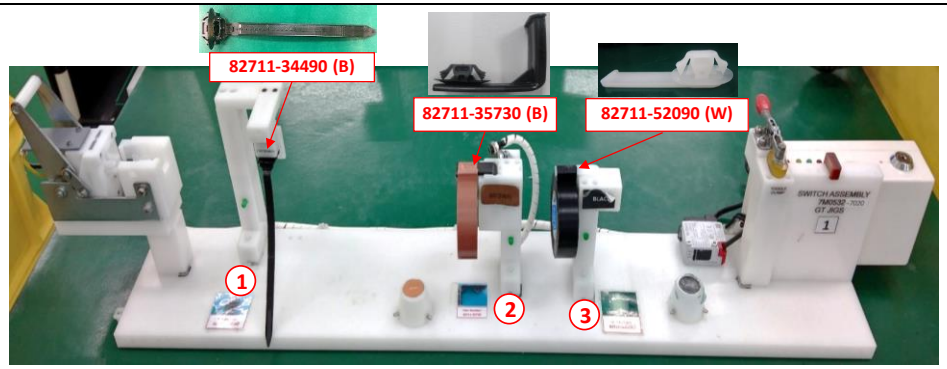
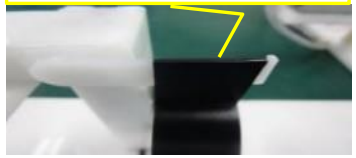
	WORK INSTRUCTION			Effectivity Date:	**July 07, 2021**
	Process Name/Title:	**TAPING ASSEMBLY PROCESS**		Validity Date:	**n/a**
	Product Name/Code: **587B / 7M0532-7020**	Customer: **TRJ**		Document No.:	**WI-ENG-PDE-209B**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3 Page No.: 1 of 6

PARTS:	1. Clamp 82711-34490 (B) 2. Clamp 82711-35730 (B) 3. Clamp 82711-52090 (W)	4. Brown tape [1pc.] 5. Black tape [1pc.] 3	JIG: 1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 3 Clamp setting	 1. Get 1 piece of clamp **82711-34490 (B)** using right hand and insert to location **1** using both hands. **Note: Please check the clamp before start of assembly to avoid wrong use of parts.** 2. Get 1 piece of clamp **82711-35730 (B)** using right hand and insert to location **2** using both hands. 4. Initially attach **Brown tape** on clamp location **2** using both hands. 3. Get 1 piece of clamp **82711-52090 (W)** using right hand and insert to location **3** using both hands. 5. Initially attach **Black tape** on clamp location **3** 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.	**STANDARD TAPING FOR CLAMP** One side tape under clamp  1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong use of clamp 6. No missing clamp

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted
07/07/21	3	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
01/06/21	2	Transfer process owner from Production (WI-PRO-ASY-058) to Engineering (WI-ENG-PDE-209B). Apply some improvements/pictures.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes
11/03/17	0	Initial issue	J. Montealto/ L. Briones	O. Merin	T. Sugiyama	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Est. Date:	November 03, 2017		

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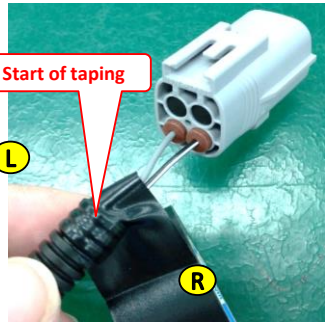
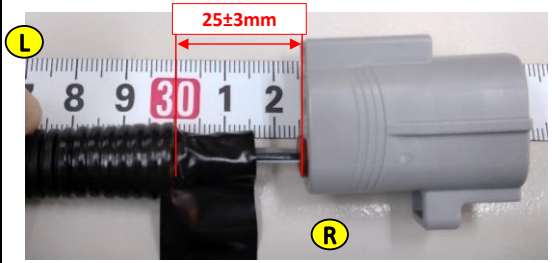
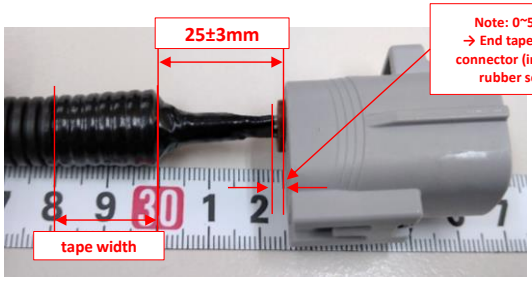
	Product Name/Code:	587B / 7M0532-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-209B
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 3	Page No.: 2 of 6

PARTS:	1. Assy parts 2. Black tape	**JIG**	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Taping 1 Black corrugated tube to wire near connector	 1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.  2. Measure from end of corrugated tube up to connector **25±3mm** then continue the taping process using both hands. ***Refer to WI-PRO-ASY-001 for taping procedure.***  3. After taping, check the measurement, and taping condition.	MEASURING TAPE 	Note: Please use calibrated/verified measuring tape when getting the measurement. 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension

