



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

April 23, 2021

Validity Date:

n/a

Product Name/Code: 101D / 7N0098-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-240B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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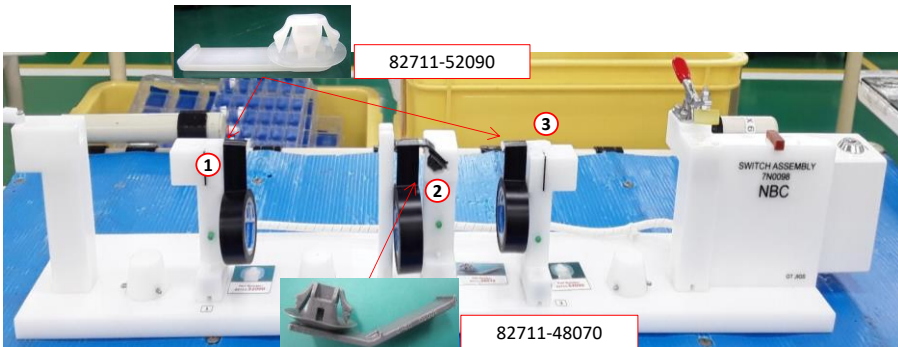

PARTS:

1. Clamp 82711-52090 (W) [2pcs]
2. Clamp 82711-48070 (GR)

3. Black tape [3pcs]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp Assembly Setting	 <p>1. Get 2 pcs of clamp 82711-52090 (W) using right hand and set to clamp location 1 and 3 using both hands.</p> <p>2. Get 1 pc of clamp 82711-48070 (GR) using right hand and set to clamp location 2 using both hands.</p> <p>3. Get black tape using right hand and conduct pre taping from clamp location 1, 2 and 3.</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>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by:	Checked by:	Approved by:	Noted by:
04/23/21	1	Change part number. Change from pre-launch to masspro.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes				
03/09/21	0	Initial issue.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
Est. Date:							March 8, 2021			

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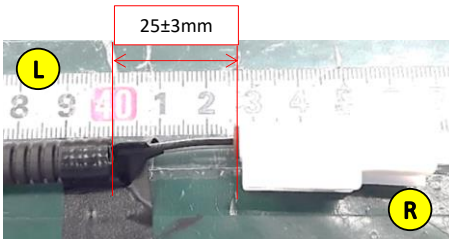
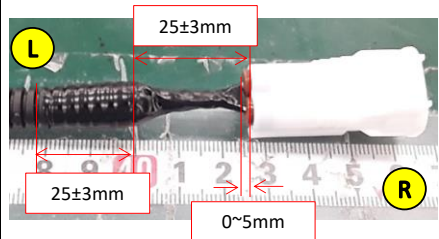

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PARTS:		1. Assy parts 2. Black tape [1pc]	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	<p>Taping COT to wire near connector</p>  <p>1. Hold the COT using left hand. Get Black tape using right hand and conduct pre taping.</p>  <p>2. Measure the end of COT to connector 25±3mm and continue taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the dimension, taping condition and wire alignment.</p>	<p>MEASURING TAPE</p> 	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong dimension5. No missing tape6. No wrong use of tape

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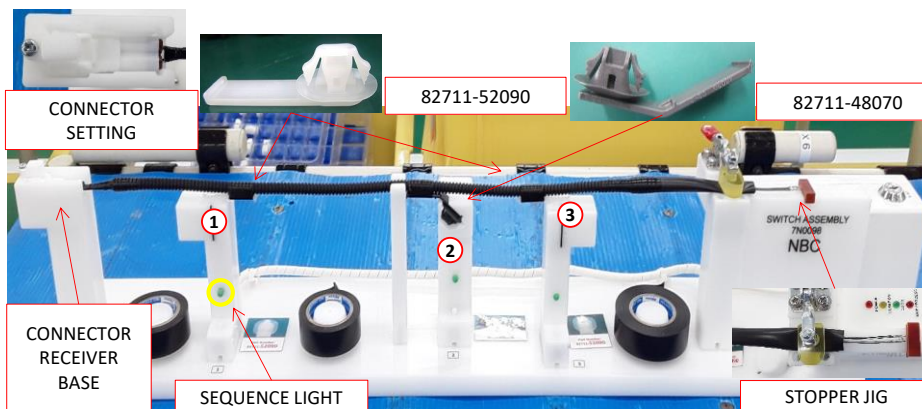
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PARTS:	1. Assy parts			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp assembly		n/a	<p><i>Make sure NO GAP between terminal and stopper jig.</i></p>  <ul style="list-style-type: none">1. No wrong use of clamp2. No damaged clamp3. No missing clamp4. No wrong use of tape5. No missing tape



1. Get the assy parts using both hands. First, put the connector into receiver base using right hand and lock using left hand. Second, put the terminal to stopper jig using right hand and pull down the toggle clamp using left hand.
Refer to above illustration for the correct setting.

2. Check the LED light for **POWER**, **CLAMP** and **SEQUENCE** Light in clamp location 1 is **ON**. If encountered abnormality, **STOP** the process, **CALL** the attention of the Leader and **WAIT** for instruction.

3. Proceed the taping from clamp **location 1, 2 and 3**. Make 3 windings and cut the tape. Press the switch button after every taping.
GO sound will be heard after pressing the switch button in **location 3**.

4. Conduct **POINT CHECKING** using right hand before removing from jig.

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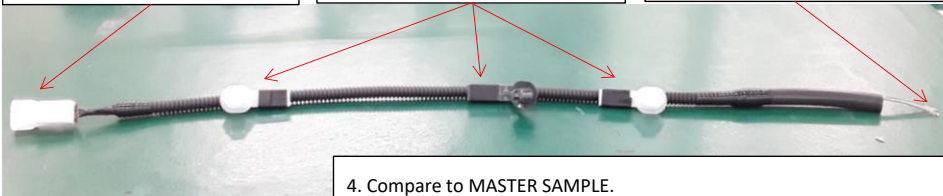


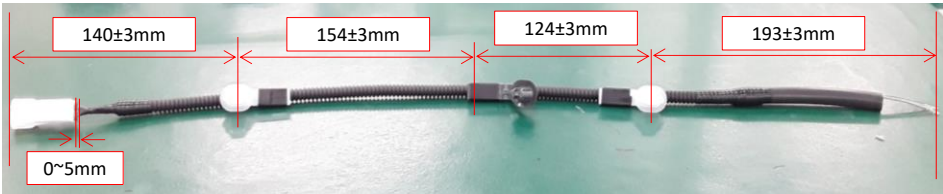
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PARTS:	n/a				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	Visual/By two's inspection	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment, alignment and taping condition.</div> <div>3. Check the terminal. Make sure no deformed terminal.</div>  <div>4. Compare to MASTER SAMPLE. <i>Please refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></div>		n/a	MASTER SAMPLE 	
5	P2 Measurement	 <div>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div> 		n/a	FOR HATSUMONO AND OWARIMONO	

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