

**WORK INSTRUCTION**

Effect: October 07, 2022

December 06, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

920B / 7R0118-7020B

Customer:

TRMX

Document No.:

WI-ENG-PDE-552C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revis 2

1

Page No.:

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PARTS:

1. Assy parts: Clamp 82711-12A80 (W); Clamp 82711-12A60 (W); Black tape

JIG:

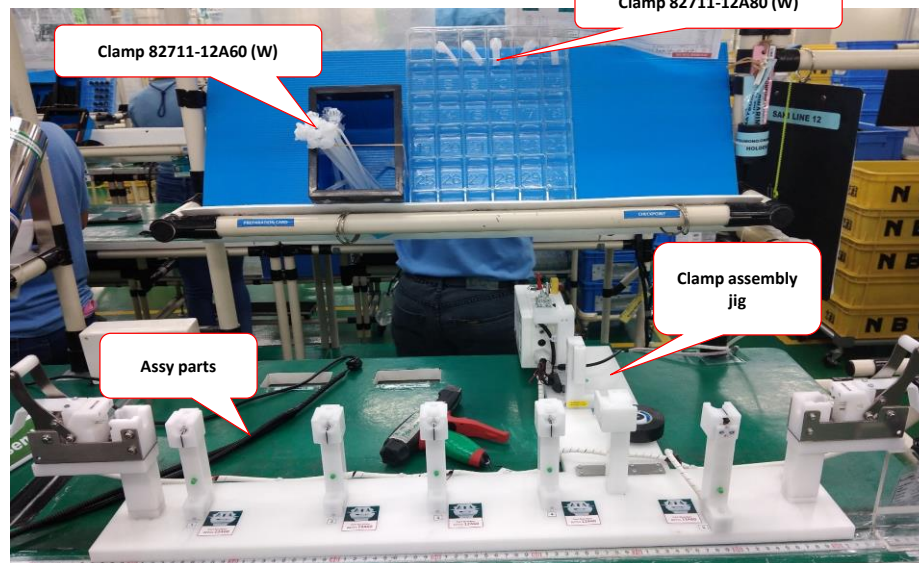
1. Clamp assembly jig

NO.**PROCESS NAME****1****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P3

Table Lay-out

**Table Lay-out****Clamp 82711-12A80 (W)****Clamp 82711-12A60 (W)****Assy parts****Clamp assembly
jig****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.

**BANDO
GUN**

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

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
12/06/22	1	Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process. Provide clamp assembly jig				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
06/29/22	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:

June 29, 2022

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☐ PRE-LAUNCH

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PARTS:

