

	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 9, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:				Document No.:		WI-ENG-PDE-224B	
	Product Name/Code: <b>587B / 7M0533-7020</b>		Customer: <b>TRJ</b>		Revision No.:		5	Page No.: 1 of 5
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO								

<b>PARTS:</b>	1. Clamp 82711-52090 (W) [4pcs] 2. Clamp 82711-3A540 (W) <span style="margin-left: 100px;">5</span> 3. Clamp 82711-34490 (B) 4. Black tape [4pcs] <span style="margin-left: 100px;">5</span> 5. Yellow tape	JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp assembly setting	<div style="text-align: center;"> </div> <div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 45%;"> <p>1. Get 4 pcs of clamp <b>82711-52090 (W)</b> using right hand and insert to clamp location <b>1, 2, 5</b> and <b>6</b> using both hands.</p> <p>2. Get 1 piece of clamp <b>82711-3A540 (W)</b> using right hand and insert to location <b>3</b> using both hands.</p> <p>3. Get 1 piece of clamp <b>82711-34490 (B)</b> using right hand and insert to location <b>4</b> using both hands.</p> </div> <div style="width: 45%;"> <p>4. Initially attach <b>Yellow tape</b> on clamp location <b>5</b> using both hands.</p> <p>5. Initially attach <b>Black tape</b> on clamp location <b>1, 2, 3</b> and <b>6</b> using both hands.</p> <div style="text-align: center; margin-top: 10px;"> <div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>STANDARD TAPING FOR CLAMP</b>            One side tape under clamp         </div> </div> </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape

Revision History							Prepared by		Reviewed by	Approved by	Noted by
07/08/21	5	Removal of validity date; add tape quantity; rephrase the instruction for band clamp cut.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
01/20/21	4	Transfer process owner from Production (WI-PRO-ASY-059B) to Engineering (WI-ENG-PDE-224B); Improve the clamp assy setting procedure and illustration as well as the Taping of COT to wire.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
03/03/20	3	Removal of marking	A. Roxas	W. Carbillon	O. Merin	n/a					
11/03/17	0	Initial issue.	J. Montealto/ L. Briones	O. Merin	T. Sugiyama	n/a					
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Note	Est. Date:	November 3, 2017			

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## TAPING ASSEMBLY PROCESS

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Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Assy parts
2. Black tape

### JIG

n/a

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

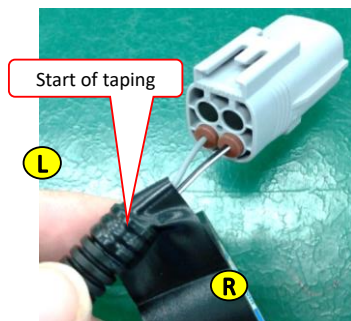
### TOOLS/PPE

### QUALITY POINTERS

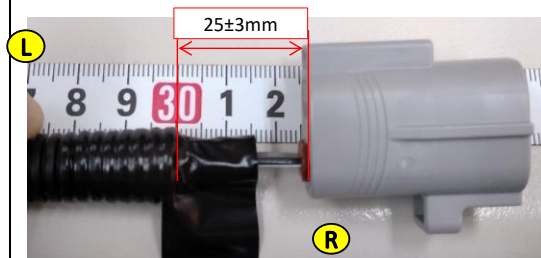
2

P2

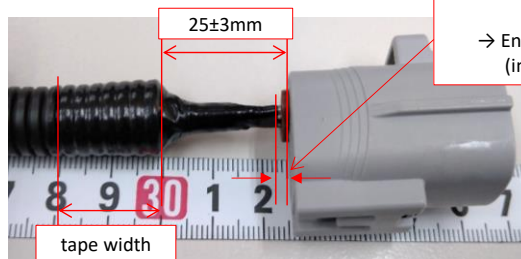
Taping  
COT to wire near  
connector



1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.



2. Measure from end of corrugated tube up to connector **25±3mm** then continue the taping process using both hands.  
*Refer to WI-PRO-ASY-001 for taping procedure.*



Note: 0~5mm  
→ End tape up to connector  
(includes rubber seal)

3. After taping, check the measurement, and taping condition.

### MEASURING TAPE



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

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## PARTS:

1. Assy parts

## JIG

1. Bando Gun
2. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

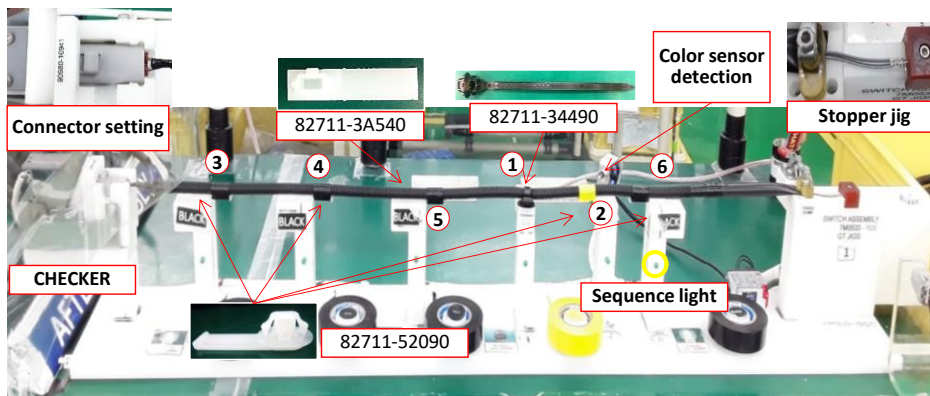
## TOOLS/PPE

## QUALITY POINTERS

3

P2

Clamp assembly



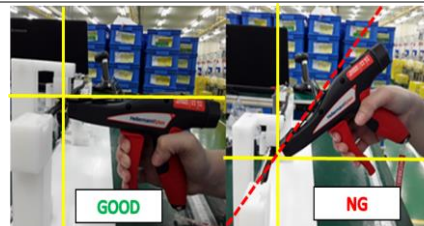
1. Get the assy parts using both hands and set to jig. First put the connector to checker using right hand and pull down the checker using left hand to check if properly locked. Second, put the terminal into stopper jig using left hand and then pull down the toggle clamp using right hand.  
*Refer to the above illustration for the proper setting.*

3. Initially tighten the Band clamp on clamp location 1 using both hands.



2. Check the LED light for **POWER, CLAMP** and **SEQUENCE LIGHT** on clamp location 1 is **ON**. If encountered abnormality, **STOP** the process, **CALL** the attention of the Leader and **WAIT** for instruction.

4. Get the Bando Gun using right hand. Cut the Band clamp on clamp location 1 using both hands. Press the SW button after cutting. Follow the sequence light for the next process.

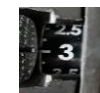


## BANDO GUN



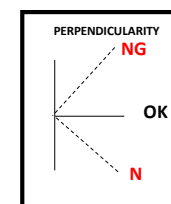
**Make sure no Gap between terminal and stopper jig**

- 1.No wrong use of clamp
- 2.No damaged clamp
3. No wrong setting of bando gun



**Fixed setting of band clamp cutter: 3 ~ 4**

## BANDO GUN ALIGNMENT



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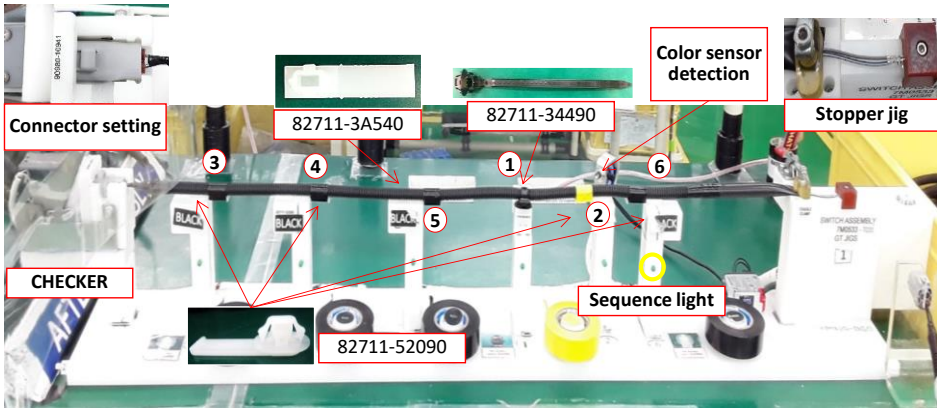

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PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp assembly (continuation)	<div></div> <div>5. Conduct taping on clamp location 2 using both hands. Make 3 winds. Beep sound will be heard if the color sensor detects the Yellow tape. Press the SW button after taping.</div> <div>6. Proceed the taping process on clamp location 3, 4, 5 and 6. Make 3 winds. Press the SW button after every taping. Go sound will be heard after taping on clamp location 6.</div> <div>7. Conduct POINT CHECKING before removal from jig using right hand.</div>	n/a	<div></div> <p>Make sure no Gap between terminal and stopper jig</p> <div>1. No wrong use of tape 2. No missing tape 3. No peel-off tape</div>

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Visual/By two's inspection

1. Check the connector if properly locked.

2. Check the clamp attachment, alignment and taping condition.

4. Check the terminal condition. Make sure no deformed terminal.

3. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.

0 - 2 mm

5. Compare to Master Sample  
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy*

MASTER SAMPLE

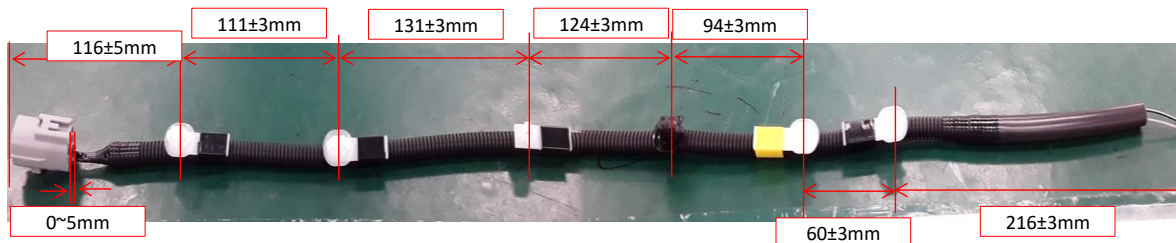


P2

Measurement



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



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