



# WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **164B / 7M0531-7020A** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO


Effectivity Date: April 23, 2021

Validity Date: n/a

Document No.: WI-ENG-PDE-026B

Revision No.: 6 Page No.: 1 of 5

<b>PARTS:</b>	1. Clamp 82711-52090 (W) 2. Clamp 82711-60640 (B)	3. Black tape [2pcs]	<b>JIG:</b>	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp Assembly setting	<p>1. Get the clamp <b>82711-52090 (W)</b>, <b>82711-60640 (B)</b> using right hand and set to location 1 and 2 using both hands.</p> <p>2. Get black tape then conduct pre-taping on <b>location 1 and 2</b>.</p> 	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No damaged clamp 2. No wrong use of clamp</p>

## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/23/21	6	Add quantity of tape for clamp setting	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
12/19/20	5	Added rolling instruction on attachment of sponge tape process; Add assy parts on parts section in page 4; Change clamp color in accordance with standardization for plastic parts	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
02/01/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-011). Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	S. Shimamura	A. Arañes
							Est. Date:	October 19, 2018		

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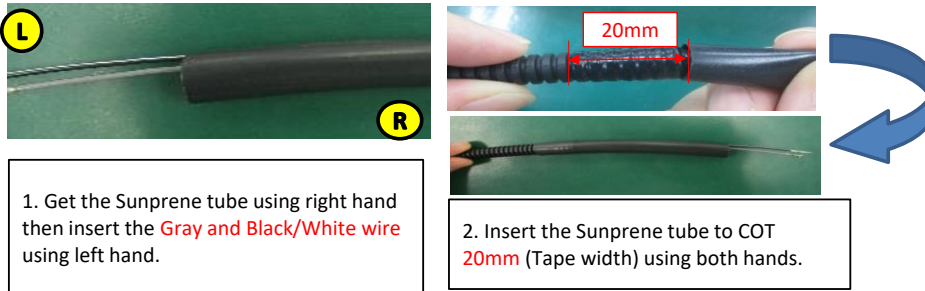
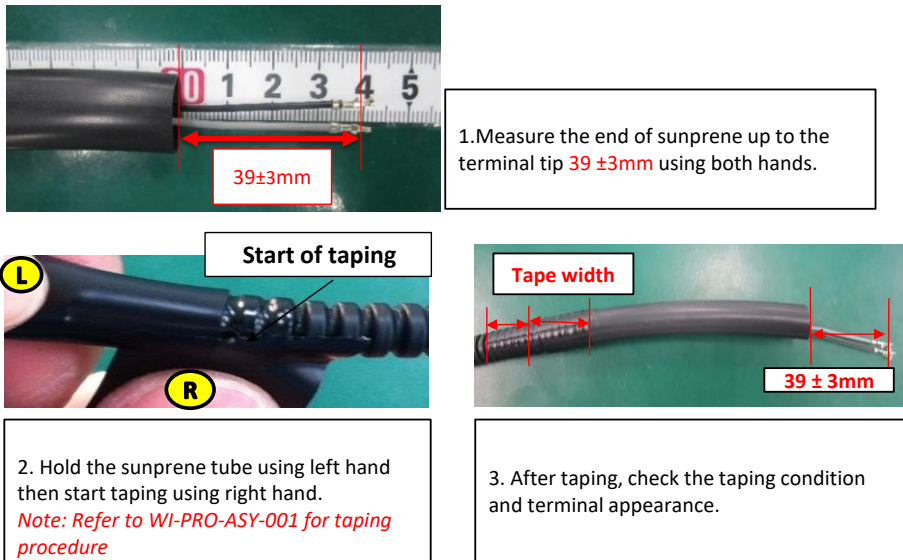

## PARTS:

1. Black tape
2. Assy parts

3. Black Sunprene tube  $\varnothing 9$  L=97 $\pm$ 3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Sunprene tube $\varnothing 9$ L=97 $\pm$ 3mm	 <p>1. Get the Sunprene tube using right hand then insert the <b>Gray and Black/White wire</b> using left hand.</p> <p>2. Insert the Sunprene tube to COT <b>20mm</b> (Tape width) using both hands.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
3	Taping COT to Sunprene tube	 <p>1. Measure the end of sunprene up to the terminal tip <b>39 <math>\pm</math> 3mm</b> using both hands.</p> <p>2. Hold the sunprene tube using left hand then start taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure</i></p> <p>3. After taping, check the taping condition and terminal appearance.</p>	<b>MEASURING TAPE</b> 	<p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No flip-out tape</li><li>3. No peel-off tape</li><li>4. No wrong dimension</li></ol>

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## PARTS:

