

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 18, 2021

Product Name/Code:

011B / 7M0365-7020A

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

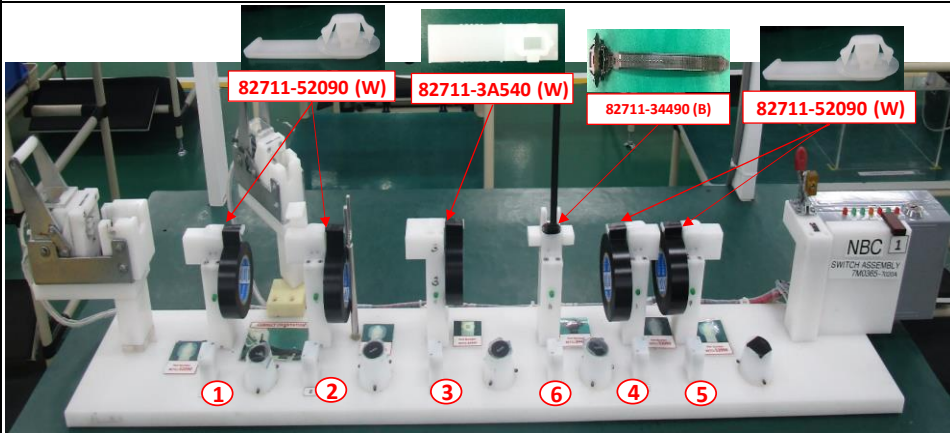

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Revision No.:

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PARTS:		WORK PROCEDURE/ ILLUSTRATION		JIG:	1. Clamp assembly jig						
NO.	PROCESS NAME			TOOLS/PPE	QUALITY POINTERS						
1	P3 Clamp setting	 <div><div>1. Get 2pcs. of clamp 82711-52090 (W) using both hands and set to location 1 and 2 using both hands.</div><div>2. Get 2pcs. of clamp 82711-52090 (W) using both hands and set to location 4 and 5 using both hands.</div><div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to location 3 using both hands.</div><div>4. Get 1pc. of clamp 82711-34490 (B) using right hand and set to location 6 using both hands.</div><div>5. Initially attach Black tape on clamp location 1, 2, 3, 4, and 5 using both hands.</div></div> <div>Note: Please check all clamp and band clamp before start of assembly to avoid wrong use of parts.</div>		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div>  <div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape</div>						
Revision History											
05/18/21	4	Removal of validity date. Apply some improvements.		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
11/11/20	3	Transfer process owner from Production (WI-PRO-ASY-019A) to Engineering (WI-ENG-PDE-193C). Apply some improvements/update pictures.		M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Previously established as Production work instruction (WI-PRO-ASY-019). Initial issue		J. Montecito L. Briones	O. Merin	T. Sugiyama	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change		Revised	Checked	Approved	Noted	Est. Date:	July 10, 2017		

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp Assembly	<p>1. Get the assy parts and set into jig. (See above picture for the correct setting). First, set the connector 6188-0066 (GR) to Checker 1 and then pull the checker fixture for continuity checking. Continue to set the Y-taping in Hook. Then, set the connector 6189-0451 (W) to Checker 2 and then pull the checker fixture for continuity checking. Last, set the B/B wires together within the stopper then press by toggle clamp. Continue the process if sequence light in location 1 was ON.</p> <p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 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.</p> <p>3. Hold the tape on clamp location 1 and start taping using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 2 was ON.</p>	n/a	<p>Must be no gap between terminal and stopper jig.</p> <p>1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape</p>

