



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

840B

/ 2

7N0120-7020B

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

January 3, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-318B

Revision No.:

2

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-12A80 (W); Clamp 82711-12A60 (W)

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div>Safety Instruction Be sure to wear prescribed 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>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Checked	Approved	Prepared by	Reviewed by	Reviewed by	Approved by
01/03/22	2	Change part number from 7N0120-7020A to 7N0120-7020B due to change in clamp (82711-12A80(W)) (82711-12A60 (W)) location and quantity. Improve work procedure in all process.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
09/10/21	1	Revise due to improve illustration; provide permanent jig; briefly discuss the process; Change pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
08/06/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Checked	Approved	Est. Date:	August 06, 2021		

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PARTS:		1. Clamp 82711-12A80 (W) [3pcs.] 2. Clamp 82711-12A60 (W) [5pcs.]	3. Black tape [3pcs.]	JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp Setting	<p>1. Get 2pcs. of clamp 82711-12A80 (W) then set to clamp location 1 and 7 using both hands.</p> <p>2. Get 1pc. of clamp 82711-12A80 (W) then set to clamp location 8 using both hands.</p> <p>3. Get 2pcs. of clamp 82711-12A60 (W) then set to clamp location 2 and 3 using both hands.</p> <p>4. Get 2pcs. of clamp 82711-12A60 (W) then set to clamp location 4 and 5 using both hands.</p> <p>5. Get 1pc. of clamp 82711-12A60 (W) then set to clamp location 6 using both hands.</p> <p>6. Initially attach Black tape on clamp location 1, 7, and 8 using both hands.</p> <p>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</p> <p>Take note: Make an excess attach tape on clamp location 8 for easy setting up of assy parts.</p>		<p>STANDARD TAPING FOR CLAMP</p> <p>One side tape under clamp</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</p>

