

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **ES1 / 7M0519-7020A** Customer: **TRJ**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

April 30, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-040B

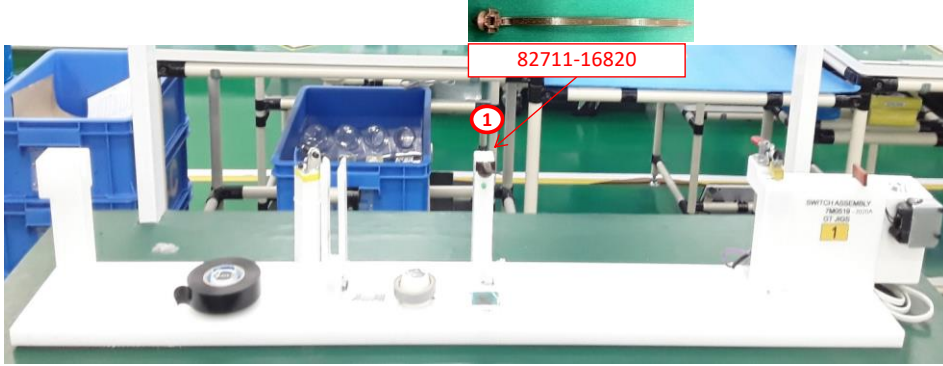
Revision No.:

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**PARTS:** 1. Band Clamp 82711-16820 (BR)**JIG:** 1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp assembly setting	 <p>1. Get the <b>clamp 82711-16820 (BR)</b> using right hand and set to jig location <b>1</b> using both hands.</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>	1. No wrong use of clamp 2. Damaged clamp

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/30/21	5	Remove validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/16/20	4	Apply some improvements, Update pictures; removal of cycle time; removal of counter set-up	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
03/01/18	n/a	Previously established Engineering Instruction(EI-ENG-PDE-018). Initial issue.	J. Loterte	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
							Established Date: November 09, 2018			

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### PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

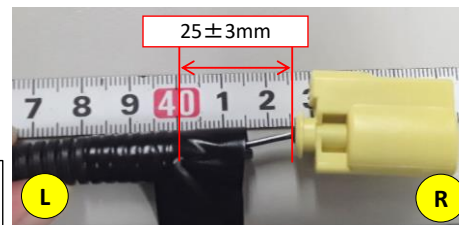
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P2

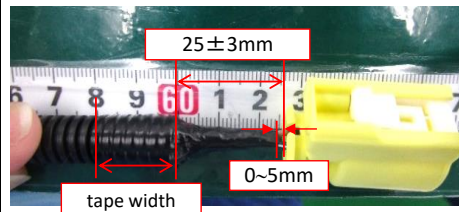
Taping  
COT to wire near  
connector



1. Hold the corrugated tube using left hand and conduct pre-taping using right hand.



2. Measure the corrugated tube up to the connector **25mm** using right hand then continue the taping process.  
*Note: Please refer to WI-PRO-ASY-001 for taping procedure*



3. After taping, check the dimension and taping condition.

### MEASURING TAPE



1. No loose tape
2. No flip-out tape
3. No peel-off tape

*Note:  
Please use calibrated/verified  
measuring tape when getting the  
measurement.*

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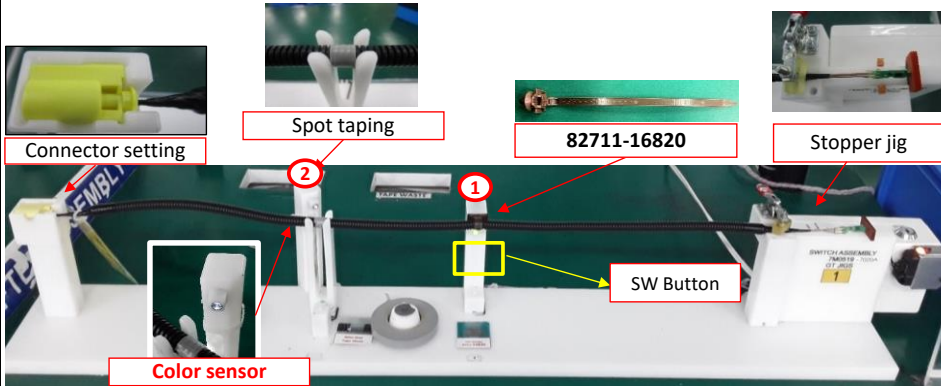
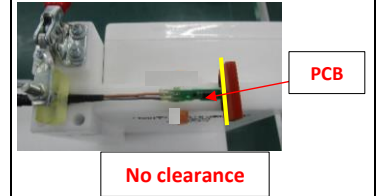

