



WORK INSTRUCTION

Effectivity Date:

May 26, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code: 096D / 7L0118-7020

Customer: TRQSS

Document No.:

WI-ENG-PDE-241C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS:

1. Clamp 82711-52090 (W) [1pc.]
2. Clamp 82711-33380 (B)

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

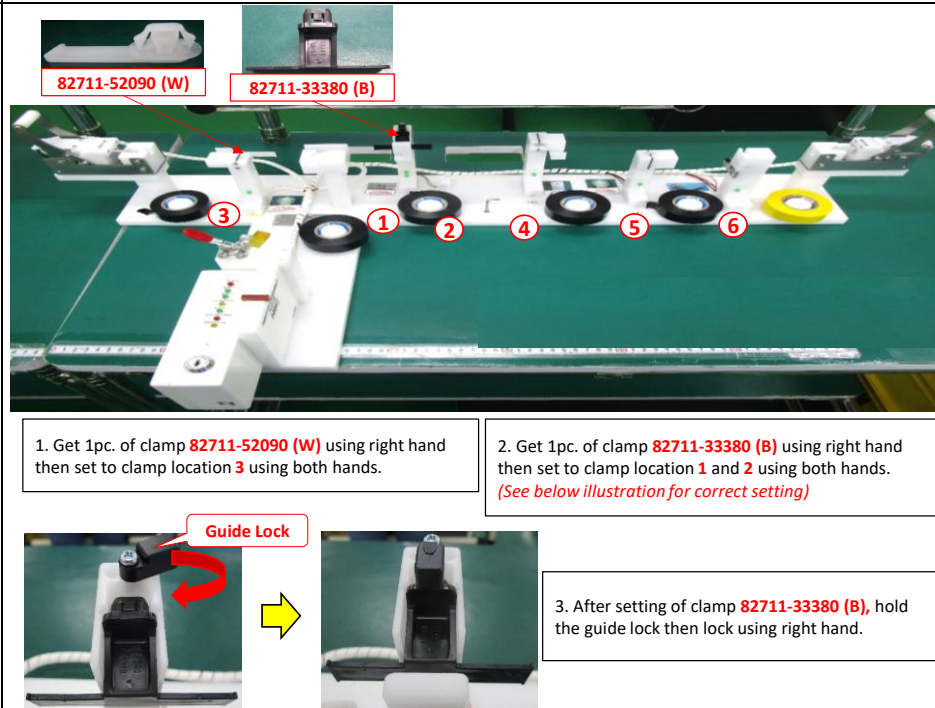
TOOLS/PPE

QUALITY POINTERS

1

P3

Clamp Setting

**Safety Instruction**

Be sure to wear required 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 parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/26/21	1	Change type of purpose from Pre-launch to masspro. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
02/25/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:

