



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **840B / 2 7N0121-7020B**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

January 3, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-319B

Revision No.:

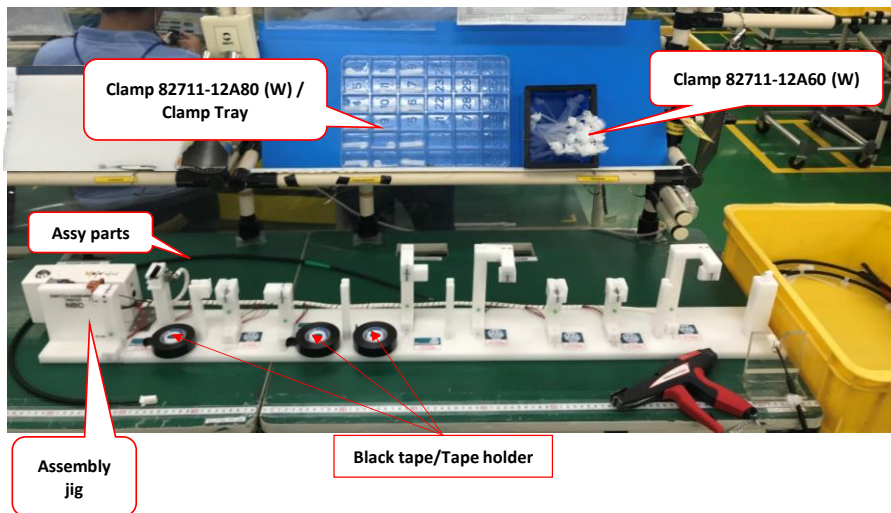
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1 of 8**PARTS:****2** 1. Assy parts: Clamp 82711-12A60 (W); Clamp 82711-12A80 (W); Black tape [3pcs.]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out 	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.	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
01/03/22	2	Change part number from 7N0121-7020A to 7N0121-7020B due to change orientation of clamp. Additional quantity of band clamp 82711-12A60 (W) from n=4pcs. to n=5pcs; Reduced quantity of clamp 82711-12A80 (W) from n=4pcs. to n=3pcs. Improve work procedure and illustration in all clamp assembly process.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/10/21	1	Revise due to transfer of insertion process to Kitting process (Refer to WI-ENG-PDE-333); Improve process illustration; Interchange taping process of COT to vinyl; COT to wire near terminal. Change from pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
08/09/21	0	Initial issue	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
			Est. Date:	August 09, 2021		

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PROTOTYPE



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PARTS:

1. Clamp 82711-12A80 (W) [3pcs.]
2. Clamp 82711-12A60 (W) [5pcs.]

3. Black tape [3pcs.]

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

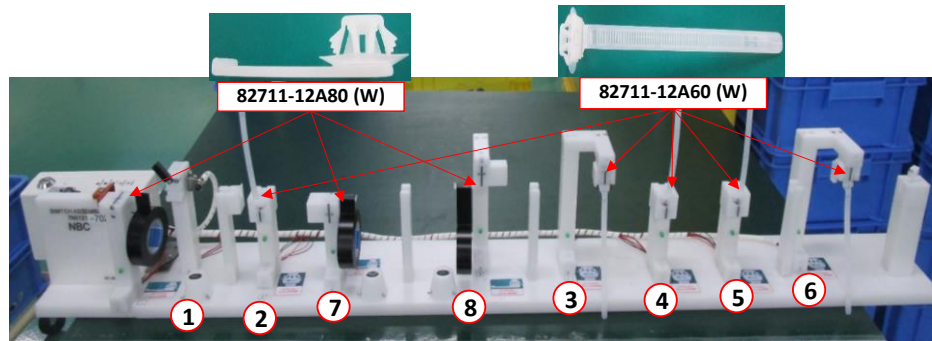
TOOLS/PPE

QUALITY POINTERS

2

P2

Clamp Setting



1. Get **2pcs.** of clamp **82711-12A80 (W)** then set to clamp location **1 and 7** using both hands.

2. Get **1pc.** of clamp **82711-12A80 (W)** then set to clamp location **8** using both hands.

3. Get **2pcs.** of clamp **82711-12A60 (W)** then set to clamp location **2 and 3** using both hands.

4. Get **2pcs.** of clamp **82711-12A60 (W)** then set to clamp location **4 and 5** using both hands.

Note: Please check the clamp before start of assembly to avoid wrong use of parts.

