

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

Effectivity Date:

**April 26, 2023**Model Code/Part Number: **895B / 7N0091-7020A** Customer: **TRJ**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

**WI-ENG-PDE-664B**

Revision No.:

**1**

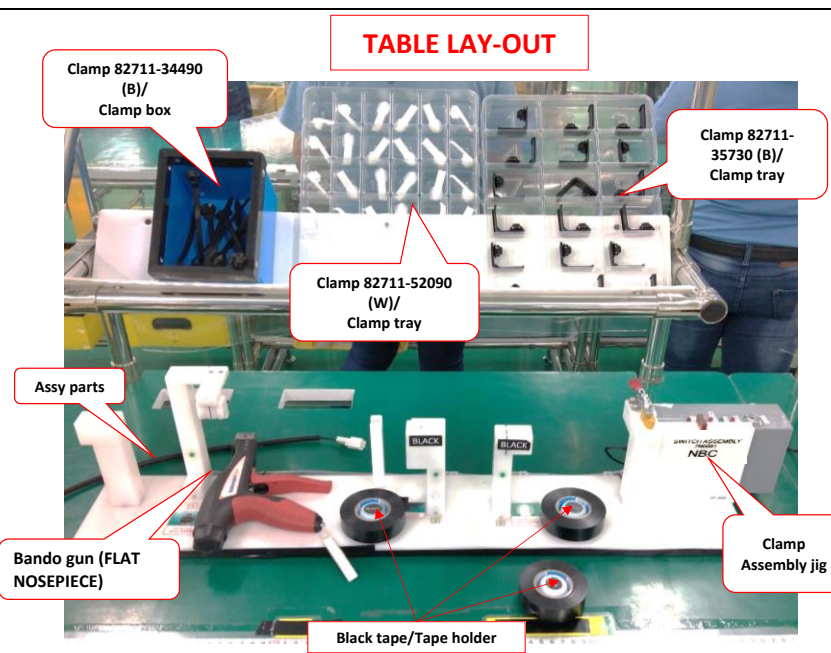

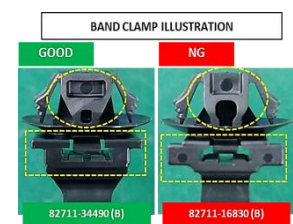
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**1 of 9****PARTS:**

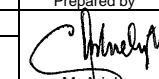
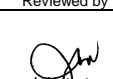
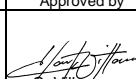
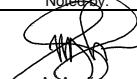
1. Assy parts; Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clamp 82711-35730 (B); Black tape [3pcs]

JIG:

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div><b>TABLE LAY-OUT</b> </div> <div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div><b>CLAMP ILLUSTRATION</b> </div> <div><b>BAND CLAMP ILLUSTRATION</b> </div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</div>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/26/23	1	Change purpose from Pre-launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/18/23	0	Initial issue Black corrugated tube Length from ø5 L=534±5mm to ø5 L=559±5mm. Remove taping from COT to wire near connector	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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**2 of 9****PARTS:**

