



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	September 07, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-334B		
Revision No.:	1	Page No.:	1 of 4

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **370B / 7L0043-7022** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:

1. Clamp 82711-52090 (W)
2. Black tape [1pc.]

JIG:

1. Clamp assembly

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp setting	 <p>1. Get 1pc. of clamp 82711-52090 (W) using right hand then set to clamp location 1 using both hands.</p> <p>2. Get the Black tape and conduct pre-taping using both hands.</p> <p>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>STANDARD TAPING FOR CLAMP</p> <p>One side tape under clamp</p>  <ol style="list-style-type: none">1. No wrong use of clamp2. No damage clamp3. No flip-out tape4. No peel-off tape5. No loose tape6. No missing tape7. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Checked	Approved	Prepared by	Reviewed by	Reviewed by	Approved by
09/07/21	1	Transfer process owner from Production WI (WI-PRO-ASY-070) to Engineering WI (WI-ENG-PDE-334B). Improve all process illustration, parts and quality pointers.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
05/10/18	0	Initial issue	A. Morcozo	W. Carbillon	-	O. Merin	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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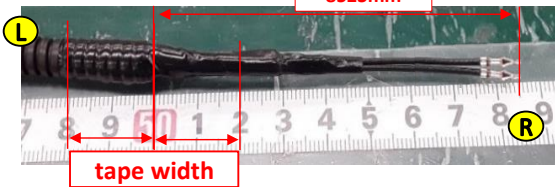


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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black COT to Black vinyl tube	<div><p>1. Hold the corrugated tube using left hand, measure from end of COT up to terminal pointed tip 85±3mm using both hands.</p></div> <div><p>2. Hold the corrugated using left hand, get the Black tape then start taping using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>MEASURING TAPE</p></div> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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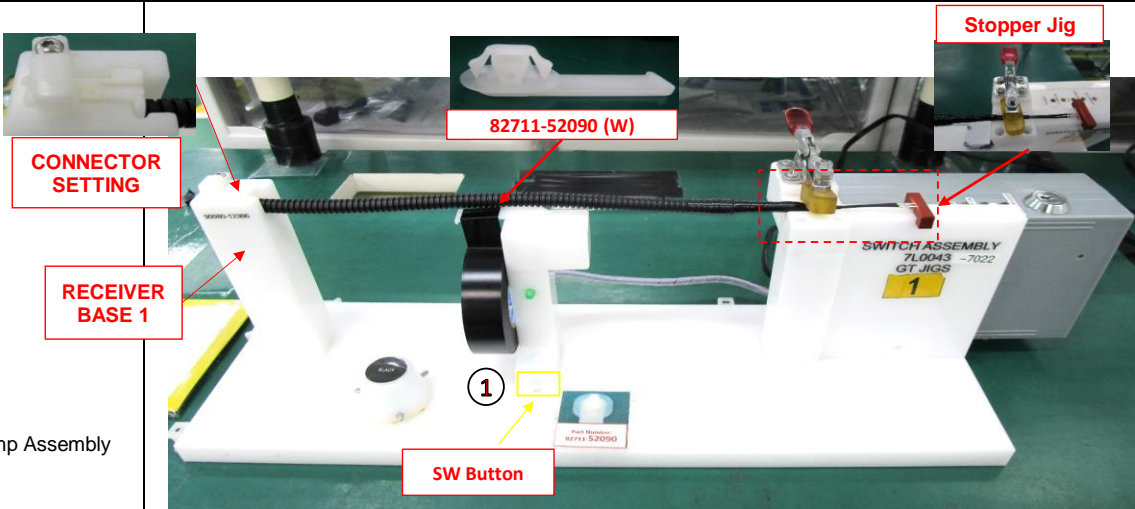

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PARTS:

1. Assy parts
2. Balck tape

JIG

1. Clamp Assembly Jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Clamp Assembly	<div></div> <div><ol style="list-style-type: none">1. Get the assy parts then put into jig. <i>(See above picture for correct setting)</i>. First, set the connector 6098-3810 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the end of B/B wire together within the stopper then press by Toggle clamp. Continue the process if sequence light on clamp location 1 was ON.2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. GO sound will be heard if the result is GOOD.4. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>	n/a	<div><ol style="list-style-type: none">1. Make sure no gap between terminal and stopper jig<ol style="list-style-type: none">1. No loose clamp attached2. No damage clamp3. No missed tape4. No missing parts5. Make sure no clearance between terminal and stopper jig.</div>

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

1

Visual/By two's inspection

1. Check the connector lock.

2. Check the clamp attachment and taping condition

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

4. Compare to Master Sample

Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

MASTER SAMPLE



P2

5

1

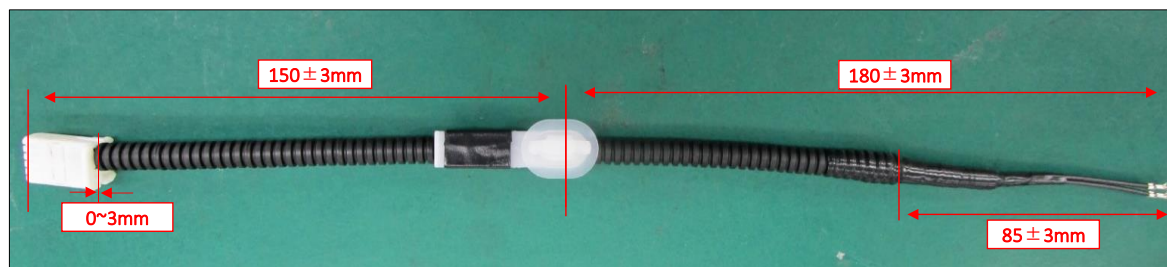
Measurement

MEASURING TAPE



Note:

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



NOTE: HATSUMONO AND OWARIMONO

1

1. No wrong dimension

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