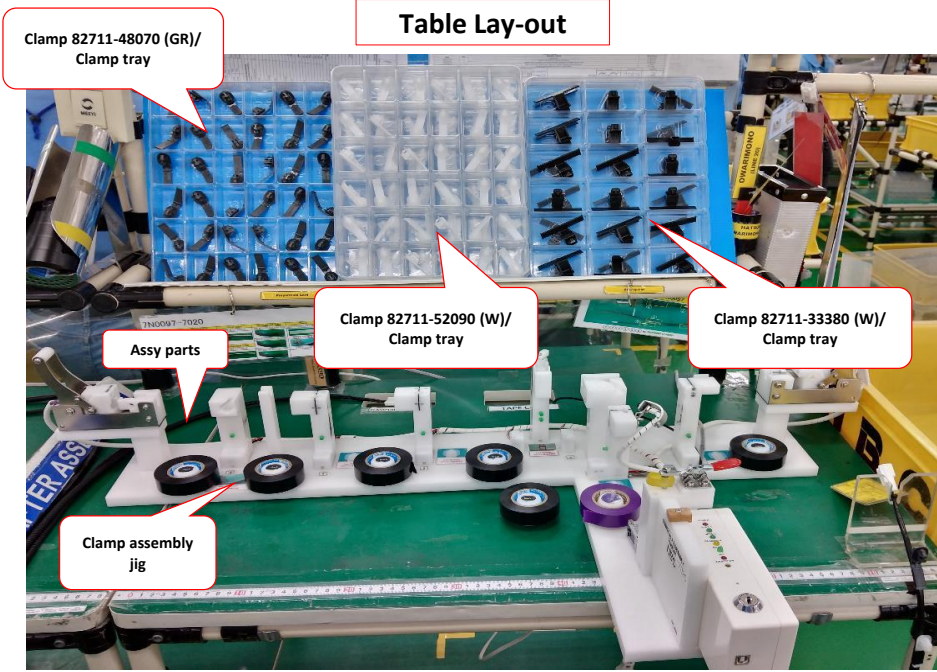
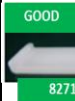

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	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model Code/Part Number: 101D / 7N0097-7020A		Customer: TRJ		Document No.:		WI-ENG-PDE-691	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0 Page No.: 1 of 10	

PARTS:		1. Assy parts; Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Clamp 82711-33380 (B); Black tape; Violet tape				JIG:		1. Clamp assembly jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		n/a		<div style="text-align: center;"> Table Lay-out </div> 				<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<div> <p>1. No missing parts/tools</p> <p>2. No excess parts/tools</p> </div> <div style="text-align: center;"> CLAMP ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>GOOD</p> <p>82711-52090 (W)</p> </div> <div style="text-align: center;">  <p>NG</p> <p>82711-12A80 (W)</p> </div> </div>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
07/26/23		0		Initial Issue. Excluded process from WI-ENG-PDE-239B ; Change Process Name/Title from "TAPING ASSEMBLY PROCESS" to " CLAMP ASSEMBLY PROCESS "; Change Document control no. from WI-ENG-PDE-239B to WI-ENG-PDE-691 due to new process distribution.				M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	

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WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model Code/Part Number: **101D**

/ **7N0097-7020A**

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Clamp 82711-48070 (GR)
2. Clamp 82711-52090 (W) [4pcs.]
3. Clamp 82711-33380 (B)