1. Clamp 82711-12A60 (W) [5pcs.]
2. Clamp 82711-12A80 (W)

3. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

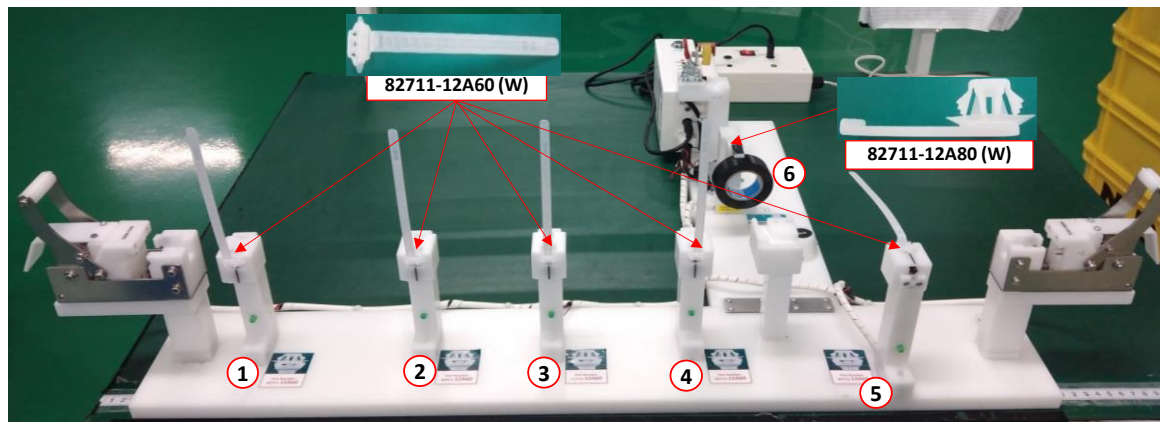
TOOLS/PPE

1 QUALITY POINTERS

2

P3

Clamp setting



1. Get 3pcs. of clamp 82711-12A60 (W) then set to clamp location 1, 2 and 3 using both hands.

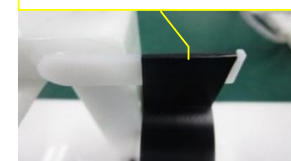
3. Get 1pc. of clamp 82711-12A80 (W) then set to clamp location 6 using both hands.

2. Get 2pcs. of clamp 82711-12A60 (W) then set to clamp location 4 and 5 using both hands.

4. Initially attach Black tape on clamp location 6 using both hands.

STANDARD TAPING FOR CLAMP

One side tape under clamp



Important reminders/Note/s:

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

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

CLAMP ILLUSTRATION



BAND CLAMP ILLUSTRATION



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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

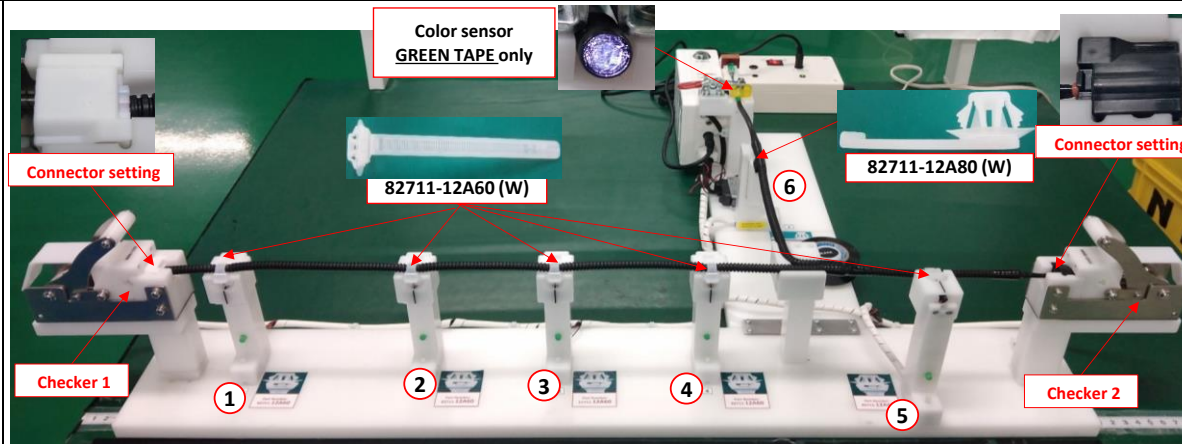
TOOLS/PPE

1 QUALITY POINTERS

3

P3

Clamp assembly



1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6189-1142 (W) to Checker 1 then pull the checker fixture for continuity checking. Set the connector 6189-1161 (B) to Checker 2 then push the checker fixture for continuity checking. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Green tape. Last, set the end of PCB within the stopper jig then press the toggle clamp. Continue if the clamp location 1 was ON.

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

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

4. Get the Bando gun using right hand then cut the clamp on location 1 using both hands. Press the SW button after cut Continue if the clamp location 2 was ON.



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



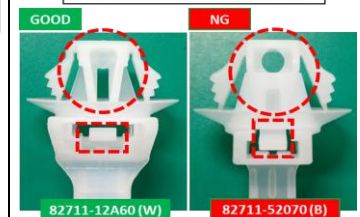
Fixed setting of band clamp cutter: 1~2



Important reminders/Note/s:
1. Make sure no gap between stopper and PCB

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

BAND CLAMP ILLUSTRATION



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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

