

	<b>WORK INSTRUCTION</b>				Effectivity Date:		October 07, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: <b>370B / 7L0046-7022A</b>		Customer: <b>TRQSS</b>		Document No.: <b>WI-ENG-PDE-135B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5		Page No.: 1 of 5	

<b>PARTS:</b>	1. Clamp 82711-52090 (W)      2. Black tape [1pc.] <span style="border: 1px solid black; padding: 2px;">5</span>	JIG:	1. Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp setting	<div style="text-align: center;"> <p style="color: red; font-weight: bold;">82711-52090 (W)</p> <p style="color: red; font-weight: bold;">1</p> <p style="color: red; font-weight: bold;">Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">           1. Get <b>1pc.</b> of lamp <b>82711-52090 (W)</b> using right hand and set to clamp location <b>1</b> using both hands.         </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">           2. Get <b>Black tape</b> and conduct pre-taping using both hands.         </div> <div style="text-align: center; margin-top: 10px;"> </div> <div style="text-align: center; margin-top: 10px;"> </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; font-weight: bold;">Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; font-weight: bold;">Housekeeping</p> <p>1. Maintain and always practice 5's.</p> <p>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; font-weight: bold;">Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div> <div style="border: 1px solid red; padding: 5px;"> <p style="color: red; font-weight: bold;">Terminal cover jig</p> </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; font-weight: bold;">STANDARD TAPING FOR CLAMP</p> <p>One side tape under clamp</p> <div style="text-align: center;"> <span style="border: 1px solid black; padding: 2px;">5</span> </div> </div> <div> <p>1. No wrong use of clamp</p> <p>2. No missing clamp</p> <p>3. No wrong use of tape</p> <p>4. No missing tape</p> </div>

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
10/07/21	5	Improve process illustration and description on process no.2 and 4. Aligned clamp assembly process based on sequence light. Apply some improvements.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
07/01/21	4	Remove validity date.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes									
12/01/17	0	Previously established as Engineering instruction (EI-ENG-PDE-007). Initial issue	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 05, 2018							

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## PARTS:

1. White tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION


TOOLS/PPE

QUALITY POINTERS

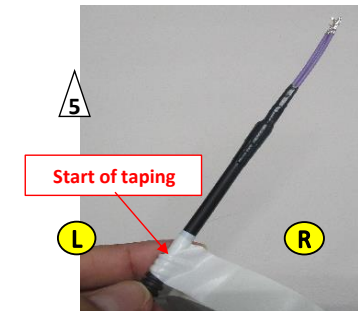
2

P2


Taping 1  
Corrugated tube to Vinyl  
tube



1. Hold the COT using left hand and measure from end of COT up to terminal tip **120±3mm** using both hands.



2. Hold the corrugated tube using left hand, get **White tape** using right hand then begin taping process using both hands.  
**Note: Refer to WI-PRO-ASY-001 for taping procedure.**

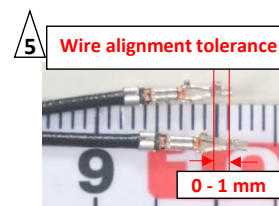


3. After taping, check the measurement, taping condition and terminal appearance.

## MEASURING TAPE



5 **NOTE: USE WHITE  
TAPE ONLY**



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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

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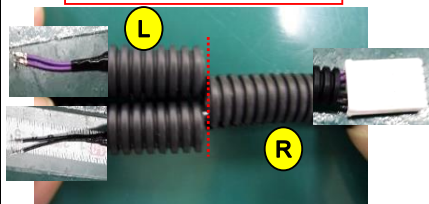
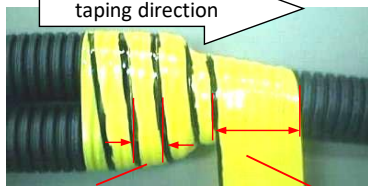
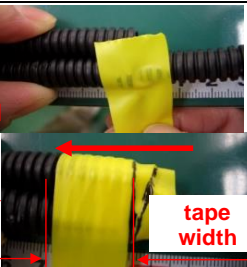
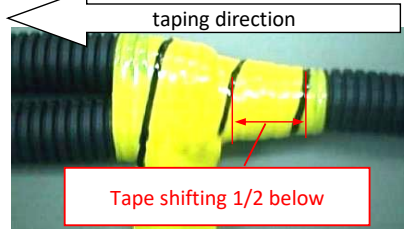
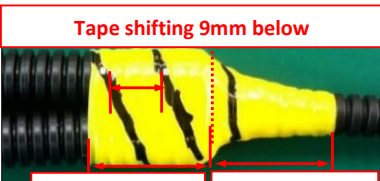


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PARTS:		1. Black tape 2. Assy parts			JIG	N/A
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Y-taping	<div><div>No wide interval</div><div></div><div>1. Fix the corrugated tube .</div><div></div><div>Tape shifting 1/3 below</div><div>Tape width</div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</div><div>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div></div> <div><div></div><div>Note: Do not exert excessive force during pulling &amp; winding of tape.</div><div>tape width</div><div>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side ,width must be same with tape (19mm).</div><div></div><div>taping direction</div><div>Tape shifting 1/2 below</div><div>4. Wind the tape backward 1/2 shifting.</div><div></div><div>Tape shifting 9mm below</div><div>Tape width</div><div>Tape width</div></div>		<div>MEASURING TAPE</div> <div></div>	<div>NOTE: USED <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <b>BLACK TAPE</b>.</div> <div>1.No flip out tape 2.No peel-off tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimesion</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div></div> <div>Connector Orientation</div>