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

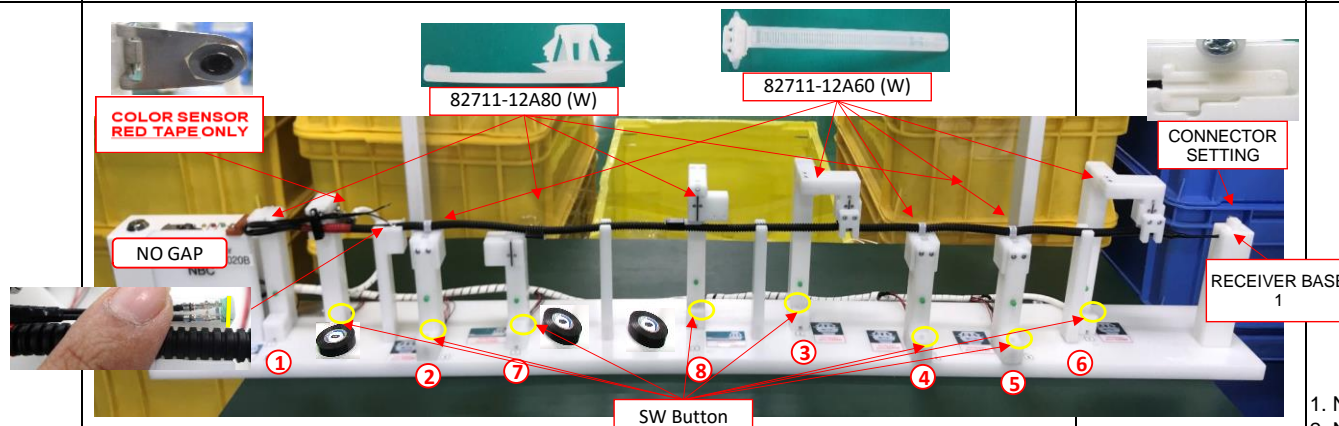
TOOLS/PPE

QUALITY POINTERS

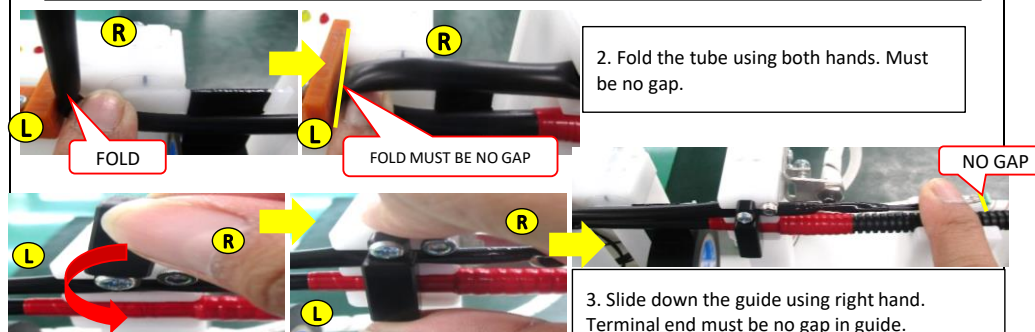
3

P2

Clamp Assembly



1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6098-3810 (W) to Receiver base 1. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Red tape. Fold the tube until the terminal end reaches the guide. (See below illustration)



2. Fold the tube using both hands. Must be no gap.

3. Slide down the guide using right hand. Terminal end must be no gap in guide.

n/a

1. No loose clamp attached
2. No damage clamp
3. No missing parts
4. No gap in between of guide

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

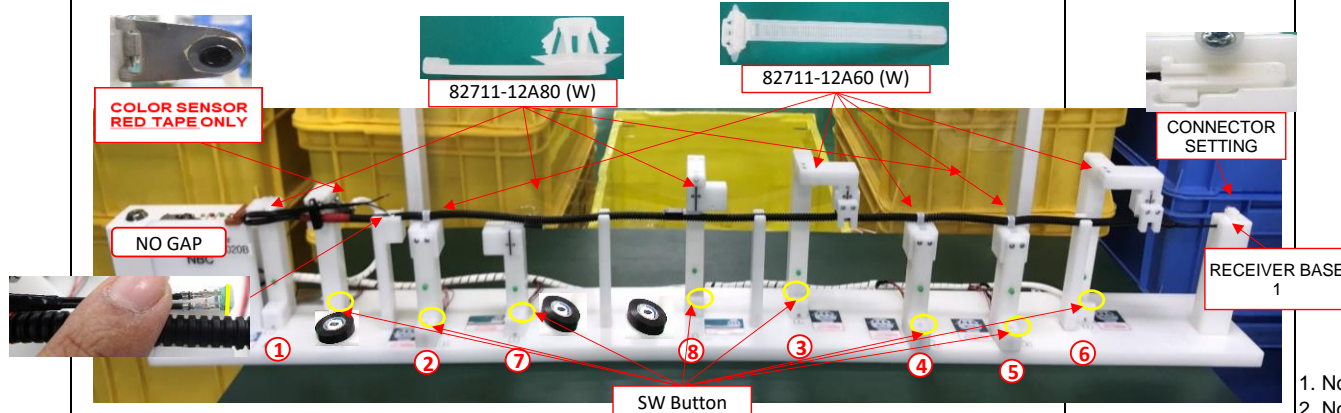
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp Assembly
(Continuation)



4. Initially tighten the band clamp on clamp location 2, 3, 4, 5 and 6 using both hands. Continue if the sequence light in location 1 was ON.

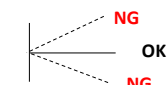
6. Get the bando gun using right hand then cut the band clamp on location 2 using both hands. Press the SW button after cut. Repeat the process on clamp location 3, 4, 5 and 6. Continue if the sequence light on clamp location 7 was ON.

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



BANDO GUN

PERPENDICULARITY



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: ø5 - 1~2, ø7 - 3~4



Fixed setting of band clamp cutter: 1~2

BANDO GUN



1. No loose clamp attached
2. No damage clamp
3. No flip-out tape
4. No peel-off tape
5. No loose tape
6. No wrong use of tape

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PARTS:

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JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

