

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

February 19, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part number **780B / 7R0102-7022**

Customer:

TRMX

Document No.:

WI-ENG-PDE-417C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

All parts; Assy parts; Clamp 82711-16830 (B); Clamp 82711-52090 (W); Black tape [2pcs]

JIG

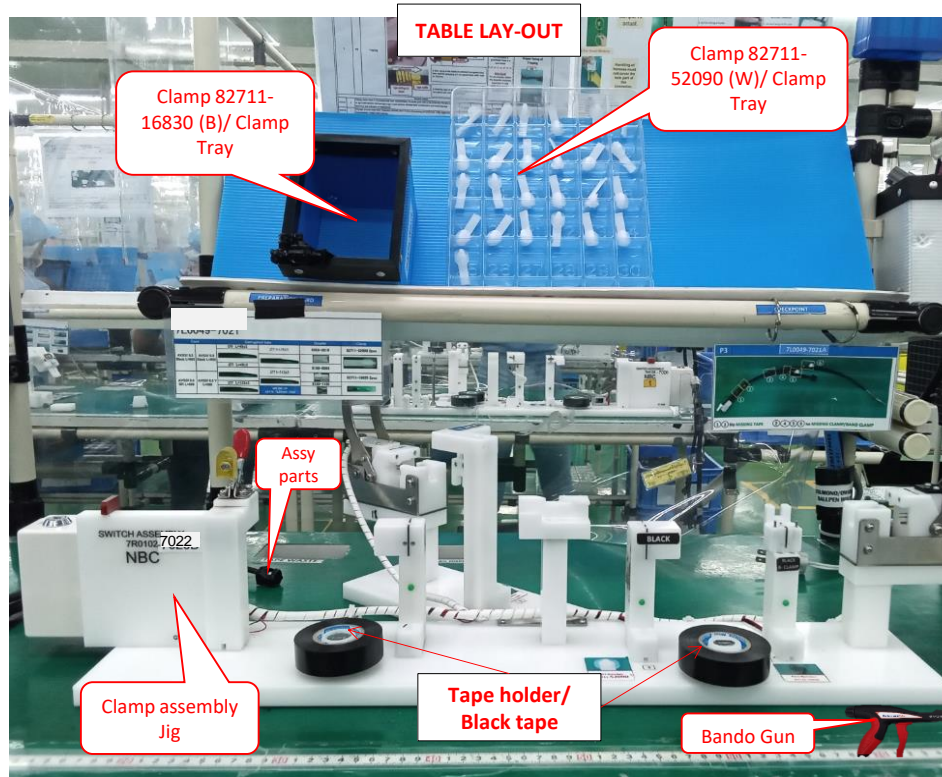
1. Clamp Assembly

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

1

P3

Table Lay-out

**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.

Note:

Please check the clamp first before setting to clamp assembly to avoid wrong use of clamp.

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

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
02/19/22	0	Initial Issue	M.Ariola	J. Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revise	Reviewed	Approved	Noted

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PARTS:

1. Clamp 82711-16830 (B) [2pcs]
2. Clamp 82711-52090 (W) [2pcs]

3. Black tape [2pcs.]

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp assembly setting	<div><p>82711-16830</p><p>82711-52090</p></div> <div><p>1. Get 2pcs of band clamp 82711-16830 (B) using right hand and insert to clamp location 1 and 2 using both hands.</p><p>2. Get 2 pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 3 and 4 using both hands.</p><p>3. Get Black tape using right hand and put pre-tape on clamp location 3 and 4 using both hands.</p><div><p>One side tape under clamp</p></div></div>	n/a	<p>Note: Please check the clamp first before setting to clamp assembly to avoid wrong use of clamp.</p> <ol style="list-style-type: none">1. No wrong use of clamp2. No damaged clamp3. No wrong use of tape

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

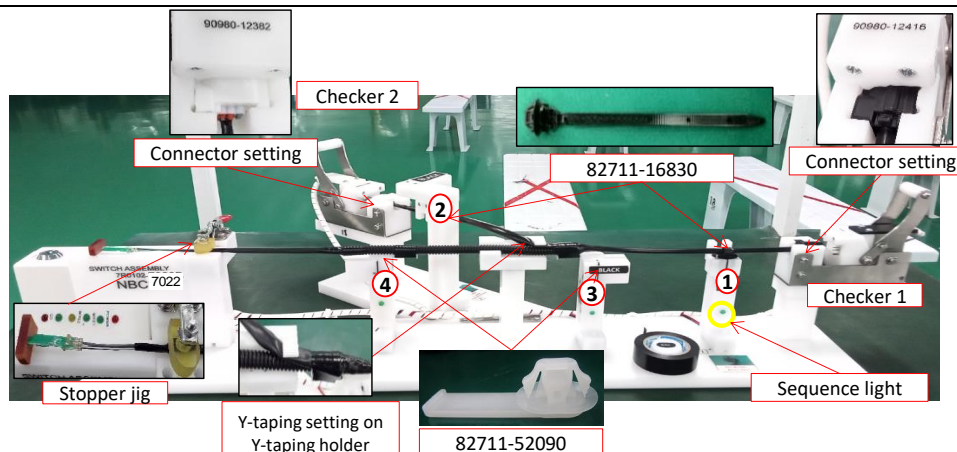
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly



1. Get the assy parts using both hands. Put first the Black connector to **Checker 1** then lock. Second, put the Y-part of the harness to holder (check the correct Y-taping setting). Third, put the PCB to **stopper jig** then pull down the toggle clamp. And last, put the White connector into **Checker 2** then lock.

