

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

Effectivity Date:

July 17, 2021Product Name/Code: **900B / 7N0114-7020A** Customer: **TRJ**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:


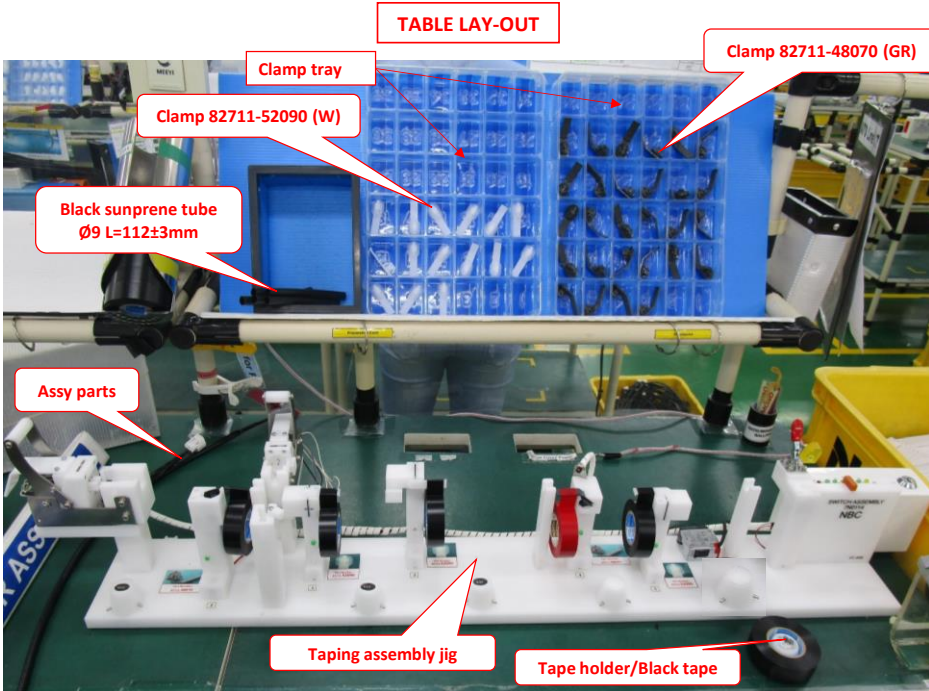
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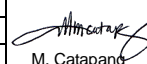



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PARTS:		1. Assy parts 2. Clamp 82711-52090 (W) 3. Clamp 82711-48070 (GR)	4. Black tape [5pcs.] 5. Red tape [1pc.] 6. Black sunprene tube Ø9 L=112±3mm 	JIG:	1. Taping assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out			<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/17/21	1	Removal of validity date. Change document status from pre-launch to masspro. Additional parts in parts section.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
07/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:

1. Assy parts
2. Clamp 82711-52090 (W) [3pcs.]
3. Clamp 82711-48070 (GR) [2pcs.]

4. Black tape [4pcs.]
5. Red tape [1pc.]

JIG

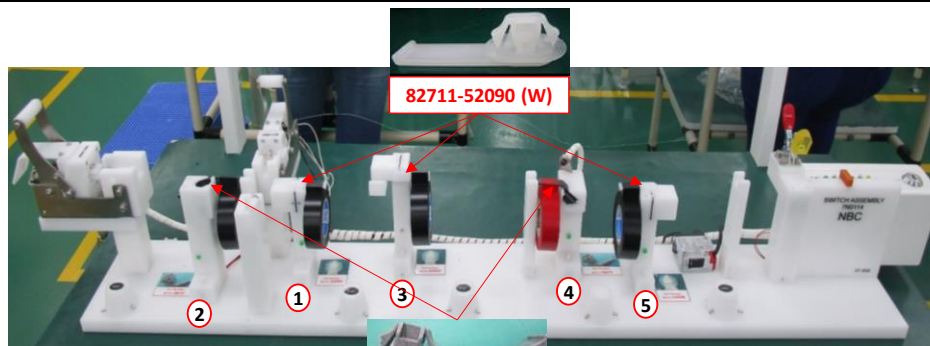
1. Taping jig

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

2

P3

Clamp setting



82711-48070 (GR)

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

1. Get **3pcs.** of clamp **82711-52090 (W)** using right hand then set to clamp location **1,3 and 5** using both hands.

