

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

Effectivity Date:

June 14, 2023Model Code/Product Number: **200D / 7R0130-7022**Customer: **TRMX**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-694

Revision No.:

0

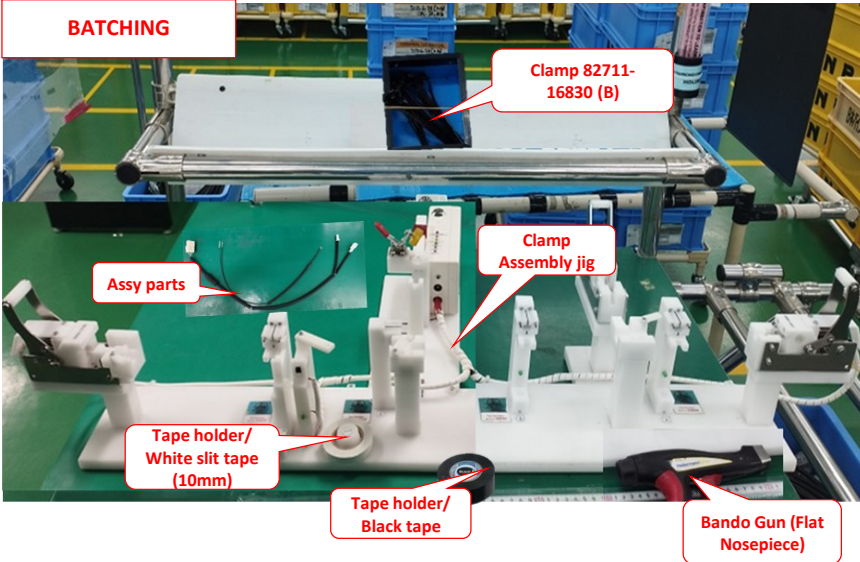
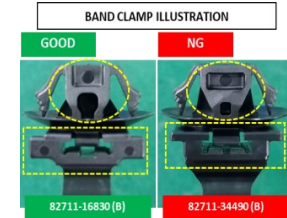
Page No.:

1 of 11**PARTS:**





1. Assy parts; Clamp 82711-16830 (B); White Slit tape (10mm); Black tape

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools  Important reminders/Note/s 1. Please check the clamp first before start assembly to avoid wrong use of clamp.

Revision History

Eff.Date	Rev.No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/14/23	0	Initial Issue. Changed Process Name/Title from "TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS"; Changed Document control number from WI-ENG-PDE-563C to WI-ENG-PDE-694 due to separation of Process	M. Ariola	J. Loterte	C. Villanueva	A.Arañes	 M. Ariola	 J. Loterte	 C. Villanueva	 A. Arañes

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PARTS:

1. Assy parts
2. Clamp 82711-16830 (B) [4pcs]

3. White slit tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

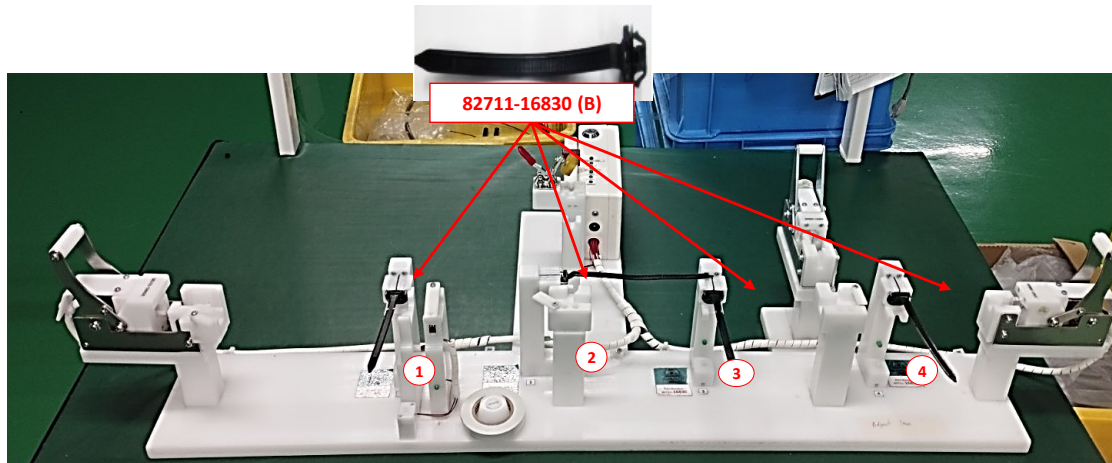
TOOLS/PPE

QUALITY POINTERS

2

n/a

Clamp setting



1. Get **2pcs** of Band clamp **82711-16830 (B)** using right hand and set to clamp location **1** and **2** using both hands.

