

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

Effectivity Date:

January 6, 2022Product Name/Code: **178D / 7N0127-7020**

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-335B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 5**PARTS:**

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-60640 (B); Black sponge tape (width=50; L=50±1mm); Black tape; Blue tape

JIG:

1. Clamp Assembly Jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div>Safety Instruction Be sure to wear prescribed 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>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Established Date:	Prepared by	Checked by	Approved by	Noted by
1/06/2021	1	Change from Pre-launch to Masspro; Improve work procedure/Illustration and quality pointers; Additional Table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
09/06/21	0	Initial issue.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					

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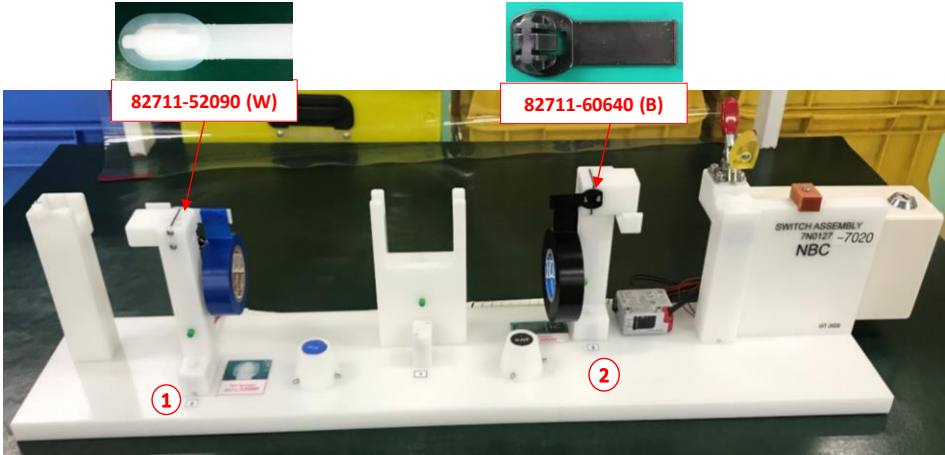

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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-60640 (B)		1. Black tape 2. Blue tape		JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	
2	P2	Clamp Setting	<div></div> <div>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</div> <div><div>1. Get 1 pc. of clamp 82711-52090 (W) then set to clamp location 1 using both hands.</div><div>2. Get 1 pc. of clamp 82711-60640 (B) then set to clamp location 2 using both hands.</div><div>3. Get the Blue tape then attach to clamp location 1 using both hands.</div><div>4. Get the Black tape then attach to clamp location 2 using both hands.</div></div>			n/a	<div><div>STANDARD TAPING FOR CLAMP</div><div>One side tape under clamp</div></div> <div>1. No loose clamp attached 2. No damage clamp 3. No wrong use of clamp 4. No damage clamp 5. No flip-out tape 6. No peel-off tape 8. No missing tape 9. No wrong use of tape</div>

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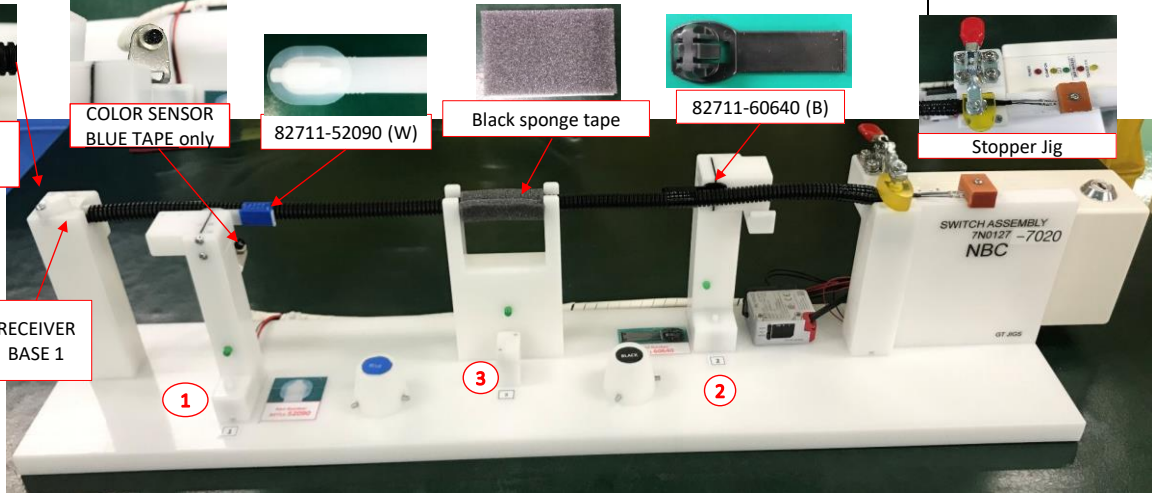