1. Assy parts

## JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

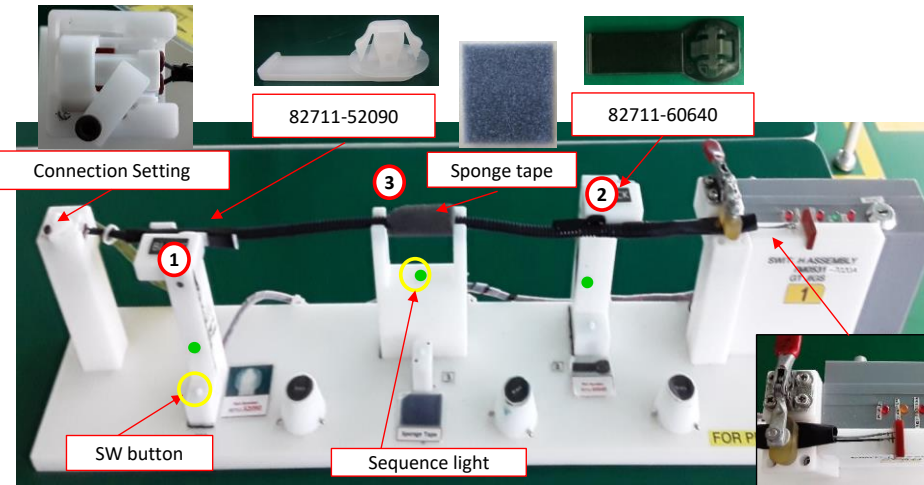
Clamp assembly

1. Put assy into jig. *(see below picture for correct setting)* Check the Sequence light button on location 1 if ON, then proceed taping process. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

2. Hold the clamp in **location 1** using left hand and begin taping using right hand. Make 3 winds. Press the SW button after taping.

3. Hold the clamp in **location 2** using left hand and begin taping using right hand. Make 3 winds. Press the SW button after taping.

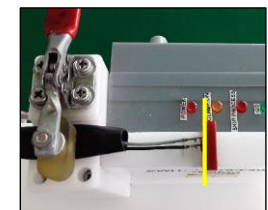
4. Attach sponge tape. (Refer to next page for detailed process) Press the SW button after attachment. Go sound will be heard.



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

N/A

1. No damaged clamp
2. No missed tape
3. No missing clamp
4. Taping should be one side under (taping side of clamp before taping with COT)



Make sure **no gap** between terminal and stopper jig

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### PARTS:

1. Black sponge tape (7M0531-0021) t=5; width=50; L=50±1mm
2. Assy parts

### JIG

1. Clamp Assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE


### QUALITY POINTERS

5

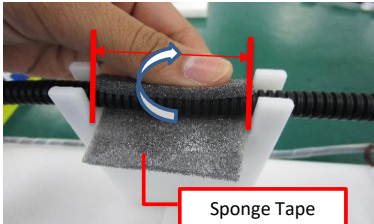
P2

Black sponge tape  
(7M0531-0021) t=5;  
width=50; L=50±1mm  
Attachment

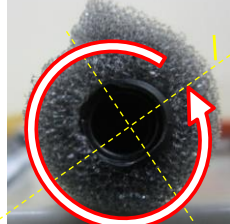
**Guide**



**Size of sponge tape should fit the jig**



**Standard attachment**




**Corrugated tube (φ5 L=392±3)**


**Sponge Tape**

1 Get sponge tape then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape.  
**Note: Do not stretch or pull the sponge tape during attachment.**


**1**




**2**




**3**



**4**



**5**




3 Press the SW button after attachment and slowly remove the assy parts from jig.

2 After attachment of sponge tape, make 5 times slowly pushing from left to right using left thumb.

4. Press the sponge tape using both palm and roll 3 times to make sure that the sponge tape attachment is GOOD.

**L**

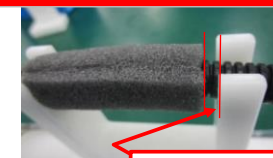


**R**

N/A

1. No peel-off attachment
2. No loose/tight attachment
3. No wrong attachment
4. No missing sponge
5. No wrong use of sponge
6. No damage sponge

### NO GOOD ATTACHMENT OF SPONGE TAPE

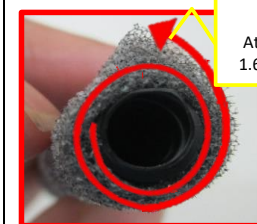


With gap on guide of jig.

### Peel-off Sponge



**Tight Attachment**  
1.6-1.7 Wrap



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**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 presence of all clamp and tape condition. Check also the clamp attachment &amp; sponge tape.

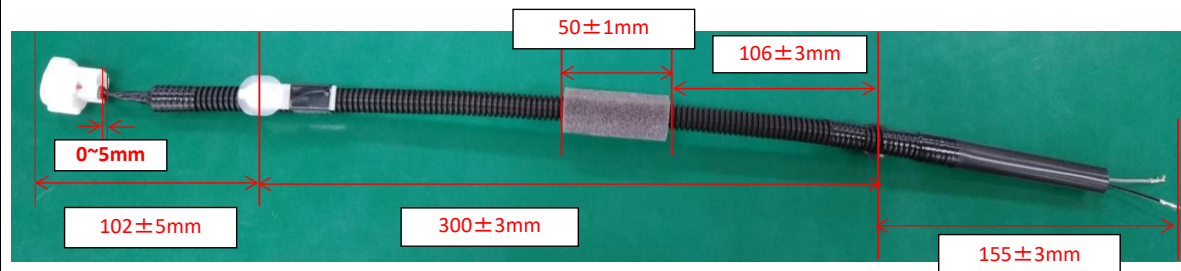
3. Check the terminal appearance.

4. Compare to Master Sample  
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy***MASTER SAMPLE**

P2

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Measurement

*Note: Please use calibrated/verified measuring tape when getting the measurement.***NOTE: FOR HATSUMONO AND OWARIMONO****CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.**NBC (Philippines)**  
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