

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 12, 2021

Product Name/Code:

**780B / 1 7R0104-7021**

Customer:

**TRMX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-204C**

Revision No.:

1

Page No.:

1 of 6

**PARTS:**

1. Assy parts
2. Clamp 82711-26380 (BR) [4pcs.]

JIG:

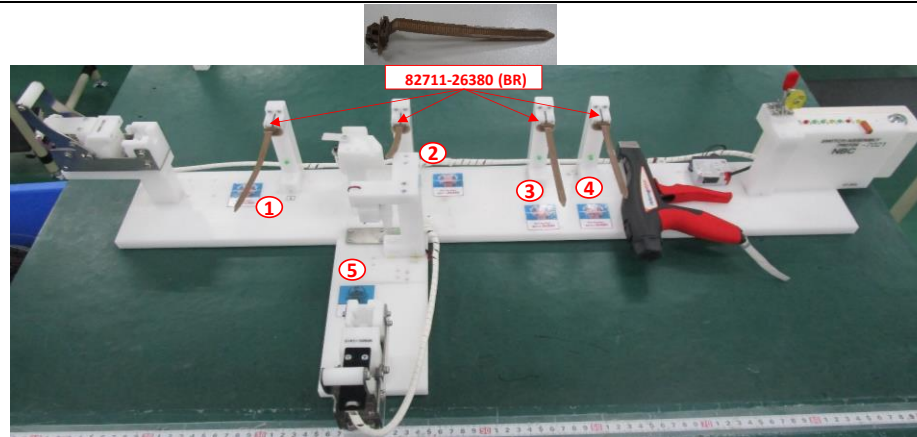
1. Clamp assembly jig

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

Clamp

P3

**1**  
Clamp setting



1. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **1** using both hands.

2. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **2** using both hands.

3. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **3** using both hands.

**Note:** Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.

4. Get 1pc. of clamp **82711-26380 (BR)** using right hand and set to clamp location **4** using both hands.

**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 workplace 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 wrong use of clamp
2. No damaged clamp
2. No wrong use of tape

Prepared by

Reviewed by

Approved by

Noted by

04/12/21 1 Change part number from 7R0104-7020B to 7R0104-7021. Apply some improvements in every process.

M. Catapang C. Villanueva A. Shimamura A. Arañes

12/04/20 0 Initial issue

M. Catapang R. Peñaloza A. Shimamura A. Arañes

Eff. Date Rev. No Details of Change

Revised Checked Approved Noted

Est. Date: December 04, 2020

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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## PARTS:

