

	WORK INSTRUCTION						Efec: January 29, 2022		February 14, 2022	
	TAPING ASSEMBLY PROCESS						Valid: -		n/a	
	Process Name/Title:				Model Code/ Part Number: 780B / 7R0104-7022		Customer: TRMX		Docu WI-ENG-PDE-391C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		0 Page No.: 1 of 7	

PARTS:	1. All Parts; Assy Parts; Clamp 82711-26380 (BR); Clamp 82711-16830 (B)						JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	QUALITY POINTERS
1	P4	<div style="text-align: center;"> TABLE LAY-OUT </div>						<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Housekeeping</p> <ol style="list-style-type: none"> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<ol style="list-style-type: none"> 1.No missing parts/tools 2. No excess parts/tools

						Prepared by		Reviewed by		Approved by		Noted by	
						 M. Ariola		 J. Loterte		 C. Villanueva		 A. Arañes	
02/14/22	0	Initial issue				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est./Date: February 14, 2022			

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

February 14, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/ Part Number: **780B / 7R0104-7022**Customer: **TRMX**

Document No.:

WI-ENG-PDE-391D

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

2. Clamp 82711-26380 (BR) [4pcs.]

3. Clamp 82711-16830 (B) [1pc]

JIG

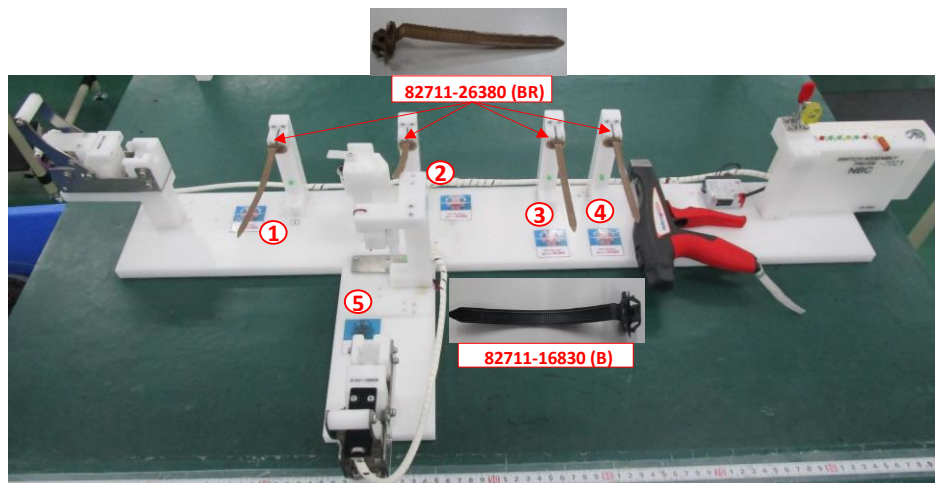
1. Clamp assembly jig

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

2

P4

Clamp setting



1. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **1** using both hands.

2. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **2** using both hands.

3. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **3** using both hands.

Note: Please check the clamp and band clamp before start of assembly to avoid wrong use of

4. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **4** using both hands.

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 wrong use of clamp
2. No damaged clamp
2. No wrong use of tape

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Customer: TRMX

Document No.:

WI-ENG-PDE-391D

Purpose: ☐ PROTOTYPE

PRE-LAUNCH


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PARTS:

1. Assy parts
2. Clamp 82711-16830 (B) [1pc]

3. Clamp 82711-26380 (BR) [4pcs]

JIG

- ### 1. Clamp assembly jig

NO.

