



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	November 25, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-228D		
Revision No.:	2	Page No.:	1 of 6

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	150B / 2 7L0058-7023	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS: <div>2</div> 1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (b); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [5pcs.]		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	<div>2</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	<div>2</div> P4 Table Lay-out	<div><div>Table Lay-out</div><div><div>Clamp 82711-48210 (B)/ Connector tray</div><div>Clamp 82711-3A640 (B)/ Connector tray</div><div>Clamp 82711-35730 (B)/ Connector tray</div><div>Clamp 82711-52090 (W)/ Connector tray</div><div>Assy parts</div><div>Clamp assembly jig</div></div></div>	<div><div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/25/21	2	Change part number from 7L0058-7022 to 7L0058-7023 due to additional clamp (82711-52090 (W)). Improve work procedure and illustration. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/01/21	1	Transfer process owner from Production (WI-PRO-ASY-134D) to Engineering (WI-ENG-PDE-228D). Improve the work procedure and illustration of all process	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
07/05/19	0	Initial issue	A. Roxas	W. Carbillon	O. Merin	n/a	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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TAPING ASSEMBLY PROPCESS

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/ 2

7L0058-7023

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

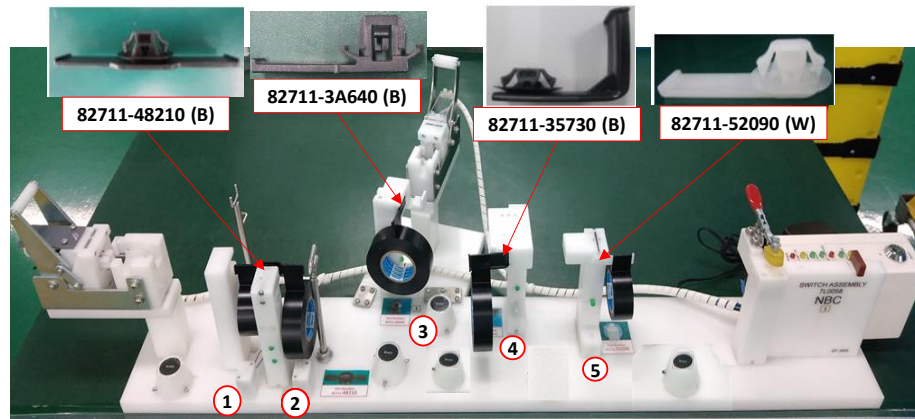
TOOLS/PPE

QUALITY POINTERS

2

P4

Clamp setting



1. Get 1 pc. of clamp **82711-48210 (B)** using right hand then insert to clamp location **1 and 2** using both hands.

2. Get 1 pc. of clamp **82711-3A640 (B)** using right hand then insert to clamp location **3** using both hands.

3. Get 1 pc. of clamp **82711-35730 (B)** using right hand then insert to clamp location **4** using both hands.

4. Get 1 pc of clamp **82711-52090 (W)** using right hand then insert to clamp location **5** using both hands.

5. Get the **Black tape** then initially attach to clamp location **1, 2, 3, 4 and 5** 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