4. Black tape [6pcs.]
5. Violet tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

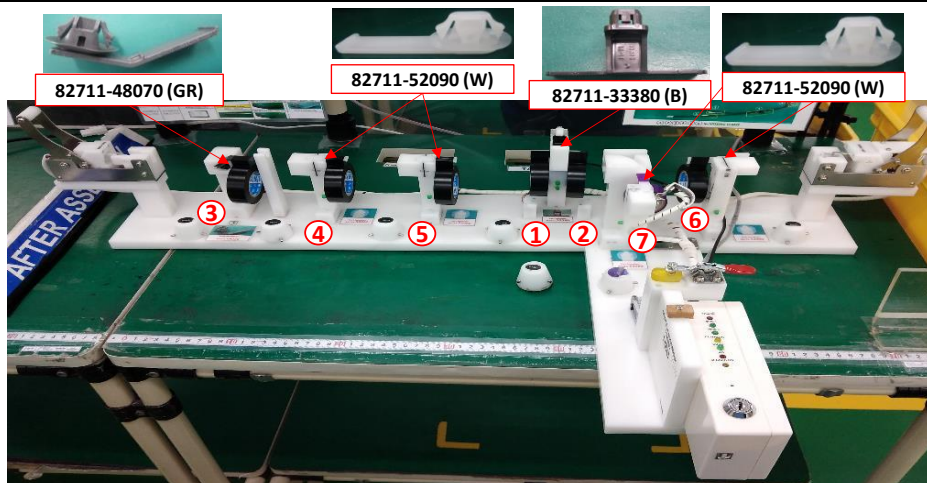
TOOLS/PPE

QUALITY POINTERS

2

n/a

Clamp setting



1. Get 1pc. of clamp **82711-48070 (GR)** using right hand then set to clamp location **3** using both hands.

2. Get 4pcs. of clamp **82711-52090 (W)** using both hands then set to clamp location **4, 5, 6 and 7** using both hands.

4. Initially attach **Black tape** on clamp location **1, 2, 3, 4, 5** and **6** using both hands.

3. Get 1pc. of clamp **82711-33380 (B)** using right hand then set to clamp location **1 and 2** using both hands then lock.

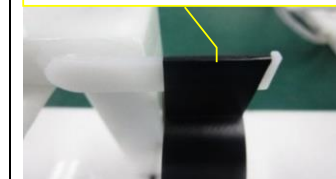


5. Initially attach **Violet tape** on clamp location **7** using both hands.

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

Important reminders/Note/s:

1. Please check the clamp first before start of assembly to avoid wrong use of clamp.

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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

3

n/a

Clamp Assembly



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

Important reminders/Note/s:

1. Make sure no gap between the terminal and stopper jig.



1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-3802 (W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the connector 6098-2220 (W) to Checker 2 then pull the checker fixture for continuity checking. Last, 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. Continue if the sequence light of location 1 was ON.