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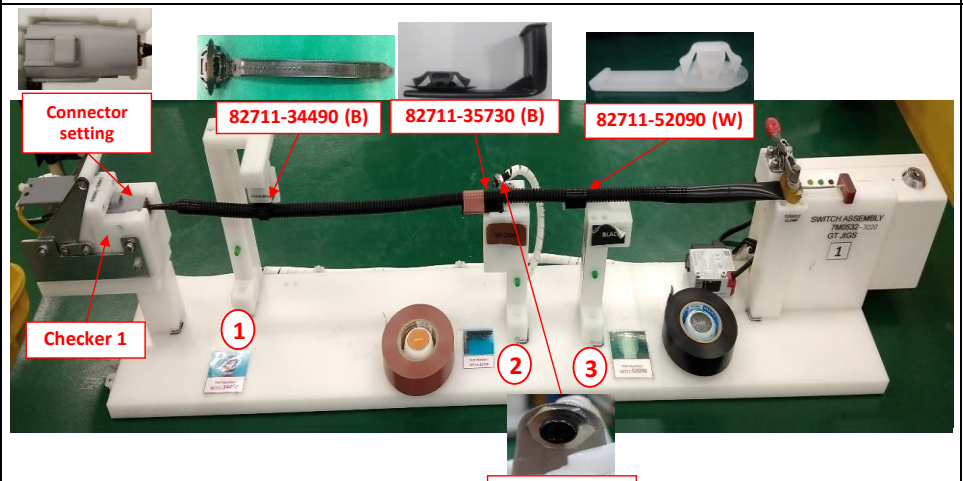
	Process Name/Title:	**TAPING ASSEMBLY PROCESS**	Validity Date:	**n/a**	
	Product Name/Code: **587B / 7M0532-7020**	Customer: **TRJ**	Document No.:	**WI-ENG-PDE-209B**	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.: 3 of 6

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 and set into jig. *(See above picture for the correct setting).* First, set the connector **6188-0066** to **Checker 1** and pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the **B/W-GR wires** together within the stopper then press by toggle clamp. Continue the process if sequence light in location **1** was **ON.** 2. Check if all **LED light** for **POWER ON 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.	n/a	 ***Note: Make sure no clearance between stopper jig and terminals.*** 1. No wrong insertion of connector 2. Make sure no gap between terminal and stopper jig

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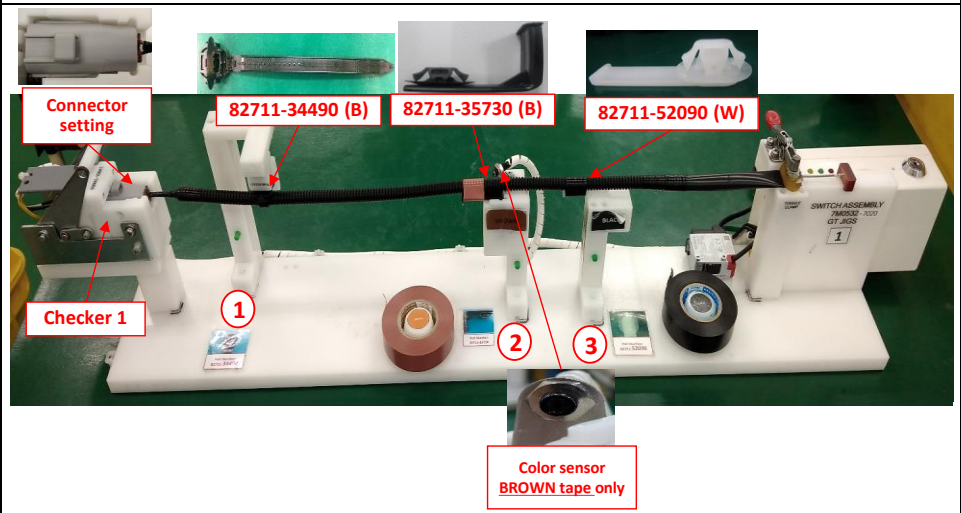
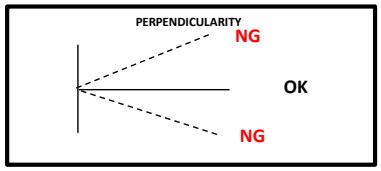
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3 Page No.: 4 of 6

PARTS:	1. Assy parts	**JIG**	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp assembly (Continuation)	 3. Initially tighten the band clamp on location **1** using both hands. Fixed setting of band clamp cutter: 3 ~ 4 BANDO GUN ALIGNMENT 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.** 	**Bando Gun** 	 ***Note: Make sure no clearance between stopper jig and terminals.*** 1. No damaged clamp 2. No wrong insertion of connector 3. Make sure no gap between terminal and stopper jig

