



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

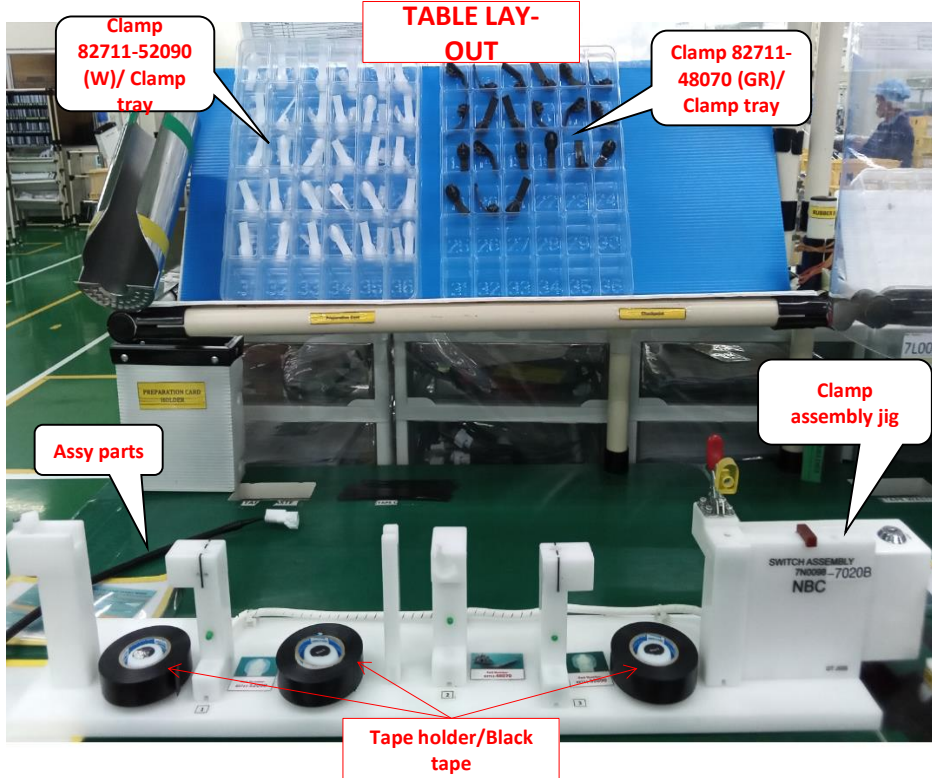
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **101D / 7N0098-7021** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	All parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [3pcs]	JIG	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	 <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level 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	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
03/02/22	0	Initial Issue	M.Ariola	J.Loterte	C.Villanueva	A. Arañes	March 2, 2022	M.Ariola	J.Loterte	C.Villanueva	A. Arañes

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PARTS:

1. Assy parts
2. Black tape

JIG

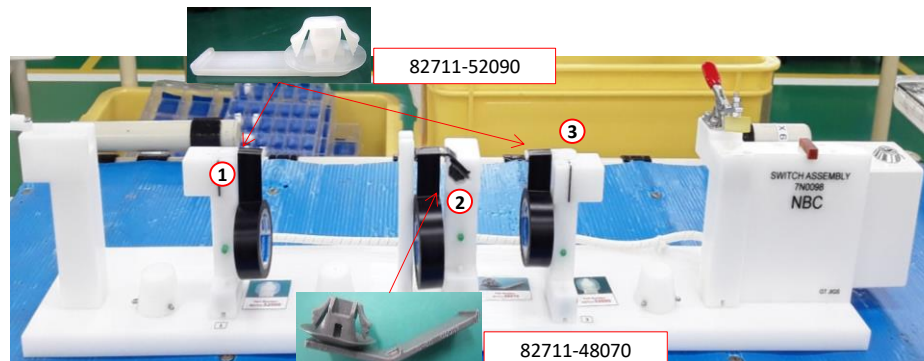
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P2