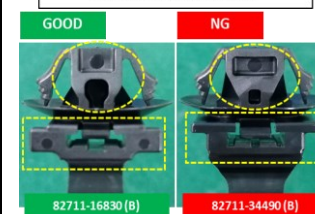
2. Get **2pcs** of Band clamp **82711-16830 (B)** using right hand and set to clamp location **3** and **4** using both hands.

1. No wrong use of clamp
2. No damaged clamp
3. no damaged clamp

Important reminders/Note/s:

1. Please check the clamp first before start assembly to avoid wrong use of clamp.

BAND CLAMP ILLUSTRATION



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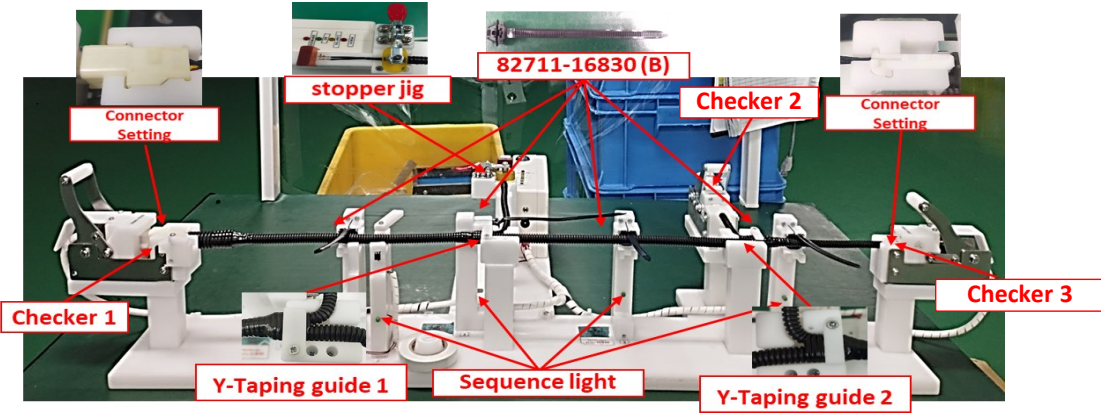


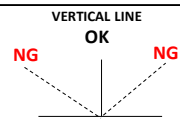
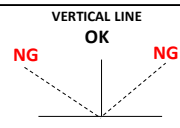

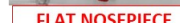
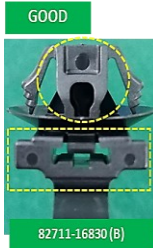
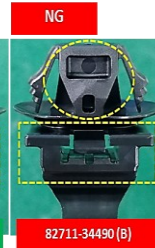


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PARTS:		1. Assy parts 2. Clamp 82711-16830 (B) [4pcs]		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly			
		<div></div> <div><p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the white connector 7282-1060 (W) to Checker 1 and lock. Second, set the Y-taping 1 to Y-Taping guide 1 and lock then set Y- Taping 2 to Y-Taping guide 2 and lock. Next set the white connector 6098-6662 (W) to Checker 2 and then pull the checker fixture for continuity checking. Third, set the white connector 6098-3802 (W) to Checker 3 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the B-B wires together within stopper then press by toggle clamp.</p><div><div><p>2. Check if LED light for POWER, CLAMP,and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction</p></div><div><p>3. Initially tighten the clamp on location 1, 2, 3 and 4 using both hands.</p></div></div><div><div><p>PROPER CUTTING POSITION OF BANDO GUN</p></div><div><p>IMPROPER CUTTING POSITION OF BANDO GUN</p></div><div><p>VERTICAL LINE OK</p></div><div><p>NG</p></div><div><p>BANDO GUN</p></div><div><p>FLAT NOSEPIECE</p></div></div></div>			<div><p>1. No wrong use of clamp 2. No damaged clamp 3. no damaged clamp</p><p><i>Important reminders/Note/s:</i></p><p>1. Please check the clamp first before start assembly to avoid wrong use of clamp.</p><div><p>BAND CLAMP ILLUSTRATION</p><div><p>GOOD</p></div><div><p>NG</p></div></div><div><p>BANDO GUN ILLUSTRATION</p><div><p>GOOD</p></div><div><p>NG</p></div></div></div>

