



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **550B / 7L0082-7022**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 20, 2021

Validity Date:

n/a

Document No.:

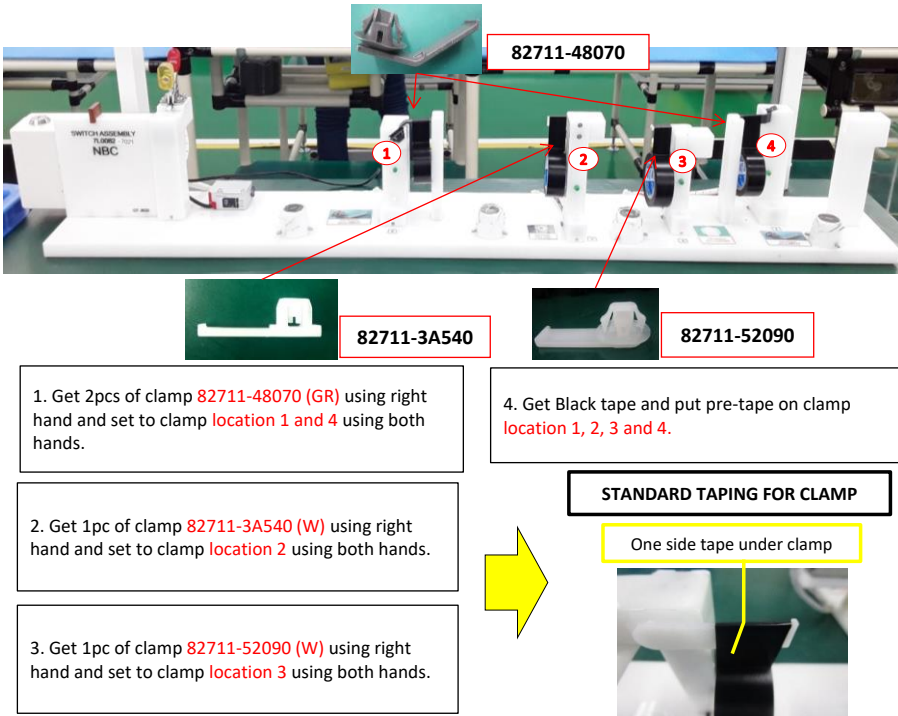
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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-48070 (GR) [2pcs]	3. Clamp 82711-3A540 (W) 4. Black tape [4pcs]	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp Assembly setting	 <div>1. Get 2pcs of clamp 82711-48070 (GR) using right hand and set to clamp location 1 and 4 using both hands.</div> <div>2. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 2 using both hands.</div> <div>3. Get 1pc of clamp 82711-52090 (W) using right hand and set to clamp location 3 using both hands.</div> <div>4. Get Black tape and put pre-tape on clamp location 1, 2, 3 and 4.</div> <div>STANDARD TAPING FOR CLAMP One side tape under clamp</div>		<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 your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Note: Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of clamp 2. No damaged clamp 2. No wrong use of tape</div>

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by:	Checked by:	Approved by:	Noted by:
05/20/21	4	Part number change from 7L0082-7021 to 7L0082-7022 due to remove taping process of Vinyl tube to wire near connector. Change connector setting sequence. Update pictures on Clamp assembly, Visual/By two's inspection and measurement.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes				
05/03/21	3	Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003. Add tape quantity. Remove validity date.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes				
07/16/19	n/a	Previously established Engineering Instruction(EI-ENG-PDE-098).Initial issue.	J. Loterte	A. Shimamura	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. date:	July 08, 2019		

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PARTS:

1. Assy parts

JIG

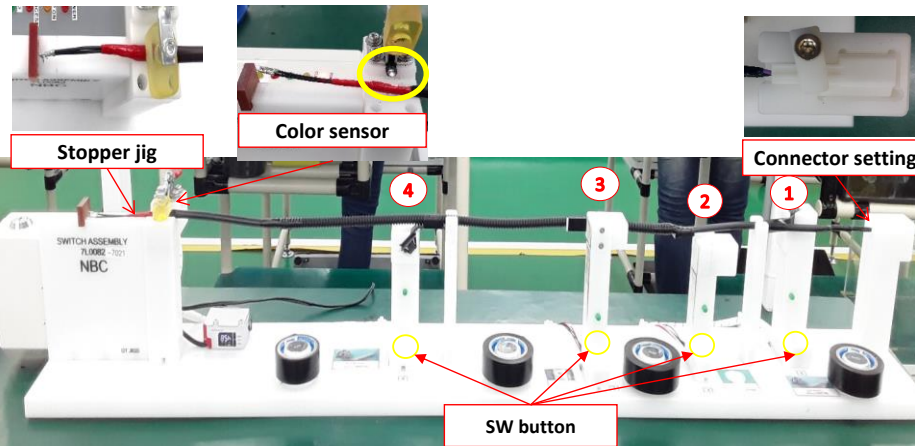
1. Clamp Assembly jig

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

2

P2

Clamp Assembly



1. Get the assy parts and set to jig using both hands. *(see above picture for correct setting)* First, put the white connector to receiver base then lock. Second, put the terminal to stopper jig and pull the toggle clamp. *Note: Beep sound will be heard if color sensor detect the RED tape.*

2. Check if all LED light for **POWER** and **CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Continue if the sequence light in **location 1** is **ON**.