1. Assy parts
2. Clamp 82711-16830 (B)

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

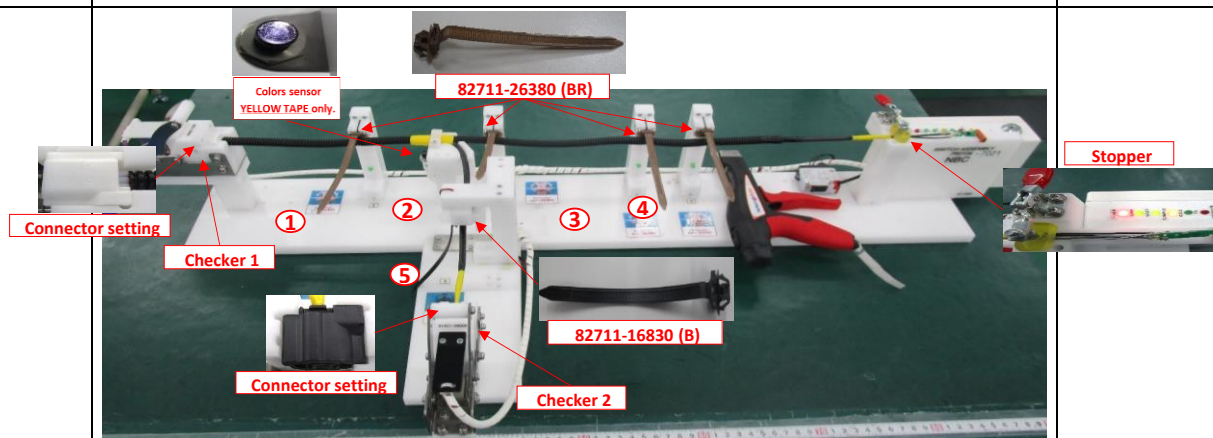
## TOOLS/PPE

## QUALITY POINTERS

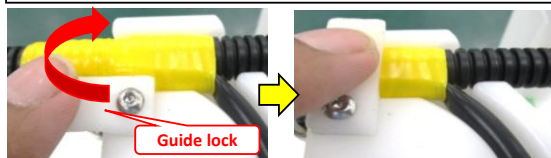
1

P3

1  
Clamp setting  
(Continuation)



5. Hold the assy parts and then set to jig. (*See above picture for correct setting*). First, set the connector **6189-1142 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. **Color sensor** light will be beep/buzz if sensor detects **Yellow tape**. (*See below illustration for Y-Taping lock.*) Second, set the **PCB** and **B/B wires** to stopper jig and push down the toggle clamp. Last, set the connector **6189-1161 (B)** to **Checker 2** then push the checker fixture for continuity checking.



7. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **5** using both hands.

6. Using left index finger, push the guide lock to lock the Y-taping portion.

8. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2, Sensor ON** was On. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

n/a



*Note: Make sure no clearance between PCB and stopper jig.*

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

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### PARTS:

1. Assy parts

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

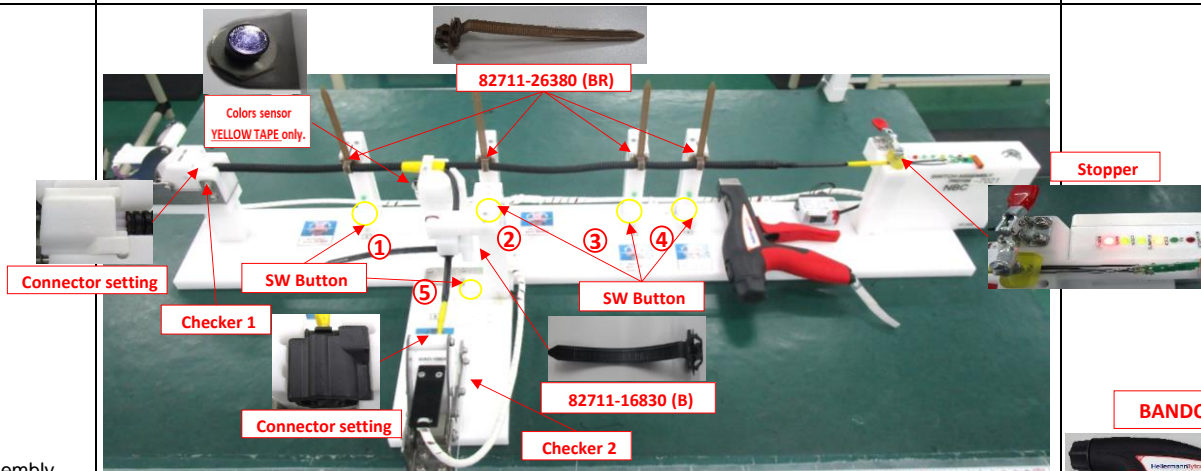
### TOOLS/PPE

### QUALITY POINTERS

2

P3

1  
Clamp assembly

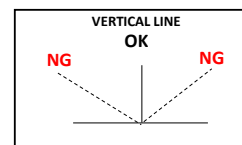


1. Initially tighten the band clamp on clamp location **1, 2, 3, 4, and 5** using both hands.

2. Get the Bando Gun using right hand and cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was on.

3. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was on.

