



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Product Name/Code: 011B / 7M0364-7020B

Customer: TRJ

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 20, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-129B

Revision No.:

4

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PARTS:	1. Clamp 82711-52090 (W) [2pcs] 2. Black Sunprene tube $\phi 9$ L=120 \pm 3mm	3. Black tape [2pcs] 4. Blue tape [1pc]	5. Assy parts		JIG:	1. Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	 P2 Clamp Assembly Setting	 1. Get 2pcs of clamp 82711-52090 (W) and set to location 1 and 2 using both hands 2. Initially attach Black tape to location 1 and 2 using both hands. Note: Please check the clamp first before start of assembly to avoid wrong use of parts	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.	1. No damaged clamp 2. No missing clamp 3. No missing tape One side tape under clamp
2	 Wire insertion to Black Sunprene tube $\phi 9$ L=120 \pm 3mm	 Get the Sunprene tube $\phi 9$ L=120\pm3mm using right hand then insert to GR/BW wires using left hand.	Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No wrong use of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by:	Checked by:	Approved by:	Noted by:
03/20/21	4	Change clamp color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). . Remove cycle time.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes				
06/17/20	3	Transferred process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-018B to WI-ENG-PDE-130B. Additional cycle time.	M. Catapang	J. Loterte	A. Shimamura	A. Arañes				
10/15/19	2	Remove marking/Include Refer Guidelines for By Two's Inspection/Changed sequence of process (Include clamp attachment)	A. Roxas	A. Morcozo	O. Merin	-				
08/13/19	1	Distribution of process/include locking jig	J. Silang	W. Carbillon	O. Merin	-	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
Established Date:							July 10, 2019			

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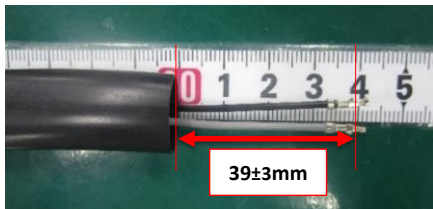



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2 of 4**PARTS:**

1. Black tape [1pc]
2. Assy parts

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 COT to Sunprene tube	<div><p>1. Measure the end of sunprene up to the terminal tip 39 ±3mm.</p></div> <div><p>2. Hold the sunprene tube using left hand then start taping using right hand. Note: Refer to WI-PRO-ASY-001 for taping procedure</p></div> <div><p>3. After taping, check the taping condition and terminal appearance.</p></div>	<div>Measuring tape</div> 	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div><ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape</div>

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

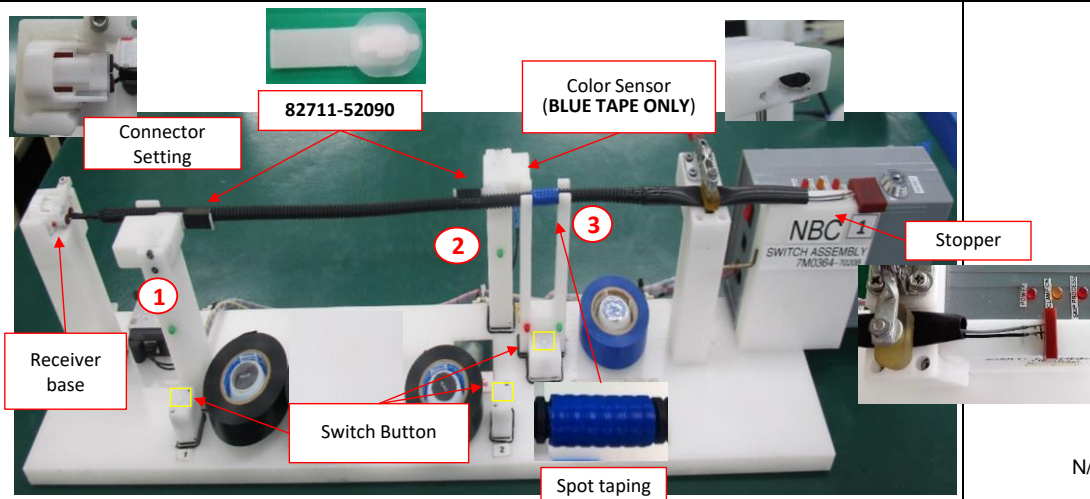
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly



N/A

1. Get the assy part and set to jig. (See above picture for correct setting). First, set the connector to **Receiver base** then lock. Last, set the **GR-B/W wires** with terminal end together within the stopper then press by **Toggle clamp**.

2. Check if **LED light** for **POWER ON, CLAMP ON** was **ON**. Check also if **clamp location 1** sequence light is **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Continue if the sequence light of **location 1** was ON.

3. Hold the **clamp** on **location 1** and start taping (3 winds) using both hands. Press the **SW button** after taping. Continue to **location 2** if light was on.

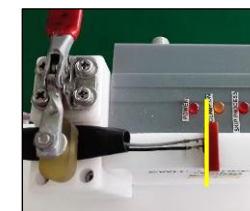
4. Hold the **clamp** on **location 2** and start taping (3 winds) using both hands. Press the **SW button** after taping. Continue to **location 3** if light was on.

3. Get **Blue tape** and conduct spot taping on **location 3** using both hands. **Go** sound will be heard if the **color sensor** detected the **Blue tape**.

5. Conduct **POINT CHECKING** before removing of harness from jig.

NOTE: YOU WILL HEAR THE NG BUZZER IF THE SENSOR DETECT WRONG USE OF TAPE AND MISSING TAPE.

1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts
5. No wrong use of tape



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

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JIG

N/A

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4Visual/By Two's
Inspection

1. Check the connector lock.

2. Check the tape condition, clamp attachment and spot taping.

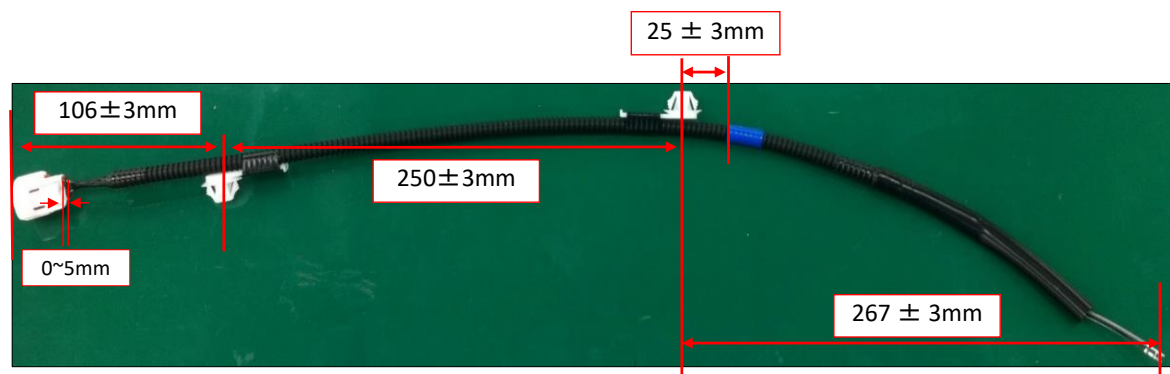
3. Check the terminal appearance.

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

P2

6

Measurement

**NOTE: FOR HATSUMONO
AND OWARIMONO**

1. No wrong dimension

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