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

3. Initially attach **Red tape** to clamp location **4** using both hands.

4. Initially attach **Black tape** to clamp location **2, 1, 3 and 5** using both hands.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp

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

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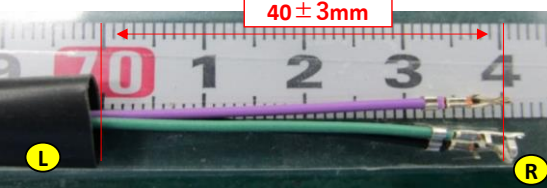
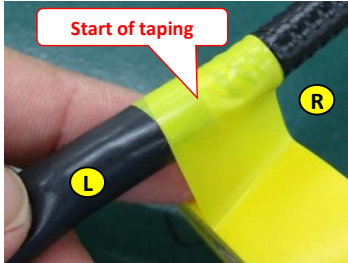
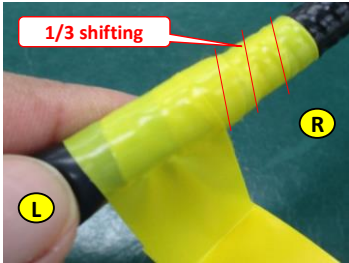
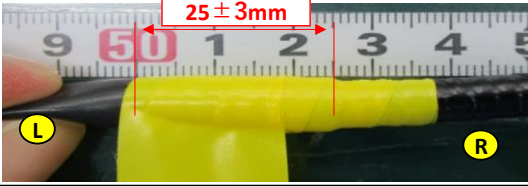

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PARTS:		1. Assy parts 2. Black sunprene tube Ø9 L=112±3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black sunprene tube Ø9 L=112±3mm	 <p>1. Get the sunprene tube $\varnothing 9$ L=112±3mm using right hand then insert the G-B-V wires using left hand.</p>	n/a	1. No wrong usage of parts
4	P3 Taping 1 Black corrugated tube to Black sunprene tube near terminal	 <p>1. Measure from end of vinyl tube up to terminal pointed tip 40 ± 3mm using both hands.</p>  <p>2. Get the Black tape using right hand then start taping process using both hands.</p>  <p>3. Wind 1/3 shifting going to sunprene tube using both hands.</p>  <p>4. Confirm measurement from end of tape up to end of tube 25 ± 3mm using both hands. Make 2 windings of tape before shifting.</p>	 <p>MEASURING TAPE</p>	<p>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINE, BUT ACTUAL SHOULD BE BLACK.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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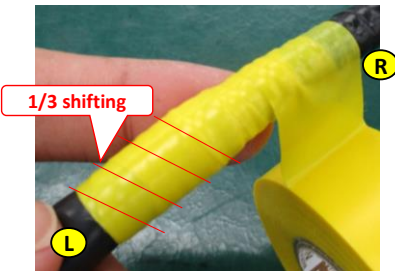
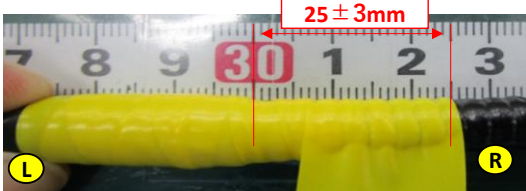

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Taping 1 Black corrugated tube to Black sunprene tube near terminal (Continuation)	 5. Wind 1/3 shifting going to COT using both hands.  6. Confirm measurement from end of vinyl tube up end of tape 25±3mm using both hands. Make 3 windings of tape before cut.  7. After taping, check the measurement and taping condition.	n/a	<div>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINE, BUT ACTUAL SHOULD BE BLACK.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>

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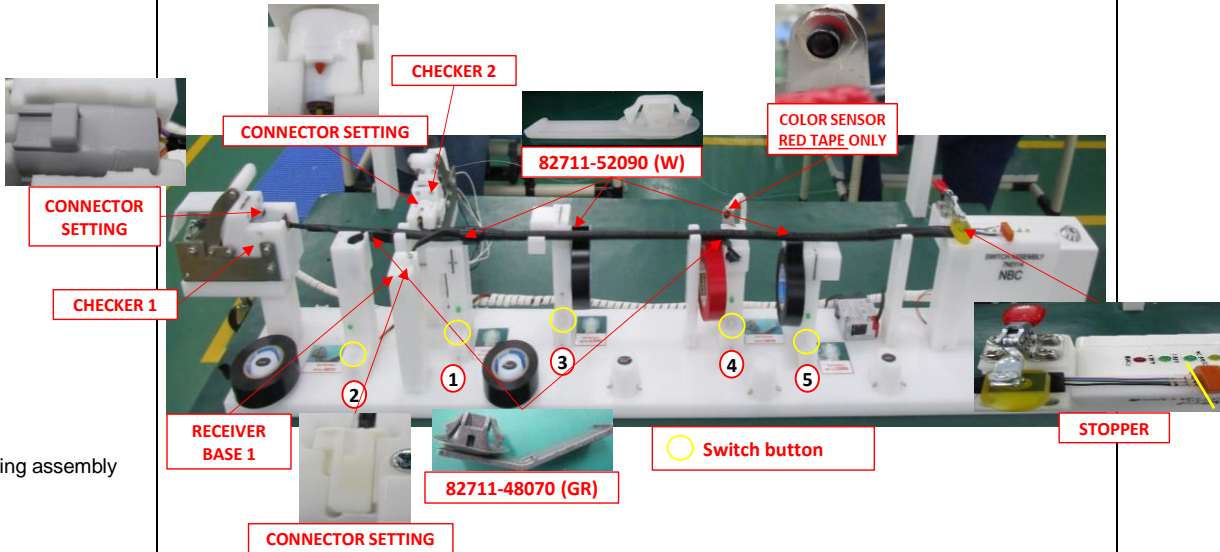

