



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **291B / 7L0036-7020**

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 18, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-198B

Revision No.:

2

Page No.:

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PARTS:

2

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

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

Clamp setting



1. Get 1pc. of clamp **82711-52090 (W)** using right hand and insert to location **1** using both hands.

2. Initially attach **Black tape** on location **1** using both hands.

Note: Please check the clamp 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.)

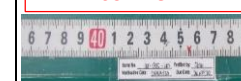
Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

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

MEASURING TAPE



STANDARD TAPING FOR CLAMP

One side tape under clamp



1. No wrong use of parts
2. No wrong use of clamp
3. No wrong use of tape

2

P2

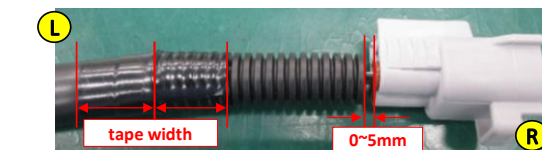
Taping 1
Black corrugated tube to
Black vinyl tube



1. Fix the corrugated and vinyl tube, make sure no gap in between.



2. Hold the corrugated tube and vinyl tube using left hand then start taping using right hand .
Refer to WI-PRO-ASY-001 for taping procedure.



3. After taping, check the measurement and taping condition.

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. No wrong use of tape
5. No wrong dimension

Note:

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/18/21	2	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
11/17/20	1	Transfer process owner from Production (WI-PRO-ASY-048) to Engineering (WI-ENG-PDE-198B). Apply some improvements/pictures. Removal of marker on taping jig.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Previously established as Production work instruction (WI-PRO-ASY-048). Initial issue	J. Montañito/ L. Bricenas	O. Merin	T. Sugiyama	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	July 10, 2017		

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DCC Stamp



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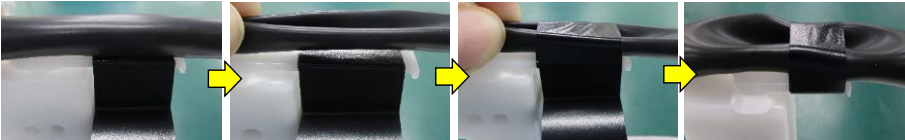

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PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp assembly	<div></div> <div><div><div>2</div><div>1. Get the assy parts and set into jig. <i>(See above picture for the correct setting)</i>. First, set the connector 6188-0294 (GR) to Receiver base 1 and then lock. Continue to set the harness in jig. Last, set the B/W-GR wires together within the stopper then press by toggle clamp. Continue the process if sequence light in location 1 was ON.</div></div><div><div>2</div><div>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.</div></div></div> <div></div> <div><div><div>2</div><div>3. On clamp location 1, fold the vinyl tube. <i>(See above picture as guide)</i>. Make 3 windings before cutting of tape. Press the SW button after taping. Go sound will be heard.</div></div><div><div>4. Conduct POINT CHECKING before removing the harness from jig.</div></div></div>	n/a	<div></div> <div>Note: Make sure theres no clearance between terminal and stopper jig.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong insertion of connector 5. Make sure no gap between terminal and stopper jig</div>

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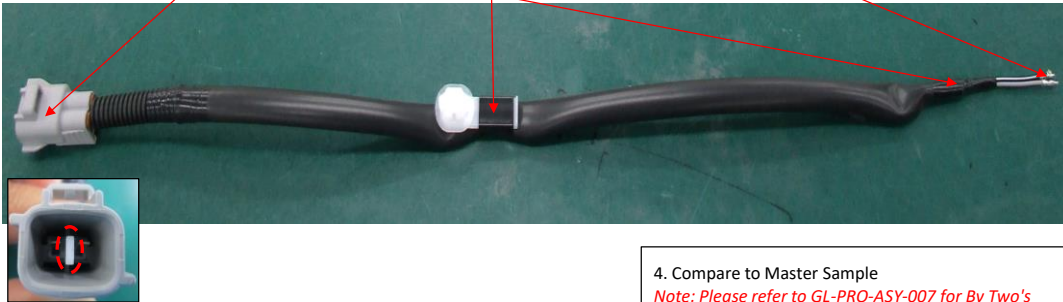

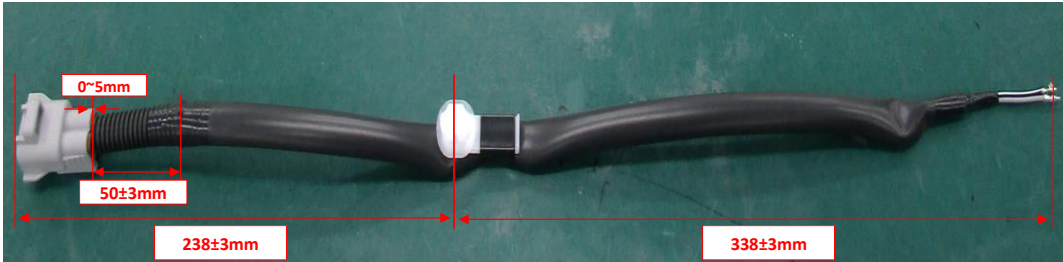
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PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Visual/By Two's Inspection P2	<div>1. Check the connector lock.</div> <div>2. Check the taping condition.</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div> <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div> 		<div>1. No missing parts</div> <div>MASTER SAMPLE</div> 
5	Measurement	<div>MEASURING TAPE</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> 		<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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