



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 25, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

800B / 7N0068-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-187C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

1 of 5

## PARTS:

1. Clamp 82711-52090 (W) [2pcs]  
2. Clamp 82711-48070 (GR)3. Clamp 82711-48210 (B)  
4. Black tape [2pcs]

5. Yellow tape [3pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

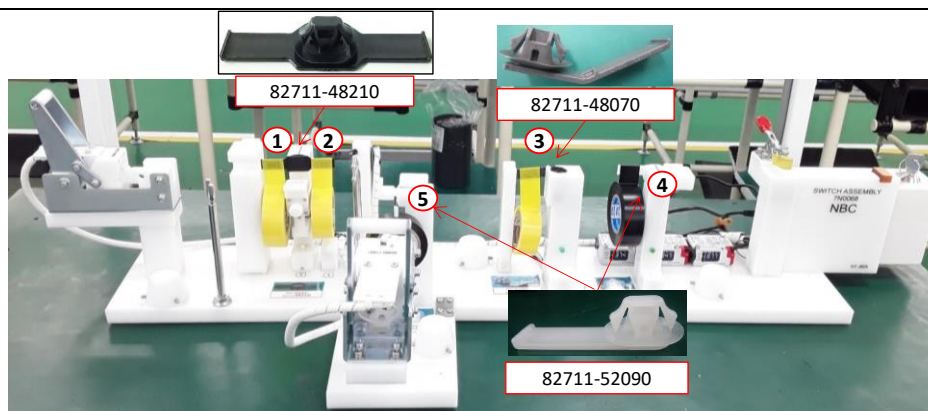
TOOLS/PPE

QUALITY POINTERS

1

P3

Clamp assembly setting



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

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

3. Get 1pc of clamp 82711-48070 (GR) using right hand and set to clamp location 3 using both hands.

4. Get Yellow tape using right hand and put pre-tape on clamp location 1, 2 and 3 using both hands.

5. Get Black tape using right hand and put pre-tape on clamp location 4 and 5 using both hands.

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

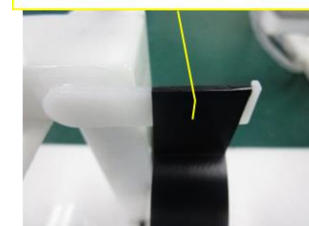
**Housekeeping**1. Maintain and always practice 5's.  
2. Personal things on the workplace is prohibited. Keep it in your locker.**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. Taping should be one side under (taping side of clamp before taping with COT.

**STANDARD TAPING FOR CLAMP**

One side tape under clamp



## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
03/25/21	2	Change status from pre-launch to Masspro	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
11/27/20	1	Change tape color of wing type clamp 82711-48210 (B) from Red to Yellow, and clamp 82711-48070 (GR) from Black to Yellow	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		J. Loterte	C. Villanueva	A. Shimamura	A. Arañes

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Page No.:

2 of 5

**PARTS:**

1. Assy parts
2. Black tape

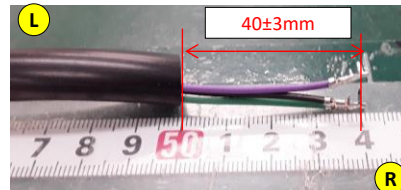
**JIG**

n/a

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

2

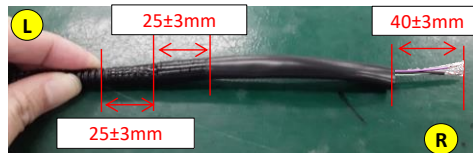
P3

Taping  
Sunprene to COT

1. Hold the assy parts using left hand.  
Measure from Sunprene tube to terminal  
pointed tip **40±3mm**.



2. Hold the assy  
parts using left  
hand. Get the  
Black tape and  
start taping using  
right hand.  
*Refer to WI-PRO-  
ASY-001 for taping  
procedure.*



3. After taping, check the measurement and  
taping condition.

**Measuring tape**

1. Check the tape from COT to Vinyl  
(Conduct bending for verification)
- 2.No flip out tape.
- 3.No tape peeling.
- 4.No loose tape



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

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Revision No.:

2

Page No.:

