



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number:

178D

/

7N0127-7021A

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

February 8, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-432B

Revision No.:

2

Page No.:

1 of 7

PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-60640 (B); Black sponge tape (width=50; L=50±1mm); Black tape; Blue tape

JIG:

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ILLUSTRATION

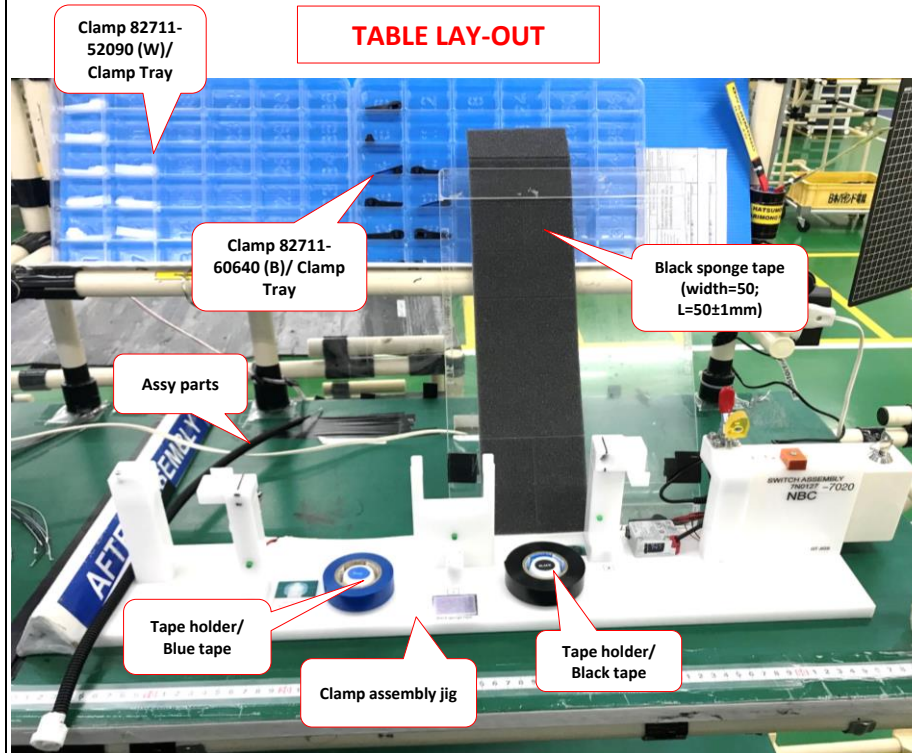
TOOLS/PPE

QUALITY POINTERS

1

P2

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

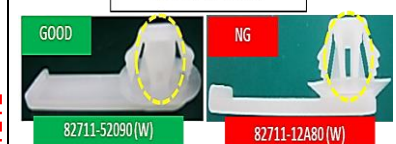
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
02/08/23	2	Work instruction improvement. Inclusion of Quality checkpoints (Page 7).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes
09/09/22	1	Improve work procedure/Illustration on page no.5 and 6; Quality pointers on Pg. no.1, 2, 3, 5, and 6.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
2/21/22	0	Initial issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Clamp 82711-52090 (W)
2. Clamp 82711-60640 (B)

