

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

Effectivity Date:

December 07, 2021

Model Code/ Part Number: **010B / 5 7L0030-7023**Customer: **TRQSS**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-169B

Revision No.:

5

Page No.:

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PARTS:

5

1. Assy parts; Label 7V1070-0020 (73230-06750); Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clip type clamp 82711-1E360(W); Black tape [2pcs

JIG:

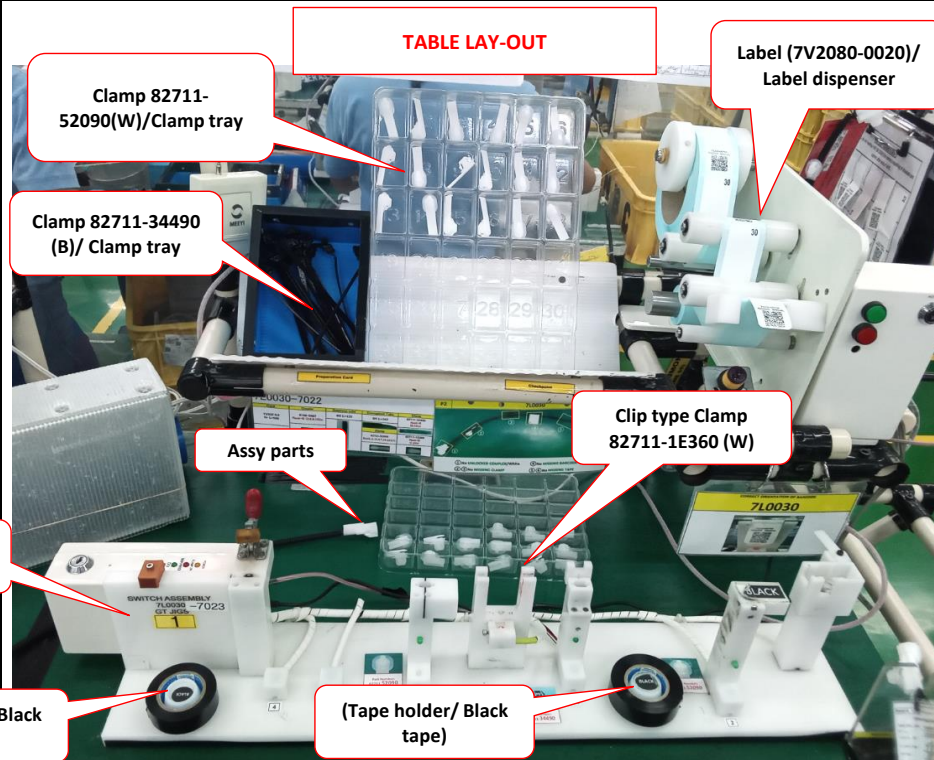
Clamp Assembly jig

NO.**PROCESS NAME****5 WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2 5

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the work place is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/07/21	5	Improve Work Procedure/Illustration; Additional Table Lay-out; Additional Clamp quantity 82711-52090 (W)	M. Ariola	J. Loterte	C.Villanueva	A. Arañes	M. Ariola	J. Loterte	C.Villanueva	A. Arañes
03/15/21	4	Change part number from 7L0030-7022 to 7L0030-2023 due to additional quality Clamp (82711-52090 (W)								
09/01/20	3	Transfer process owner for Production (WI-PRO-ASY-042A) to Engineering (WI-ENG-PDE-169A); Apply some improvements; include cycle time	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
Established Date:							July 10, 2017			

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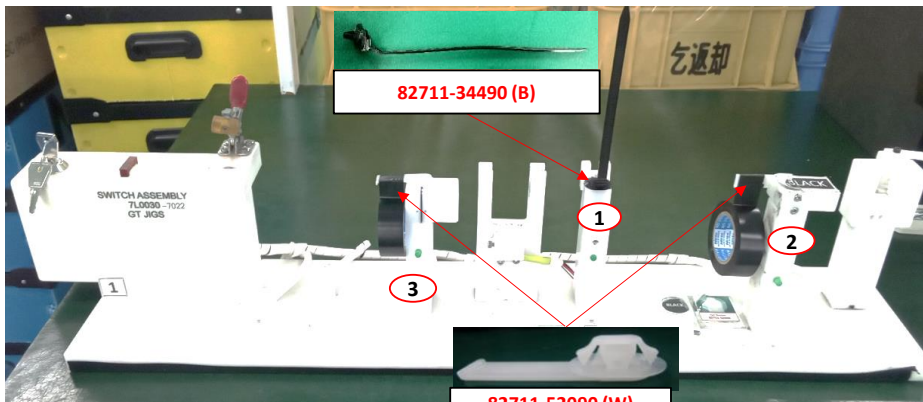