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

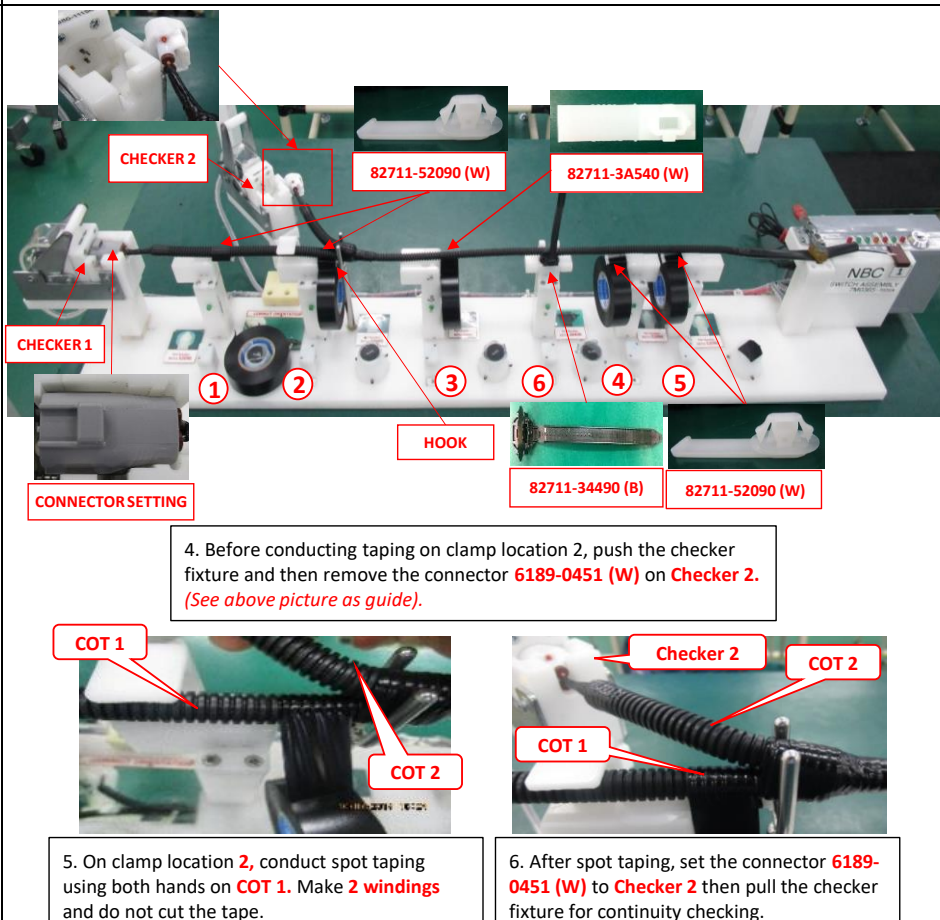
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly
(Continuation)



n/a



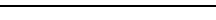
Must be no gap between
terminal and stopper jig.

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

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PARTS:		<div><div>4</div><div>1. Assy parts 2. Black tape</div></div>	JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div><div>4</div><div>P3</div><div>Clamp Assembly (Continuation)</div></div>	<div><div><div><div><div>CHECKER 2</div><div>CONNECTOR SETTING</div></div><div><div>82711-52090 (W)</div><div>82711-3A540 (W)</div><div>82711-34490 (B)</div><div>82711-52090 (W)</div></div><div><div>CHECKER 1</div><div>1</div><div>2</div><div>3</div><div>6</div><div>4</div><div>5</div></div><div><div>CONNECTOR SETTING</div><div>HOOK</div></div><div><div><div>COT 2</div><div>COT 1</div></div><div><div>COT 2</div><div>COT 1</div></div></div><div><div>7. Tape the combined COT 1 and COT 2 using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue if sequence light on location 3 was ON.</div><div><div>8. Hold the tape on clamp location 3 and start taping using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 4 was ON.</div><div>9. Hold the tape on clamp location 4 and start taping using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 5 was ON.</div></div></div></div></div></div>	n/a	<div><div><div><div><div></div><div></div></div><div>Must be no gap between terminal ang stopper jig.</div></div><div><div>1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape</div></div></div></div>

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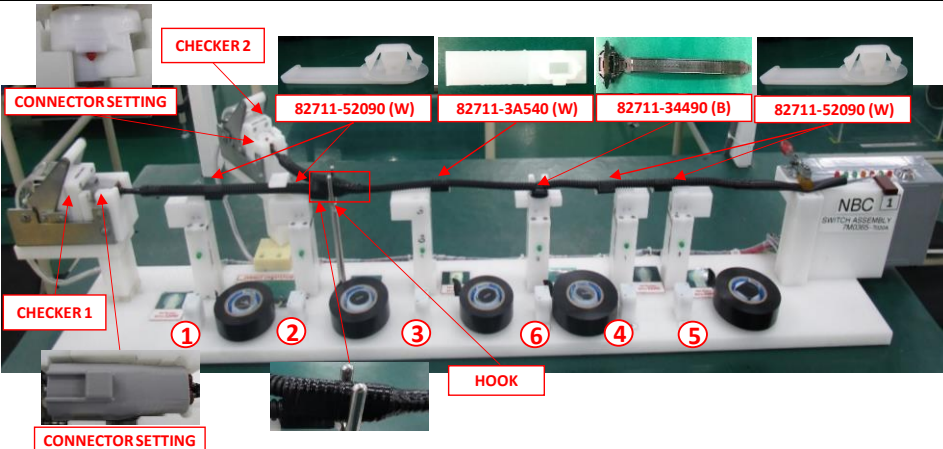
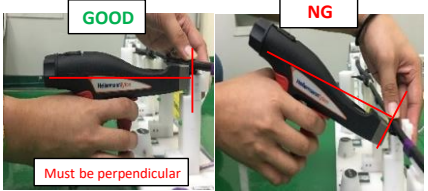
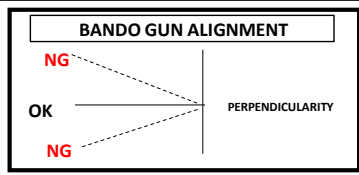

