PARTS: △3	1. Assy parts: Clamp 82711-34490 (B); Clamp 82711-16820 (BR); Clip type clamp 82711-1E360 (W); Label 7V1080-0020 (73230-06B20 Passenger power); Clamp 82711-52090 (W)	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 — 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 work place 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

Table Lay-out — labels: Label 7V1080-0020 (73230-06B20); Clip type clamp 82711-1E360 (W); Clamp 82711-52090 (W); Assy parts; Clamp 82711-34490 (B); Clamp 82711-; Clamp Assembly Jig; Bando Gun

Revision History			Prepared by	Reviewed by	Approved by	Noted by
01/05/22	3	Change part number from 7L0032-7022 to 7L0032-7023 due to additional of clamp (82711-52090 (W). Improve work procedure in all process. Additional table lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes
03/11/21	2	Change clamp color in accordance with color standardization for plastic parts (GL-COM-003); Put measuring tape illustration and instruction on Measurement; Remove cycle time; Rephrase the band cut measurement instruction	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
09/01/20	1	improvements; Add cycle time; separate P1 and P2 process	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Check ed	Approved	Noted

Established Date: July 10, 2017

Prepared by: K. Doria Reviewed by: J. Loterte Approved by: C. Villanueva Noted by: A. Arañes

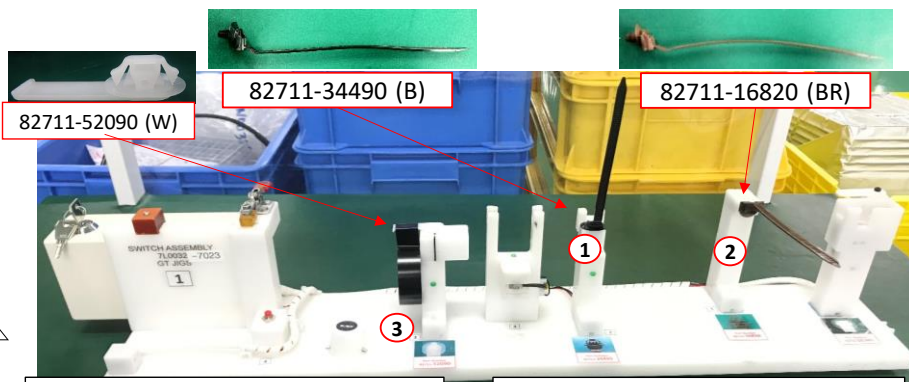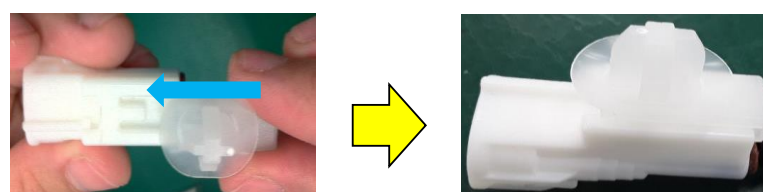|				
NBC	**WORK INSTRUCTION**		Effectivity Date:	January 5, 2022
	Process Name/Title: **TAPING ASSEMBLY PROCESS**		Validity Date:	n/a
	Model Code/Part Number: **010B** / △3 **7L0032-7023**	Customer: **TRQSS**	Document No.:	WI-ENG-PDE-168B
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.: 3	Page No.: 2 of 5

PARTS:	1. Clamp 82711-34490 (B) 2. Clamp 82711-16820 (BR)	4. Clamp 82711-52090 (W) △3 3. Clip type clamp 82711-1E360 (W)	**JIG**	1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2 P2	Clamp assmbly setting △3	 82711-52090 (W) — 82711-34490 (B) — 82711-16820 (BR) 1. Get 1 pc each of band clamp **82711-34490 (B)** and **82711-16820 (BR)** then attach to clamp location ① **and** ②. 2. Get 1 pc of Clamp **82711-52090 (W)** then attach to **clamp location** 3. Initially attached black tape on clamp location 3.	n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No damaged clamp 7. No wrong use of clamp 8. No missing clamp
3	Clamp attachment (clip type clamp) △3	 1. Hold the connector using left hand, get the clip type clamp **82711-1E360 (W)** then insert the clamp using right hand. *Note: Sound will be heard if properly inserted.*	n/a	1. Must be fully inserted

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	WORK INSTRUCTION		Effectivity Date:		January 5, 2022
Process Name/Title:	**TAPING ASSEMBLY PROCESS**		Validity Date:		n/a
Model Code/Part Number: **010B** / △3 **7L0032-7023**		Customer: **TRQSS**	Document No.:		WI-ENG-PDE-168B
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 3 of 5

PARTS:	1. Assy parts		JIG	1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly		

