

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

Effectivity Date:

April 24, 2023Model Code/Part Number: **817B / 7N0050-7020B**Customer: **TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

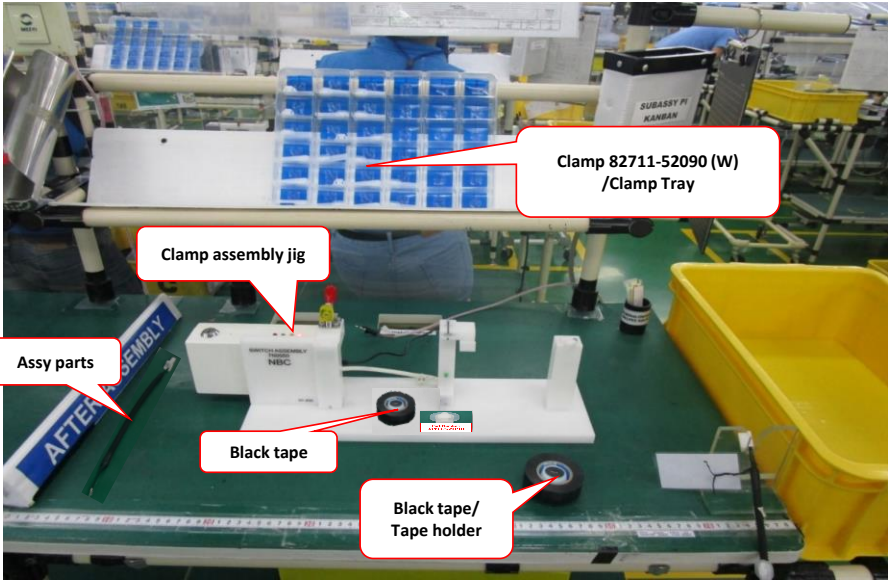



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PARTS:		1. Clamp 82711-52090 (W) 2. Black tape [2pcs]		3. Assy parts		JIG:	1. Clamp Assembly jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS					
1	P2	<p style="text-align: center;">TABLE LAY-OUT</p>  <p>Clamp 82711-52090 (W) /Clamp Tray</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>	1. No missing parts/tools 2. No excess parts/tools					
Revision History												
04/24/23	5	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a	<div>Prepared by  J. Loterte</div> <div>Reviewed by  C. Villanueva</div> <div>Approved by  A. Arañes</div> <div>Noted by: n/a</div>		
09/23/22	4	Improve quality pointers: Reminders/notes and references in process no.2, 3,4 and 5 due to document improvement. Work procedure/illustration in process no.5 - visual/by two's inspection.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes			
01/03/22	3	Change COT length from L=230±3mm to L=228±2mm (Refer to WI-ENG-PDE-257A) ; Change tolerance to range in taping process from L=25±3mm to L=22-28mm due to encountered minimum dimension from end tape to terminal tip. Additional note in clamp setting and improve work procedure.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes			
09/23/21	2	Add notes on taping of COT to wire near connector and clamp assembly; update the illustration.				D. Castillo	J. Loterte	C. Villanueva	A. Arañes			
07/08/21	1	Changed from pre-launch to masspro.				D. Castillo	C. Villanueva	A. Shimamura	A. Arañes			
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:	April 8, 2021	

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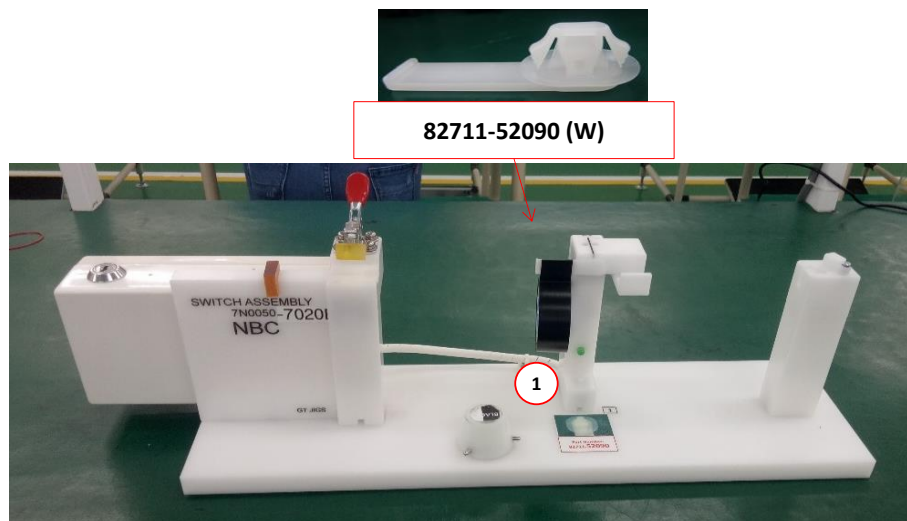
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2 of 7**PARTS:**