1. No wrong use of clamp
2. No damaged clamp
3. no damaged clamp

Important reminders/Note/s:

1. Please check the clamp first before start assembly to avoid wrong use of clamp.

BAND CLAMP ILLUSTRATION

GOOD



NG



82711-16830 (B) 82711-34490 (B)

BANDO GUN ILLUSTRATION

GOOD



NG



FLAT NOSEPIECE EXTENDED NOSEPIECE

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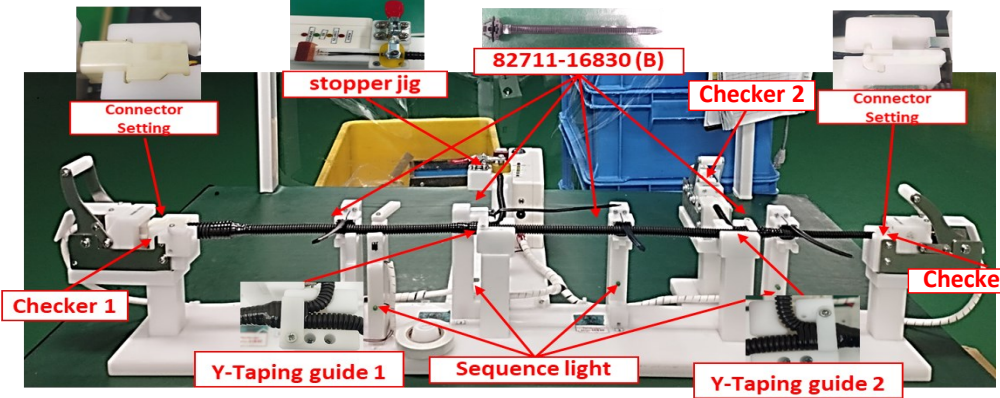
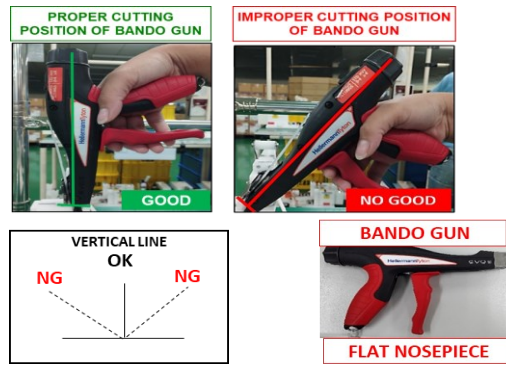
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PARTS:	1. Assy parts 2. Clamp 82711-16830 (B) [4pcs]			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Clamp Assembly (Continuation)	 <p>4. Get the Bando Gun using right hand and cut the band clamp on location 1 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp</p> <p>5. Cut the band clamp on clamp location 2 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 3 was</p> <p>6. Cut the band clamp on clamp location 3 using both hands. Press the SW button after cutting of band</p> <p>7. Cut the band clamp on clamp location 4 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 5 was</p> 			<p>1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment</p> <p>Important reminders/Note/s:</p> <p>1. Please check the clamp first before start assembly to avoid wrong use of clamp.</p> <p>2. Setting of band clamp cutter must be 3.0 for both COT $\phi 5$ and $\phi 7$.</p>

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PARTS:

1. Assy part
2. White Slit tape (10mm)

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

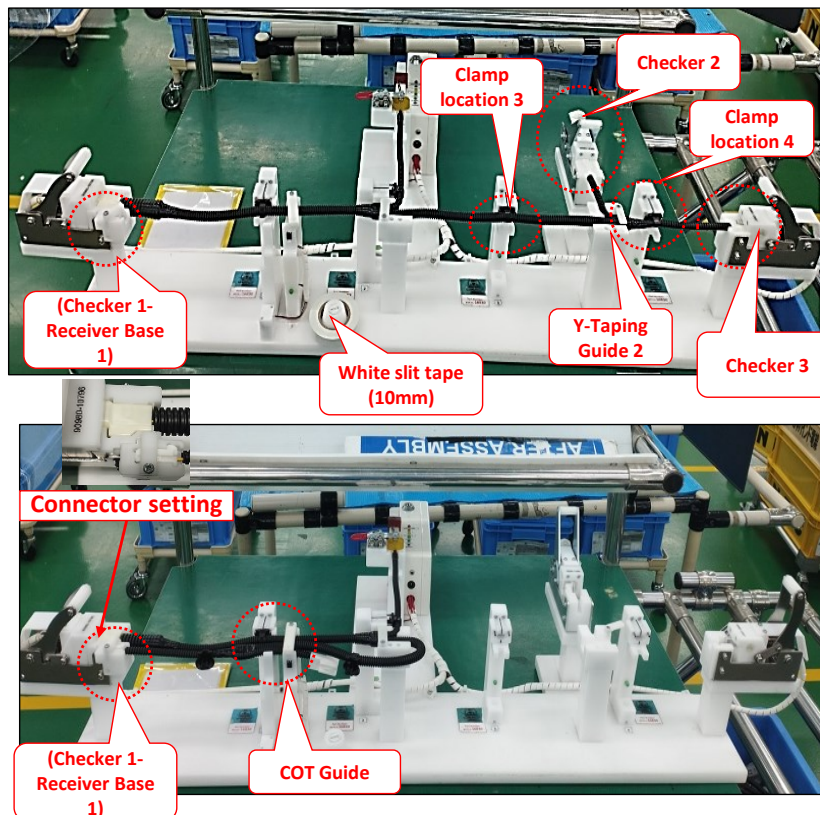
TOOLS/PPE

QUALITY POINTERS

3

n/a

Clamp Assembly
(Continuation)



7. After attachment of clamps, initially remove the connector **6098-3802 (W)** from **checker 2**, second remove the Connector **6098-6662(W)** from **checker 3**. Third, remove the clamp in location **4** and unlock the Y-taping Guide **(2)** lock then clamp location **3**.

8. After removal, put the connector **6098-6662 (W)** to connector **receiver base 1** and continue to set the harness to COT guide then lock.

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

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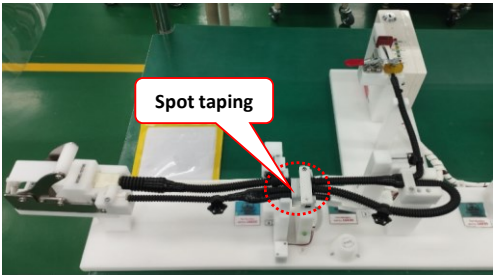
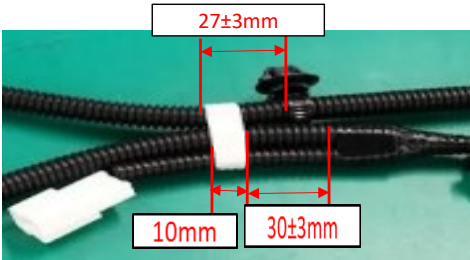
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PARTS:		1. Assy part 2. White Slit tape (10mm)		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly (Continuation)			
		<div><div></div><div></div></div> <div>9. Get the White slit tape (10mm) conduct spot taping (2 winds) then cut the tape.</div> <div>10. Conduct point checking before removing of harness.</div> <div></div> <div>11. Remove the harness. First, remove connector from checker 1 to connector receiver base 1. Second, pull the toggle clamp and remove clamp location 2. Third, unlock the y-taping guide lock then remove the y-taping. Last, unlock the spot taping guide lock then remove clamp location 1.</div> <div>12. After Spot taping, check the measurement, alignment and tape condition.</div>			1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape