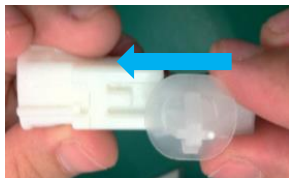
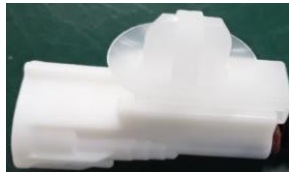
PARTS:

5

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

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp assembly setting P2	 <p>82711-34490 (B)</p> <p>82711-52090 (W)</p> <ol style="list-style-type: none">1. Get 1 pc of band clamp 82711-34490 (B) using right hand and set to clamp location ① using both hands.2. Get 2 pcs of clamp 82711-52090 (W) using both hands and set to clamp location ③ and ② using both hands.3. Get the Black tape using right hand and conduct pre-taping on clamp location ③ and ② using both hands.	n/a	 <p>One side tape under clamp</p> <ol style="list-style-type: none">1. No damaged clamp2. No wrong use of clamp3. No missing clamp
3	Clamp attachment (clip type clamp)	  <ol style="list-style-type: none">1. Hold the connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i>	n/a	<ol style="list-style-type: none">1. Must be fully inserted

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

5 WORK PROCEDURE/ ILLUSTRATION

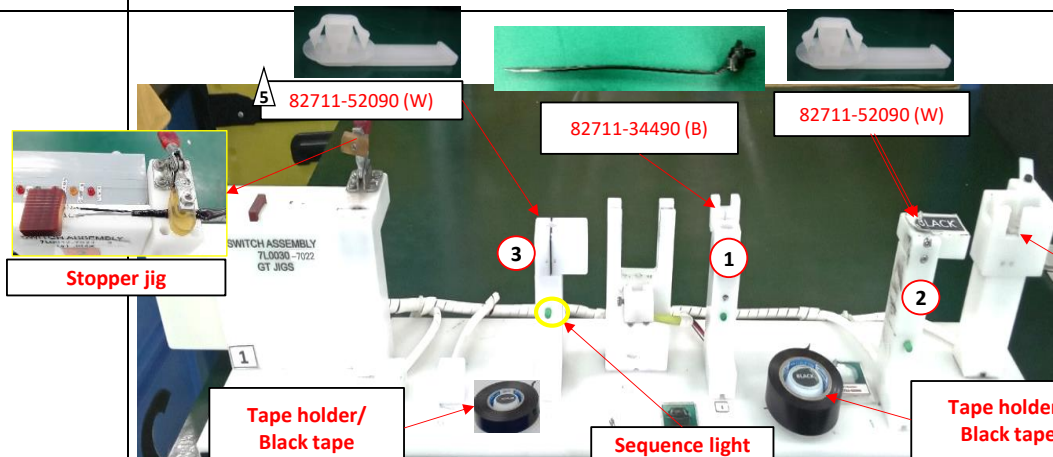
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp assembly



1. Put the assy parts into jig using both hands. First put the connector to receiver base using left hand and lock using right hand. Second, put the terminal into stopper jig using left hand and pull down the toggle clamp using right hand.
Refer to above illustration for the correct setting.

3. Initially tighten the band clamp 82711-34490 on clamp location 1 using right hand.

4. Get the bando gun using right hand then cut the band clamp on Location ①. Press the **SW button** every cut using both hand.

2. Check if the LED light for **POWER, CLAMP and SEQUENCE LIGHT** is **ON**. If encountered abnormality, **STOP** the process, **CALL** the attention of the Leader and **WAIT** for instruction.