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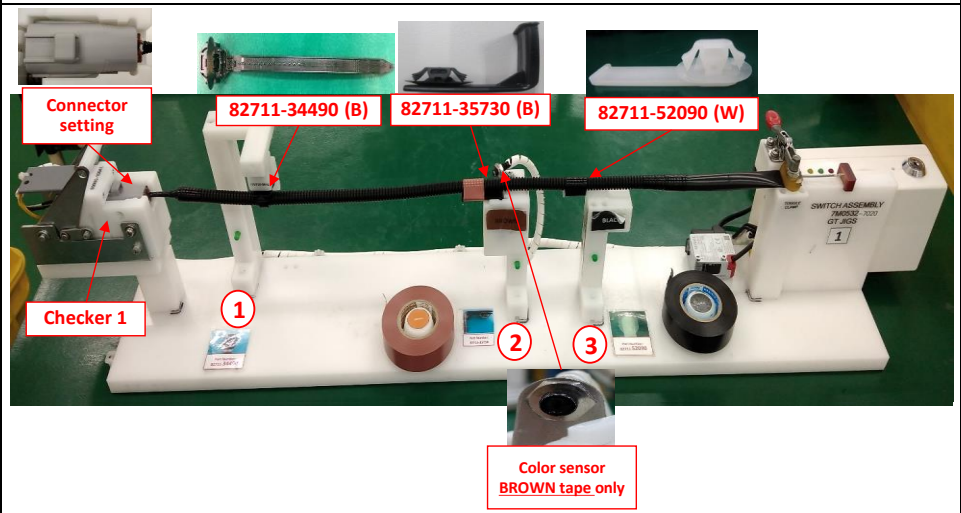
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 3	Page No.: 5 of 6

PARTS:	1. Assy parts	**JIG**	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp assembly (Continuation)	 Color sensor **BROWN tape only** 5. Hold the clamp in location **2** using left hand and begin taping using right hand. **Color sensor light** will beep/buzz if sensor detects **Brown tape** during taping. Make **3 windings** before cutting of tape. Press the **SW button** after taping. Continue the process if sequence light in location **3** was **ON.** 3 6. Hold the clamp in location **3** 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. 7. Conduct **POINT CHECKING** before removing the harness from jig.	n/a	 ***Note: Make sure no clearance between stopper jig and terminals.*** 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. Make sure no gap between terminal and stopper jig

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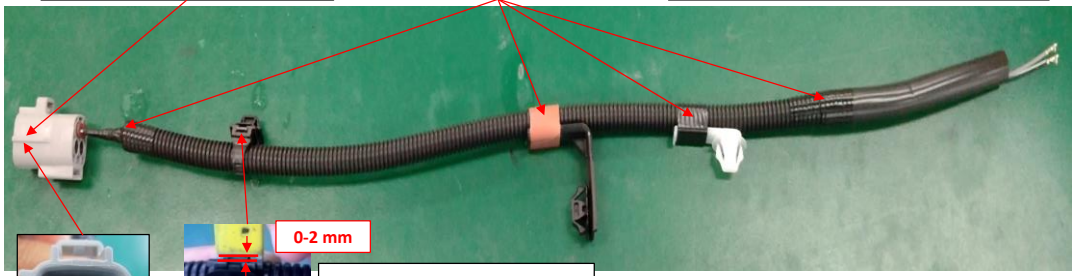
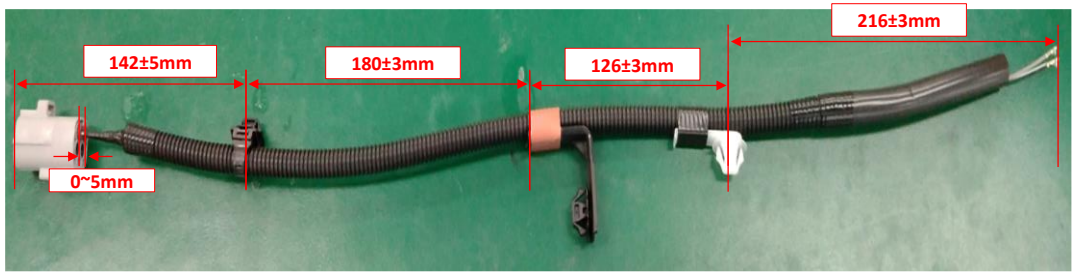
PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 △3 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.  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. △3 5. Compare to Master Sample *Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy*		1. No missing parts **MASTER SAMPLE**
5	Measurement	MEASURING TAPE Note: Please use calibrated/verified measuring tape when getting the measurement.  		***NOTE: FOR HATSUMONO AND OWARIMONO*** 1. No wrong dimension

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