3. Black tape
4. Blue tape

JIG

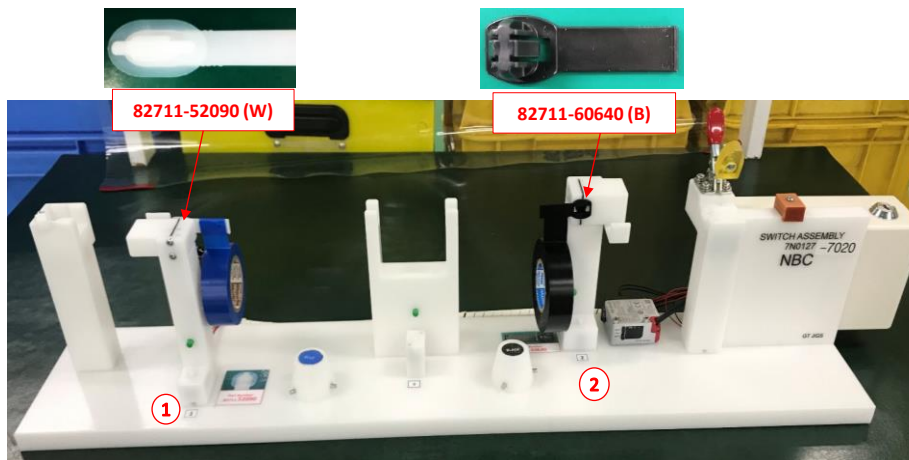
1. Clamp Assembly Jig

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

2

P2

Clamp Setting



1. Get 1 pc. of clamp **82711-52090 (W)** then set to clamp location **1** using both hands.

2. Get 1 pc. of clamp **82711-60640 (B)** then set to clamp location **2** using both hands.

3. Get the **Blue tape** then attach to clamp location **1** using both hands.

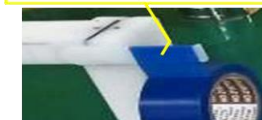
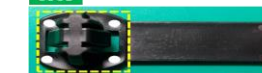
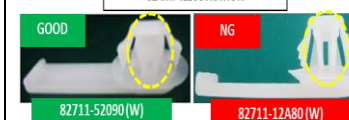
4. Get the **Black tape** then attach to clamp location **2** using both hands.

n/a

1. No loose clamp attached
2. No damage clamp
3. No wrong use of clamp
4. No damage clamp
5. No flip-out tape
6. No peel-off tape
8. No missing tape
9. No wrong use of tape
10. No wrong use of clamp

STANDARD TAPING FOR CLAMP

One side tape under clamp

**CLAMP ILLUSTRATION****GOOD****82711-60640 (B)****NG****82711-21020 (B)****CLAMP ILLUSTRATION****GOOD****82711-52090 (W)****NG****82711-12A80 (W)****Important reminders/Note/s:**

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

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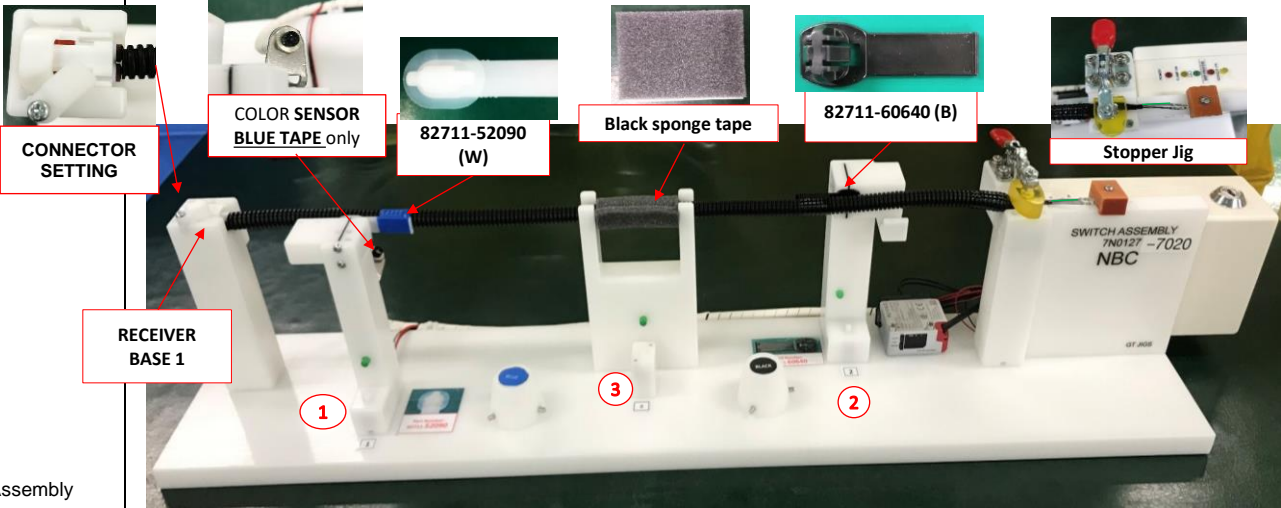