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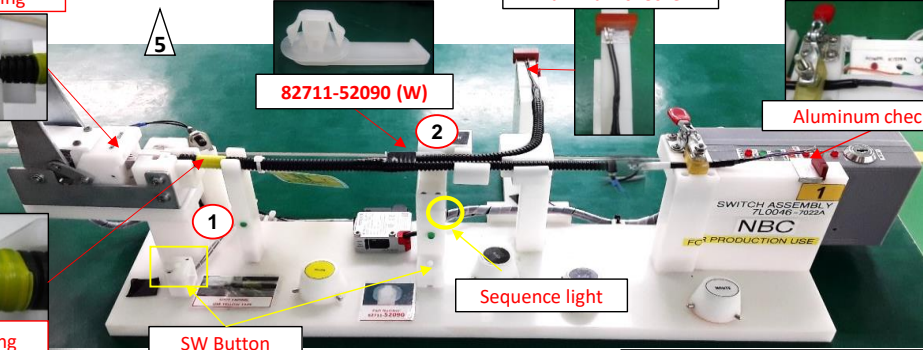
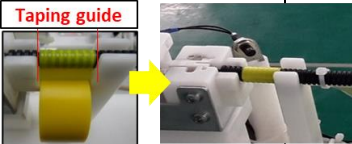


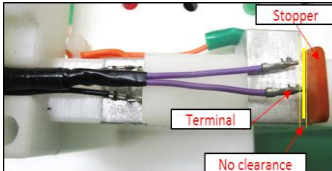
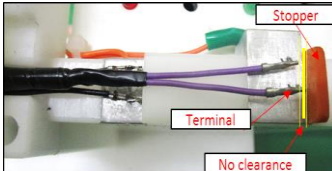
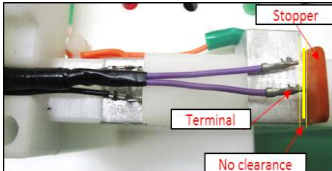
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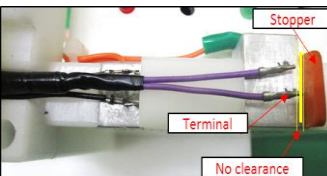
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PARTS:		1. Black tape 2. Yellow tape		3. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp Assembly	<div><div><div>Connector setting</div><div></div></div><div><div>Spot taping</div><div></div></div><div><div>5</div><div></div></div></div> <div><div><p>1. Get the assy parts and set into jig. (See above illustration for correct setting). First, set the connector 6098-3810 (W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the B/B wires with terminal end together within the stopper then press by Toggle clamp. Last, set the V/V wires with terminal end together within the stopper then press by toggle clamp. Color sensor light will beep/buzz if sensor detects White tape. Continue if the sequence light in location 1 was ON. Note: Terminal should touch the aluminum to check the continuity. Refer to above illustration for the proper setting.</p></div><div><p>2. Check if all LED light for POWER ON, WIRE1 and WIRE2 and CLAMP ON was ON. Check also if clamp location ① sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p></div><div><p>3. Get Yellow tape using right hand and begin the spot taping on location 1 using both hands. Make 2~3 windings and then cut the tape. Make sure that the Yellow tape detected by the color sensor. Press the SW button after taping. Continue if sequence light on clamp location 2 was ON.</p></div><div><p>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut ten tape. Press the SW button after taping. Go sound will be heard.</p></div><div><p>5. After taping, conduct POINT CHECKING before removing teh harness from jig</p></div></div> <div><div><div>Taping guide</div><div></div></div><div><div>Aluminum checker</div><div></div></div><div><div>Aluminum checker</div><div></div></div><div><div>Stopper</div><div></div></div><div><div>Terminal</div><div></div></div><div><div>No clearance</div><div></div></div></div> <div>n/a</div> <div><div>1. No loose attachment of clamp</div><div>2. No damage clamp</div><div>3. No missed tape</div><div>4. No missing parts</div><div>5. No wrong use of tape</div></div>					

n/a



Stopper

Terminal

No clearance

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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PROTOTYPE



PRE-LAUNCH



MASSPRO

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**PARTS:**

N/A

**JIG**

N/A

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

5

P2

Visual Inspection/By Two's inspection

1. Check the connector lock.

2. Check the taping condition.

3. Check the terminal appearance, make sure no deformed terminal.



4. Compare to MASTER SAMPLE.

*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.***MASTER SAMPLE**

6

Measurement

10 ± 5mm

COT to End of tape

0~5mm

15 + 10  
-5

195 ± 3mm

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

255 ± 3mm

215 ± 3mm

**NOTE: HATSUMONO AND  
OWARIMONO**

1. No wrong dimension

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