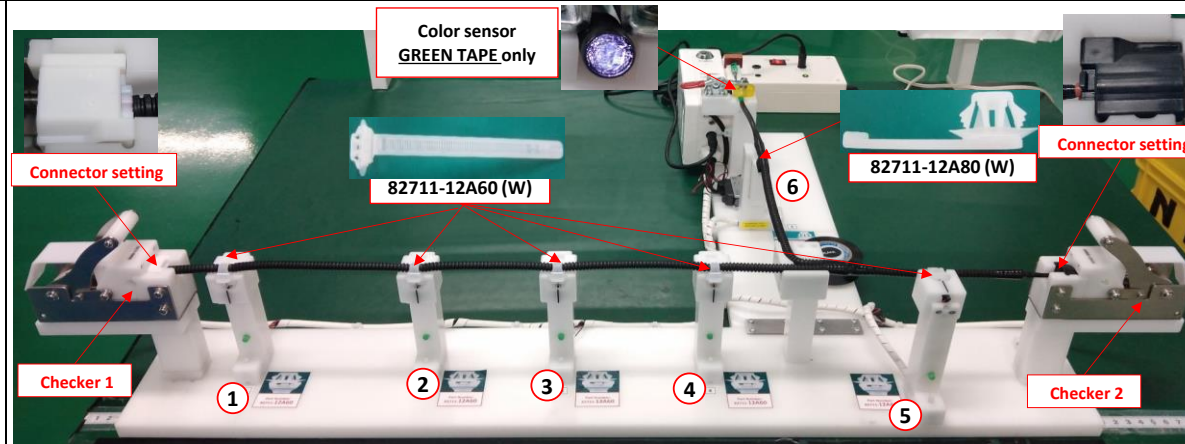
TOOLS/PPE

1 QUALITY POINTERS

3

P3

Clamp assembly
(Continuation)



5. Cut the clamp on location **2** using both hands. Press the **SW button** after cut Continue if the clamp location **3** was **ON**.

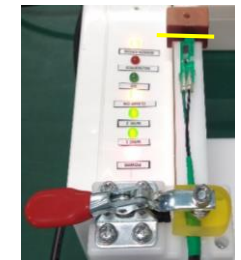
8. Cut the clamp on location **5** using both hands. Press the **SW button** after cut Continue if the clamp location **6** was **ON**.

6. Cut the clamp on location **3** using both hands. Press the **SW button** after cut Continue if the clamp location **4** was **ON**.

9. Hold the tape on clamp location **6**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **GO** sound will be heard.

7. Cut the clamp on location **4** using both hands. Press the **SW button** after cut Continue if the clamp location **5** was **ON**.

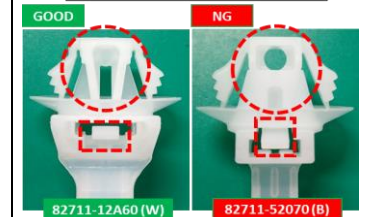
10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:
1. Make sure no gap between stopper and PCB

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

BAND CLAMP ILLUSTRATION



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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE


1 QUALITY POINTERS

4

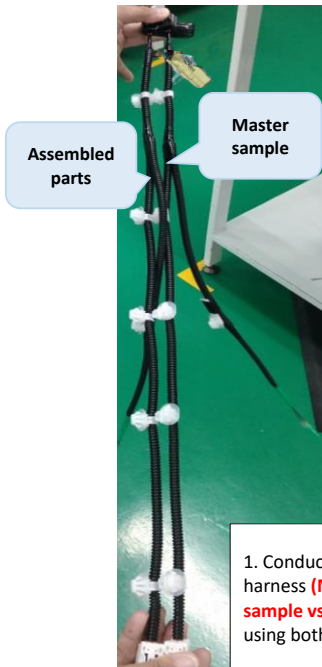
P3

Visual/By two's inspection

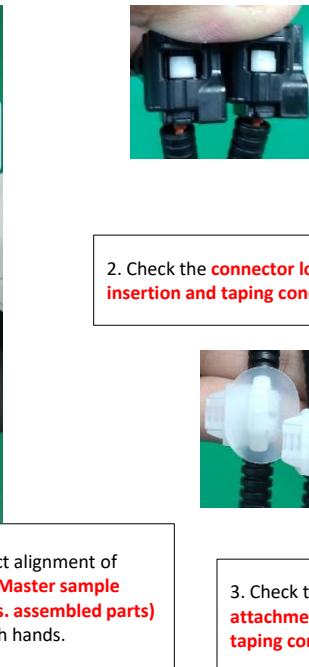
ACTUAL PRODUCT



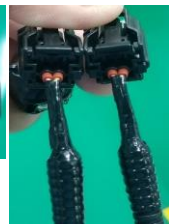
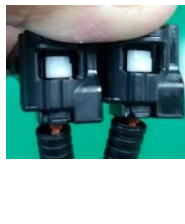
Assembled parts