WORK PROCEDURE/ ILLUSTRATION

82711-52090

82711-34490

82711-16820

Connector setting

Stopper jig

SW Button
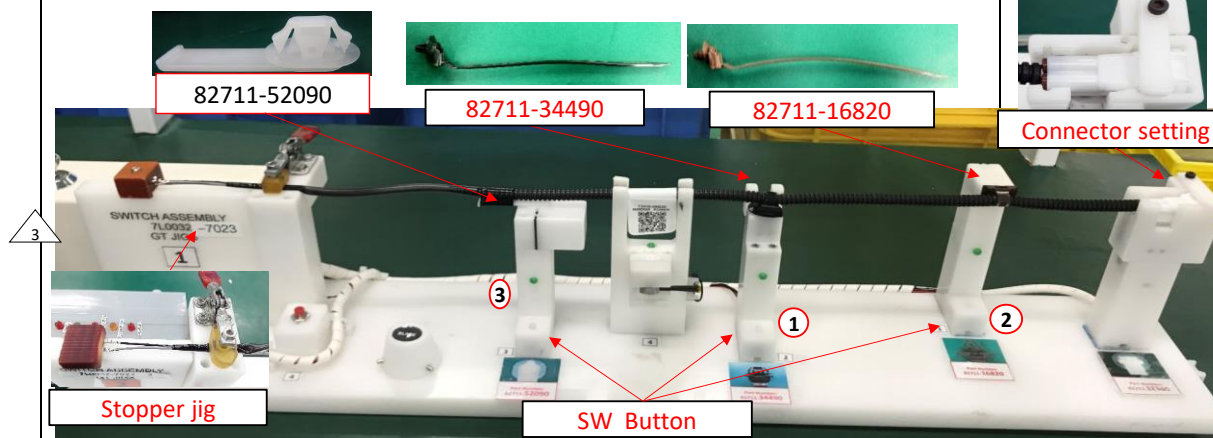
1. Put the assy parts into jig using both hands. First put the connector into receiver base using left hand and lock using right hand. Second, put the terminal to stopper jig using left hand and pull down the toggle clamp using right hand.
Refer to above illustration for the correct setting.

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

3. Initially tighten the two clamp **82711-34490 (B)** and **82711-16820 (BR)** using right hand.

4. Get the bando gun using right hand then cut the band clamp on Location ① and ②. Press the switch button after every cutting of band clamp. Continue if the sequence light in location 3 was ON.

① GOOD / NG
② GOOD / NG

5. Hold the tape on clamp location 3 then start taping using both hands. Make 3 windings of tape then cut the tape. Proceed to label attachment.

QUALITY POINTERS

Note:
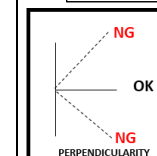**Make sure no clearance between terminal and stopper jig**

1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
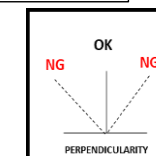4. No wrong setting of Bando gun

Fixed setting of band clamp cutter: 1 ~ 2

BANDO GUN ALIGNMENT

① NG / OK / NG PERPENDICULARITY

② OK / NG / NG PERPENDICULARITY

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		WORK INSTRUCTION		Effectivity Date:	January 5, 2022
NBC	Process Name/Title:	**TAPING ASSEMBLY PROCESS**		Validity Date:	n/a
	Model Code/Part Number: **010B** / △3 **7L0032-7023**		Customer: **TRQSS**	Document No.:	WI-ENG-PDE-168B
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 3	Page No.: 4 of 5

PARTS:	1. Label 7V1080-0020 (73230-06B20 Passenger power)	JIG	1. Clamp assembly jig

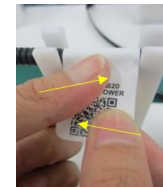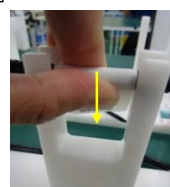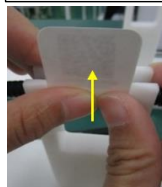| NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 — Clamp assembly Label Attachment	Model Code — Item no. & name 73230-06B20 PASSENGER POWER — Item no. & name 1. Get the label. **Check the model code, item no. & name** 2. Align the end part of label in the jig. 3. Fold the center part of the label 4. Align both end part of label. 5. After alignment, Press the label with both fingers. Make sure it was attach properly. 6. Press the label upside down using finger. GOOD — Acceptable overlap **0~1mm** 7. Press the SW button after label attachment. Conduct **POINT CHECKING** and remove the harness from jig.		**Model / Item no. / Item name** 7L0030 / 73230-06750 / Passenger Manual 7L0031 / 73230-06740 / Driver Manual 7L0032 / 73230-06B20 / Passenger Power 7L0033 / 73230-06760 / Driver Power 1. No bubbles 2. No damage 3. No peel off 4. No wrong use of label 5. No missing parts 6. No loose attachment NG
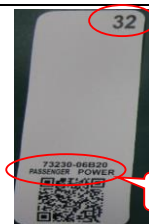
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NBC	**WORK INSTRUCTION**			Effectivity Date:		January 5, 2022
	Process Name/Title:	**TAPING ASSEMBLY PROCESS**		Validity Date:		n/a
	Model Code/Part Number: **010B** / △3 **7L0032-7023**		Customer: **TRQSS**	Document No.:		WI-ENG-PDE-168B
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 5 of 5

PARTS:	n/a		JIG	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Visual/By two's inspection	1. Check the connector lock 2. Check the clamp attachment, alignment & tape condition 4. Check the presence of label and terminal appearance. 3. Using a steel rule check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value. 0 – 2 mm 5. Compare to Master sample. *Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.*		**MASTER SAMPLE** MASTER SAMPLE
7	P2 Measurement	*Note:* *Please use calibrated/verified measuring tape when getting the measurement.* 115± 5mm 133± 3mm 133± 3mm 184± 3mm 53± 3mm 28 +4 -3 0~5mm 216± 3mm 349± 3mm		**FOR HATSUMONO AND OWARIMONO ONLY** 1. No wrong measurement

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