

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Model code/Part number:

J34A / 7L0108-7020F

Customer:

TRQSS

Car Model:

MAZDA-CX

Validity Date:

n/a

Purpose:

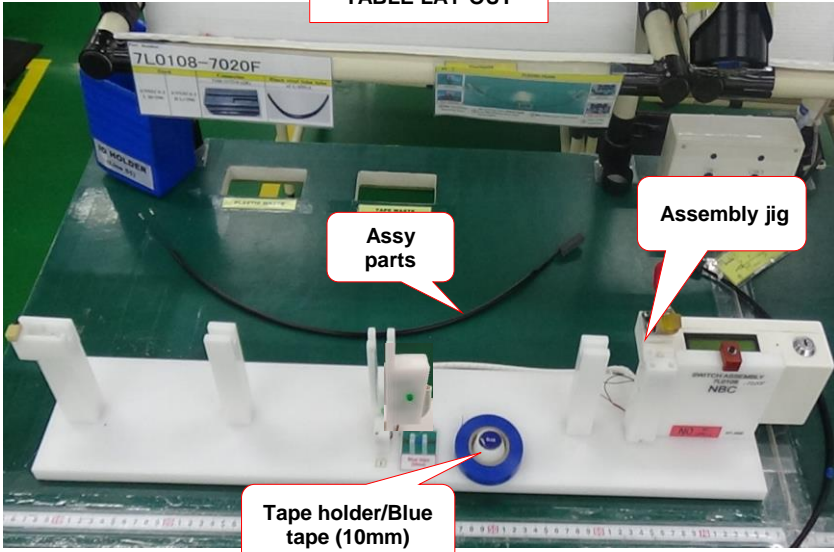
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts; Blue tape (10mm)				JIG:		1. Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	<div><p>TABLE LAY-OUT</p><p>Assembly jig</p><p>Assy parts</p><p>Tape holder/Blue tape (10mm)</p></div>				<div><p>Safety Instruction</p><p>Be sure to wear prescribed 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></div>		<div><p>1. No missing parts/tools 2. No excess parts/tools</p></div>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/02/24	2	Improved Measurement and Visual Inspection/Quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a
07/28/23	1	Additional process, measurement confirmation to prevent out of tolerance in SV tube (Vinyl) to terminal tip (DC-0723-146). Improved Clamp assembly jig to prevent missing spot tape (DC-0723-158), improvement affected by QC claim.				D.Castillo	J.Loterte	C. Villanueva	A. Arañes
07/18/23	0	Initial issue. Updated template; Inclusion of CAR MODEL "MAZDA-CX" ; Excluded process from WI-ENG-PDE-236 ; Change Process Name/ Title from TAPING ASSEMBLY PROCESS to CLAMP ASSEMBLY PROCESS ; Change Document control no. from WI-ENG-PDE-236 to WI-ENG-PDE-704 due to separation of process. Inclusion of Quality checkpoints. (Refer to ENGDRR-131)				D.Castillo	J.Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	July 18, 2023		