Clamp assembly setting



1. Get 2 pcs of clamp **82711-52090 (W)** using right hand and set to clamp location **1** and **3** using both hands.

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

3. Get black tape using right hand and conduct pre taping from clamp location **1~3**.



n/a

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

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

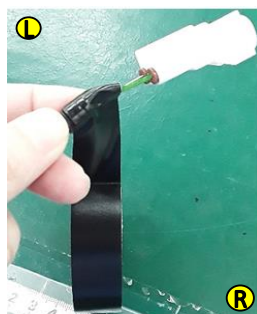
TOOLS/PPE

QUALITY POINTERS

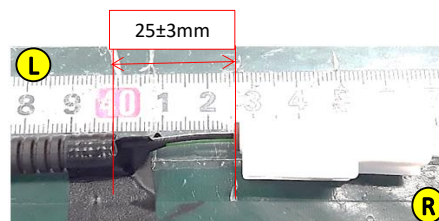
3

P2

Taping COT to wire near connector

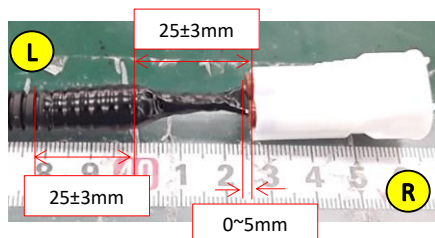


1. Hold the COT using left hand. Get Black tape using right hand and conduct pre taping.



2. Measure the end of COT to connector 25mm and continue taping process.

Note: Refer to WI-PRO-ASY-001 for taping procedure.



3. After taping, check the dimension, taping condition and wire alignment.

MEASURING TAPE



Note:
Please use calibrated/verified measuring tape when getting the measurement.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape

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PARTS:		1. Assy parts			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assy	<div></div> <div><p>1. Get the assy parts using both hands. First, put the connector into receiver base using right hand and lock using left hand. Second, put the terminal to stopper jig using right hand and pull down the toggle clamp using left hand. <i>Refer to above illustration for the correct setting.</i></p><p>2. Check the LED light for POWER, CLAMP and SEQUENCE Light in clamp location 1 is ON. If encountered abnormality, STOP the process, CALL the attention of the Leader and WAIT for instruction.</p><p>3. Proceed the taping from clamp location 1, 2 and 3. Make 3 windings and cut the tape. Press the switch button after every taping. Go sound will be heard after pressing the switch button in location 3.</p><p>4. Conduct POINT CHECKING using right hand before removing from jig.</p></div>		n/a	<div><p><i>Make sure NO GAP between terminal and stopper jig.</i></p></div> <div><p>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</p></div>

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PARTS:

n/a

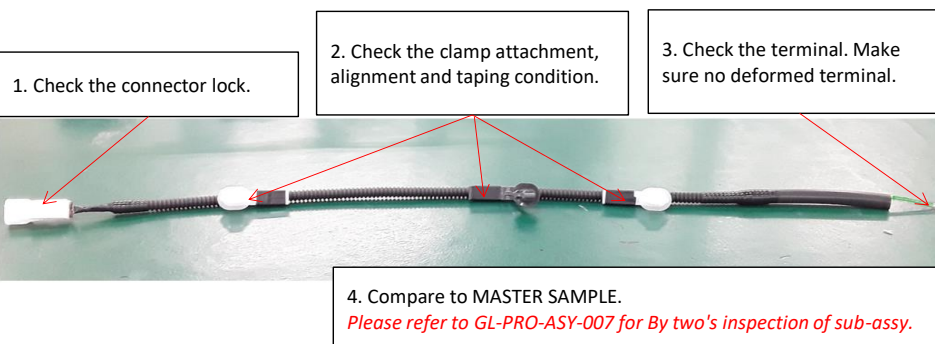
JIG

n/a

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5

Visual/By two's inspection



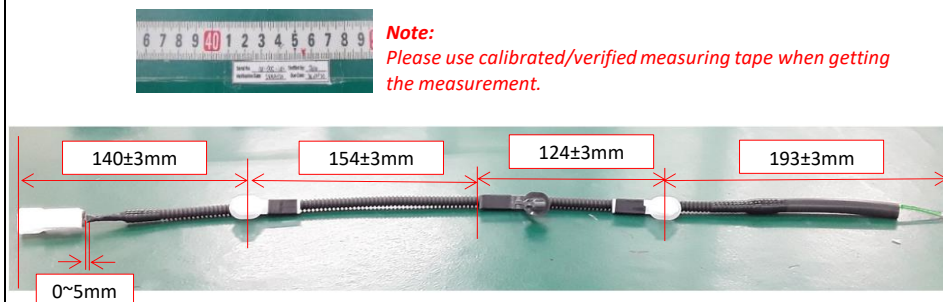
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6

P2

Measurement



n/a

**FOR HATSUMONO AND
OWARIMONO**

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