Refer to the above illustration for the correct setting.

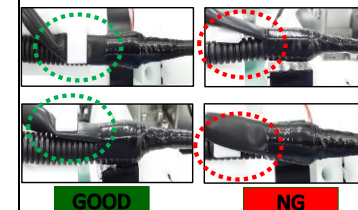
3. Initially tighten the band clamp on clamp location **1** and **2** using both hands.

2. Check if LED for **POWER, CLAMP, WIRE1&WIRE2** and **SEQUENCE LIGHT** in the first location is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

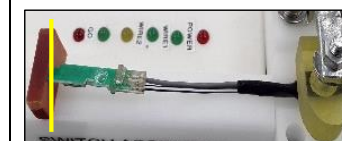


n/a

Y-TAPING SETTING IN CLAMP ASSEMBLY JIG



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



Make sure no clearance between PCB and stopper jig

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

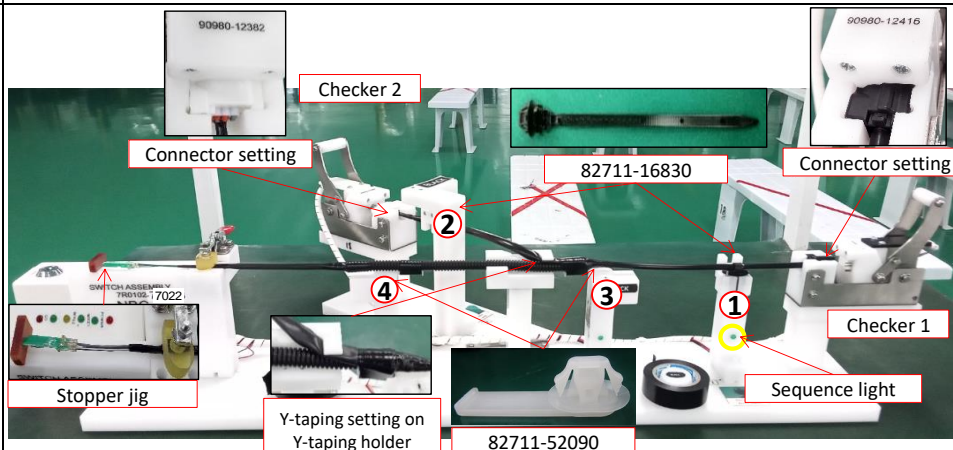
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Clamp Assembly
(continuation)

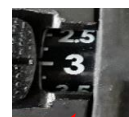
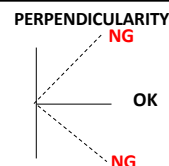
4. Get the Bando gun using right hand and cut the band clamp on clamp location **1** and **2** using both hands. Press the switch button after every cutting.

5. Tape the clamp on location **3** and **4** using both hands. Make 3 windings and cut the tape. Press the **switch button** after every taping. Go sound will be heard.

6. Conduct **POINT CHECKING** before removing from jig.



BANDO GUN ALIGNMENT



Fixed setting of
band clamp
cutter: 1 ~ 3

BANDO GUN



Note:
Make sure no clearance between PCB
and stopper jig

1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

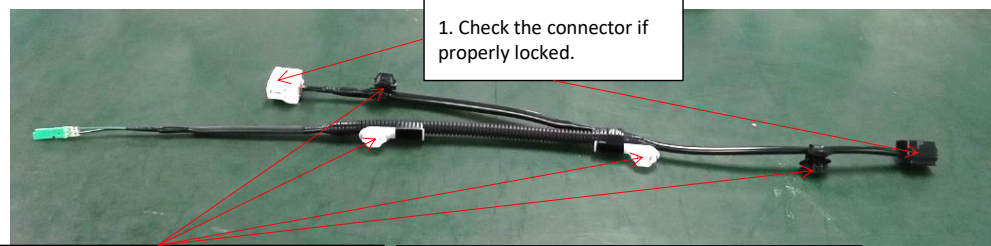
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

Visual/By two's inspection

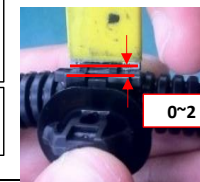


1. Check the connector if properly locked.

2. Check the clamp attachment and alignment.

3. Using steel rule, check if the band cut measurement is within the required dimension (**0~2mm**) and should not exceed the maximum value.

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



MASTER SAMPLE



P3

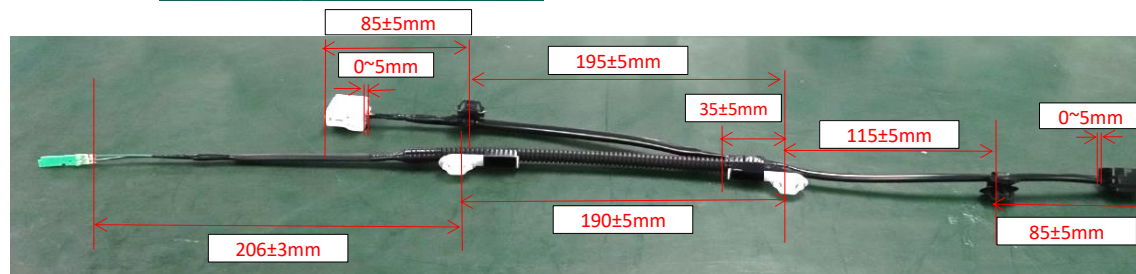
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Measurement



Note:

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



For Hatsumono and Owarimono

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