



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **D01L / 7M0651-7020C**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 9, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-353C

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-52070(W); Clamp 82711-52090; Sky Blue Tape; Black tape

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

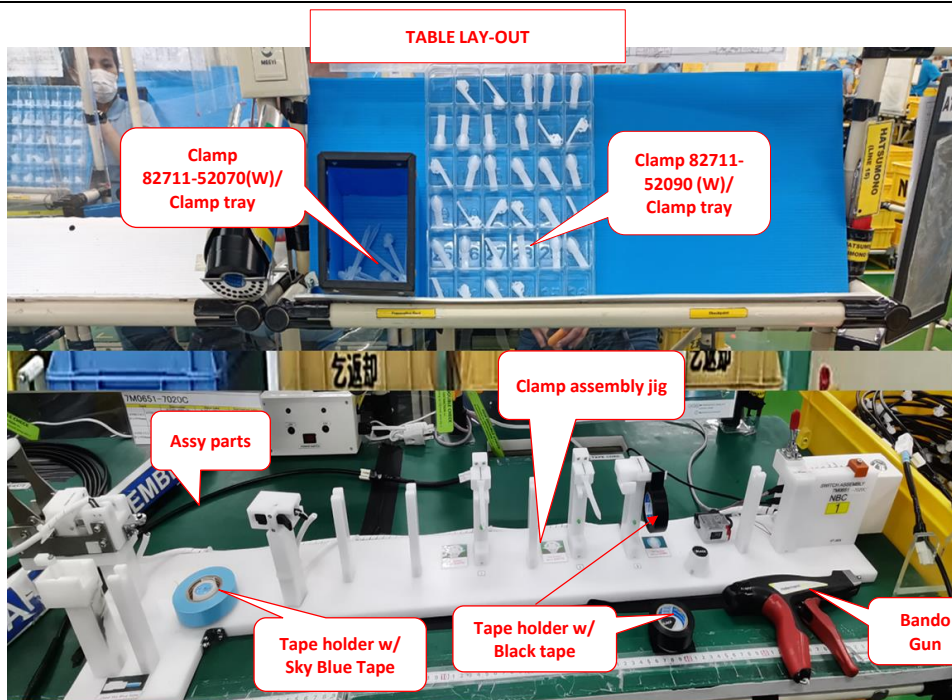
TOOLS/PPE

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.

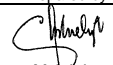
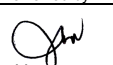
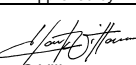
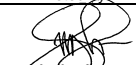
1. No missing parts/tools
2. No excess parts/tools

Important reminders/Note/s:

1. Please check the clamp first before start of assembly to avoid wrong use of clamp.
2. Used **YELLOW TAPE** to easy visualization of shifting lines, But actual should be **BLACK TAPE**.



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
12/09/22	1	Improve Quality pointers; Reminders/notes and references on pages no. 1 to 9 due to documents improvement. Work procedure/illustration on process no.7- Visual and By two's inspection.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes					
05/25/22	0	Initial Issue	M. Ariola	J. Loterte	C.Villanueva	A. Arañes		M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:		May 25, 2022		

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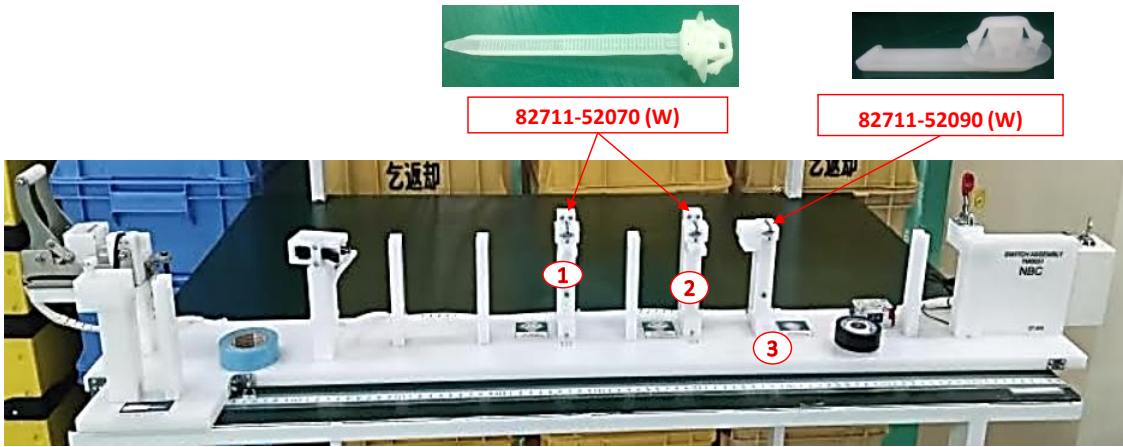