5. Get **1pc.** of clamp **82711-12A60 (W)** then set to clamp location **6** using both hands.

6. Initially attach **Black tape** on clamp location **1, 7, and 8** using both hands.

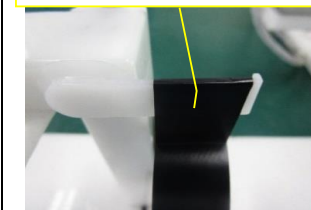


Take note: Make an excess attach tape on clamp location 8 for easy setting up of assy parts.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp



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

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PARTS:		1. Assy parts		JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Clamp Assembly</p> <p>1. Get the assy parts then put into jig. <i>(See above picture for correct setting)</i>. First, set the connector 6098-3810 (W) to Receiver base 1. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Green tape. Fold the tube until the terminal end reaches the guide. <i>(See below illustration)</i></p> <p>2. Fold the tube using both hands. Must be no gap.</p> <p>3. Slide down the guide using right hand. Terminal end must be no gap in guide.</p>		n/a	<p>1. No loose clamp attached</p> <p>2. No damage clamp</p> <p>3. No missing parts</p> <p>4. No gap in between of guide</p>

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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	P2	<p>Clamp Assembly (Continuation)</p>	 	<ol style="list-style-type: none">1. No loose clamp attached2. No damage clamp3. No flip-out tape4. No peel-off tape5. No loose tape6. No wrong use of tape

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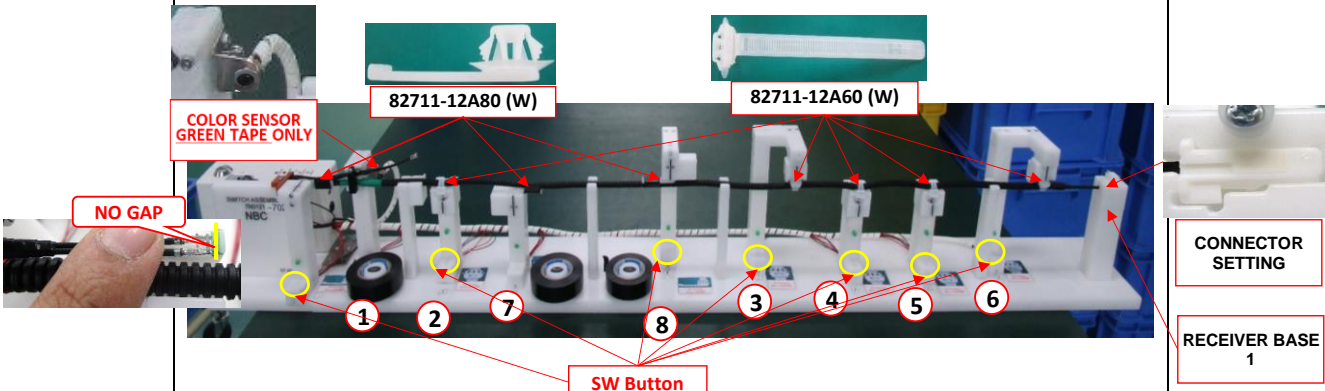