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp Assembly (Continuation)	<div></div> <div><p>10. Hold the tape on clamp location 5 and start taping using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 6 was ON.</p><div><p>Must be perpendicular</p></div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$</p></div> <div><p>11. Initially tighten the band clamp on clamp location 6 using both hands.</p><p>12. Get the bando gun using right hand then cut the band clamp on location 6. Press the SW button after cut. Go sound will be heard.</p><div><p>BANDO GUN ALIGNMENT</p><p>NG</p><p>OK</p><p>PERPENDICULARITY</p><p>NG</p></div><p>13. Conduct POINT CHECKING before removing the harness from jig.</p></div>	n/a	<div><p>Must be no gap between terminal and stopper jig.</p></div> <p>1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape</p>

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

4

Visual/By two's inspection

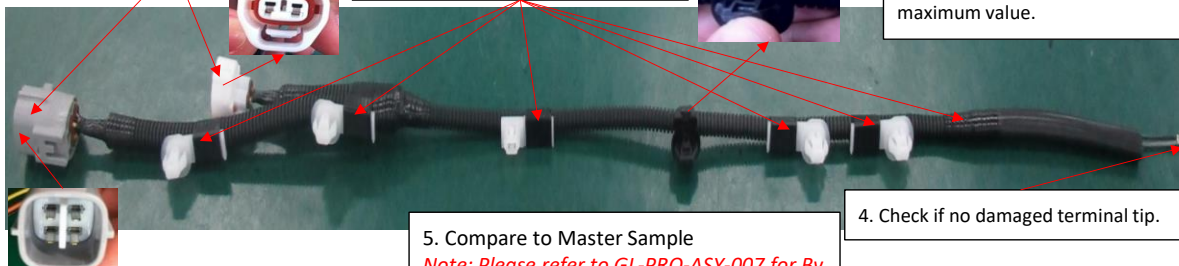
1. Check all the connector lock.



2. Check the clamp attachment, alignment of Y-Taping & tape condition.



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.



5. Compare to Master Sample

Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

4. Check if no damaged terminal tip.

MASTER SAMPLE



4

P3

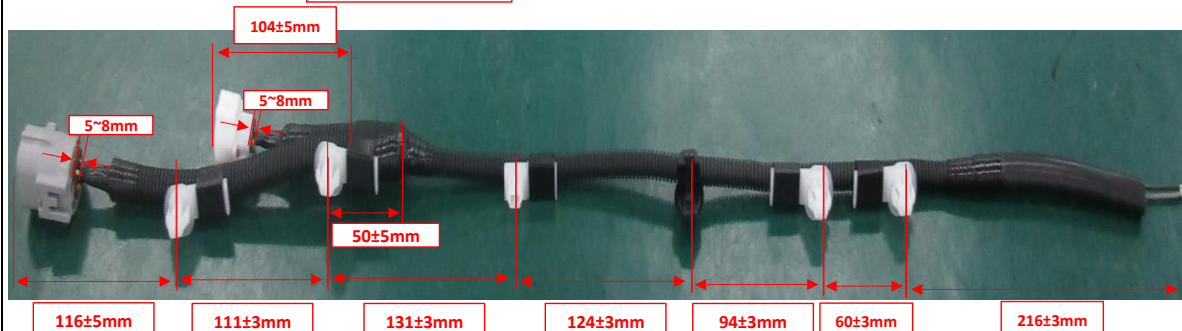
Measurement



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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