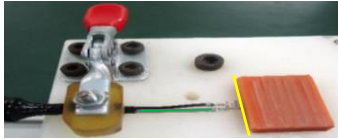
☒ MASSPRO

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PARTS:	1. Assy parts 2. Black sponge tape (width=50; L=50±1mm) 3. Black tape 4. Blue tape			JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	
3	P2 Clamp Assembly	<div></div> <div><p>1. Get the assy parts then put into jig. <i>(See above picture for correct setting).</i> First, set the connector 6189-0451 (W) to Receiver base 1. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Blue tape. Last, set the end of G-B/W wire together within the stopper then press by Toggle clamp then continue if the sequence light on clamp location 1 was ON.</p><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON. SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p><p>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Continue the process on clamp location 2.</p><p>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Continue the process on attachment of sponge tape. <i>(Proceed on next page for the instruction of sponge tape attachment.)</i></p><p>5. Conduct POINT CHECKING before removing the harness from jig.</p></div>		<div></div> <div><p>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of clamp/tape</p><div></div><p>Important reminders/ Note/s: 1. make sure no gap between terminal and stopper jig.</p></div>	

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PARTS:

1. Black sponge tape (width=50; L=50±1mm)

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

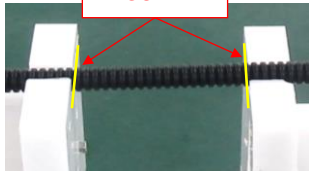
TOOLS/PPE

4

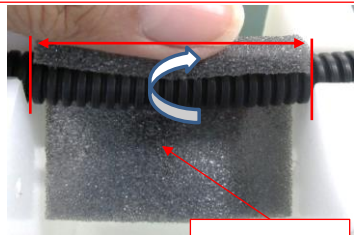
P2

Sponge Tape Attachment

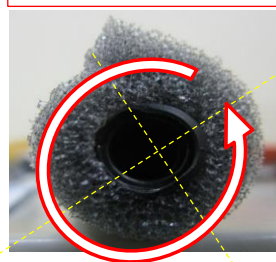
GUIDE



Size of sponge tape should fit the jig






Standard attachment





1 Get **sponge tape(width=50; L=50±1mm)** then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape.
Note: Do not stretch or pull the sponge tape

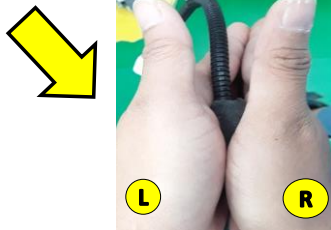
1 **2** **3**



4 **5**



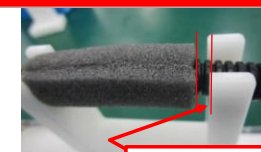
2. Press the sponge tape using both palm and roll 3 times to make sure that the sponge tape attachment is GOOD.



L **R**

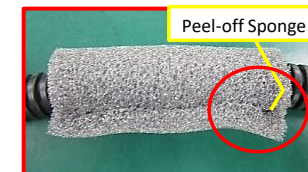
1. No peel-off attachment
2. No loose/tight attachment
3. No wrong attachment
- 4.No missing sponge
- 5.No wrong use of sponge
- 6.No damage sponge

NO GOOD ATTACHMENT OF SPONGE TAPE

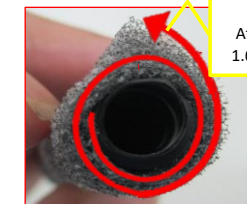


With gap on guide of jig.

Peel-off Sponge



Tight Attachment
1.6-1.7 Wrap



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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Visual/By Two's Inspection

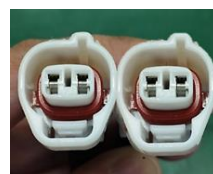


ACTUAL PRODUCT



Assembled parts

Master sample



3. Check the **connector lock** and **wire insertion**



4. Check the **presence of all clamp attachment** and **taping condition**.



5. Check the **presence of Black sponge tape**



6. Check the **taping condition** and **terminal appearance**. Must be **no deformed terminal**.

MASTER SAMPLE



CLAMP ILLUSTRATION



82711-60640 (B)



82711-21020 (B)

CLAMP ILLUSTRATION



82711-52090 (W)



82711-12A80 (W)

