

	WORK INSTRUCTION						Effectivity Date:		March 11, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		-	
	Process Name/Title:				Model Code/Product Number: 241B / 7L0048-7023		Customer: TRQSS		Document No.: WI-ENG-PDE-452C	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1	

PARTS:	1. Assy parts; Clamp 82711-48240 (W);Clamp 82711-16820 (BR); Clamp 82711-34490 (B); Clamp 82711-52090 (W); Black tape	JIG:	1. Clamp assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Table-Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; display: inline-block;">Table Lay-out</div> <p>Clamp 82711-48240 (W)/Clamp Tray</p> <p>Clamp 82711-16820 (BR)</p> <p>Clamp 82711-34490 (B)</p> <p>Clamp 82711-52090 (W)/ Clamp Tray</p> <p>Assy part</p> <p>Bando Gun</p> <p>Clamp Assembly Jig</p> <p>Black Tape/Tape holder</p>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> 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										
03/11/22	1	Change Pre-launch to Masspro.	K. Doria	J. Loterte	C. Villanueva	A. Arañes	Prepared by 	Checked by 	Approved by 	Noted by
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	March 08, 2022		

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PARTS:

1. Clamp 82711-16820 (BR)
2. Clamp 82711-34490 (B)

3. Clamp 82711-52090 (W)

JIG

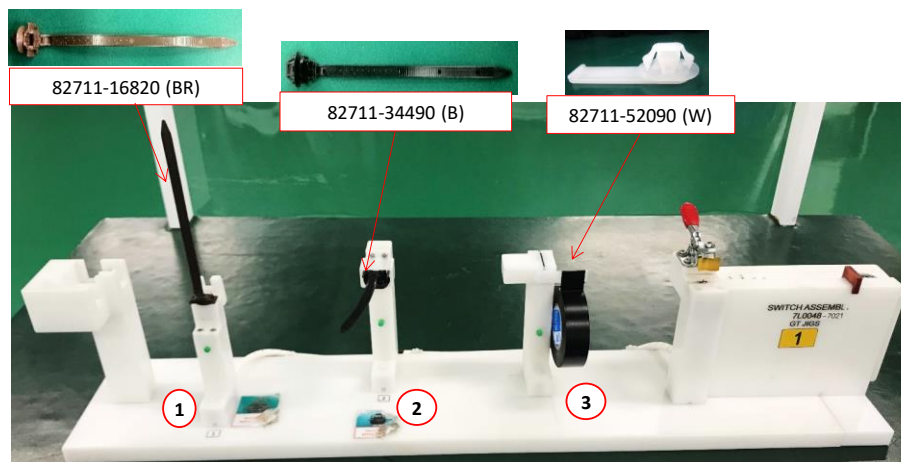
1. Clamp assembly jig

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

2

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Clamp Assembly setting



1. Get 1pc of Band clamp **82711-16820 (BR)** using right hand and set to clamp location **1**.

2. Get 1pc of Band clamp **82711-34490 (B)** using right hand and set to clamp location **2**.

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

4. Initially attached the black tape on clamp location **3**.

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

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PARTS:

1. Assy parts
2. Clamp 82711-48240 (W)

JIG

1. Clamp attachment holder jig

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

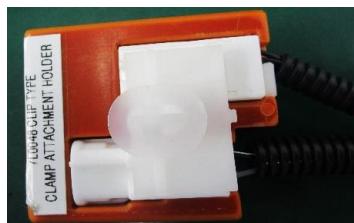
3

P3

Clamp Attachment

CONNECTOR SETTING

1. Set the 2 connectors into clamp holder jig using both hands.
Follow the above illustration for the correct setting.

**Pushing direction**

2. Hold the clamp using right hand, strongly push the clamp, sound will be heard if fully inserted.

3. After inserting the clamp, remove the 2 connectors from clamp holder jig using both hands.
Check the clamp attachment.

Clamp Attachment Holder jig

1. No wrong attachment of clamp
2. No damage on parts
3. No unlock attachment

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Clamp Assembly

82711-16820 82711-34490 82711-52090 (W) Stopper jig

Sequence Light

Connector Setting

1. Get the assy parts using both hands. Put first the connectors to receiver base, second, put the terminal/PCB to stopper jig then pull down the toggle clamp using right hand.
Refer to above illustration for the correct setting.
Check if LED for **POWER, CLAMP** and **SEQUENCE** light in clamp location 1 is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

2. Initially tighten the band clamp from location 1~2 using both hands.

3. Get the bando gun and cut the band clamp on location 1. Press the switch button after cutting. Continue to location 2 if light was **ON**.

4. Cut the band clamp on location 2. Press the switch button after cutting. Continue to location 3 if light was **ON**.

5. Hold the tape on clamp location 3, and start taping (3 windings) using both hands. Press the switch button after cutting. **GO** sound will be heard.

6. Conduct POINT CHECKING before removing from clamp assembly jig.

Bando Gun

Note:
Make sure no gap between stopper jig and PCB

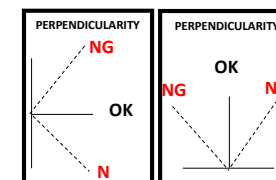


1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp



Fixed setting
of band
clamp cutter:
3 ~ 4

BANDO GUN



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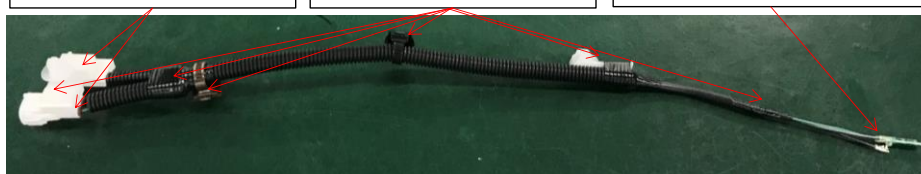
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Visual/By two's inspection

1. Check the connector if properly locked.

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

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



4. 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

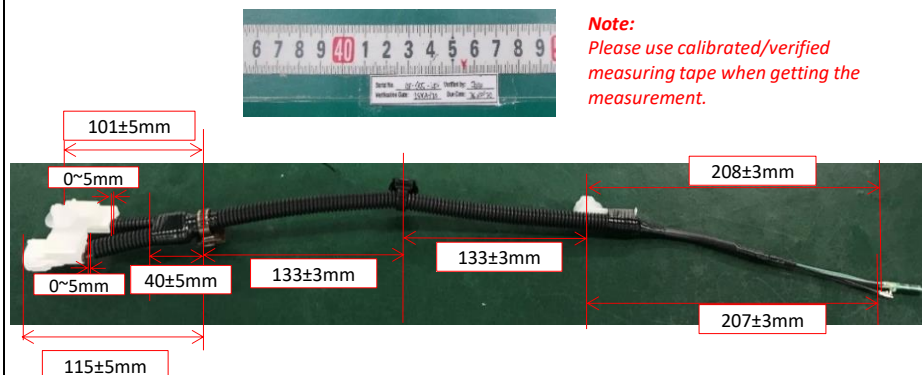
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Master Sample

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Measurement



n/a

For Hatsumono and Owarimono

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