PROCESS NAME

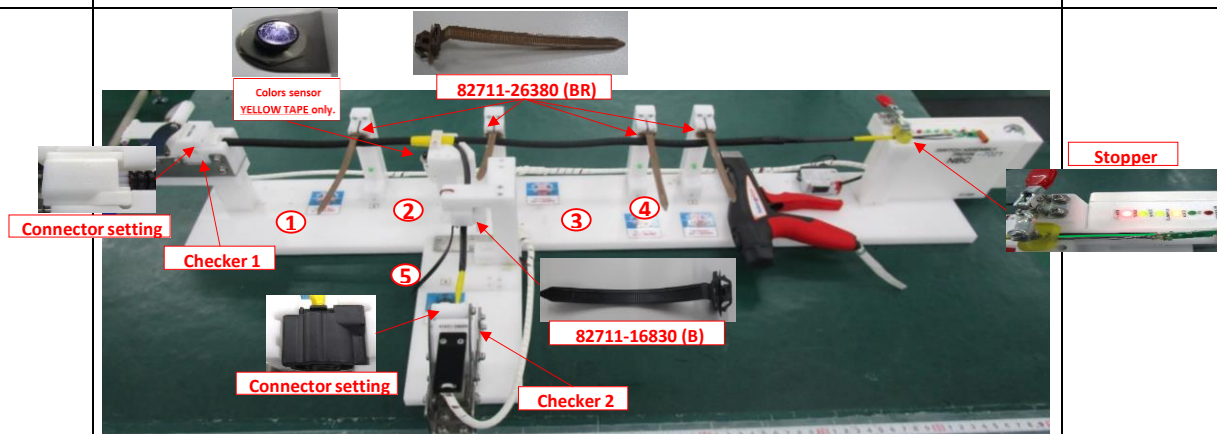
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P4

Clamp setting
(Continuation)

5. Hold the assy parts and then set to jig. *(See above picture for correct setting).* First, set the connector **6189-1142 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. **Color sensor** light will be beep/buzz if sensor detects **Yellow tape**. *(See below illustration for Y-Taping lock.)* Second, set the **PCB and B/B wires** to stopper jig and push down the toggle clamp. Last, set the connector **6189-1161 (B)** to **Checker 2** then push the checker fixture for continuity checking.



7. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **5** using both hands.

6. Using left index finger, push the guide lock to lock the Y-taping portion.

8. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2, Sensor ON** was On. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.



Note: Make sure no clearance between PCB and stopper iia.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

n/a

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

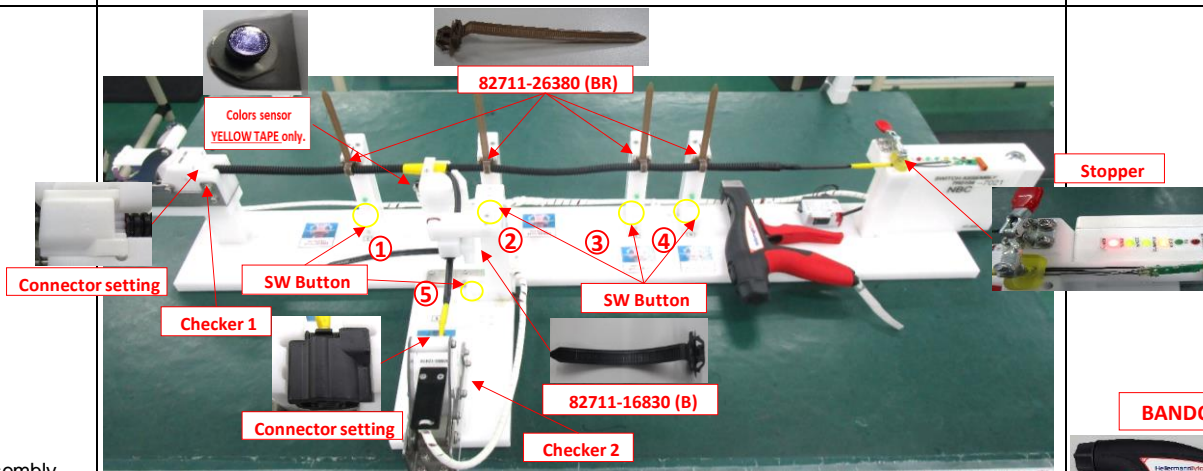
TOOLS/PPE

QUALITY POINTERS

4

P4

Clamp assembly

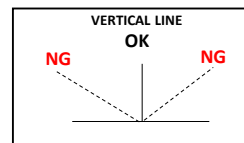


1. Initially tighten the band clamp on clamp location **1, 2, 3, 4, and 5** using both hands.

2. Get the Bando Gun using right hand and cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was on.

3. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was on.