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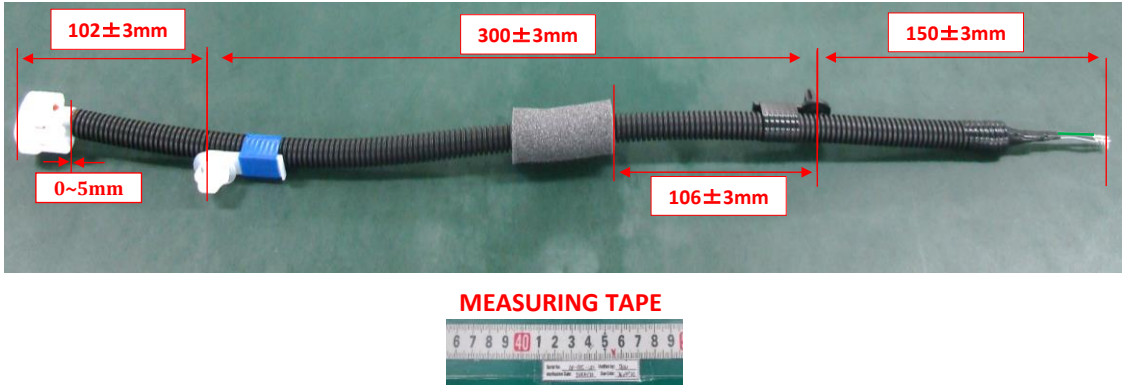
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a			JIG	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement					<p>1. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/ verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono</p>

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PROTOTYPE



PRE-LAUNCH



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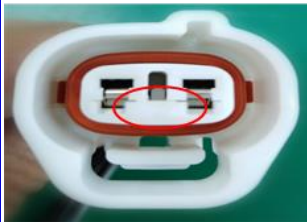
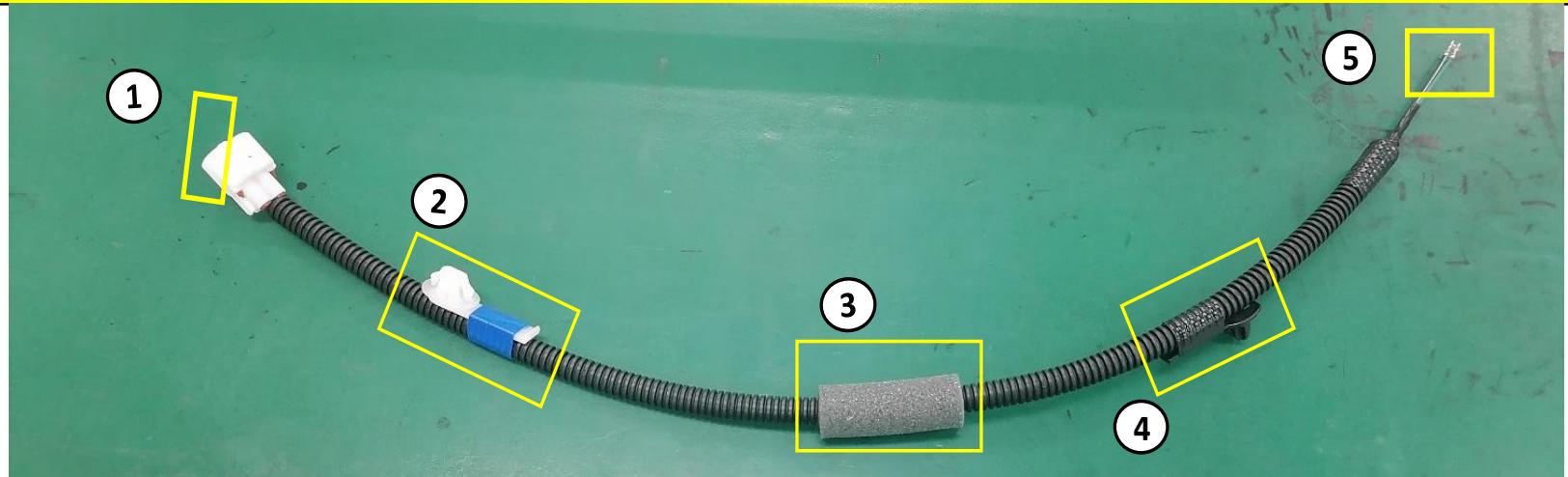
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PARTS:

n/a

JIG

n/a

**QUALITY CHECKPOINTS****P2****7N0127-7021A****GOOD****NO GOOD****① No Unlock/ Half Lock Connector****⑤ No Deformed Terminal****② ④ No Missing Clamp****③ No Missing Sponge**

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