3 of 5

**PARTS:**

1. Assy parts

**JIG**

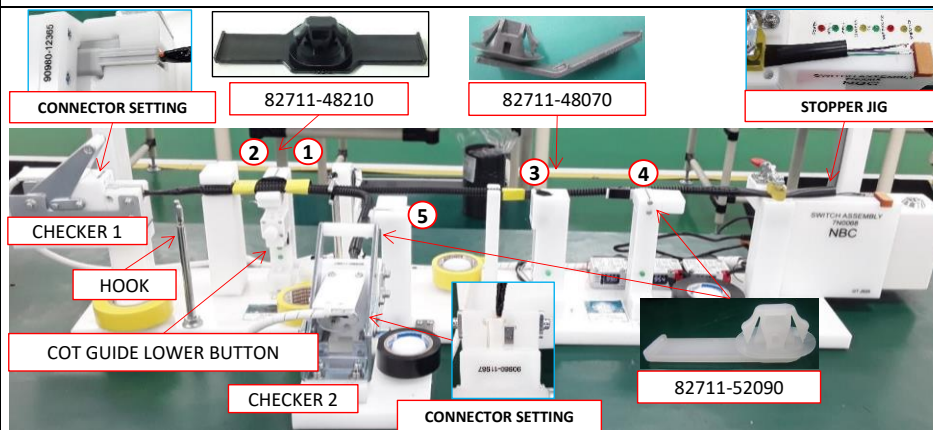
1. Clamp assembly jig

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

3

P3

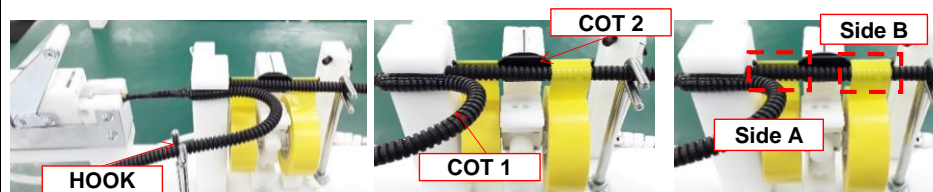
Clamp Assembly



1. Get the assy parts using right hand and set to jig using both hands. First, put the Gray Connector to checker 1, second, put the Sunprene tube to toggle clamp and last, initially put the COT (with White connector) in HOOK.

*Note: Refer to above illustration for correct setting*

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



n/a

Make sure no Gap between terminal and stopper jig



1. No wrong use of tape
2. No lacking and excess tape windings
3. No missing tape

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4 of 5

**PARTS:**

1. Assy parts

**JIG**

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Clamp Assembly (continuation)	<p><b>CONNECTOR SETTING</b></p> <p><b>CHECKER 1</b></p> <p><b>CHECKER 2</b></p> <p>3. Hold the COT2 and put the White connector to checker 2 using both hands.</p> <p><b>Side B</b></p> <p><b>Side A</b></p> <p>5. Combine the <b>COT1</b> and <b>COT2</b> on <b>SIDE B</b> of the clamp using both hands. Make 3 winds and cut the tape. Beep sound will be heard if the color sensor detects the Yellow tape. Press the SW button after taping.</p> <p><b>Side B</b></p> <p><b>Side A</b></p> <p>6. Combine the <b>COT1</b> and <b>COT2</b> on <b>SIDE A</b> of the clamp using both hands. Make 3 winds and cut the tape. Beep sound will be heard if the color sensor detects the Yellow tape. Press the SW button after taping.</p> <p>7. Tape the clamp on clamp location <b>3</b> using both hands. (Yellow tape) Make 3 winds then cut the tape. Beep sound will be heard if the color sensor detects the Yellow tape.</p> <p>8. Tape the clamp on location <b>4</b> and <b>5</b> (black tape) using both hands. Make 3 winds. Press the switch button after taping.</p> <p>9. Conduct <b>POINT CHECKING</b>, press the button of COT guide then slowly remove the harness from jig.</p> <p><b>NOTE:</b> Push the lower button for COT guide using left hand.</p> <p><b>COT GUIDE</b></p> <p><b>COT GUIDE</b></p>	n/a	1. No wrong use of tape 2. No lacking and excess tape windings 3. No missing tape

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5 of 5

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JIG

n/a

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TOOLS/PPE

QUALITY POINTERS

4

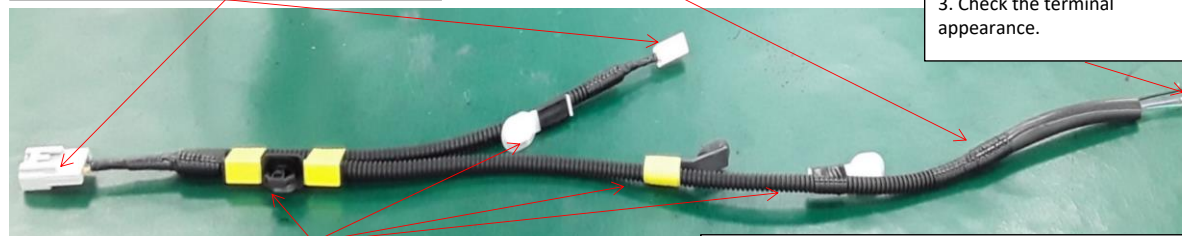
Visual/By two's inspection

P3

1. Check the connector lock.

2. Check the taping on COT to Sunprene. Conduct bending for verification.

3. Check the terminal appearance.



4. Check the clamp attachment and taping condition. Conduct bending.

5. Compare to Master sample. *Refer to GL-PRO-ASY 007 for By two's inspection of Sub-assy*

MASTER SAMPLE

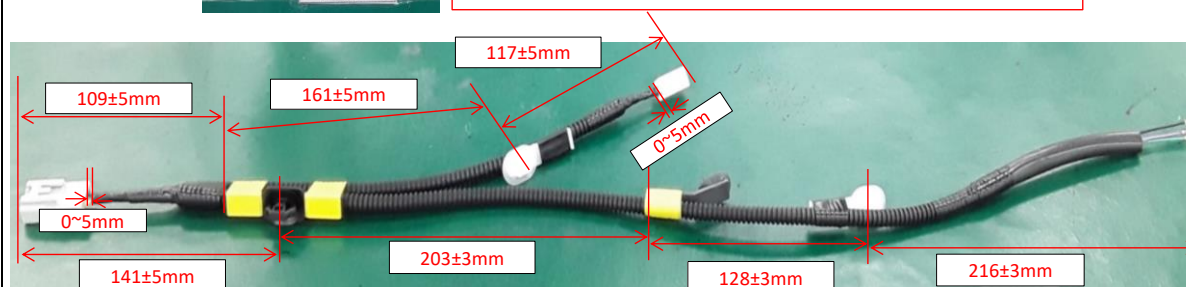


5

Measurement



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



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