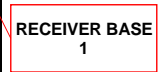

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PARTS:		1. Assy parts 2. Black tape	JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Clamp Assembly (Continuation)	<div><p>5. Hold the tape on clamp location 1 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in location 2 was ON.</p><p>6. Get the bando gun using right hand then cut the band clamp on location 2 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 3 was ON.</p><p>7. Cut the band clamp on location 3 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 4 was ON.</p><div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>NG OK NG</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$</p></div><div><p>GOOD</p><p>NG</p><p>Fixed setting of band clamp cutter: 1~2</p></div></div>	  	1. No loose clamp attached 2. No damage clamp 3. No flip-out tape 4. No peel-off tape 5. No loose tape 6. No wrong use of tape

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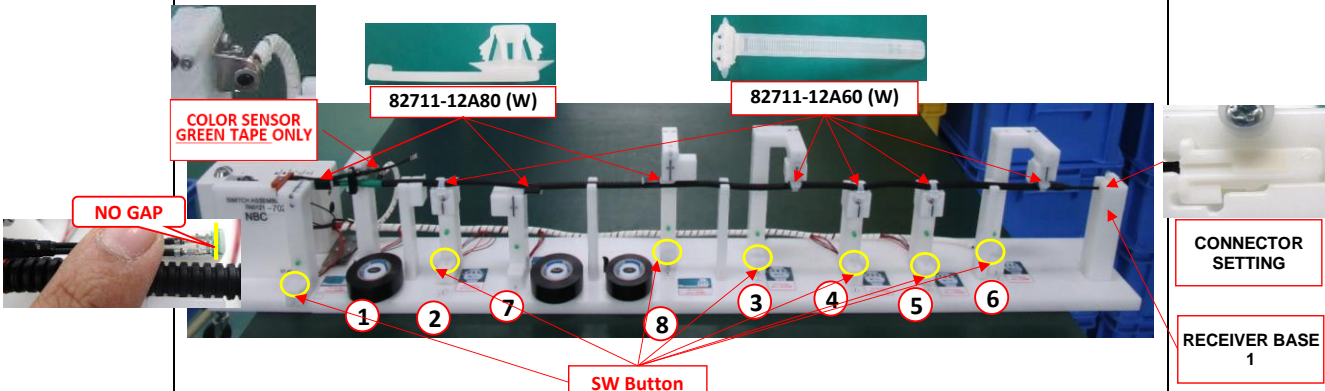
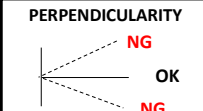




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NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	<div>Clamp Assembly (Continuation)</div> <div></div> <div><div>8. Cut the band clamp on location 4 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 5 was ON.</div><div>9. Cut the band clamp on location 5 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 6 was ON.</div><div>10. Cut the band clamp on location 6 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 7 was ON.</div><div><div>BANDO GUN ALIGNMENT</div><div>PERPENDICULARITY</div><div></div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</div><div></div></div><div></div></div>	<div>CONNECTOR SETTING</div> <div>RECEIVER BASE 1</div> <div>BANDO GUN</div> <div></div> <div></div>	<div>1. No loose clamp attached</div> <div>2. No damage clamp</div> <div>3. No flip-out tape</div> <div>4. No peel-off tape</div> <div>5. No loose tape</div> <div>6. No wrong use of tape</div>

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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	P2 Clamp Assembly (Continuation)	<p>11. Hold the tape on clamp location 7 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in location 8 was ON.</p> <p>12. Hold the tape on clamp location 8 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. GO sound will be heard.</p> <p>13. After taping, conduct POINT CHECKING before removing the harness from the jig.</p>	n/a	1. No loose clamp attached 2. No damage clamp 3. No flip-out tape 4. No peel-off tape 5. No loose tape 6. No wrong use of tape

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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	<p>1. Check the double lock connector.</p> <p>2. Check the taping condition, clamp attachment and alignment.</p> <p>3. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p> <p>4. Check the terminal appearance, make sure no deformed terminal.</p> <p>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></p>			<p>MASTER SAMPLE</p>
5	Measurement	<p>MEASURING TAPE</p> <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>			<p>NOTE: FOR HATSUMONO AND OWARIMONO</p> <p>1. No wrong dimension</p>

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