1. Clamp 82711-34490 (B)
2. Clamp 82711-52090 (W)

3. Black tape

**JIG**

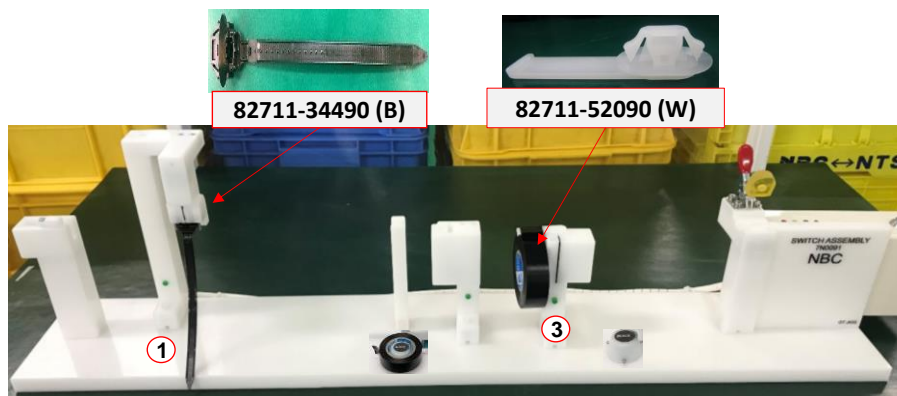
1. Clamp Assembly jig

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

2

P2

Clamp setting



1. Get 1 pc. of band clamp **82711-34490 (B)** then set to clamp location **1** using both hands.

2. Get 1 pc. of clamp **82711-52090 (W)** then set to clamp location **3** using both hands.

3. Initially attach **Black tape** on clamp location **3** using both hands.

n/a

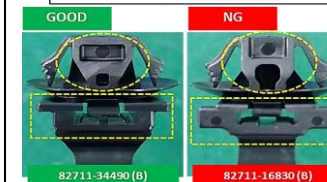
1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape
4. No missing clamp

**Important reminders/Note/s:**

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

**STANDARD TAPING FOR CLAMP**

One side tape under clamp

**CLAMP ILLUSTRATION****BAND CLAMP ILLUSTRATION**

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Clamp Assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

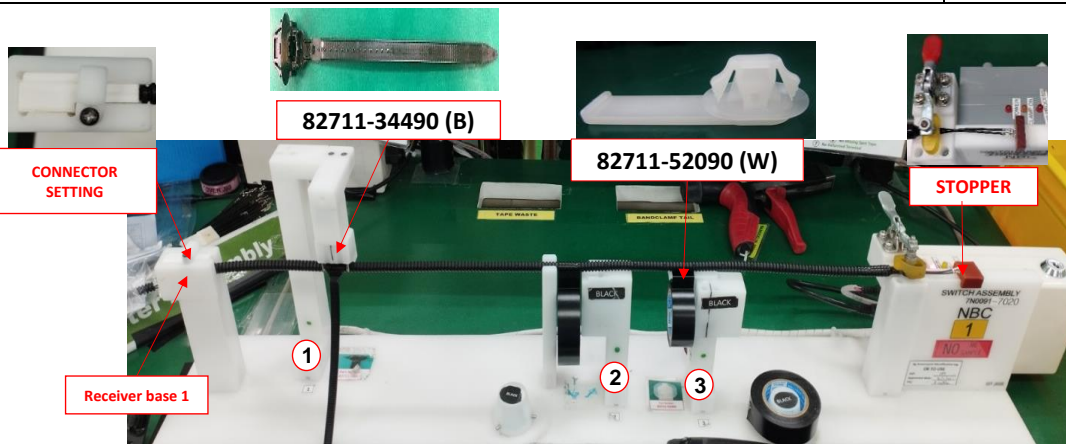
### TOOLS/PPE

### QUALITY POINTERS

3

P2

Clamp Assembly



1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.

2. Check if all LED light for POWER ON, and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.

3. Get the black tape and hang to COT on location 2, for spot taping.

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process



### Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).

### BAND CLAMP ILLUSTRATION



### BAND GUN ILLUSTRATION



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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

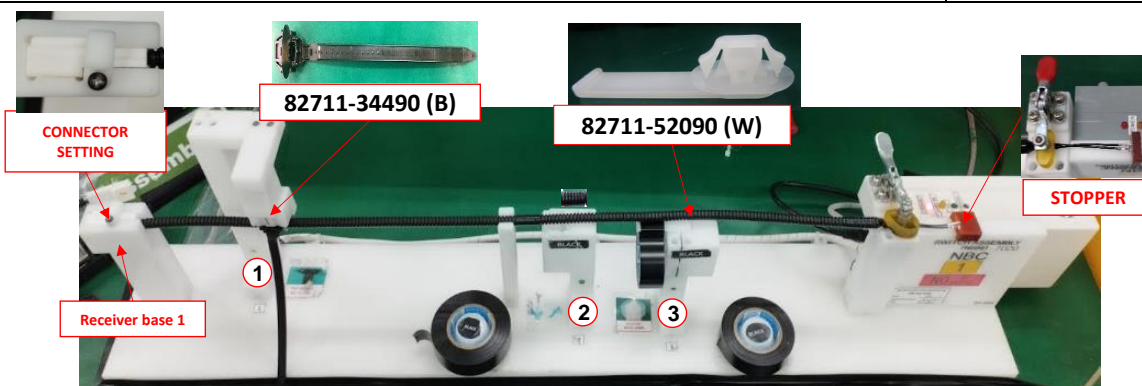
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp Assembly  
(Continuation)