1. Clamp 82711-3A540 (W)
2. Clamp 82711-52090 (W) [1pc.]
3. Clamp 82711-48070 (GR)

4. Black tape [5pcs.]
5. Yellow tape [1pc.]

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

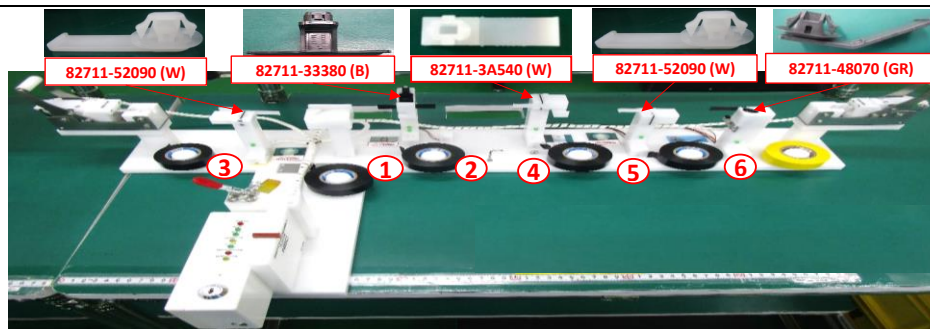
TOOLS/PPE

QUALITY POINTERS

1

P3

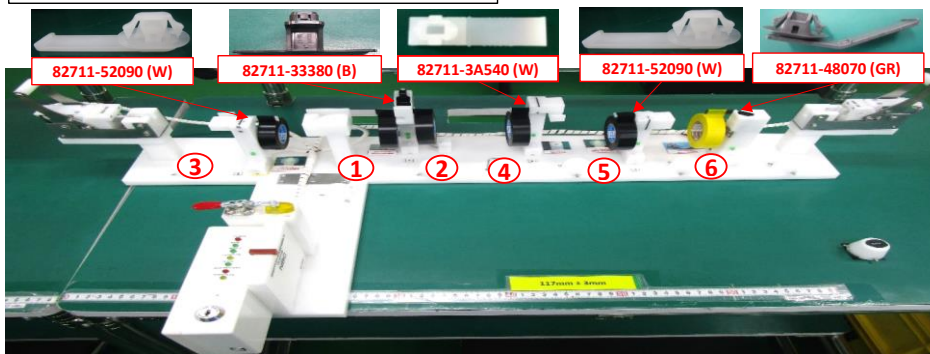
Clamp Setting
(Continuation)



4. Get 1pc. of clamp **82711-3A540 (W)** using right hand then set to clamp location **4** using both hands.

5. Get 1pc. of clamp **82711-52090 (W)** using right hand then set to clamp location **5** using both hands.

6. Get 1pc. of clamp **82711-48070 (GR)** using right hand then set to clamp location **6** using both hands.



7. Initially attach **Black tape** on clamp location **1, 2, 3, 4, and 5** using both hands.

8. Initially attach **Yellow tape** on clamp location **6** using both hands.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.

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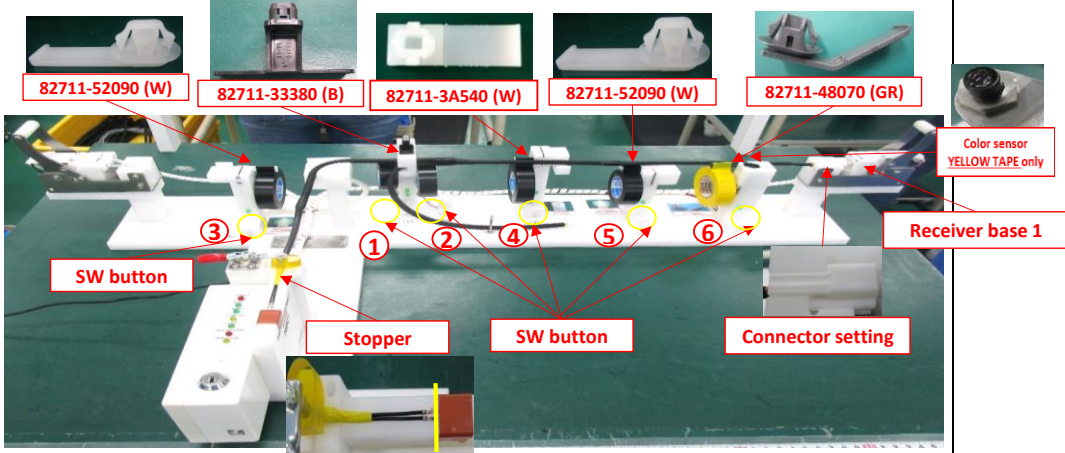
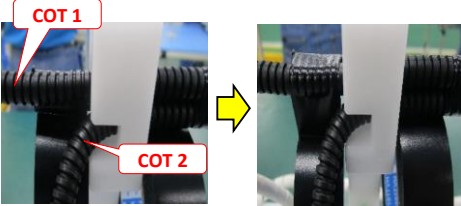
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PARTS:	1. Assy parts			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp Assembly		n/a	<div><p>Note: Make sure no gap between stopper jig and terminals.</p></div> <div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div>
		<div><p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6098-3802 (W) to Receiver base 1 then pull the checker fixture for continuity checking. Second, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then press by Toggle clamp. Initially put the other side of harness (COT with connector 6098-2220 (W)) in Hook. Check if the sequence light of location 1 was ON.</p><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was On. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><div><p>3. Hold the tape on clamp location 1, make 2 spot windings on COT 1 and do not cut the tape. <i>(See illustration.)</i></p></div></div>			

