



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 320B / 4 7L0052-7023

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

November 26, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-138C

Revision No.:

4

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PARTS:

4

1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Black tape [5pcs.]; Yellow tape [1pc.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

4

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

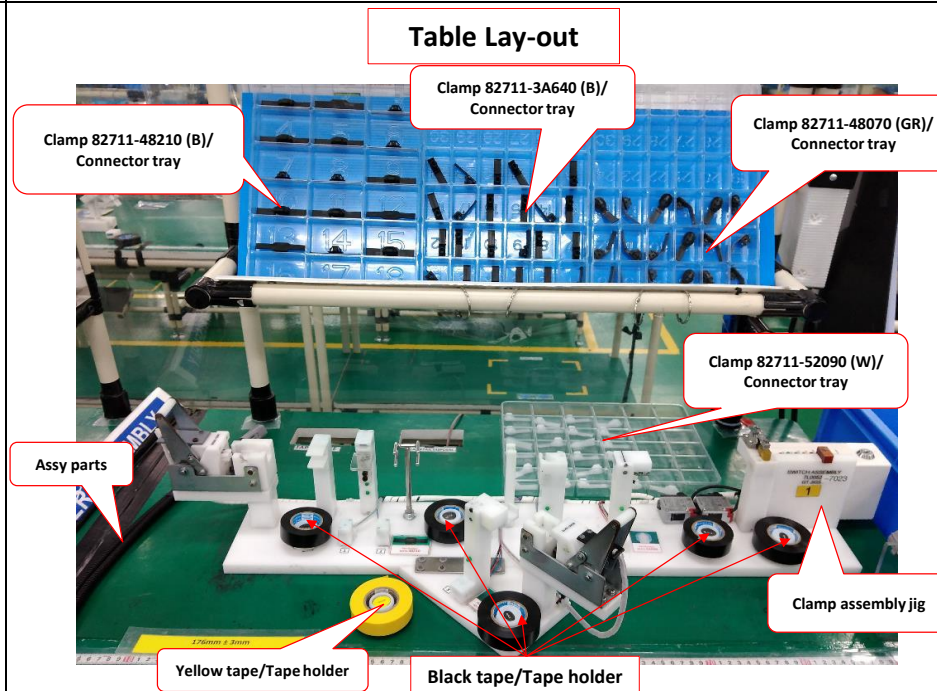
QUALITY POINTERS

1

P3

4

Table Lay-out

**Safety Instruction**

Be sure to wear required 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 missing parts/tools
2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
11/26/21	4	Change part number from 7L0052-7022 to 7L0052-7023 due to additional clamp (82711-52090 (W)). Improve work procedure and illustration in all process. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
08/12/21	3	Change Clamp assembly setting. Add Taping 3 Black Corrugated tube to Black Sunprene tube from P2. Remove spot taping process and transfer to P2. Add measuring tape in Measurement process and master sample.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
05/18/21	2	Remove cycle time. Add tape quantity. Transfer taping of COT to sunprene near terminal.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

Prepared by

Reviewed by

Approved by

Noted by

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PARTS:



1. Clamp 82711-48210 (B)
2. Clamp 82711-48070 (GR)
3. Clamp 82711-3A640 (B)

4. Clamp 82711-52090 (W)
5. Black tape [5pcs.]

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

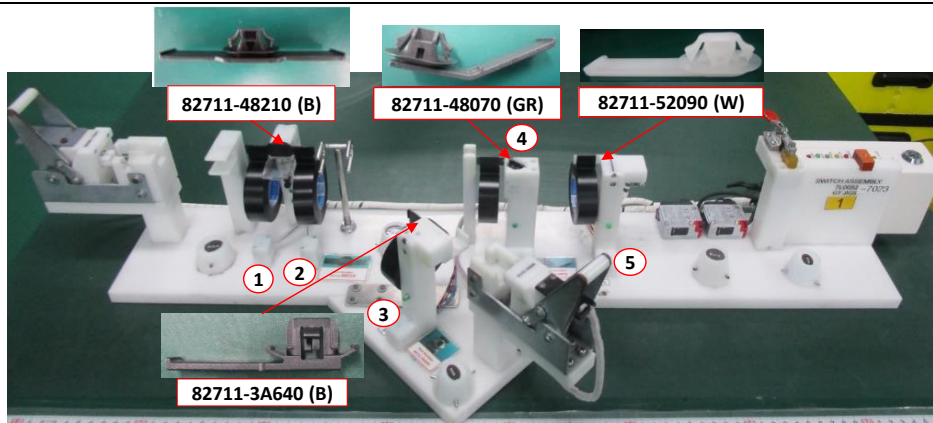
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp setting



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

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

3. Get 1 pc. of clamp **82711-48070 (GR)** using right hand then insert to clamp location **4** using both hands.

2. Get 1 pc. of clamp **82711-3A640 (B)** using right hand then insert to clamp location **3** using both hands.

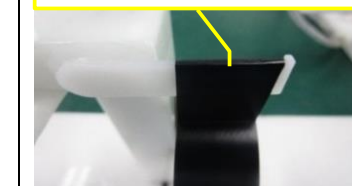
4. Get 1 pc of clamp **82711-52090 (W)** using right hand then insert to clamp location **5** using both hands.