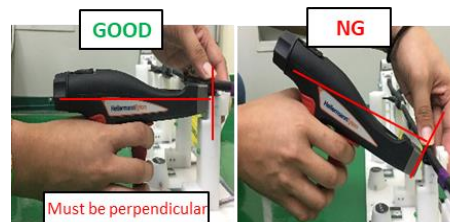


4. Initially tighten the band clamp on **location 1** using both hands.

5. Get the bando gun using right hand then cut the band clamp on location **1**. Continue the process if sequence light button on location **2** was on.



BANDO GUN (FLAT NOSEPIECE)



1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process



Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).

BAND CLAMP ILLUSTRATION



BANDO GUN ILLUSTRATION



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PARTS:

1. Assy parts
2. Black tape

3. Clamp 82711-35730 (B)

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

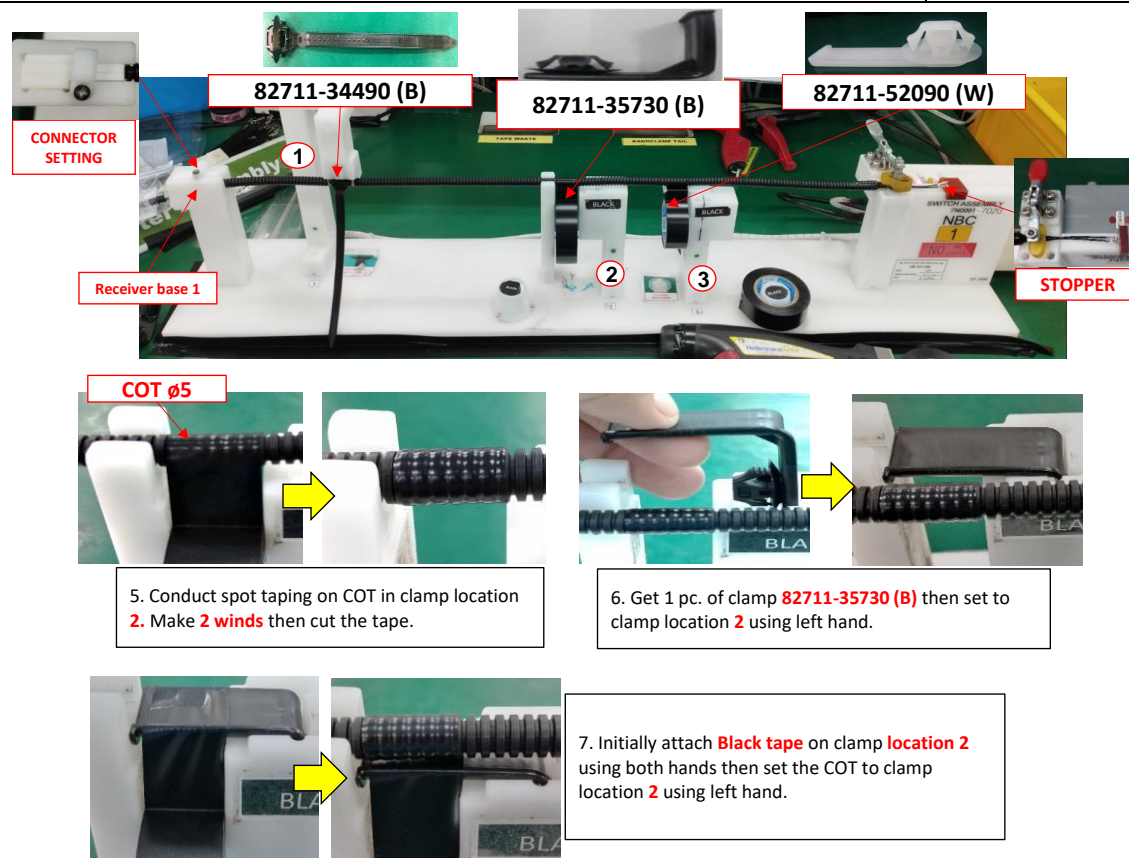
TOOLS/PPE

QUALITY POINTERS

3

P2

Clamp Assembly  
(Continuation)