3. Hold the tape on clamp **location 1** and start taping (3 windings) using both hands. Press the switch button after taping. Continue to **location 2** if light was **ON**.

4. Repeat the step 3 to clamp **location 2 and 3**. Continue to **location 4** if light was **ON**.

5. Hold the tape on clamp **location 4**, and start taping (3 windings) using both hands. Press the switch button after taping. **GO** sound will be heard.

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

n/a



Make sure no gap between terminal and stopper jig.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No tight/loose clamp attachment

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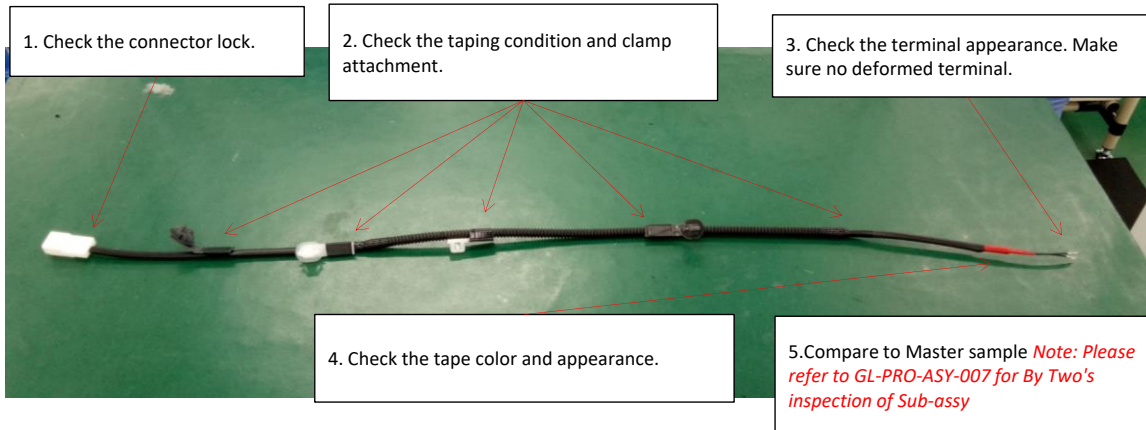

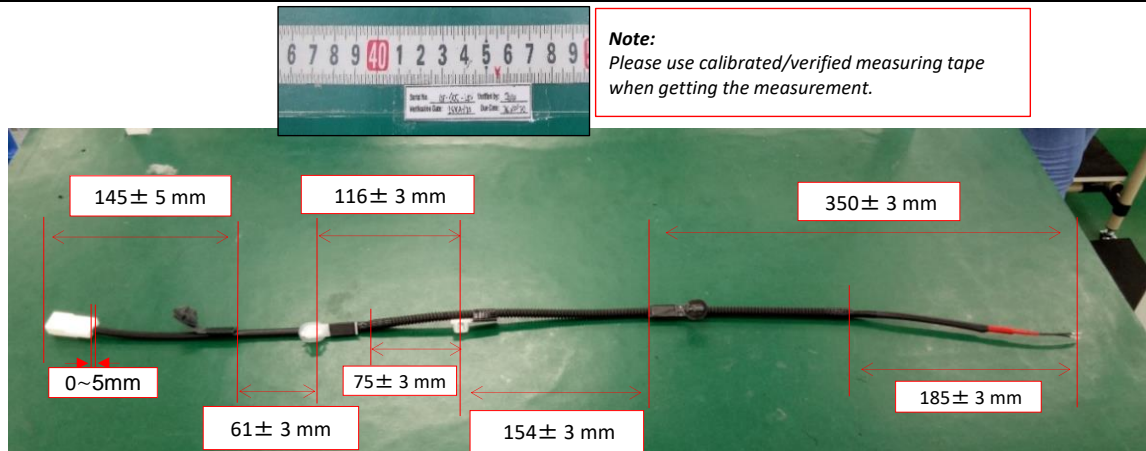
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PARTS:	N/A			JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P2 Visual Inspection			MASTER SAMPLE 	
4	P2 Measurement			For Hatsumono and Owarimono only	

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