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P4

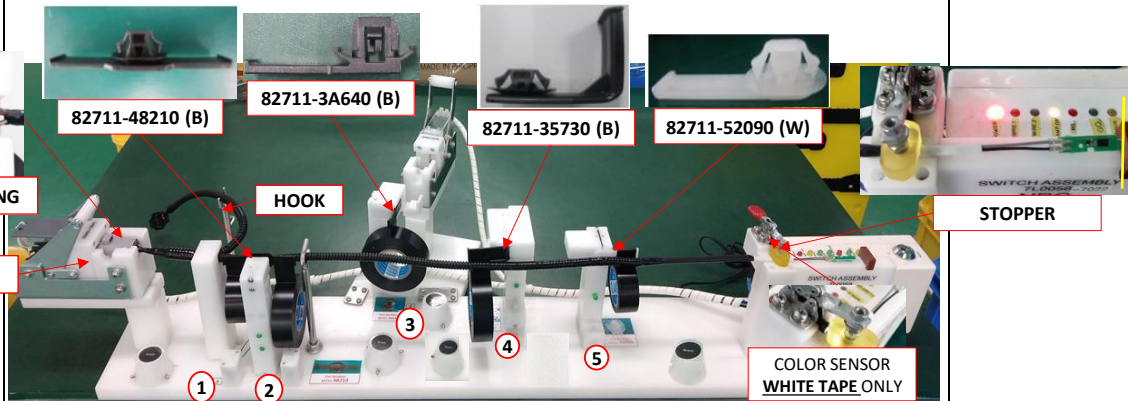
Clamp assembly

CONNECTOR SETTING

CHECKER 1

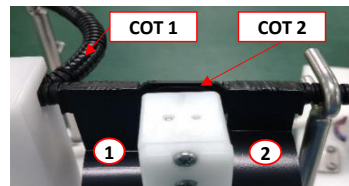
HOOK

STOPPER



1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, put the assy parts with black connector **6189-1161 (B)** into **HOOK**. Continue to set the harness in jig. Last, set the PCB within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.



3. On clamp location **1**, make **2 windings** of tape using both hands. Repeat the process on clamp location **2**.

Note: DO NOT CUT THE TAPE.

n/a

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

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PARTS:

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2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