4. Cut the band clamp on clamp location **3** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **4** was on.



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For:  $\phi 5$  - 1~2,  $\phi 7$  - 3~4



Note: Make sure no clearance between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts

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## PARTS:

1. Assy parts

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

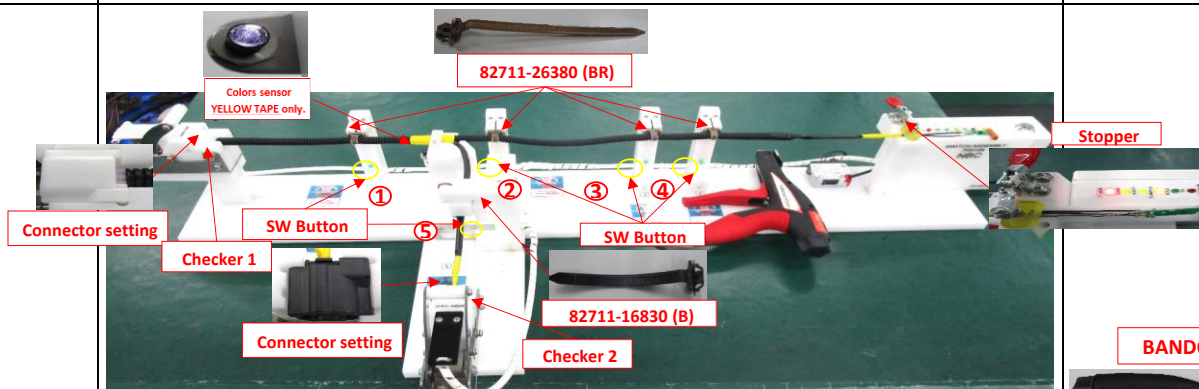
## TOOLS/PPE

## QUALITY POINTERS

2

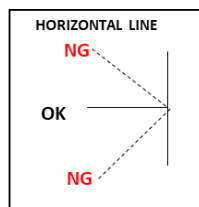
P3

1  
Clamp assembly  
(Continuation)



- 1. No loose attachment of clamp
- 2. No damaged clamp
- 3. No missed tape
- 4. No missing parts
- 5. No wrong use of tape

## BAND CLAMP CUT POSITION FOR 82711-16830 (B)



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For:  $\phi 5 - 1 \sim 2$ ,  $\phi 7 - 3 \sim 4$

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## PARTS:

1. Assy parts

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

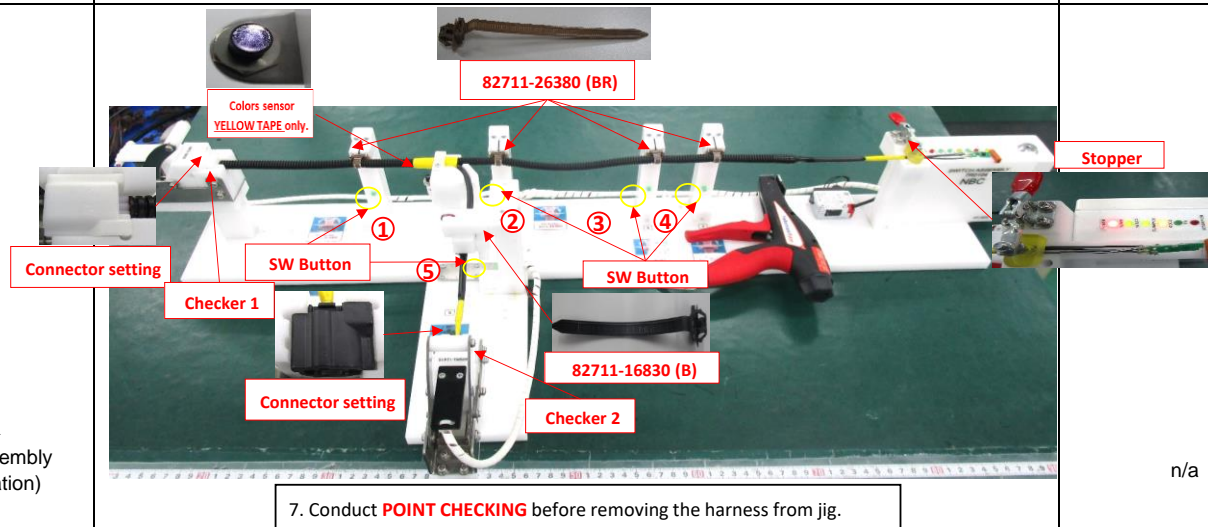
## TOOLS/PPE

## QUALITY POINTERS

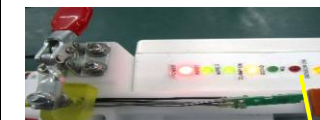
2

P3

1  
Clamp assembly  
(Continuation)



n/a



Note: Make sure no clearance  
between PCB and stopper jig.

