



WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **D01L / 7M0647-7020D** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

May 28, 2021

Validity Date:

n/a

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Revision No.:

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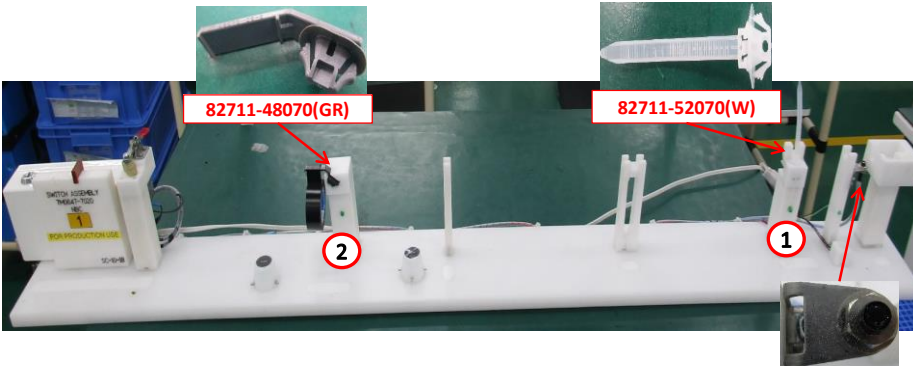
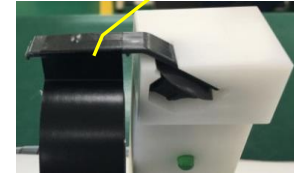
PARTS:

4

1. Clamp 82711-52070 (W)
2. Clamp 82711-48070 (GR)
3. Black tape [1pc.]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 4 Clamp setting	 <p>1. Get 1pc. of band clamp 82711-52070 (W) using right hand and set to location 1 using both hands.</p> <p>2. Get 1pc. of clamp 82711-48070 (GR) using right hand and set to location 2 using both hands.</p> <p>3. Initially attach Black tape on clamp location 2 using both hands.</p> <p>Note: Please check the clamp first before start of assembly to avoid wrong use of clamp.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>STANDARD TAPING FOR CLAMP</p> <p>One side tape under clamp</p>  <ol style="list-style-type: none">1. No loose attachment of clamp2. No wrong use of clamp3. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/28/21	4	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
11/28/20	3	Changed effectivity and validity date. Apply some improvements. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
03/01/19	n/a	Previously established as Engineering instruction (EI-ENG-PDE-071). Initial issue	J. Loterte	R. Alcantara	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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DCC Stamp



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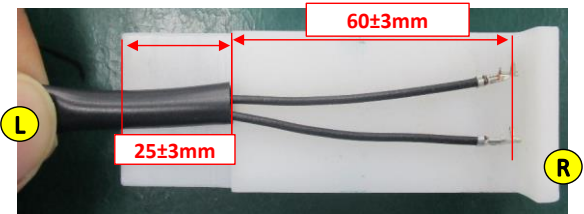
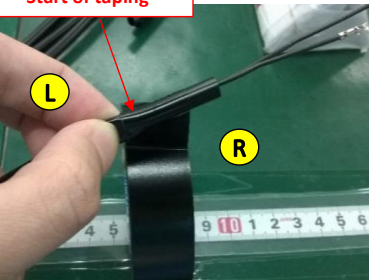
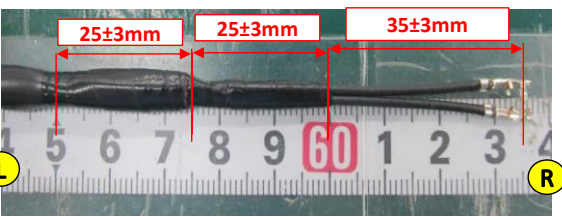