BANDO GUN



Note:
Make sure no clearance between terminal and stopper jig

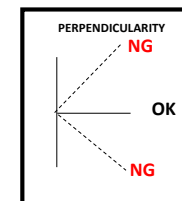


1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun
5. No wrong use of tape
6. No peel off tape
7. No missing tape



Fixed setting of
band clamp
cutter: 1 ~ 2

BANDO GUN ALIGNMENT



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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 (Continuation)	<div data-bbox="577 413 1514 903"> </div> <div data-bbox="577 924 1061 1078"> <p>5. Hold the tape on clamp location ② using both hands. Make 3 windings then cut the tape using both hand. Press the SW button every taping. Continue if sequence light on clamp location ③ was ON.</p> </div> <div data-bbox="577 1136 1061 1270"> <p>6. Hold the tape clamp on location ③ using both hands. Make 3 windings then cut the tape. Press the SW button every taping. Proceed to attachment of Label.</p> </div> <div data-bbox="1122 919 1328 1110"> </div> <div data-bbox="1081 1120 1514 1327"> </div>	<p>Note: Make sure no clearance between terminal and stopper jig</p> <ol style="list-style-type: none"> 1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No wrong use of tape 6. No peel off tape 7. No missing tape <div data-bbox="1554 908 1760 1104"> <p>BANDO GUN</p> </div> <div data-bbox="1803 976 2069 1275"> <p>BANDO GUN ALIGNMENT</p> <p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p> </div>

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☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts; Label (7V1070-0020)

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

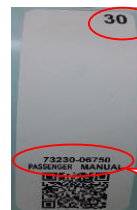
TOOLS/PPE

QUALITY POINTERS

5

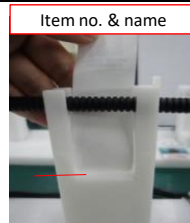
P2

Clamp assembly
Label Attachment



Model Code

Item no. & name

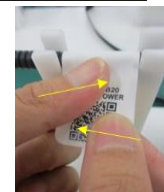


Item no. & name

1. Get the label.

Check the model code, item no. & name

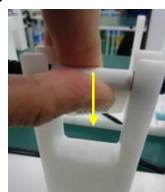
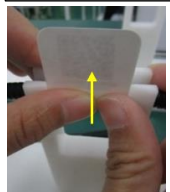
2. Align the end part of label in the jig.



3. Fold the center part of the label

4. Align both end part of label .

5. After alignment , Press the label with both fingers.
Make sure it was attach properly.



6. Press the label upside down using finger.

7. Press the SW button after label attachment. Conduct **POINT CHECKING** and remove the harness from jig.



GOOD

Acceptable overlap
0~1mm



Label Dispenser

1. No bubbles
- 2.No damage
- 3.No peel off
- 4.No wrong use of label
5. No missing parts
6. No loose attachment



NG

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

5

Visual/By two's inspection

1. Check the connector lock

2. Check the clamp attachment, alignment and tape condition,

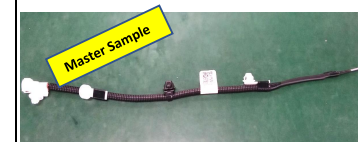
3. Check the presence of label and terminal appearance.

3. Using a steel rule check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.



5. Compare to Master sample.
Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.

MASTER SAMPLE



P2

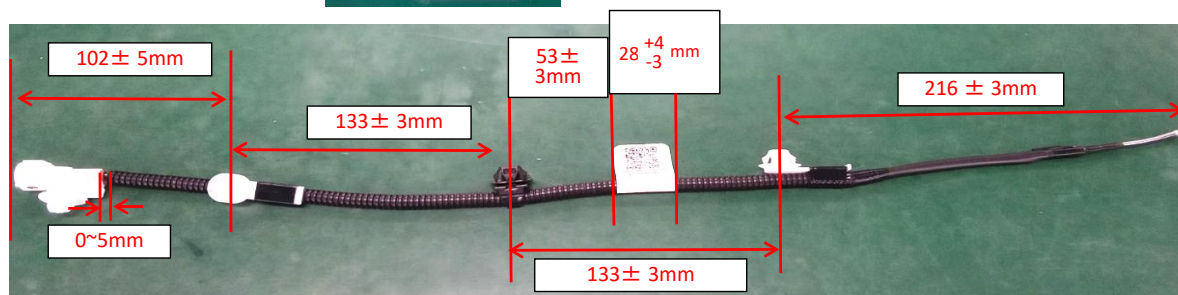
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Measurement



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



FOR HATSUMONO AND
OWARIMONO ONLY

1. No wrong measurement

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