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PARTS:	1. Assy parts 2. Black sponge tape (width=50; L=50±1mm) 1. Black tape 2. Blue tape			JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	
3	P2 Clamp Assembly	 <p>1. Get the assy parts then put into jig. (<i>See above picture for correct setting</i>). First, set the connector 6189-0451 (W) to Receiver base 1. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Blue tape. Last, set the end of GR-B/W wire together within the stopper then press by Toggle clamp then continue if the sequence light on clamp location 1 was ON.</p> <p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON. SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p> <p>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Continue the process on clamp location 2.</p> <p>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Continue the process on attachment of sponge tape. (<i>Proceed on next page for the instruction of sponge tape attachment.</i>)</p> <p>5. Conduct POINT CHECKING before removing the harness from jig.</p>		 <p>Make sure no gap between terminal and stopper jig</p> <p>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of clamp/tape</p>	

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PARTS:

1. Black sponge tape (width=50; L=50±1mm)

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

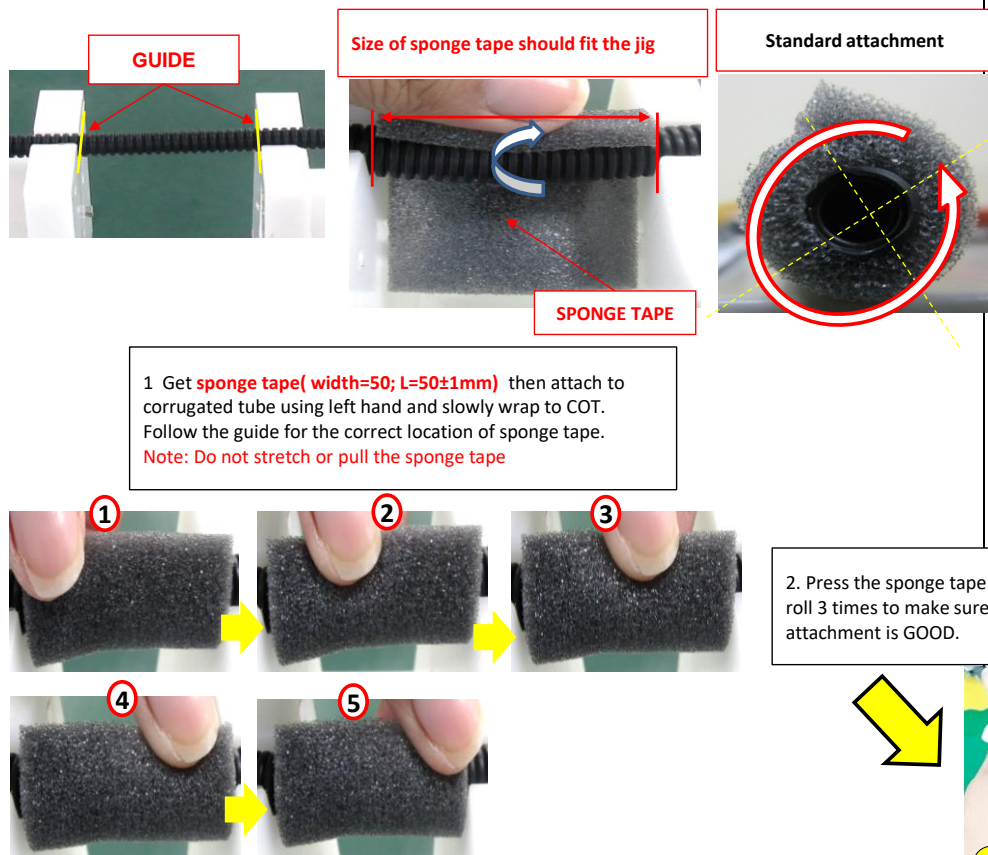
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

