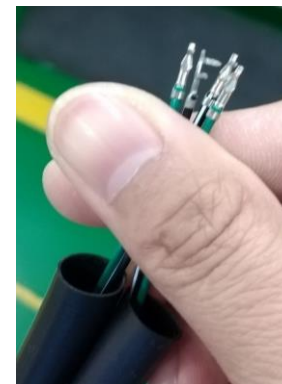
P3

Visual/By two's inspection
(Continuation)

5. Check the **Y-Taping condition**, **presence of all clamp attachment**, **taping condition** and **band clamp cut condition**.



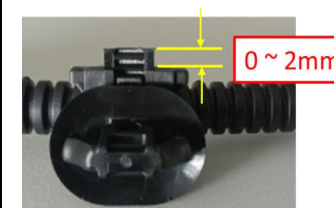
6. Conduct **bending of COT and tube** then check the **taping condition**.



7. Check the **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

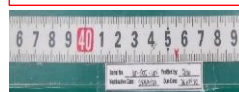
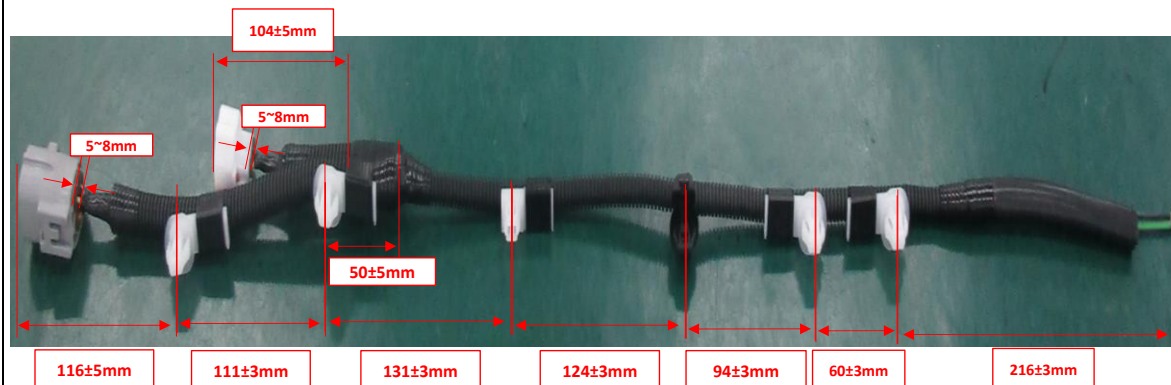
n/a

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

5

P3

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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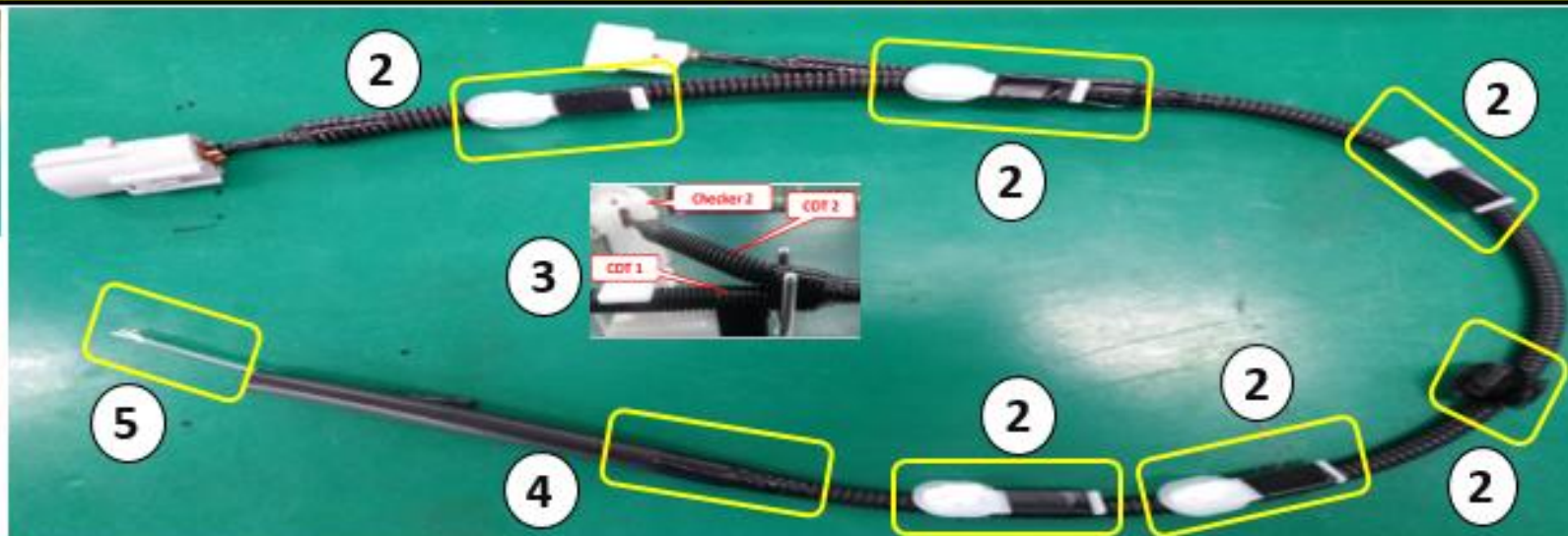
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PARTS:

n/a

JIG

n/a

3 QUALITY CHECKPOINTS**P3****7M0365-7021****GOOD****NO**

1 No Unlock/Halflock Connector
(on 2 connector)

2 No Missing Clamp
(6pcs.)

3 Checking of Inside Spot

4 Conduct Bending on Sunprene tube

5 No Deformed

6 Checking of Clamp Alignment

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