1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

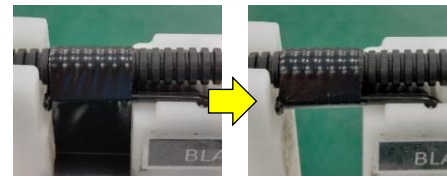
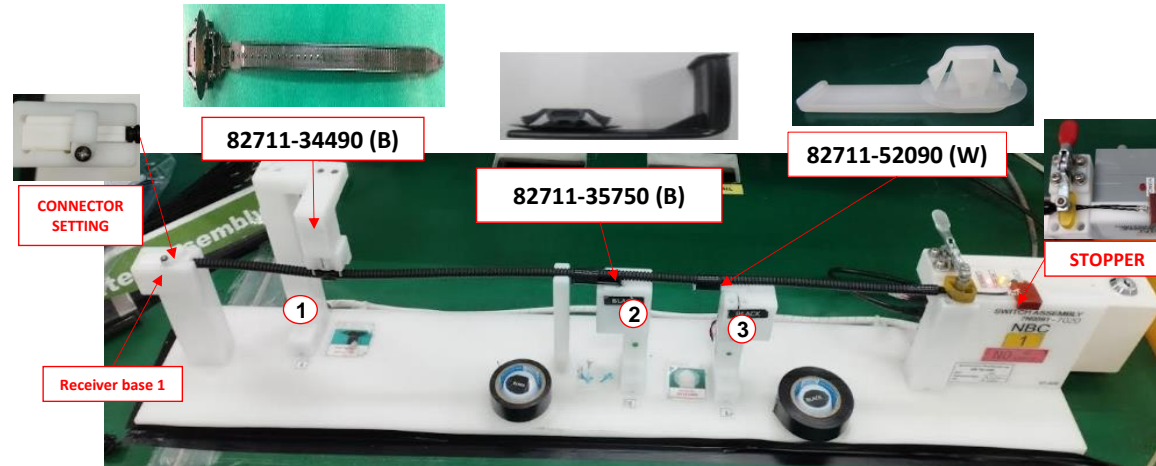
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly  
(Continuation)



8. Conduct taping on clamp location **2** using both hands. Make **3 winds** then cut the tape. Press the **SW button** after taping. Continue the process if sequence light in location **3** was **on**.

9. Tape the clamp on location **3** using both hands. Make **3 winds** then cut the tape. Press the **SW button** after taping. **GO** sound will be heard.

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

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process



Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.

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### PARTS:

1. Assembled parts
2. Engineering sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Visual/By two's inspection

**ACTUAL PRODUCT**



**Assembled parts**



**Engineering sample**



2. Check the **connector lock condition, wire insertion**



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



3. Check the **presence of all clamp attachment and taping condition.**



4. Check the **taping condition and terminal appearance. Must be no deformed terminal.**

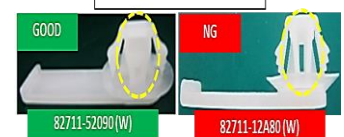


### ENGINEERING SAMPLE

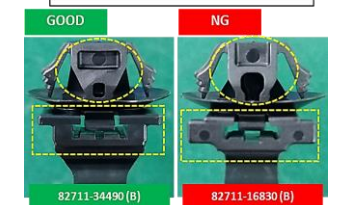


1. No skip checking during inspection.

#### CLAMP ILLUSTRATION



#### BAND CLAMP ILLUSTRATION



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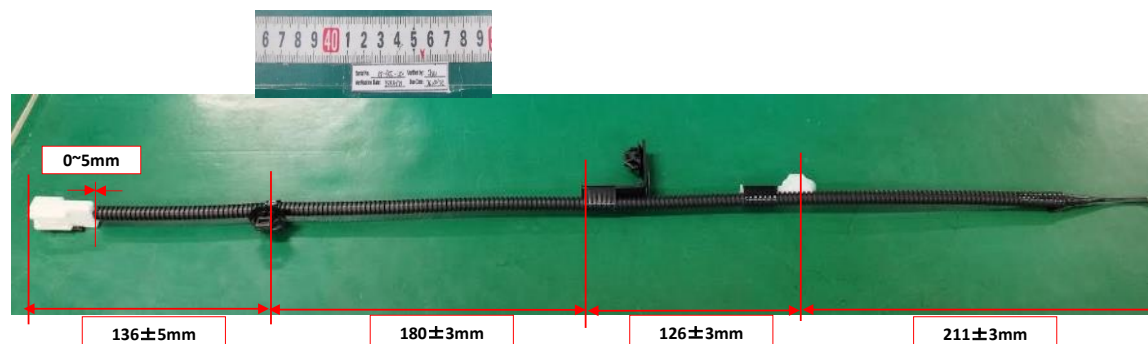
n/a

**JIG**

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****6**

Measurement

**MEASURING TAPE**

1. No wrong measurement.

**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

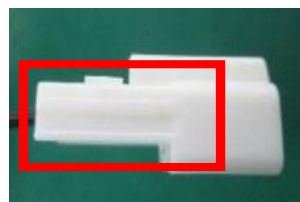
## QUALITY CHECKPOINTS

P2

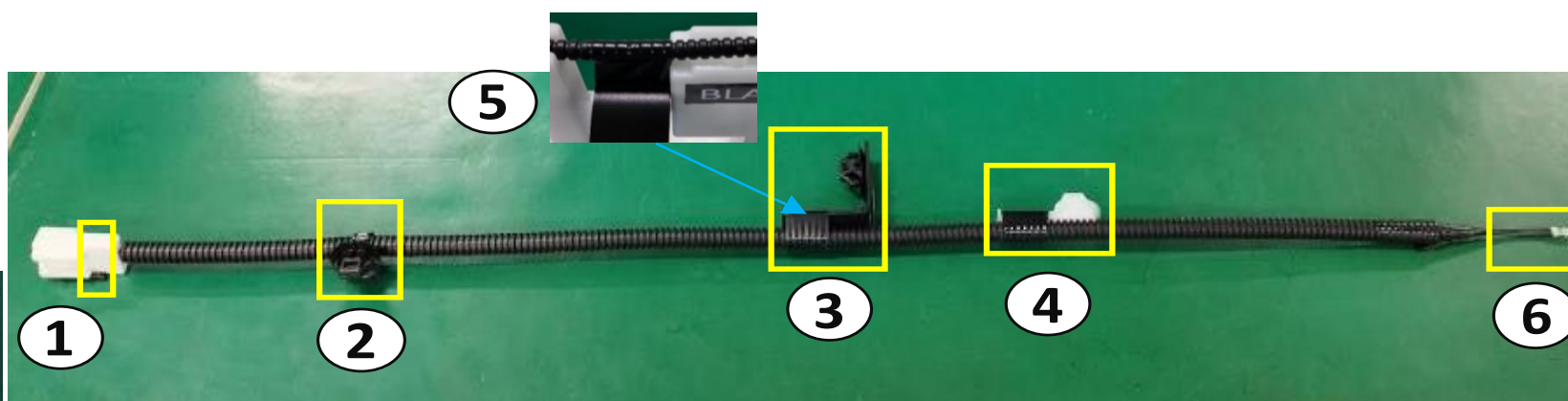
7N0091-7020A



GOOD



NO GOOD



① No Unlock/Halflocked Connector

② ③ ④ No Missing Clamp

⑤ No Missing Spot Tape

⑥ No Deformed Terminal

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