4. Cut the band clamp on clamp location **3** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **4** was on.



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



Note: Make sure no clearance between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

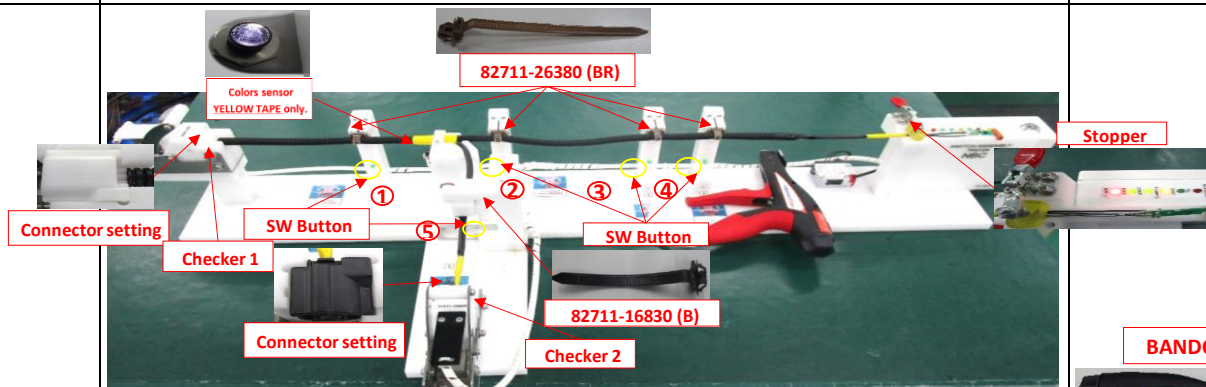
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

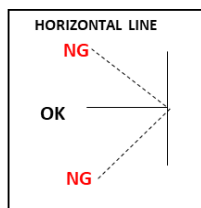
P4

Clamp assembly
(Continuation)

5. Cut the band clamp on clamp location 4 using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location 5 was on.

6. Cut the band clamp on clamp location 5 using both hands. (*See below illustration*). Press the **SW button** after cutting of band clamp. **Go** sound will be heard.

BAND CLAMP CUT POSITION FOR 82711-16830 (B)



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



Note: Make sure no clearance between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

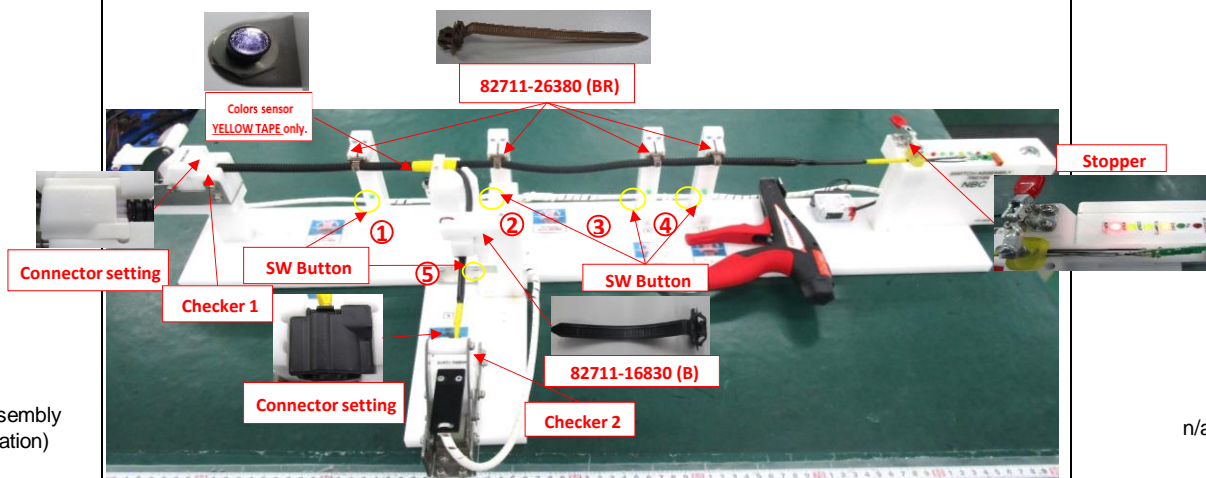
TOOLS/PPE

QUALITY POINTERS

6

P4

Clamp assembly
(Continuation)