1. No loose attachment of clamp
2. No damaged clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape

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PARTS:

n/a

JIG

n/a

NO.

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TOOLS/PPE

QUALITY POINTERS

3

P3

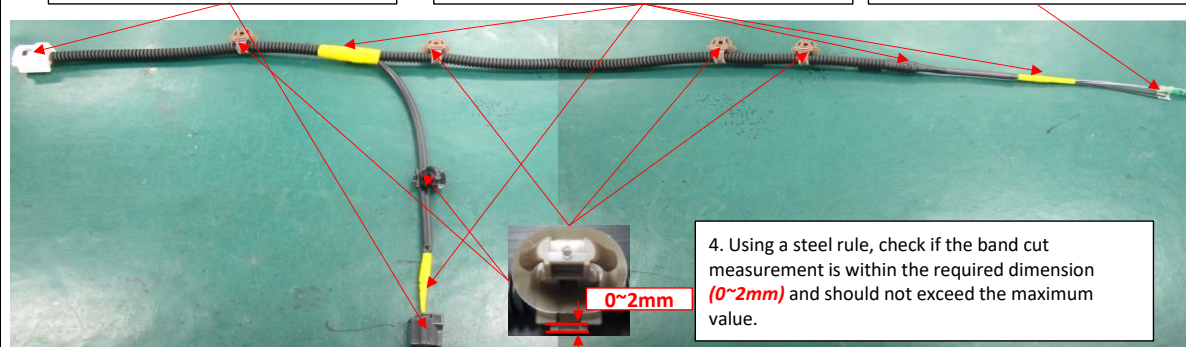
1

Visual/By two's inspection

1. Check the connector if properly locked.

2. Check the taping condition.

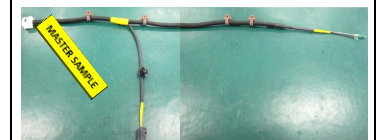
3. Check the terminal appearance. Make sure no deformed terminal.



4. 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.*

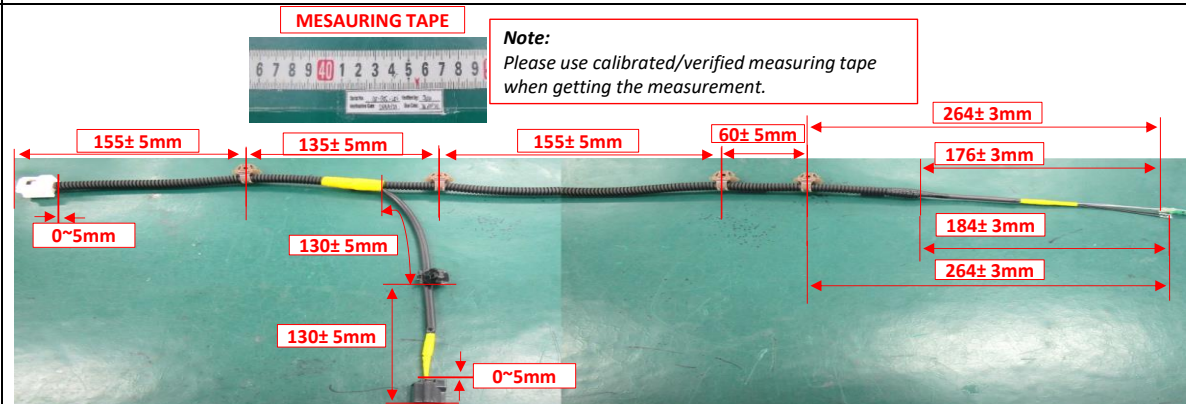
**MASTER SAMPLE**



4

1

Measurement



**NOTE: For HATSUMONO AND OWARIMONO**

1. No wrong dimension

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