4

P2

Sponge Tape Attachment



1 Get **sponge tape(width=50; L=50±1mm)** then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape.
Note: Do not stretch or pull the sponge tape

2. Press the sponge tape using both palm and roll 3 times to make sure that the sponge tape attachment is GOOD.

n/a

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JIG

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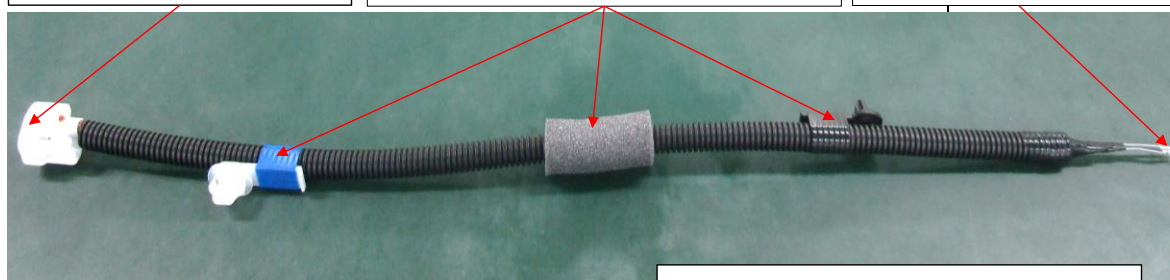
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

Visual/By Two's
Inspection

P2

1. Check the double lock connector.

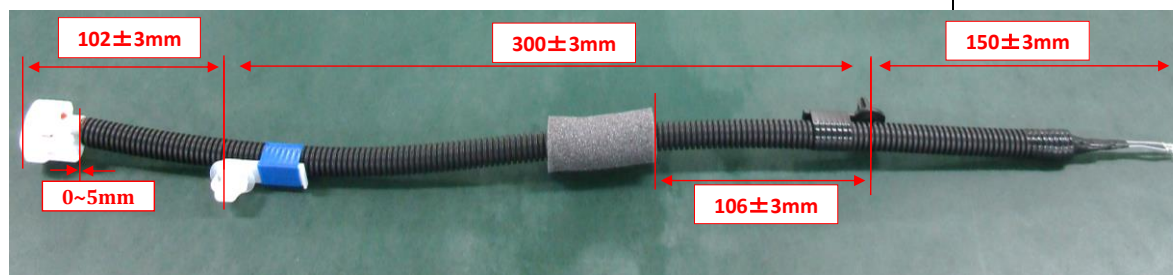
2. Check the taping condition, clamp attachment,
sponge tape attachment and alignment.3. Check the terminal appearance,
make sure no deformed terminal.

4. Compare to Master Sample

*Note: Please refer to GL-PRO-ASY-007 for By Two's
Inspection of Sub-Assy***MASTER SAMPLE**

6

Measurement

MEASURING TAPE**Note:**Please use calibrated/verified measuring tape
when getting the measurement.**NOTE: FOR HATSUMONO
AND OWARIMONO**

1. No wrong dimension

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