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

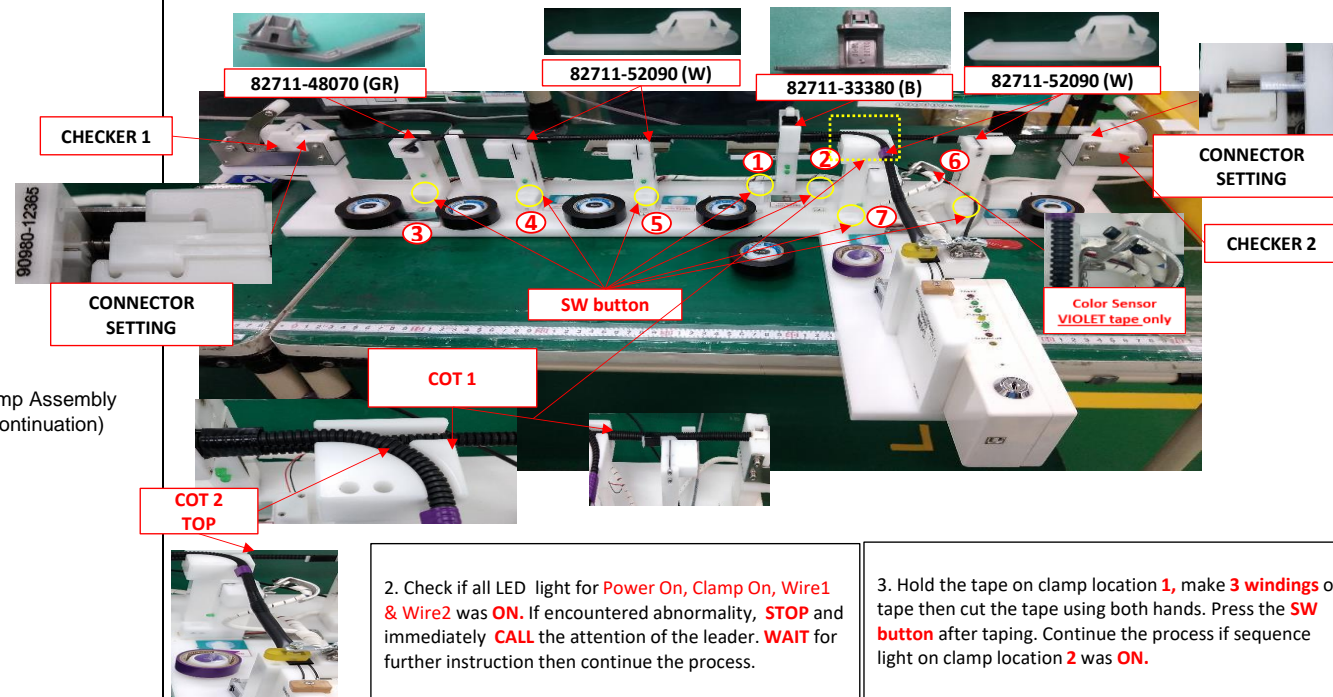
TOOLS/PPE

QUALITY POINTERS

3

n/a

Clamp Assembly
(Continuation)



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.

3. Hold the tape on clamp location 1, make 3 windings of tape 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.

4. Hold the tape on clamp location 2, make 3 windings of tape 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.

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

Important reminders/Note/s:

1. Make sure no gap between the terminal and stopper jig.



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WORK INSTRUCTION

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

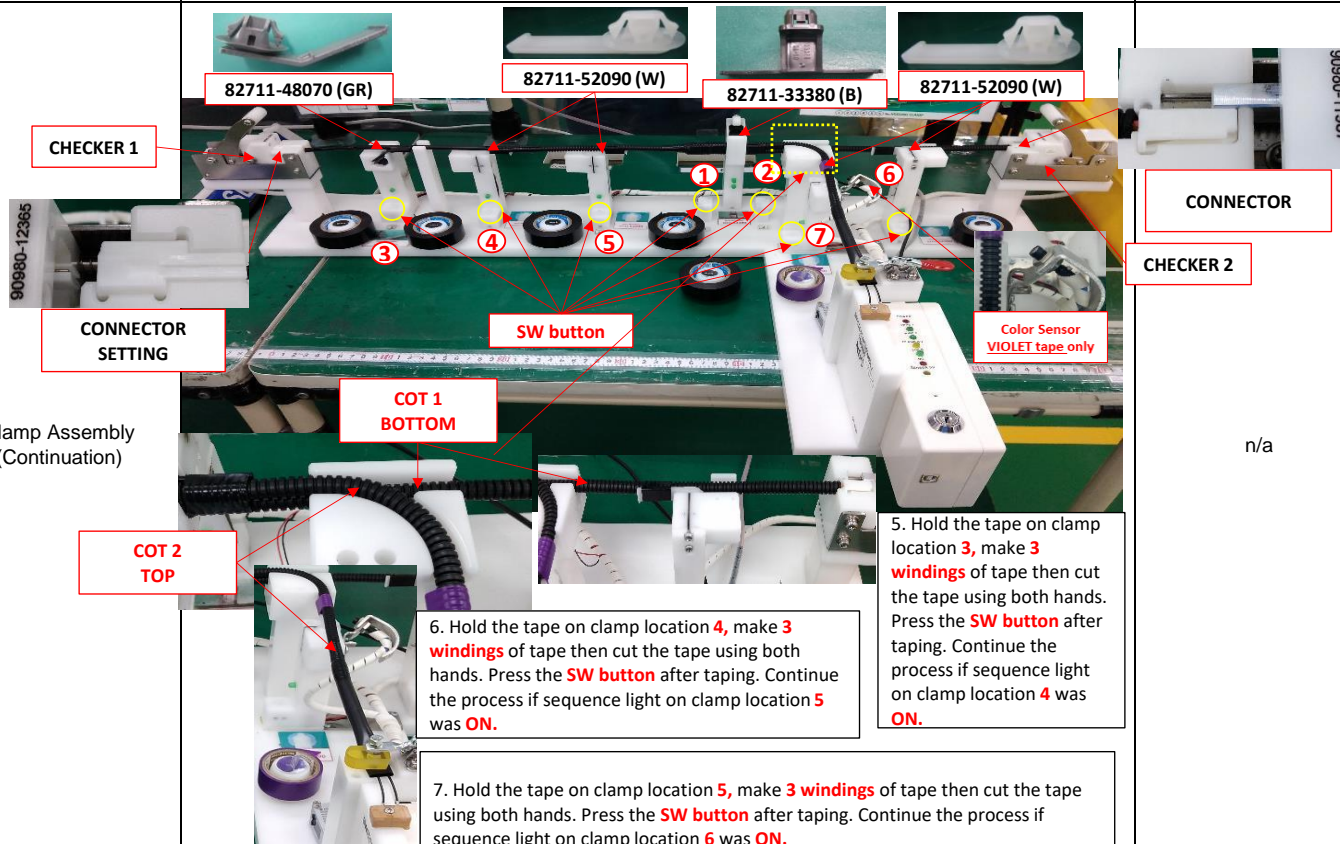
TOOLS/PPE

QUALITY POINTERS

3

n/a

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

Important reminders/Note/s:

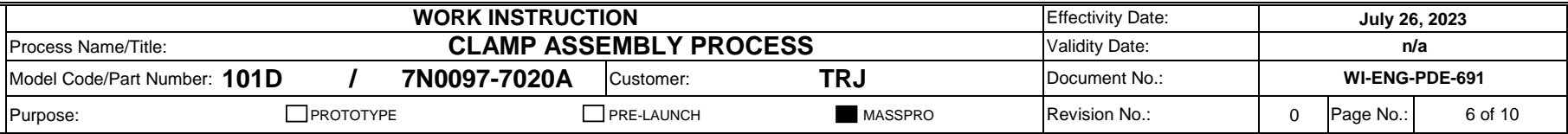
1. Make sure no gap between the terminal and stopper jig.



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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

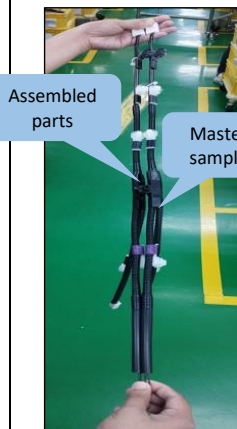
4

n/a

Visual/By Two's Inspection



ACTUAL PRODUCTS



Assembled parts

Master sample

1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **connector lock condition, insertion, terminal and taping condition.**



4. Check the **Taping condition**. Conduct **slightly pulling of VT** during bending of part with COT to VT taping to avoid overlook of missing tape.



3. Check the **presence of all clamp attachment.**



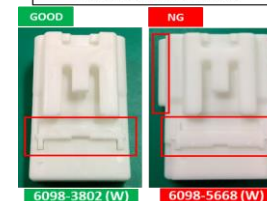
5. Check the **presence of wing-type clamp and taping condition**. Conduct **slightly bending of parts with wing-type clamp.**

MASTER SAMPLE

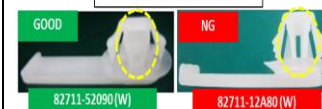


1. No skip checking during inspection.

CONNECTOR ILLUSTRATION



CLAMP ILLUSTRATION



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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

n/a

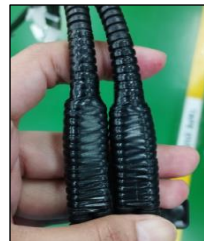
Visual/By Two's
Inspection (Continuation)