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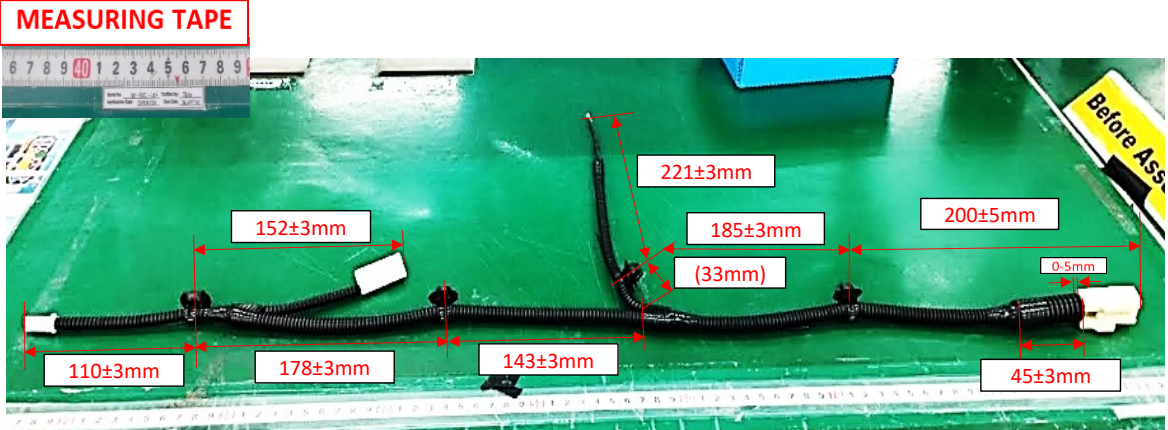
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PARTS:		n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	n/a	Measurement 1 (Straight harness)				1. No wrong Dimension Important reminders/Note/s: 1. For Hatsumono and Owarimono 2. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

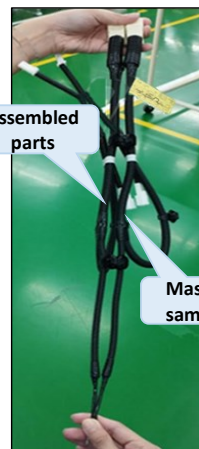
TOOLS/PPE

QUALITY POINTERS

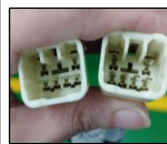
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n/a

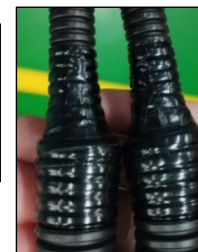
Visual/By two's Inspection



1. Conduct **alignment of harness (Master sample vs. assembled parts)** using both hands.



2. Check the **connector lock, terminal, insertion** and **taping condition.**



3. Check the **taping condition.**



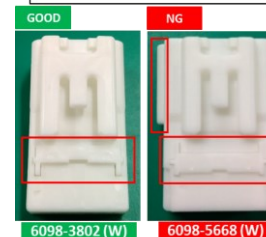
4. Check the **connector lock, terminal** and **insertion.**

MASTER SAMPLE



1. No skip checking during inspection.

CONNECTOR ILLUSTRATION



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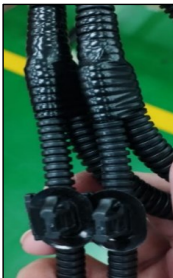



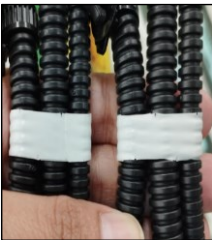



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PARTS:		1. Assembled parts 2. Master sample			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Visual/By two's Inspection (Continuation)	<div><div>ACTUAL PRODUCT</div></div> <div><div>5. Check the Y-Taping condition and presence of band clamp cut condition.</div><div>7. Check the taping condition and terminal appearance. Must be no deformed terminal.</div><div><div>6. Check the Spot taping condition, color of tape (White Slit tape 10mm), and presence of band clamp cut condition.</div></div></div>			<div>MASTER SAMPLE</div>  <div>1. No skip checking during inspection.</div> <div>Important reminders/Note/s:</div> <div>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-16830 (B)</div></div><div><div>NG</div><div>82711-34490 (B)</div></div></div>

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PARTS:

n/a

JIG

n/a

NO.