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

JIG

1. Clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2****P2****Clamp Setting****82711-52090 (W)****1**

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

2. Get the **Black tape** and conduct pre-taping on clamp **location 1** using both hands.

n/a**STANDARD TAPING FOR CLAMP**

One side tape under clamp



1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Important reminders/Note/s:

1. Please check the **Clamp** first before start of assembly to avoid wrong use of clamp.

CLAMP ILLUSTRATION

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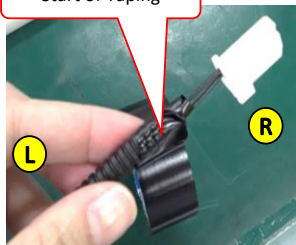
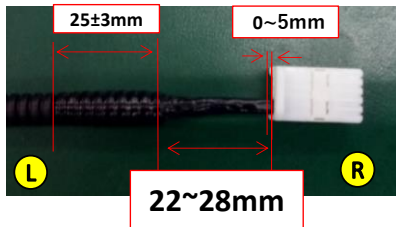

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PARTS:

1. Assy part
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 Corrugated tube to wire near connector	 <p>Note: Avoid pulling down the COT to adjust the dimension if still within the tolerance during measurement. If encountered abnormality STOP the process, CALL the Leader and WAIT for instruction.</p>  <p>1. Get the Black tape, hold corrugated tube using left hand then start pre-taping using both hands</p>  <p>2. Measure from end of corrugated tube up to the edge of connector 22~28mm. Then continue taping using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

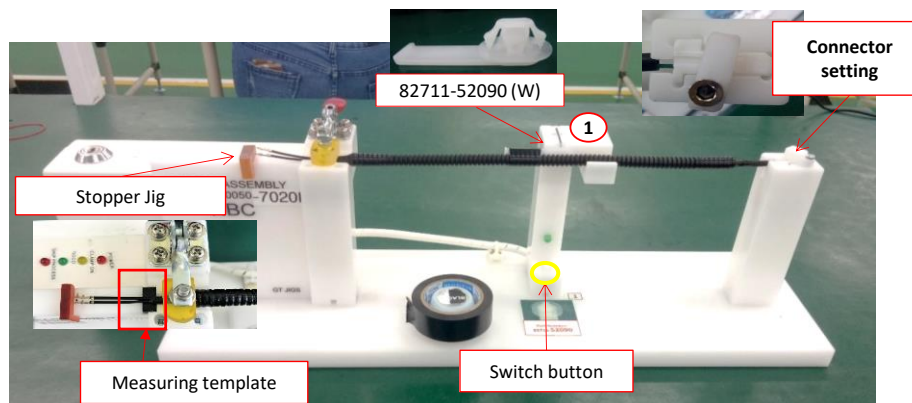
TOOLS/PPE

QUALITY POINTERS

4

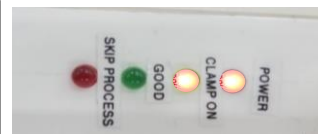
P2

Clamp Assembly



1. Get the assy parts (*see above picture for correct setting*) and then put it on jig using both hands. First, set the connector 6098-3810 (W) to Receiver base then lock and set the B-B wires with terminal end together within the stopper then press by Toggle clamp. *Note: Check if the end tape is within the measuring template. If encountered outside the template, STOP the process, CALL the leader and WAIT for instruction.*

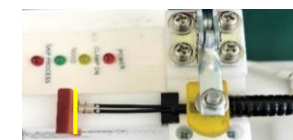
2. Check if all LED light for POWER ON and CLAMP was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light in location 1 is ON.



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.

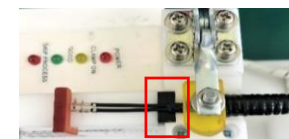
4. Conduct POINT CHECKING before removing the harness from jig

N/A



Important reminders/Note/s:
1. Make sure no gap between stopper jig and terminals

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process



Important reminders/Note/s:
1. Make sure that the end tape on wire will not exposed outside of measuring template.