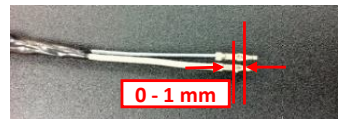
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PARTS:		1. Assy parts 2. Black tape		JIG	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black vinyl tube to wire near terminal	 <p>1. Measure from end of vinyl tube up to terminal pointed tip 60±3mm and vinyl tube 25±3mm using the provided measuring jig.</p>  <p>2. Get the black tape and start taping process using both hands. Note: Please refer to GL-PRO-ASY-001 for taping procedure.</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>		 <p>MEASURING JIG</p>  <p>MEASURING TAPE</p>	 <p>0 - 1 mm</p> <p>Wire alignment tolerance</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension 5. No wrong use of tape</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</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

4

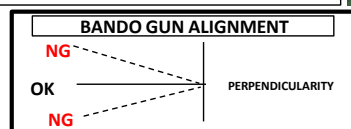
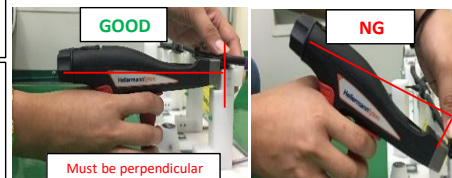


1. Get the assy parts and set into jig. (See above picture for the correct setting). First, set the connector 4G5400-0000 (W) to Receiver base 1 and then lock. Color sensor light will beep/buzz if sensor detects Orange tape. Continue to set the harness in jig. Then, set the B/B wires together within the stopper then press by toggle clamp. Continue the process if sequence light in location 1 was ON.

3. Initially tighten the band clamp on location 1 using right hand.

4. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after cut. Continue the process if sequence light on location 2 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.



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

Bando Gun



NOTE: MAKE SURE THAT THE TERMINAL AND STOPPER JIG HAS NO GAP.

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 <div>4</div> Clamp Assembly (Continuation)	<div><div>Stopper jig</div><div>82711-48070</div><div>Connector Setting</div><div>Receiver base 1</div><div>1</div><div>82711-52070</div><div>Color Sensor (Orange tape)</div><div>2</div></div> <div>5. Hold the clamp in location 2 using left hand and begin taping using right hand. Make 3 windings before cutting of tape. Press the SW button after taping. Go sound will be heard.</div> <div>6. Conduct POINT CHECKING before removing the harness from jig.</div>		n/a	<div><div>NOTE: MAKE SURE THAT THE TERMINAL AND STOPPER JIG HAS NO GAP.</div></div> <div>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts</div>

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

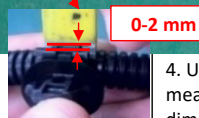
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Visual/By Two's Inspection

1. Check the connector lock.

2. Check the clamp attachment and taping condition.

3. Check the terminal appearance. make sure no deformed terminal.



0-2 mm

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

5. Compare to Master Sample

Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

MASTER SAMPLE



P2

5

Measurement

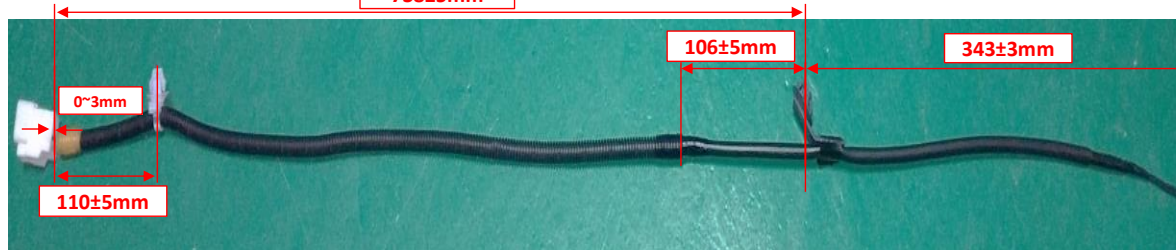
MEASURING TAPE



Note:

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

738±5mm



NOTE: FOR HATSUMONO AND OWARIMONO

1. No missing parts

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