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PARTS:		1. Clamp 82711-52070 (W) [2pcs.] 2. Sky Blue tape 3. Black tape		4. Clamp 82711-52090 (W)		JIG	n/a
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
2	P3	Clamp setting	<div></div> <div>1. Get the 2pcs. of clamp 82711-52070 (W) using right hand then insert to clamp location 1 and 2 using both hands.</div> <div>2. Get 1 pc. of clamp 82711-52090 (W) then set to clamp location 3 using both hands.</div> <div>3. Initially attach the black tape to location 3 using both hands.</div>				<div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape 4. No wrong insertion of clamp</div> <div>Important reminders/Note/s:</div> <div>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</div> <div>2. Used YELLOW TAPE to easy visualization of shifting lines, But actual should be BLACK TAPE.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52070 (B)</div></div><div><div>NG</div><div></div><div>82711-12A60 (W)</div></div></div>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P3

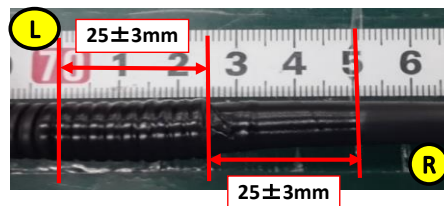
Taping 1
Black Corrugated tube to
Black Vinyl tube



Note:
Must be no gap between COT
and vinyl

1. Fix the corrugated tube to vinyl tube using left hand then get **Black tape** and start taping using right hand.

Note: Refer to WI-PRO-ASY-001 for taping procedure



2. After taping, check the tape condition & measurement.

MEASURING TAPE



Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Must be no gap between COT and Vinyl tube.

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

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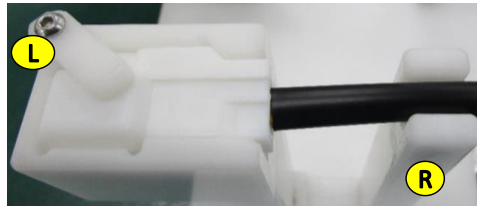



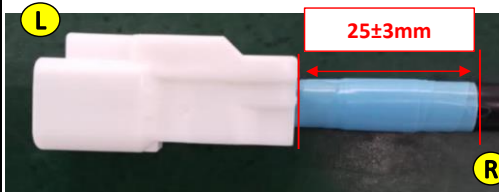
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PARTS:		1. Assy parts 2. Sky Blue tape		JIG	1. Spot taping jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Spot taping		1. Put the connector 4G5400-0000 (W) into Receiver base using both hands then lock.	<div>MEASURING TAPE</div> 	<div><div>1</div><div>Important reminders/Note/s:</div><div>1. Use <u>SKY BLUE TAPE only.</u></div><div>2. Please use calibrated/verified measuring tape when getting the measurement.</div></div>
				2. Get the Sky Blue tape then attach to tube using both hands (must be follow the guide).		
				3. Continue taping process using both hands then make 3 windings of tape before cut. Remove the harness using both hand.		
				3. After taping, check the measurement and taping condition.		

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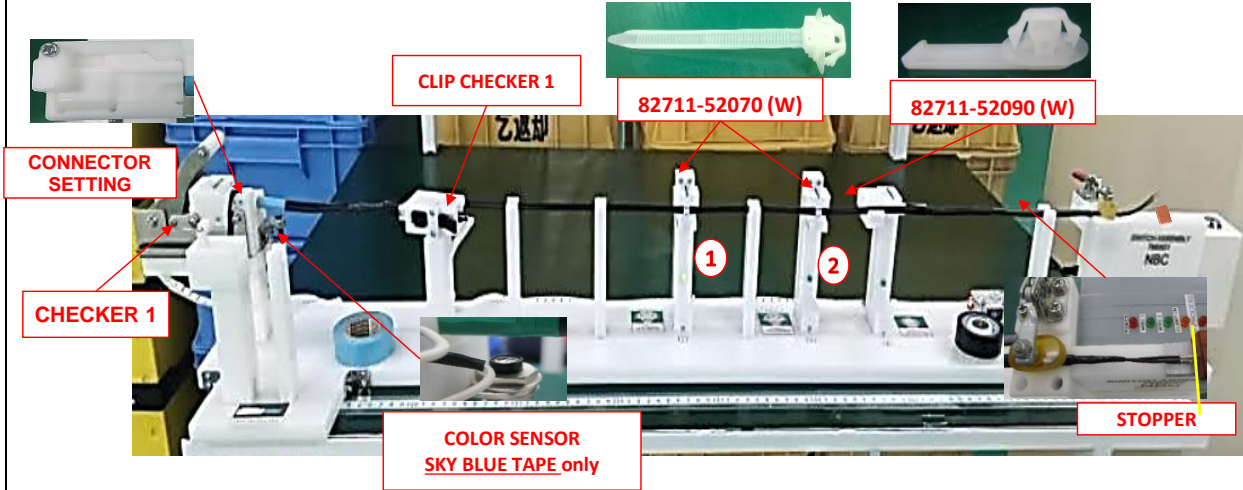


