

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

Effectivity Date:

March 1, 2021

Product Name/Code: **780B / 7R0105-7020B** Customer: **TRMX**

Validity Date:

-

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

WI-ENG-PDE-200B

Revision No.:

1

Page No.:

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PARTS: 1. Clamp 82711-16830 (B)**JIG**

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Clamp assembly setting	<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 work place 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>	1. No wrong use of clamp 2. No damaged clamp

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	Prepared by:	Reviewed by:	Approved by:	Noted by:
03/01/21	1	Part number change; change status from pre-launch to masspro; change dimension from clamp to PCB from 395mm Tto 419mm	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		J. Loterte	C. Villanueva	Shimamura	A. Arañes

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DCC Stamp

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts
2. Black tape

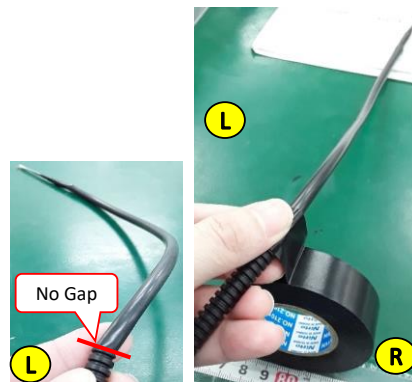
JIG

n/a

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

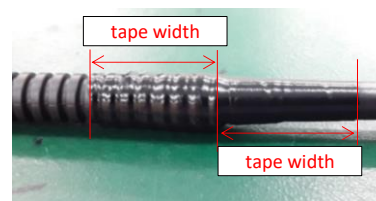
2

P2

Taping
COT to Sunprene

1. Hold the COT using left hand. Get Black tape using right hand and start taping using both hands. Make sure no gap between COT and Sunprene tube.

Refer to WI-PRO-ASY-001 for taping procedure.



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

MEASURING TAPE

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape

Note:

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

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

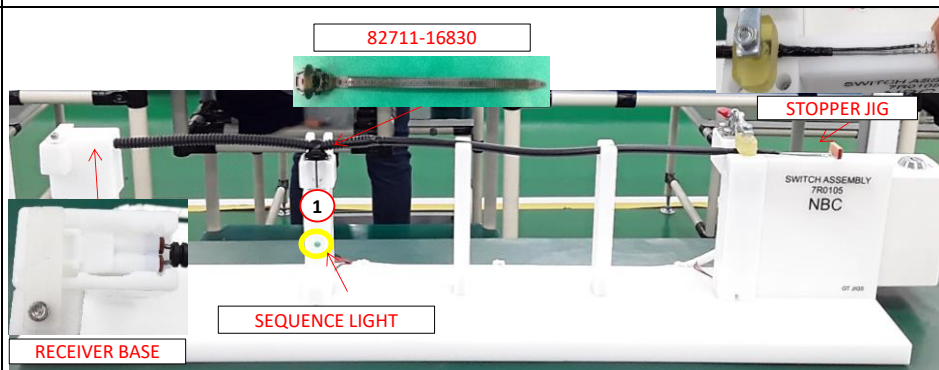
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp assembly

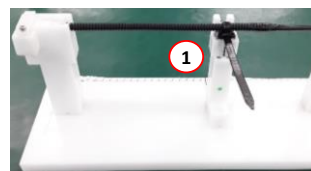


1. Get the assy parts using both hands. First, put the connector into receiver base then lock. Second, put the terminal to stopper jig. Pull down the toggle clamp using right hand.
Refer to above illustration for the correct setting.

2. Check if LED light for **POWER**, **CLAMP** and **SEQUENCE LIGHT** is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

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

4. Get the bando gun and cut the clamp on location **1**. Press the switch button after cutting.



5. Conduct **POINT CHECKING** before removal from jig.

BANDO GUN

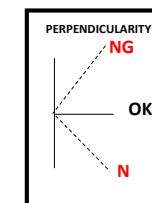


Make sure no Gap between terminal and stopper jig



Fixed setting of band clamp cutter: 1~3

BANDO GUN ALIGNMENT



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n/a

JIG

n/a

NO.

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TOOLS/PPE

QUALITY POINTERS


4

Visual/By two's inspection

1. Check if the connector was properly locked.

2. Check the clamp attachment and alignment.

3. Check the terminal condition. Make sure no deformed terminal.

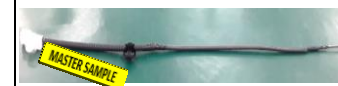


0 - 2 mm

4. Confirm the band cut measurement using steel rule if the band cut is longer than the requirement. (0~2mm only).

5. Compare to Master Sample.
Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

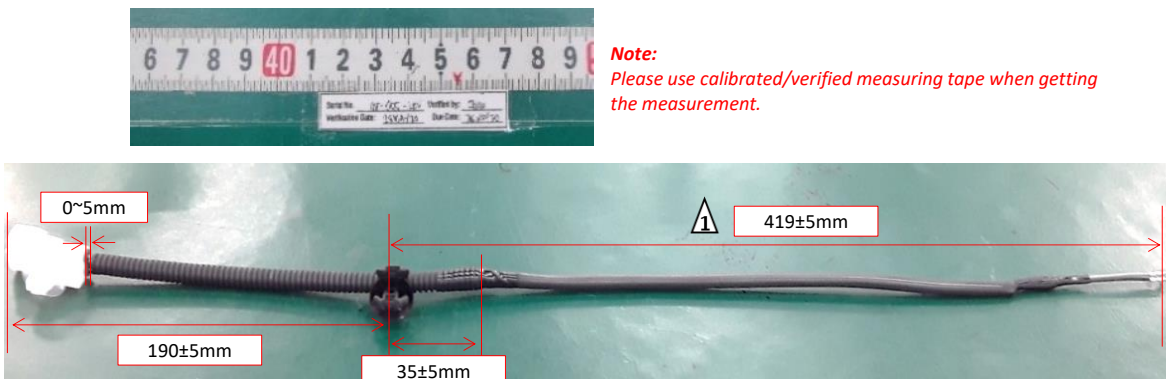
MASTER SAMPLE



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P2

Meaasurement



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

For Hastumono and Owarimono

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