7. Conduct **POINT CHECKING** before removing the harness from jig.

n/a



Note: Make sure no clearance between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

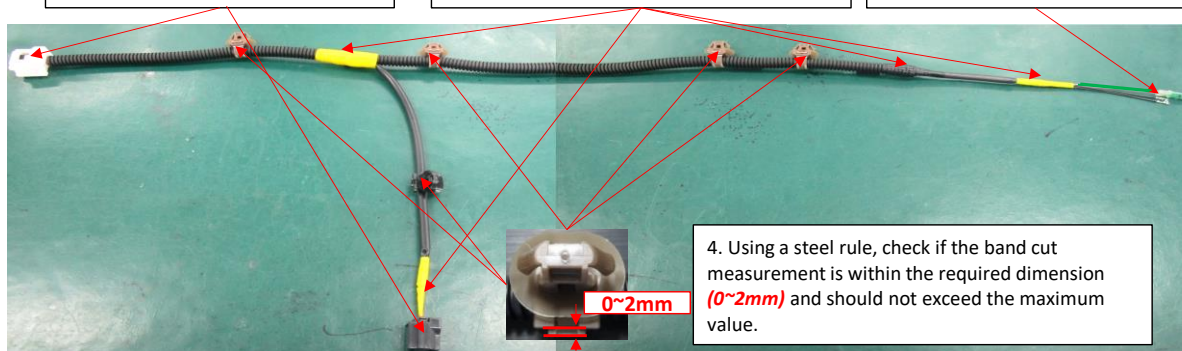
Visual/By two's inspection

P4

1. Check the connector if properly locked.

2. Check the taping condition.

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



5. Compare to Master sample.

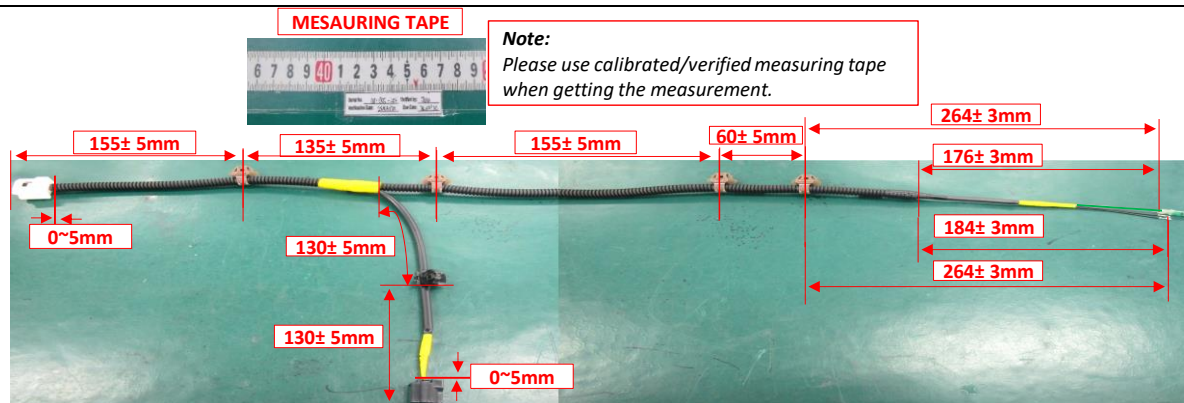
Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.

MASTER SAMPLE



8

Measurement



NOTE: For HATSUMONO AND OWARIMONO

1. No wrong dimension

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