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION


TOOLS/PPE

QUALITY POINTERS


5

P2

Visual/By Two's Inspection




ACTUAL PRODUCT




Assembled parts

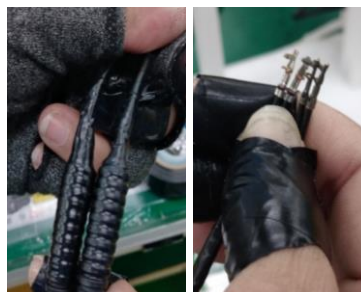
Master sample




2. Check the **terminal**, **connector lock** condition, **insertion** and **taping condition**.



3. Check the **presence of clamp** and **taping condition**.



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



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

1. No skip process

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PARTS:

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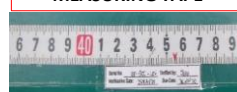
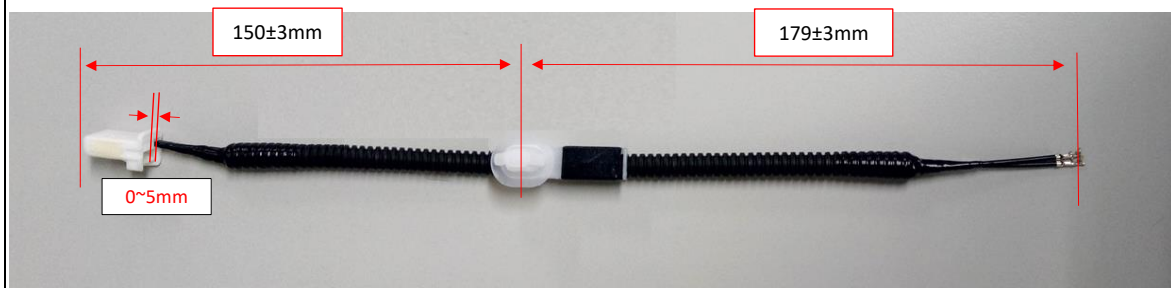
JIG

N/A

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

6

Measurement

MEASURING TAPE**Note:***Please use calibrated/verified measuring tape when getting the measurement.***Important reminders/Note/s:**
1. FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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PARTS:

n/a

JIG

N/A

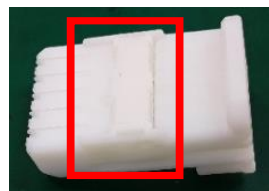
5 QUALITY CHECKPOINTS

P2

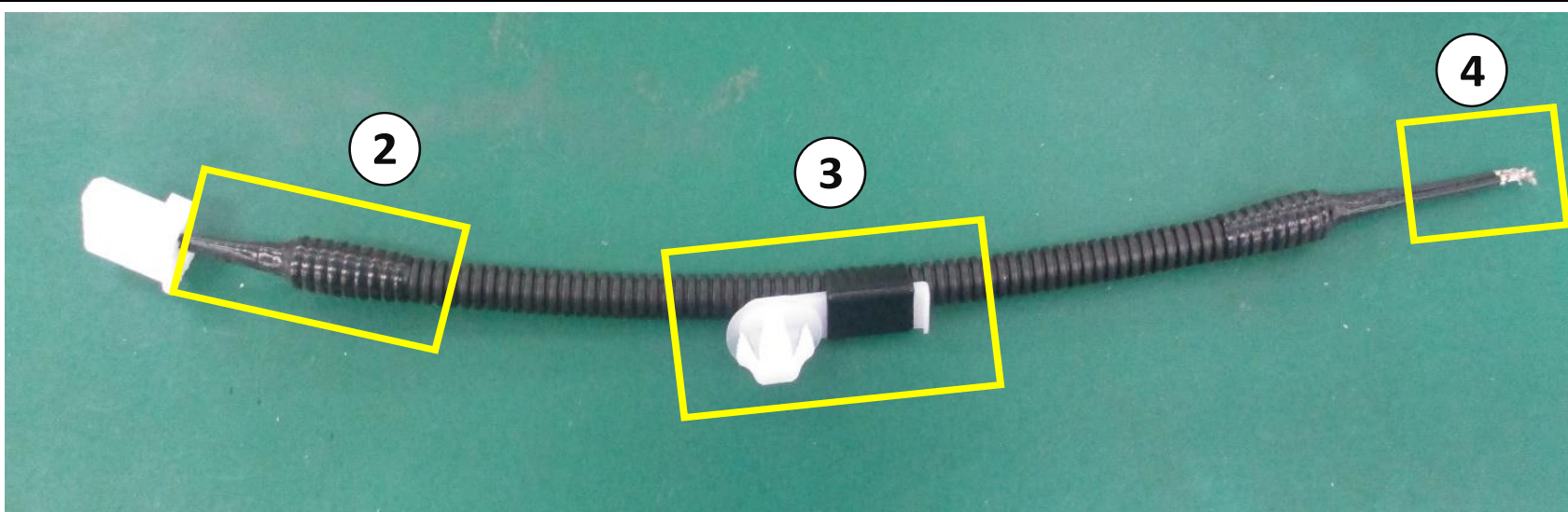
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GOOD



NO GOOD



- ① No Unlock/
Halflocked
Connector
- ② No Missing Tape
- ③ No Missing Clamp (1pc.)
- ④ No Deformed Terminal

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