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DCC Stamp


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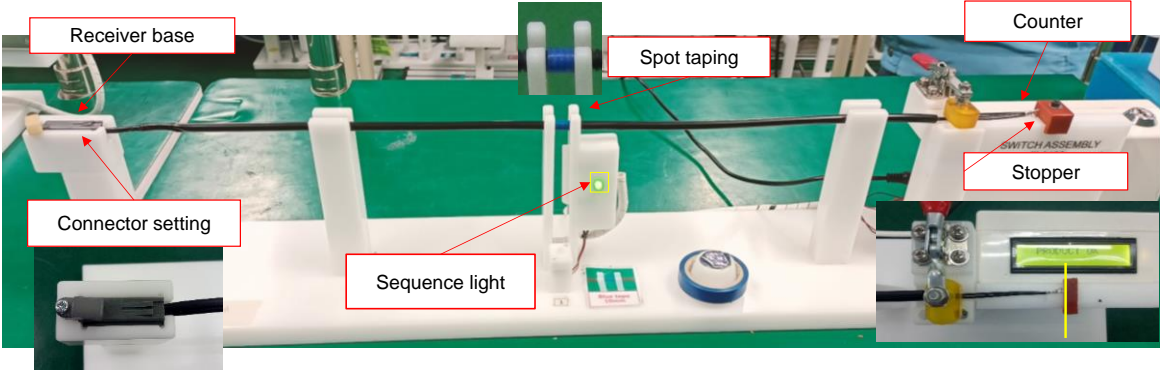
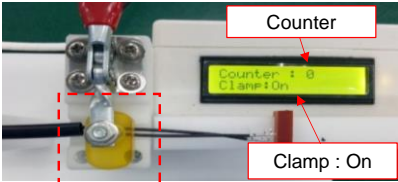
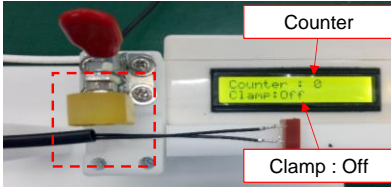
PARTS:		1. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	<div></div> <div>1.Measure from end of SV tube (Vinyl) up to terminal pointed tip 65±3mm.</div>				1.No wrong Dimension

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PARTS:		1. Assy parts 2. Blue tape (10mm)		JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	CLAMP ASSY Spot taping	<div></div> <div><p>1. Get the assy parts and set to jig using both hands. First, put the connector to Receiver base then lock. Last, set the terminal to stopper jig then pull down the toggle clamp. . Refer to the above illustration for the correct setting.</p><p>2. Check if the Clamp is ON. Check if location 1 sequence light is 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 of Location 1 is ON</p><p>3. Get the Blue tape (10mm) and start taping (3 windings only) using both hands. Press the SW button after taping. GO sound will be heard. Note: Controller will alarm if detect excessive and lacking of tape.</p><p>4. Conduct Point Checking using right hand and slowly remove the harness from jig.</p><div></div><div></div></div> <div><p>Important Reminders/Note/s:</p><p>1. Make sure no gap between terminal and stopper jig 2. Use BLUE TAPE only 3. Counter will be the basis of harness quantity per box. Only LEADER are allowed to reset the counter.</p></div>			

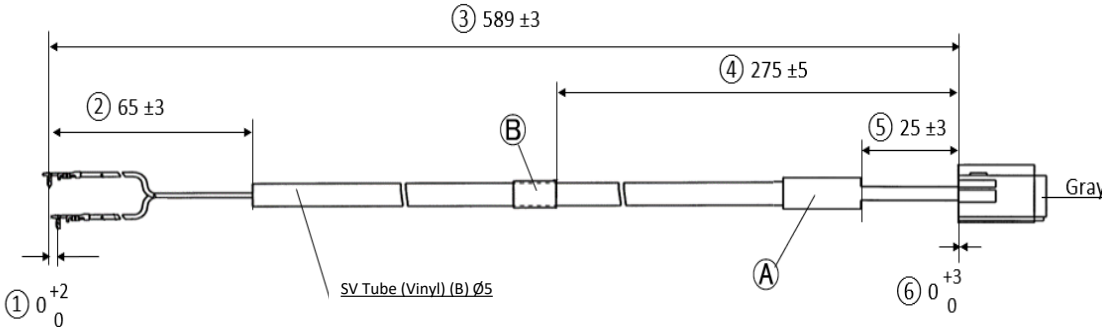

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	CLAMP ASSY	<div>Measurement</div> <div></div> <div>NOTE: A - Taping (B) B - Taping (L)</div> <div>MEASURING TAPE </div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimesion</div>		

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PARTS:

1. Assy parts

JIG:

n/a

2**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0108-7020F****1** No Missing Tape (Black Tape)

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