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PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	Clamp Assembly			 STOPPER
			<p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 4G5400-0000(W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Clamp assembly jig will beep/buzz if color sensor detects Sky Blue tape. Next, set the connector 7282-1027 (W) to Clip checker 1 then lock. Last, set the B/B wires together within stopper then press by toggle clamp. Continue if the sequence light on clamp location 1 was ON.</p>		<p>Important reminders/Note/s: </p> <p>1. Make sure no gap between stopper jig terminals.</p> <p>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between terminal and stopper jig.</p>
			<p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON. SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p>	<p>3. Initially tighten the band clamp on clamp location 1 and 2 using right hand.</p>	

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PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P3 Clamp Assembly (Continuation)	<p>4. Get the bando gun using right hand then cut the band clamp on location 1 and 2. Press the SW button every cut. Go sound will be heard.</p> <p>5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands.</p> <p>6. Conduct POINT CHECKING before removing the harness from jig.</p>		<p>BANDO GUN ALIGNMENT</p> <p>GOOD NG</p> <p>BANDO GUN</p>	<p>STOPPER</p> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper jig terminals.</p> <p>2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p>

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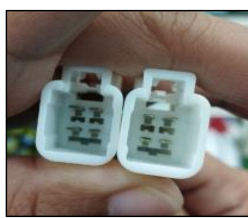









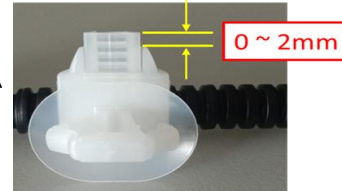


MASSPRO

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PARTS:		1. Assembled parts 2. Master sample		JIG	n/a
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P3	Visual/By Two's Inspection	<div><div>ACTUAL PRODUCT</div></div> <div><div><div>Assembled parts</div><div>Master sample</div><div></div></div><div><div></div><div>2. Check the connector lock, insertion, and terminal.</div></div><div><div></div><div>3. Check the spot taping condition and color of tape.</div><div><div></div><div>4. Check the presence of clamp attachment, band clamp cut.</div></div><div>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</div></div></div>		<div><div>MASTER SAMPLE</div><div></div><div>1. No skip checking during inspection.</div></div> <div><div>1 Important reminders/Note/s:</div><div>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</div><div><div><div>0 ~ 2mm</div></div><div>BAND CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div>82711-52070 (B)</div></div><div><div>NG</div><div>82711-12A60 (W)</div></div></div></div></div>

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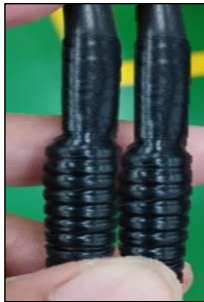





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PARTS:		1. Assembled parts 2. Master sample		JIG	n/a
NO.	PROCESS NAME	<div>1</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
7	P3	<div>Visual/By Two's Inspection (Continuation)</div> <div><div>ACTUAL PRODUCT</div><div></div><div>5. Check the connector, terminal and Y-taping condition.</div><div>6. Check the taping condition.</div><div>7. Check the taping condition, terminal appearance. Must be no deformed terminal.</div></div>		<div>MASTER SAMPLE</div> <div></div> <div>1. No skip checking during inspection.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div><div>82711-52090 (W)</div></div><div><div>NG</div><div><div>82711-12A80 (W)</div></div></div></div></div>	

