

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 17, 2023

Validity Date:

n/a

Model Code/Part Number:

920B / 7R0122-7021A

Customer:

TRMX

Document No.:

WI-ENG-PDE-682

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. All parts: Assy parts: Clamp 82711-52070 (W)

JIG:

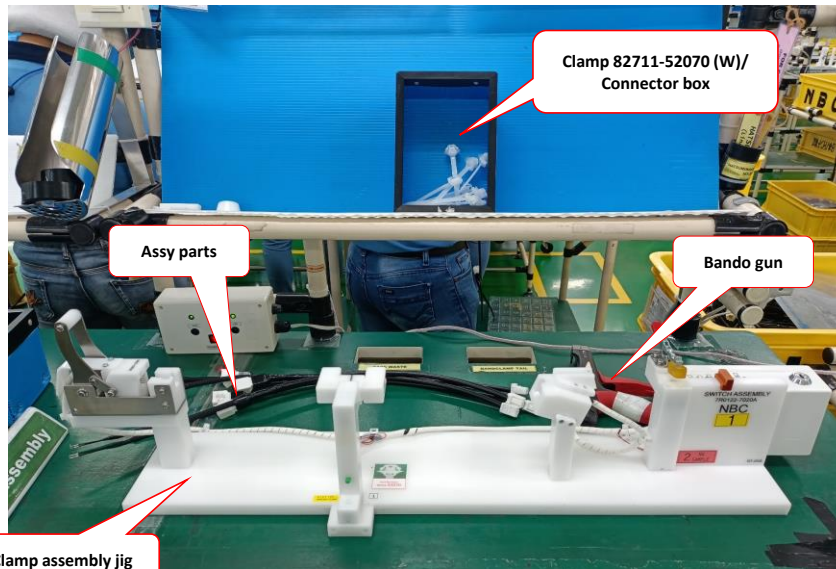
1. Clamp assembly jig

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

1

n/a

Table Lay-out

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/17/23	0	Initial issue.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes
							Est. Date:	May 17, 2023		

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2 of 6**PARTS:**

1. Clamp 82711-52070 (W)

JIG

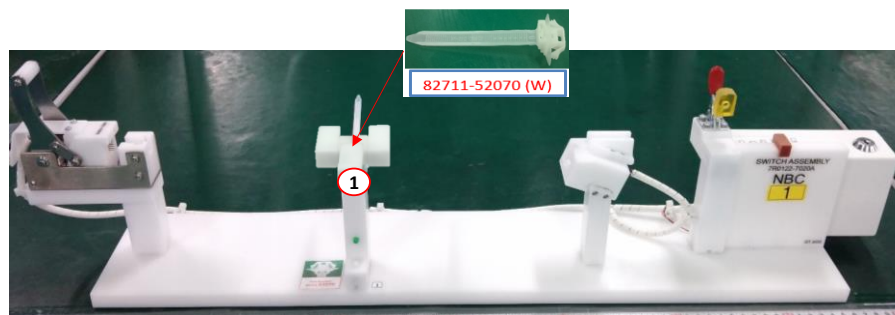
1. Clamp assembly jig

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

2

n/a

Clamp Setting




1. Get **1pc.** of clamp **82711-52070 (W)** using right hand then set to clamp location **1** using both hands.

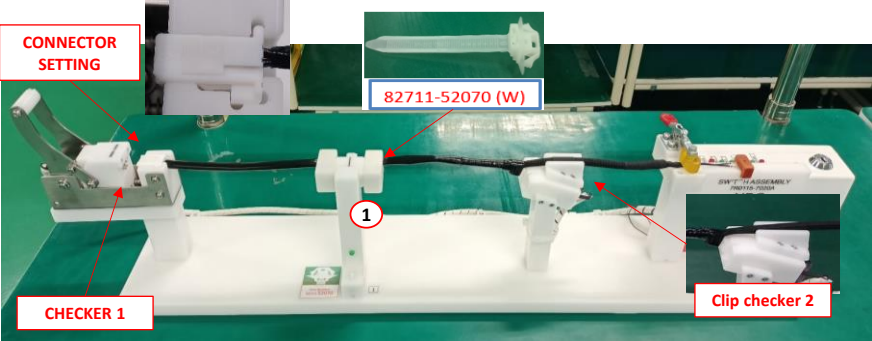
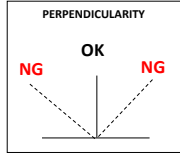