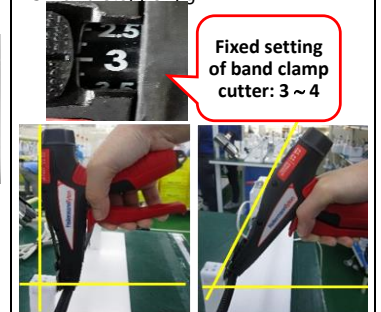
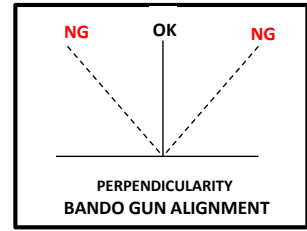
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### PARTS:

1. Gray tape (10mm)
2. Assy parts

### JIG

1. Clamp Assembly Jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp Assembly	BANDO GUN	
		<p>1. Get the assy parts using right hand and set to jig using both hands. First, put the Yellow connector to receiver base and second, put the PCB to stopper jig. Push down the toggle clamp using right hand. <i>Note: See below illustration for proper setting.</i></p>  <p>2. Initially tighten the band clamp 82711-16820 (BR) using both hands.</p> <p>3. Get the bando gun and cut the band clamp 82711-16820 (BR) on location 1 using right hand. Press the SW button after cutting.</p> <p>4. Get the Gray tape and start taping on location 2 using right hand, make 3 winds and press the SW button. Beep sound will be heard if the color sensor detects Gray tape. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the Leader and <b>WAIT</b> for instruction.</p> <p>5. Conduct <b>POINT CHECKING</b> before removal from jig.</p>		 <p>1. No missed tape 2. No missing parts 3. Make sure no clearance between PCB and stopper jig</p>   <p>Fixed setting of band clamp cutter: 3 ~ 4</p> 

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PARTS:

N/A

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Visual/By Two's Inspection

P2

1. Check the taping condition.

3. Check the presence of Gray tape.

2. Check the clamp attachment. Confirm the band cut measurement using steel rule. If the band cut is longer than the requirement (**0~2mm only**).

4. Check the connector lock and rubber seal condition.

*Note: Refer to Taping jig counter set up WI-ENG-PDE-182*

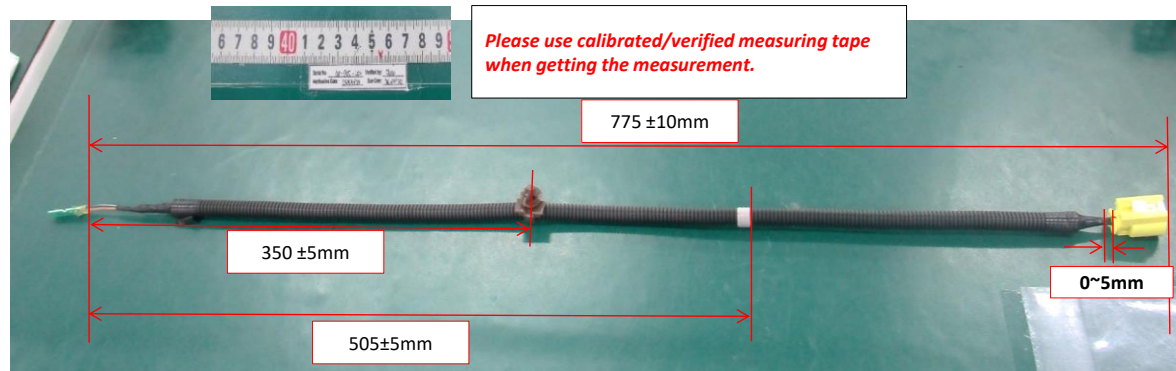
5. Compare to Master Sample  
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy*

MASTER SAMPLE



5

Measurement



*Please use calibrated/verified measuring tape when getting the measurement.*

**NOTE: FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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