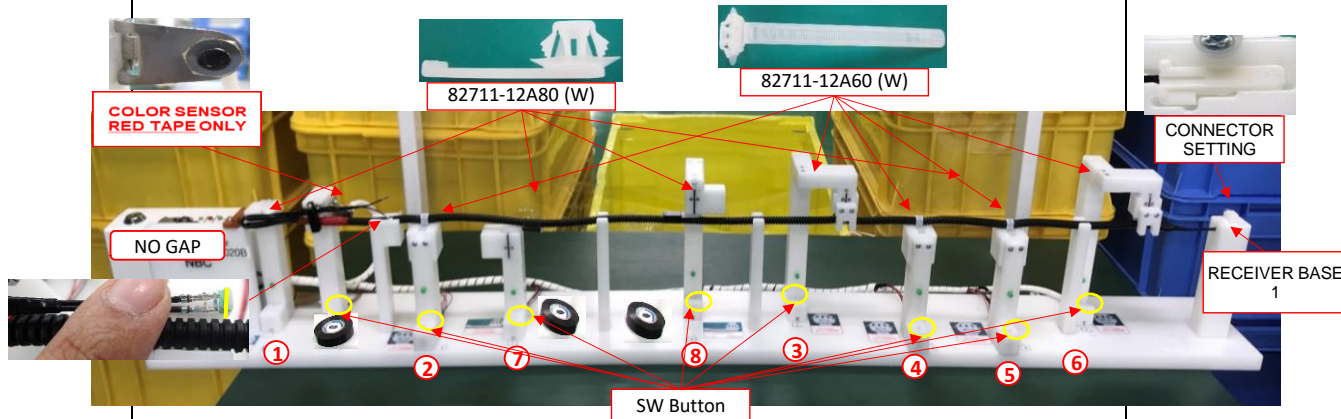
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp Assembly
(Continuation)



n/a

7. Hold the tape on clamp location 7 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in location 8 was ON.

8. Hold the tape on clamp location 8 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. GO sound will be heard.

10. After taping, conduct POINT CHECKING before removing the harness from the jig.

1. No loose clamp attached
2. No damage clamp
3. No flip-out tape
4. No peel-off tape
5. No loose tape
6. No wrong use of tape

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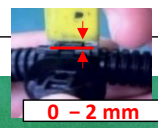

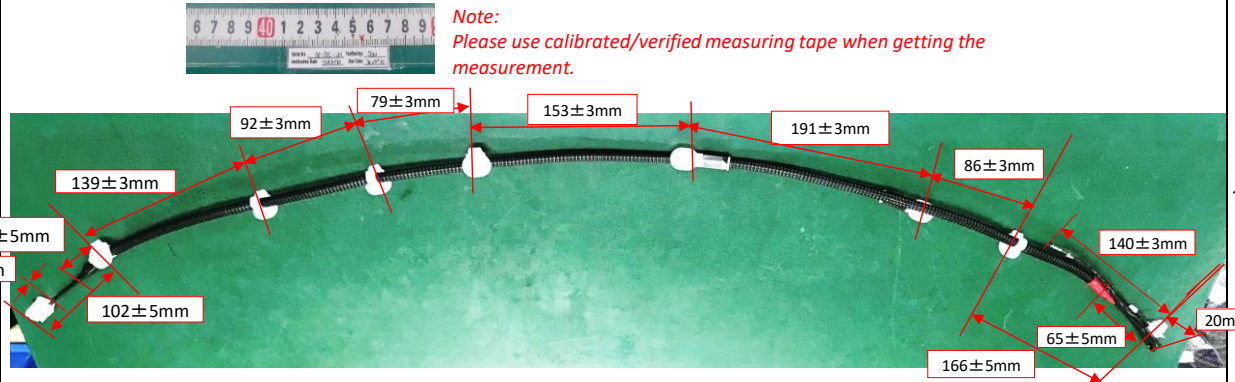
☒ MASSPRO

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PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Visual/By Two's Inspection	<p>1. Check the double lock connector.</p> <p>2. Check the taping condition, clamp attachment and alignment.</p> <p>3. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p> <p>4. Check the terminal appearance, make sure no deformed terminal.</p> <p>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></p>		<p>MASTER SAMPLE</p> 
5	Measurement	<p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p> 		<p><i>NOTE: FOR HATSUMONO AND OWARIMONO</i></p> <p>1. No wrong dimension</p>

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