5. Get the **Black tape** then initially attach to clamp location **1, 2, 3, 4 and 5** using both hands.

n/a

### STANDARD TAPING FOR CLAMP

One side tape under clamp



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

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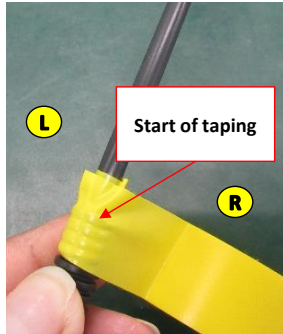


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PARTS:		1. Assy parts 2. Yellow tape		JIG	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3 Taping 1 Black Corrugated tube to Black Sunprene tube	 <p>1. Measure from end of COT up to hotmelted wire <b>176mm</b> using both hands.</p>  <p>2. Fix the COT and sunprene tube using both hands. Make sure no gap in between.</p> <p><b>Must be no gap</b></p>  <p>3. Get the <b>Yellow tape</b> using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>4. After taping, check the dimension and taping condition.</p>	<p><b>MEASURING JIG</b></p> 	<p><b>NOTE: USE YELLOW TAPE ONLY</b></p> <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol>	

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PARTS:		1. Assy parts 2. Black tape	JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	<div><div>CONNECTOR SETTING</div><div>CHECKER 1</div><div>82711-48210 (B)</div><div>82711-3A640 (B)</div><div>82711-48070 (GR)</div><div>82711-52090 (W)</div><div>4</div><div>1</div><div>2</div><div>3</div><div>5</div><div>SW button</div><div>CONNECTOR SETTING</div><div>CHECKER 2</div><div>COLOR SENSOR YELLOW TAPE ONLY</div><div>COLOR SENSOR VIOLET TAPE ONLY</div><div>STOPPER</div></div> <div><p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector <b>6188-0066 (GR)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>6189-1161 (B)</b> to <b>Checker 2</b> then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB within the stopper then press by <b>Toggle clamp</b>. Continue if the sequence light of location <b>1</b> was <b>ON</b>.</p><p>2. Check if all LED light for <b>Power On, Clamp On, Wire1 &amp; Wire2</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</p><p>3. Hold the tape on clamp location <b>1</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>2</b> was <b>ON</b>.</p></div>	n/a	<div><div><p>Note: Make sure no gap between stopper jig and PCB</p></div><div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div></div>

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PARTS:		1. Assy parts 2. Black tape	JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Clamp Assembly (Continuation)	<p>CONNECTOR SETTING</p> <p>CHECKER 1</p> <p>82711-48210 (B)</p> <p>82711-3A640 (B)</p> <p>82711-48070 (GR)</p> <p>82711-52090 (W)</p> <p>1</p> <p>2</p> <p>3</p> <p>4</p> <p>5</p> <p>SW button</p> <p>CHECKER 2</p> <p>CONNECTOR SETTING</p> <p>STOPPER</p> <p>COLOR SENSOR YELLOW TAPE ONLY</p> <p>COLOR SENSOR VIOLET TAPE ONLY</p> <p>4. Hold the tape on clamp location <b>2</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>3</b> was <b>ON</b>.</p> <p>5. Hold the tape on clamp location <b>3</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>4</b> was <b>ON</b>.</p> <p>6. Hold the tape on clamp location <b>4</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>5</b> was <b>ON</b>.</p> <p>7. Hold the tape on clamp location <b>5</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard.</p> <p>8. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</p>	n/a	<p>Note: Make sure no gap between stopper jig and PCB</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>

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PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Visual/By Two's Inspection	<p>1. Check the connector lock.</p> <p>2. Check the Y-taping, spot taping and clamp attachment condition.</p> <p>3. Conduct bending of clamp with 2 sides taping.</p> <p>4. Check the alignment of COT and spot taping on two sides taping.</p> <p>5. Compare to Master sample. <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></p>		<p><b>MASTER SAMPLE</b></p>
6	Measurement	<p><b>MEASURING TAPE</b></p> <p>Note: Please use calibrated/verified measuring tape</p> <p>152±3mm, 188±3mm, 128±3mm, 213±3mm, 0~5mm, 42±3mm, 198±3mm, 80±3mm, 176±3mm</p>	<p>NOTE: FOR HATSUMONO AND OWARIMONO</p>	<p>1. No wrong dimension</p>

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