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

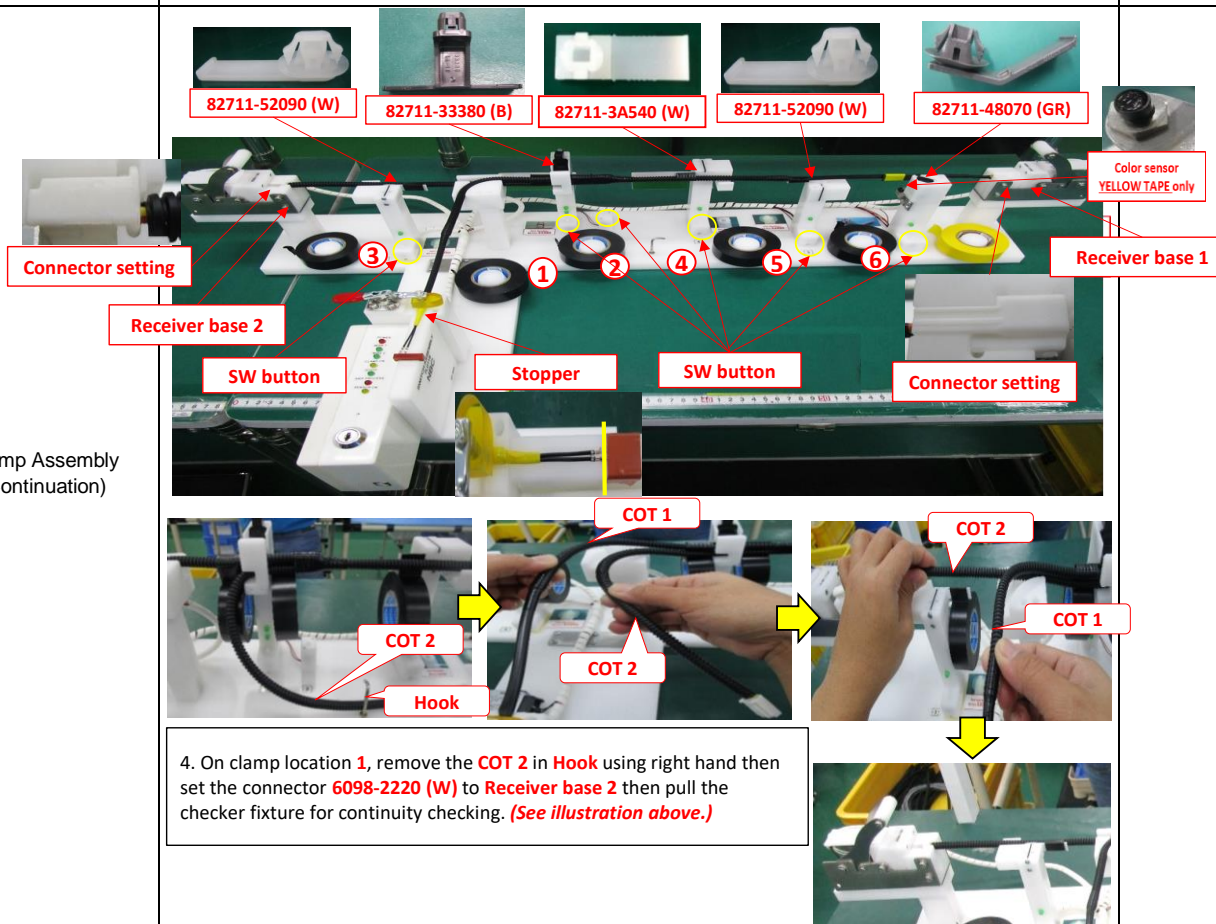
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly
(Continuation)