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

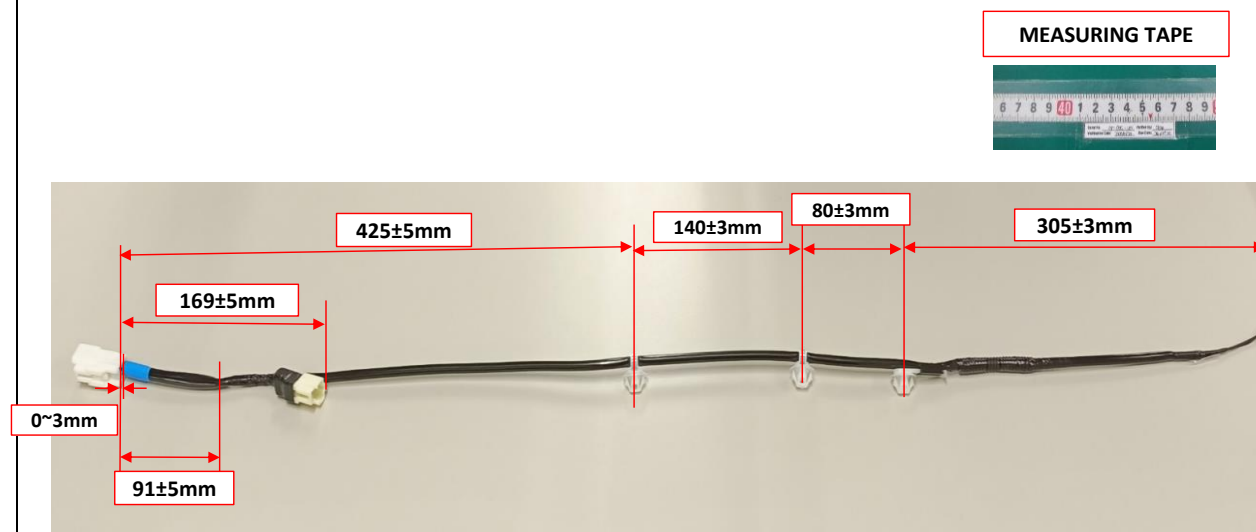
TOOLS/PPE

QUALITY POINTERS

8

P3

Measurement



MEASURING TAPE

1. No wrong dimension

1

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

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PARTS:

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JIG

n/a

1 QUALITY CHECKPOINTS

P3

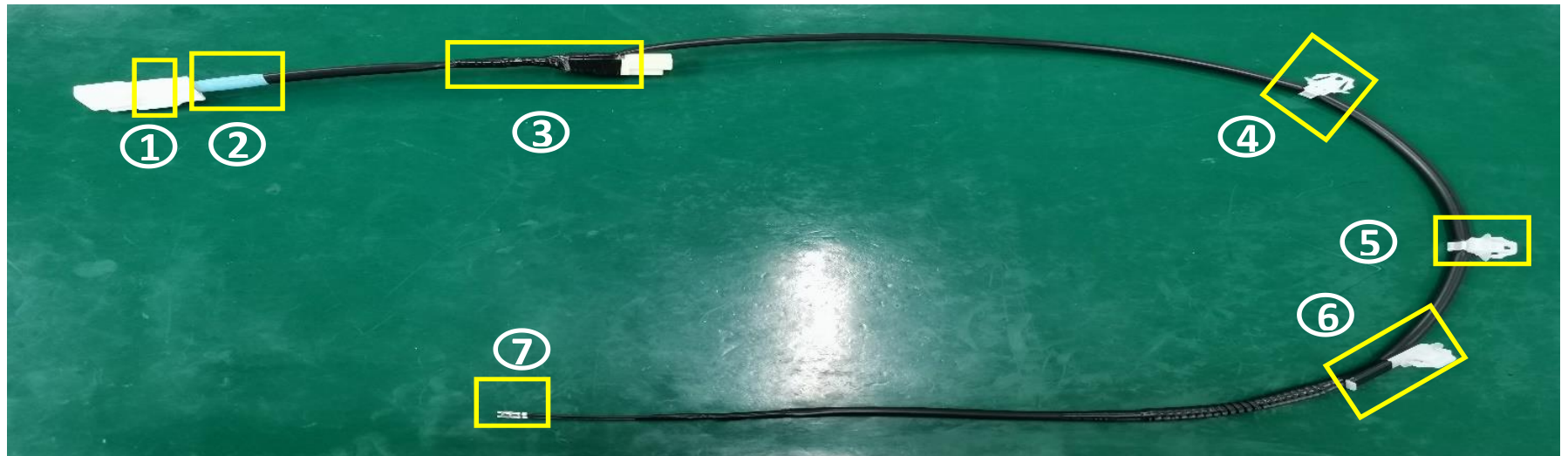
7M0651-7020C



GOOD



NO GOOD



- ① **No Unlock/ Half Lock Connector**
- ② **No Missing Spot tape (sky blue)**
- ③ **No Missing tape**

- ④ ⑤ ⑥ **No Missing Band clamp and common clamp**
- ⑦ **No Deformed Terminal**

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