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PARTS:	1. Assy parts 2. Black tape			JIG	1. Taping assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3 Taping assembly	 <p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Third, set the connector 6098-3810 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Last, set the terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p>			 <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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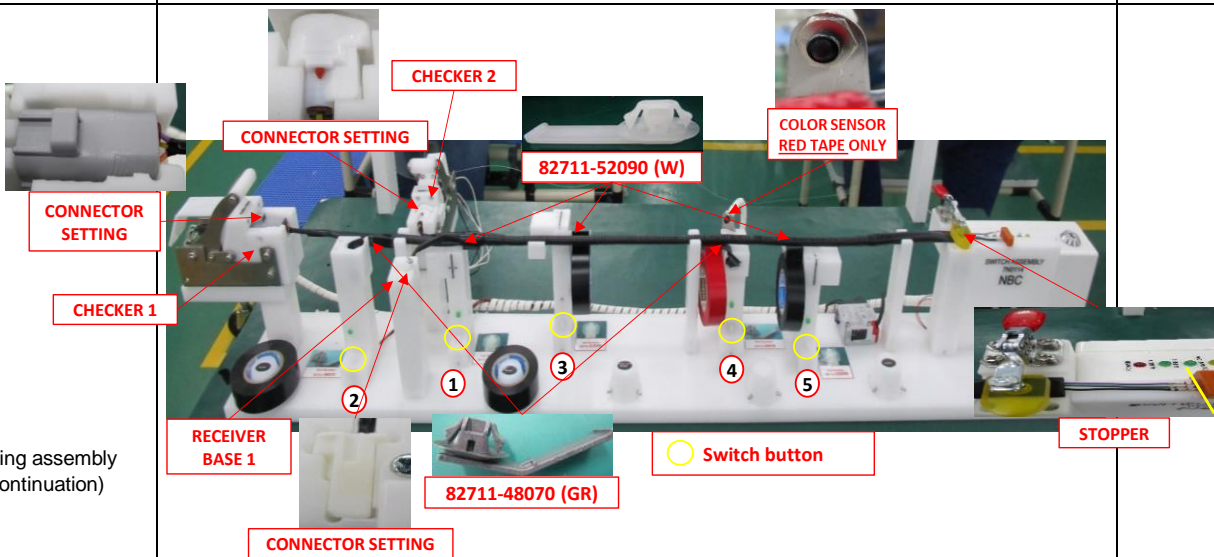

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P3 Taping assembly (Continuation)	 <p>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 2 was ON.</p> <p>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 3 was ON.</p>		 <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P3 Taping assembly (Continuation)	<p>5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</p> <p>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Color sensor light will beep/buzz if sensor detects Red tape. Press the SW button after taping. Continue the process if sequence light in clamp location 5 was ON.</p> <p>7. Hold the tape on clamp location 5. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</p>	n/a	 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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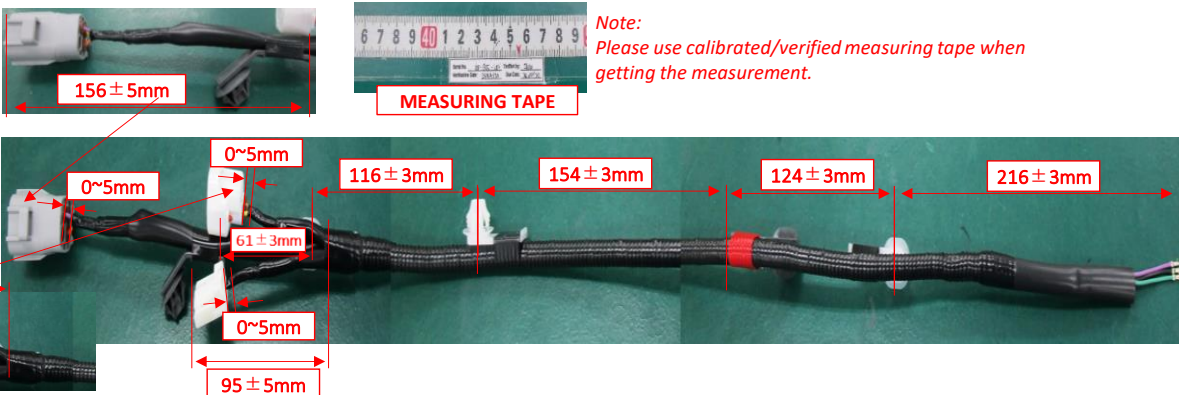
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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P3 Visual Inspection/By Two's inspection	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment and taping condition</div> <div>3. Check the terminal tip appearance. Make sure no deformed terminal.</div> 			<div>MASTER SAMPLE</div> 
7		<div>4. Compare to MASTER SAMPLE.</div> <div>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</div>  <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>			<div>NOTE: HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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