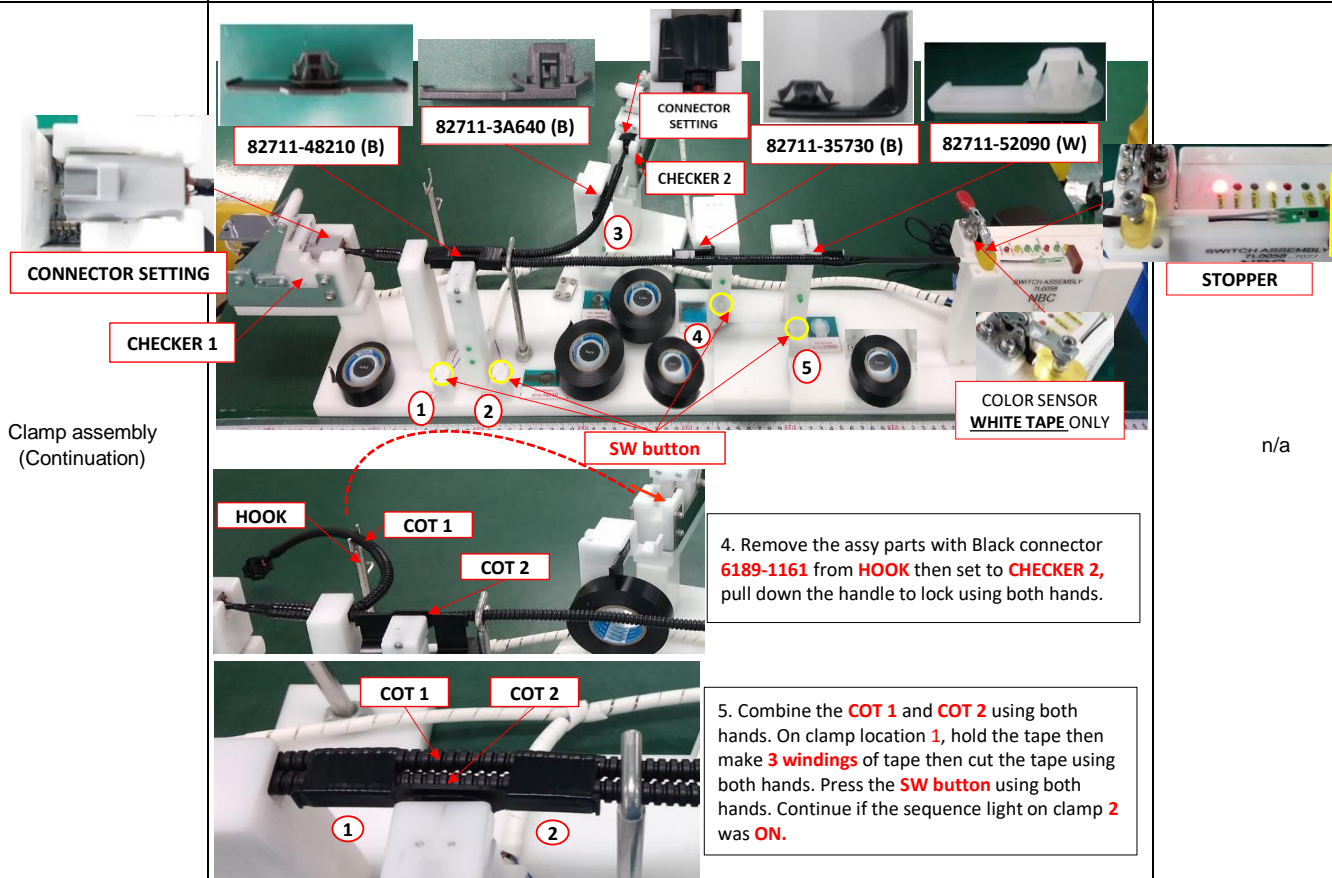
TOOLS/PPE

QUALITY POINTERS

3

P4

Clamp assembly
(Continuation)



n/a

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

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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

P4

Clamp assembly
(Continuation)

82711-48210 (B)

82711-3A640 (B)

CONNECTOR SETTING

CHECKER 2

82711-35730 (B)

82711-52090 (W)

CONNECTOR SETTING

CHECKER 1

STOPPER

COLOR SENSOR
WHITE TAPE ONLY

SW button

COT 1

COT 2

1. No wrong use of parts

2. No wrong use of tape

3. No damaged clamp

4. No wrong clamp position

6. On clamp location **2**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** using both hands. Continue if the sequence light on clamp **3** was **ON**.

7. Hold the tape on clamp location **3**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **4** was **ON**.

8. Hold the tape on clamp location **4**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **5** was **ON**.

9. Hold the tape on clamp location **5**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard.

10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Visual/By two's inspection

2

1. Check the connector lock.

2. Check the Y-taping, spot taping and clamp attachment condition.

3. Conduct bending of clamp with 2 sides taping.

GOOD

NG

4. Check the alignment of COT, spot taping on two sides taping and half-wrap taping.

5. Compare to Master sample. Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.

MASTER SAMPLE

P4

5

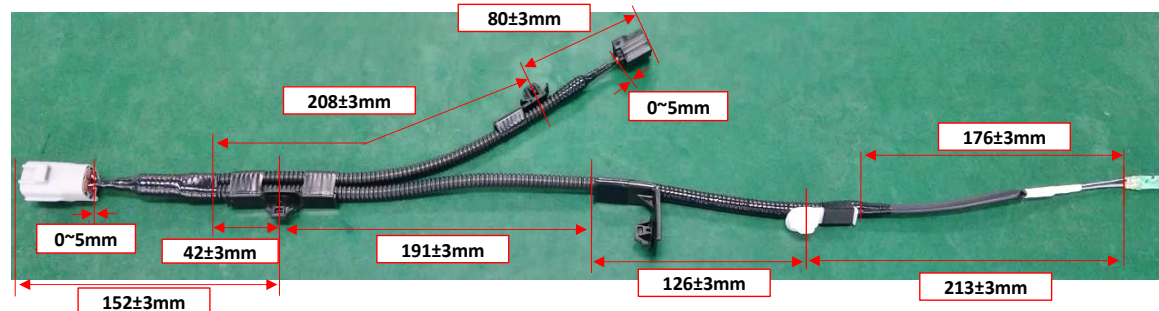
Measurement

2

MEASURING TAPE

Note:

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



NOTE: FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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