

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

Effectivity Date:

April 25, 2022

Model Code/Part Number:

N/A / 7H0346W7020C

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-466B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 4

PARTS:

1. Assy parts; Clamp 82711-48070 (GR); Clamp 82711-52090 (W); 82711-3A540 (W); Black tape [5pcs.]

JIG:

1. Temporary Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<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>	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
04/25/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/07/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				

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DCC Stamp

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Clamp 82711-48070 (GR) [2pcs]
2. Clamp 82711-52090 (W) [2pcs]

3. 82711-3A540 (W)
4. Black tape [5pcs]

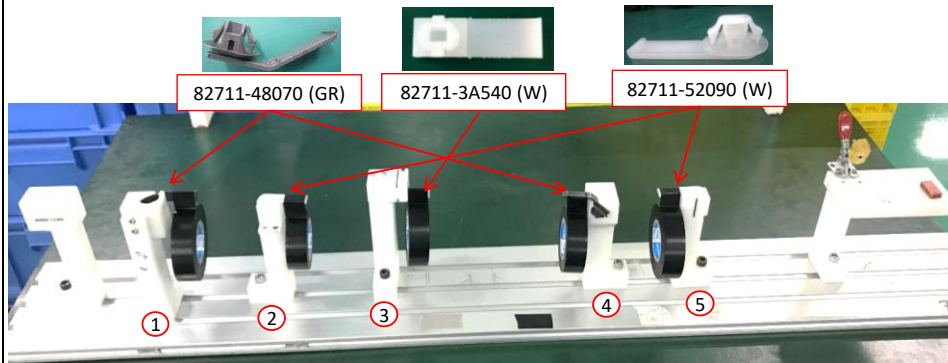
JIG

1. Temporary Clamp Assembly jig

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

2

P2

Temporary Clamp
Setting

1. Get 2pcs. of clamp **82711-48070 (GR)** using right hand and set to **clamp location 1** and **4** using both hands.

2. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to **clamp location 2** and **5** using both hands.

3. Get 1pc. of clamp **82711-3A540 (W)** using right hand and set to **clamp location 3** using both hands.

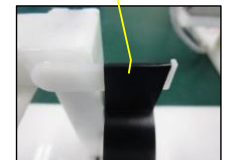
4. Get the **Black tape** using right hand. Conduct pre-taping on **clamp location 1, 2, 3, 4 and 5** using both hands.

n/a

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

STANDARD TAPING FOR CLAMP

One side tape under clamp



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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts

JIG

1. Temporary Clamp Assembly jig

NO.

PROCESS NAME

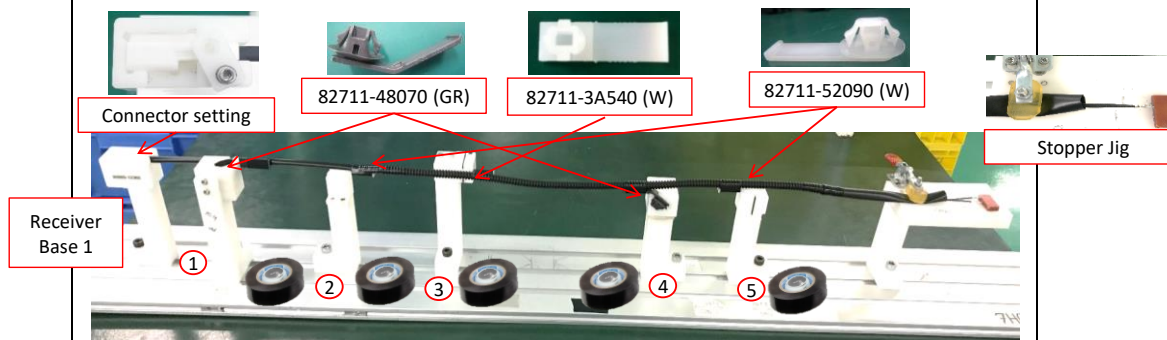
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P2

Temporary Clamp
Assembly

1. Get the assy parts using right hand and set to jig using both hands. First, put the connector into receiver base and lock. Second put the terminal into stopper jig then pull down the toggle clamp. If encountered abnormality, **STOP** the process, **CALL** the attention of leaders and **WAIT** for instruction.
Note: Please refer to above illustration for correct setting.

2. Hold the clamp on **location 1** using left hand and start taping using right hand. Make **3 winds** and cut the tape. Proceed to **location 2,3,4 and 5** and repeat the process.

3. Conduct **POINT CHECKING** using right hand before removal from jig.

n/a

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

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

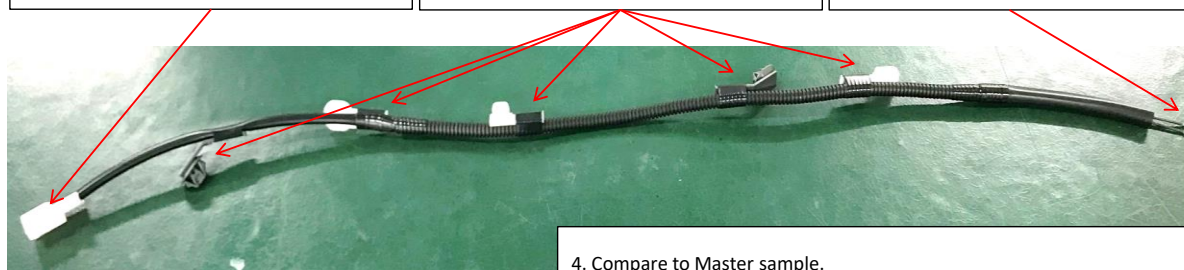
4

Visual/By two's inspection

1. Check the connector lock.

2. Check the clamp attachment and taping condition.

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



4. Compare to Master sample.

Note: Refer to GL-PRO-ASY-007 for By two's inspection for sub-assy.

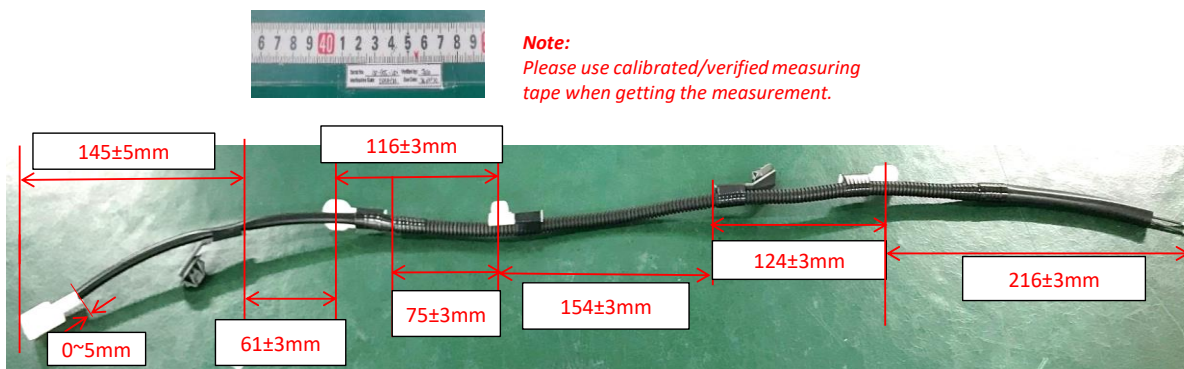
MASTER SAMPLE



P2

5

Measurement



For HATSUMONO and
OWARIMONO.

1. No wrong dimension

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