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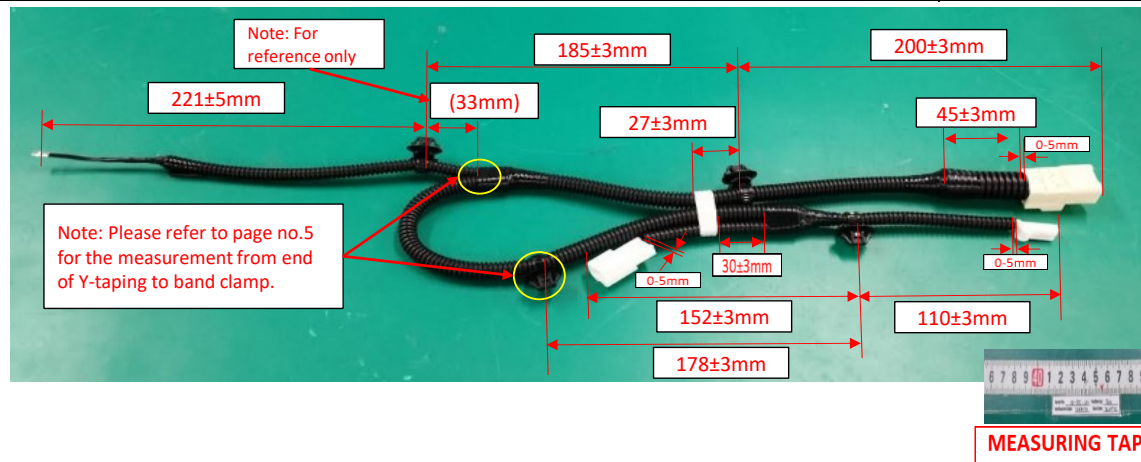
TOOLS/PPE

QUALITY POINTERS

7

Measurement 2
(Sub-Assy finished
product)

n/a



1. No wrong Dimension

Important reminders/Note/s:

1. For Hatsumono and Owarimono

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

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PARTS:

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JIG

n/a

QUALITY CHECKPOINTS

n/a

7R0130-7022

①



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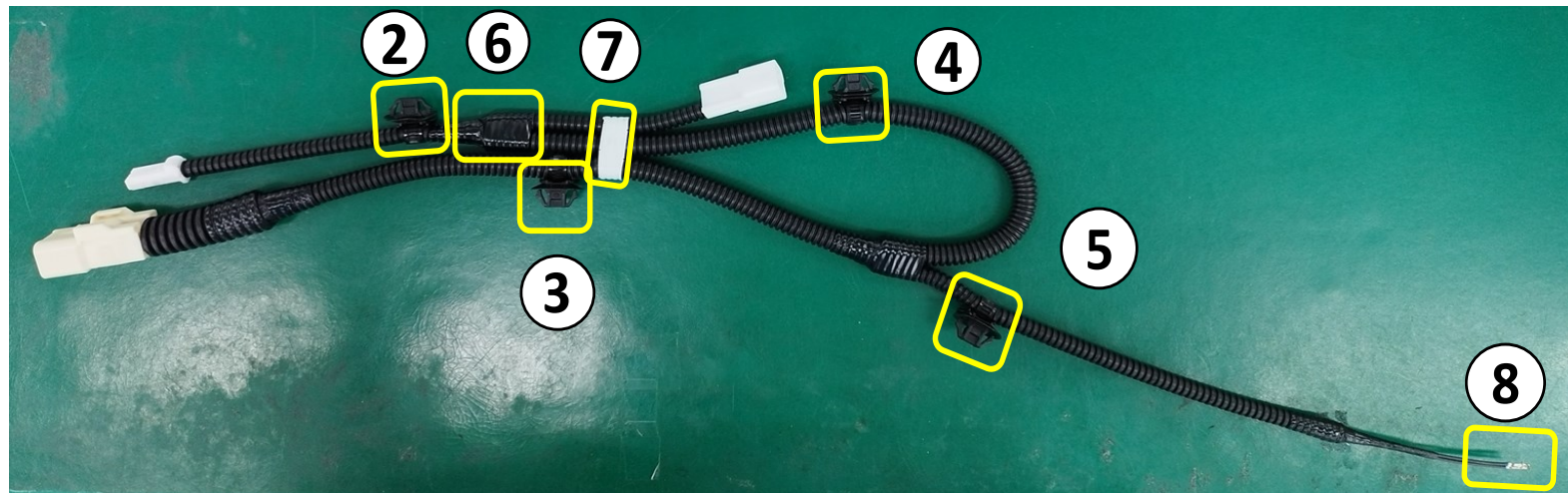
NO GOOD



GOOD



NO GOOD



① No **Unlock/Halflock Connector**

② ③ ④ ⑤ No **Missing Band Clamp**

⑥ No **Missing tape**

⑦ No **Missing Spot Tape**

⑧ No **Deformed Terminal**

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