ACTUAL PRODUCTS



6. Check the **connector lock**, **insertion** and **terminal**.



7. Check the **Y-taping condition**.



9. Check the **terminal appearance**. Must be **no deformed terminal**.



8. Check the **taping condition** of COT to VM tube (Sunprene). Conduct **slightly bending**.

MASTER SAMPLE



1. No skip checking during inspection.

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9 of 10**PARTS:**

n/a

JIG

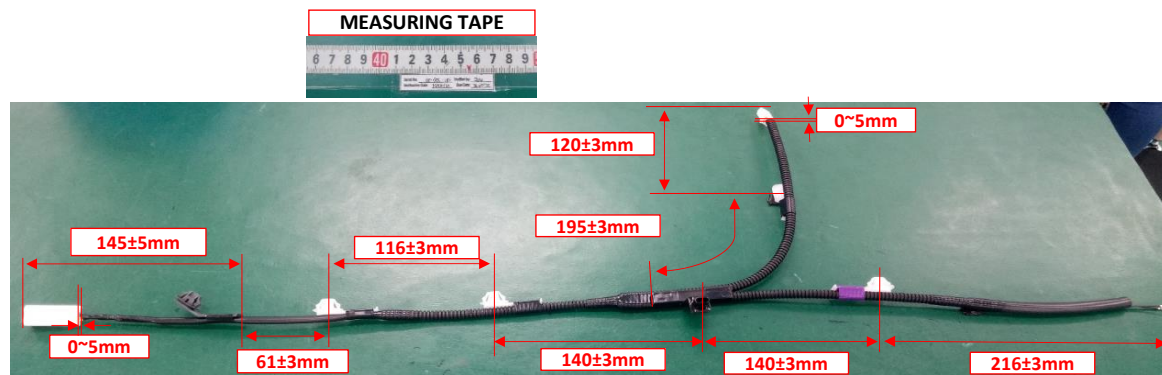
n/a

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

5

Measurement

n/a



1. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono

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PARTS:

n/a

JIG

n/a

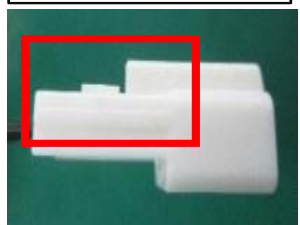
QUALITY POINTERS

n/a

7N0097-7020A



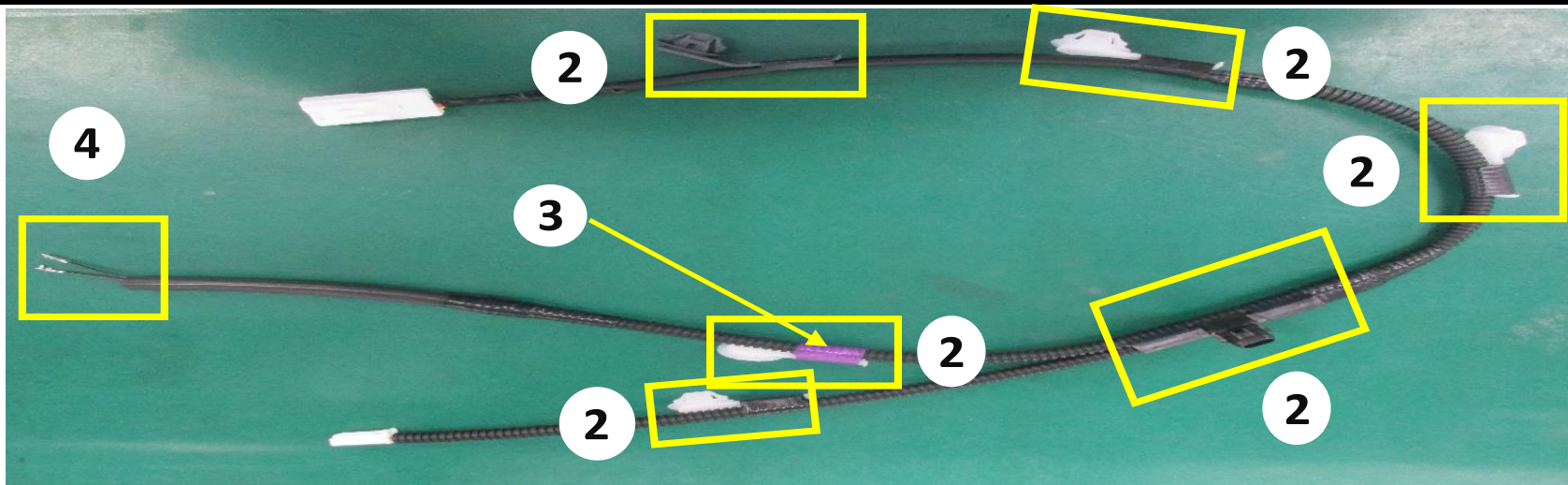
GOOD



NO

1

**No Unlock/
Halflocked
Connector**



2

**No Missing Clamp
(6pcs.) and
BENDING of 2 sides
of wing clamp**

3

**No Wrong Used of Tape
(violet tape)**

4

**No Deformed
Terminal**

5

**Checking of Clamp
Alignment**

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