n/a

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

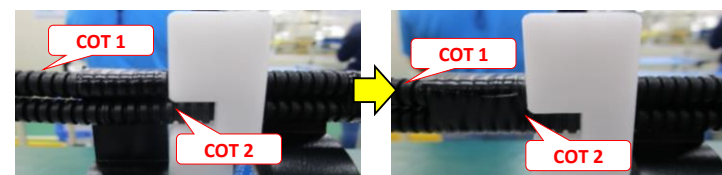
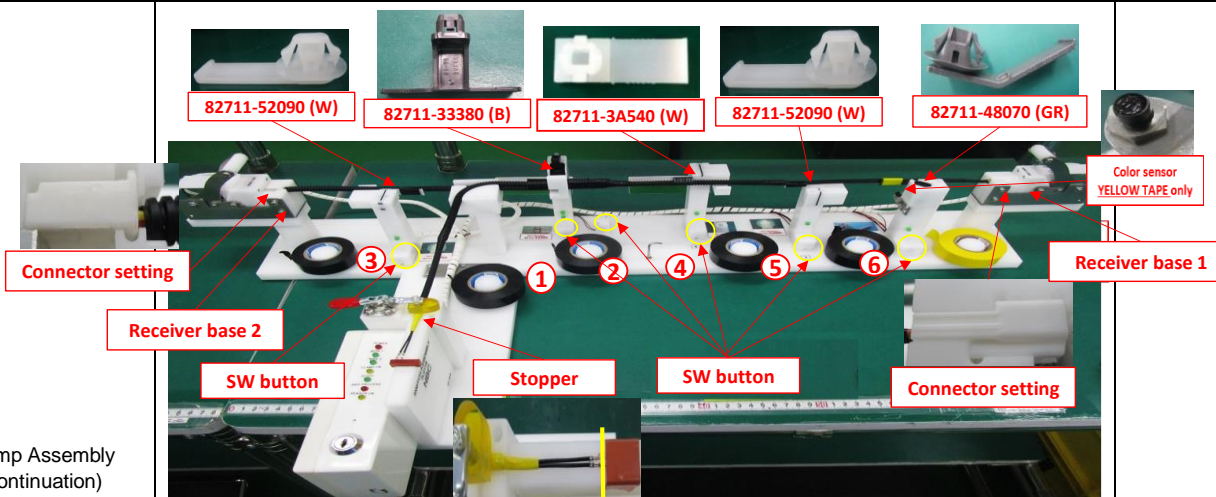
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly
(Continuation)



5. Hold the tape on clamp location **1**, make **3 windings** of tape on combined **COT 1 and COT 2** then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **2** was **ON**.

1

6. Hold the tape on clamp location **2**, make **3 windings** then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **3** was **ON**.

n/a

- Note: Make sure no gap between stopper jig and terminals.
1. No wrong use of parts
 2. No wrong use of tape
 3. No damaged clamp
 4. No wrong clamp position

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PARTS:

1. Assy parts

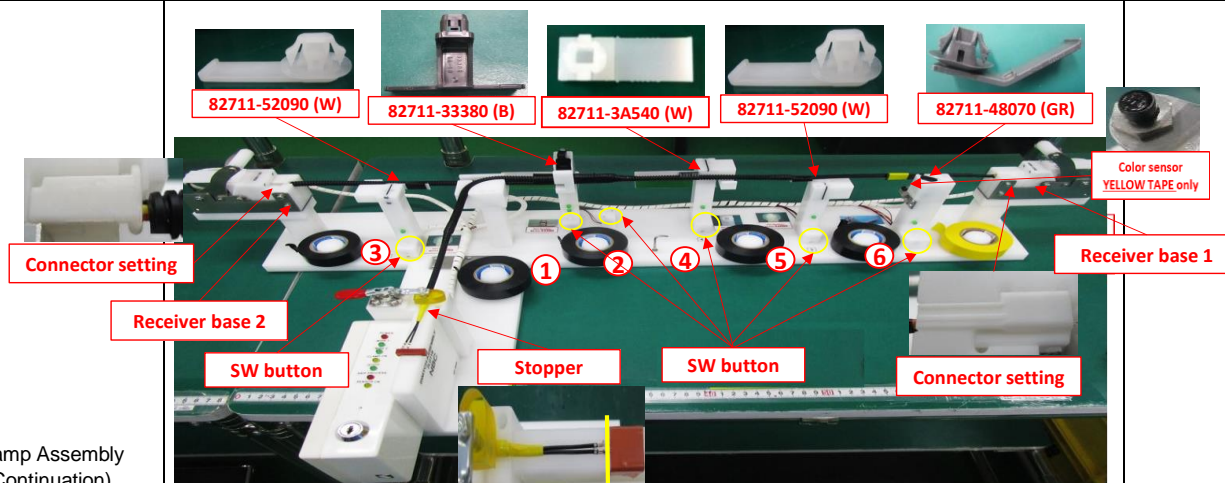
JIG

1. Clamp assembly jig

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

2

P3

Clamp Assembly
(Continuation)