1. No missing clamp
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp positionng parts/tools
5. No excess parts/tools

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly	<div>  <p>CONNECTOR SETTING</p> <p>82711-52070 (W)</p> <p>CHECKER 1</p> <p>Clip checker 2</p> <p>1</p> </div> <div> <p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6098-3909 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 7188-0996 (W) to Clip Checker 2 for continuity checking then set the tube to tube guide. Last, set the terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>3. Initially tighten the band clamp from location 1 using both hands.</p> <p>4. Get the bando gun and cut the band clamp on location 1 using both hands. Press the SW button after cut. GO sound will be heard.</p> <div>  <p>BANDO GUN ALIGNMENT</p> <p>PERPENDICULARITY</p> <p>OK</p> <p>NG</p> <p>NG</p> </div> <p>5. Conduct POINT CHECKING before removing from clamp assembly jig.</p> </div> <div>  <p>BANDO GUN</p> </div> <div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun</p> <div>  <p>BANDO GUN ILLUSTRATION</p> <p>GOOD</p> <p>NG</p> <p>FLAT NOSEPIECE</p> <p>EXTENDED NOSEPIECE</p> </div> </div>		

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PARTS:

1. Assy parts
2. Engineering sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

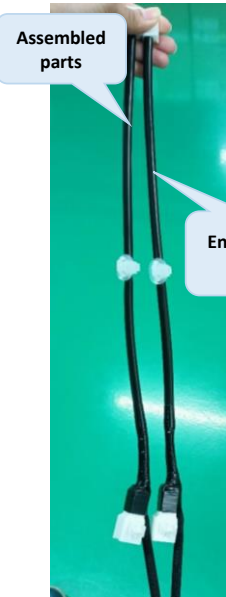
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Visual/By two's inspection

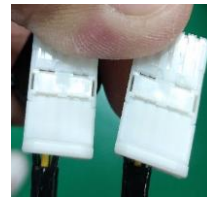


ACTUAL PRODUCT

ENGINEERING SAMPLE



Assembled parts



Engineering sample



3. Check the **presence of clamp attachment and band clamp cut condition.**



4. Check the **Y-taping condition.**



5. Check the **terminal appearance.**



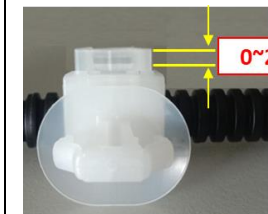
6. Check the **Tesa taping condition, Spot taping (End of tesa tape Must not visible).**



7. Check the **terminal appearance. Must be no deformed terminal.**

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

1. No skip checking during inspection



0~2mm

Important reminders/Note/s:

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

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PROTOTYPE

☐

PRE-LAUNCH

☒

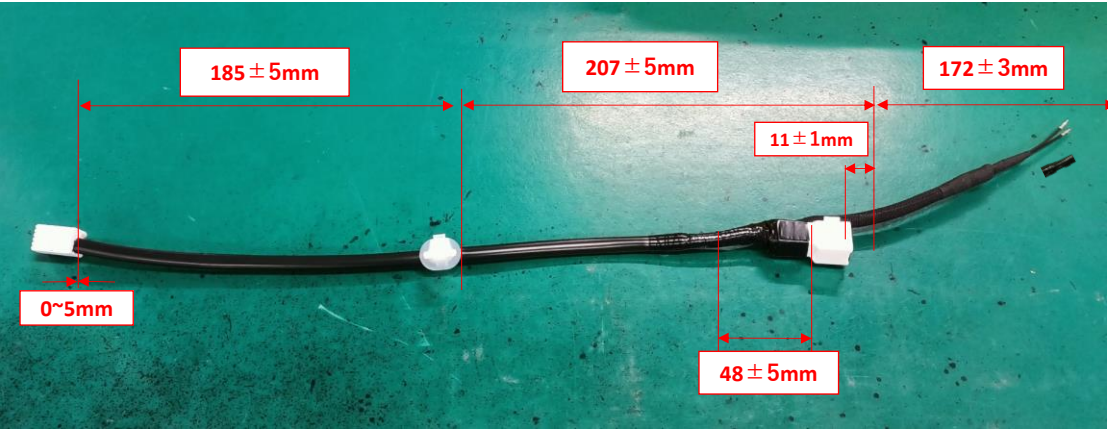
MASSPRO

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PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	n/a			<p>Important reminders/Note/s:</p> <p>1. FOR HATSUMONO AND OWARIMONO</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No wrong dimension</p>	

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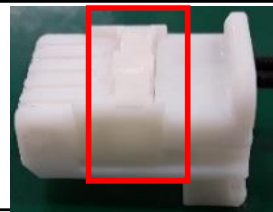
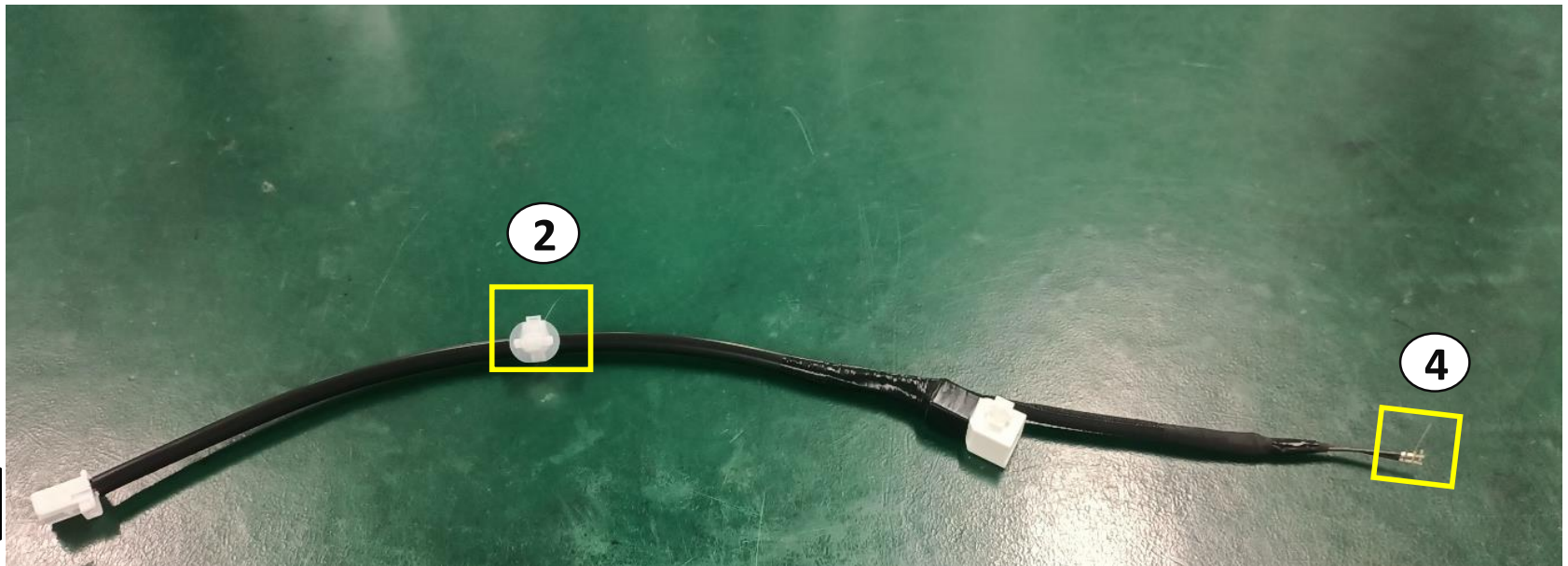
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6 of 6**PARTS:**

1. Assy parts

JIG

n/a

QUALITY CHECKPOINTS**n/a****7R0122-7021A****GOOD****NO GOOD****① No Unlock/Halflocked Connector****② No Missing Clamp****④ No Deformed Terminal****③ Check the alignment (clip and clamp)**

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