Master sample




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



3. Check the **presence of clamp attachment, cut appearance and Y-taping condition..**



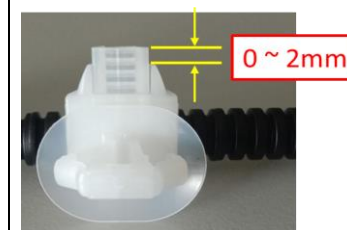
3. Check the **presence of ALL clamp attachment and cut appearance.**



MASTER SAMPLE



1. No skip process



Important reminders/Note/s:

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

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6 of 8**PARTS:**

1. Assy parts

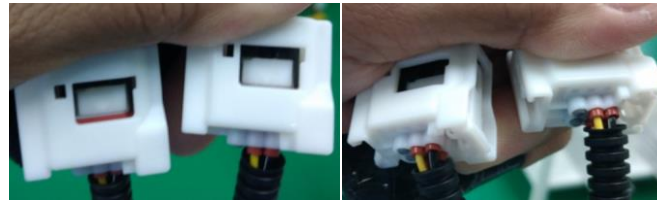
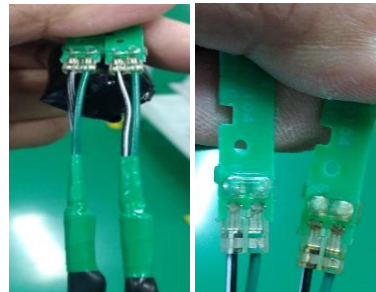
JIG

n/a

NO.**PROCESS NAME****1****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1****QUALITY POINTERS**

4

P3

Visual/By two's inspection
(Continuation)5. Check the **terminal, connector lock** condition and **insertion**.6. Check the **presence of clamp, taping condition of clamp and COT to VT taping condition**.7. Check the **tape color, taping condition and PCB appearance**.**MASTER SAMPLE**