n/a



Note: Make sure no gap between stopper jig and terminals.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

7. Hold the tape on clamp location **3**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **4** was **ON**.

8. Hold the tape on clamp location **4**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **5** was **ON**.

9. Hold the tape on clamp location **5**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **6** was **ON**.

10. Hold the tape on clamp location **6**. Make **3 windings** of tape then cut the tape using both hands. (Note: Color sensor light will beep or buzz if sensor detects Yellow tape during taping). Press the **SW button** after taping. Go sound will be heard.

11. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

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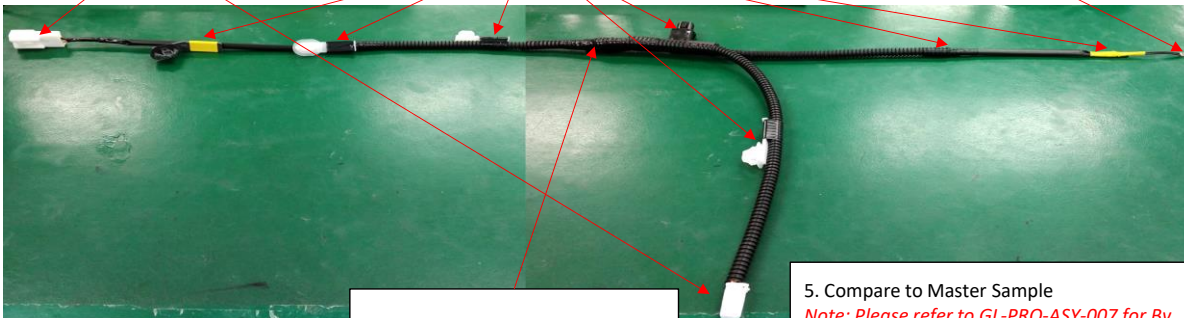
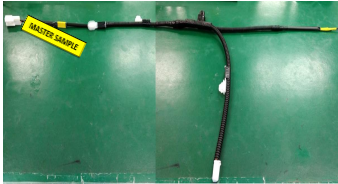
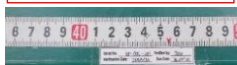
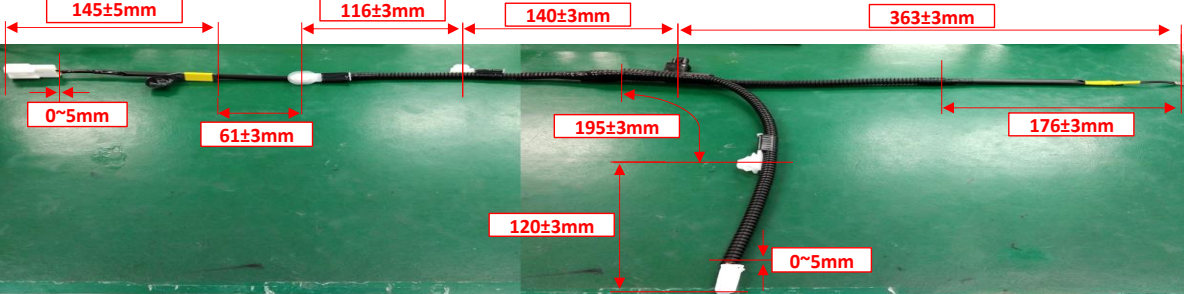
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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Visual/By Two's Inspection	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment and taping condition.</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div>  <div>4. Check the Y-taping condition.</div> <div>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div>		<div>MASTER SAMPLE</div> 
4		Measurement	<div>MEASURING TAPE</div>  <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> 		<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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