1. No skip process

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

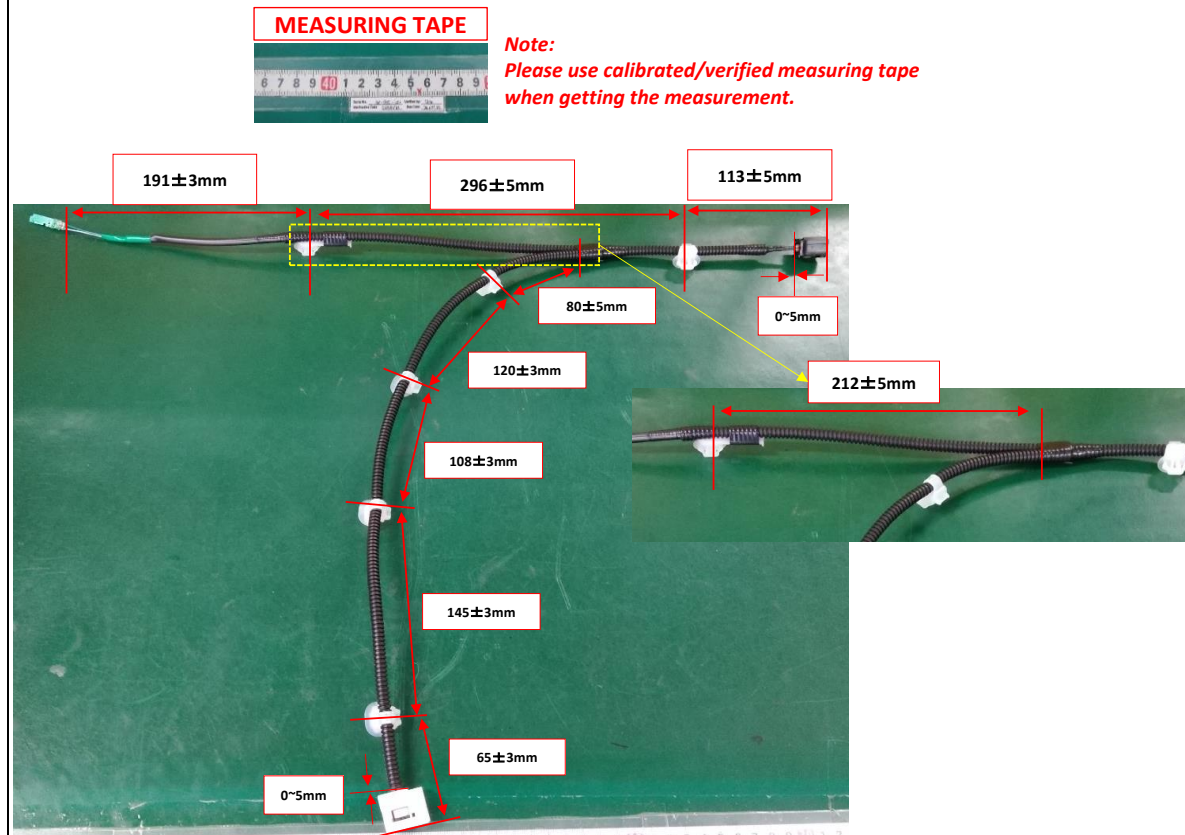
TOOLS/PPE

1 QUALITY POINTERS

5

P3

Measurement



Important reminders/Note/s:
1. FOR HATSUMONO AND
OWARIMONO

1. No wrong dimension

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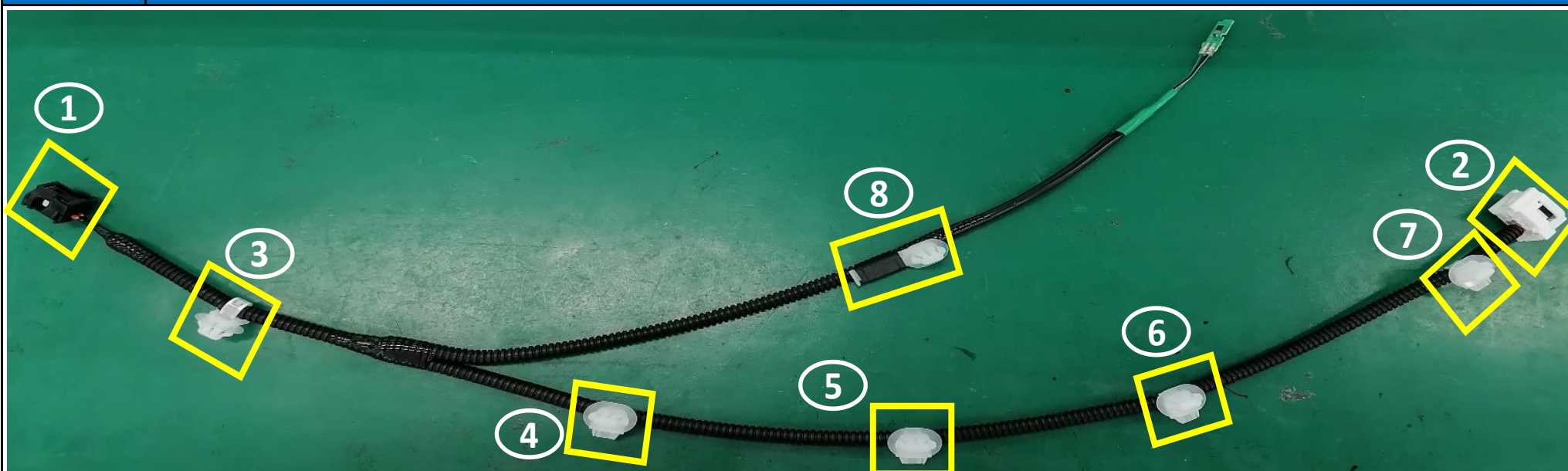
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PARTS:

n/a

JIG

n/a

1 QUALITY CHECKPOINTS**P3****7R0118-7020B****1 2 No UNLOCKED/HALFLOCKED CONNECTOR****9 CORRECT FACING OF CLAMP****3 4 5 6 7 8 No MISSING CLAMP/BAND CLAMP**

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