



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	July 17, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-310B		
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Process Name/Title:

Product Name/Code: 291B / 7L0037-7020

Customer: TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

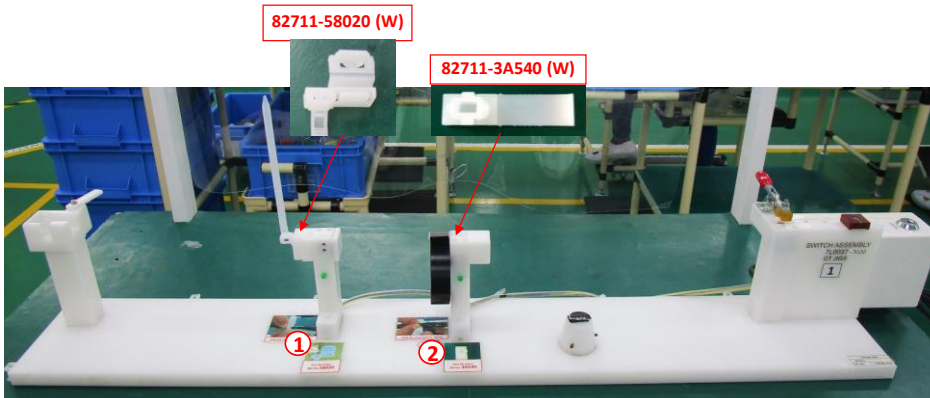

PARTS:

1. Assy parts
2. Clamp 82711-58020 (W)
3. Clamp 82711-3A540 (W)

4. Black tape [1pc.]

JIG:

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp setting	<div></div> <div><p>1. Get 1 piece of clamp 82711-58020 (W) using right hand and insert to location 1 using both hands.</p><p>2. Get the clamp 82711-3A540 (W) using right hand and insert to location 2 using both hands.</p><p>3. Initially attach Black tape on location 2 using both hands.</p></div> <div><p>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</p></div>	<div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><p>Housekeeping</p><p>1. Maintain and always practice 5's.</p><p>2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div> <div><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>	<div><p>STANDARD TAPING FOR CLAMP</p><p>One side tape under clamp</p></div> <div><p>1. No wrong use of parts</p><p>2. No wrong use of clamp</p><p>3. No wrong use of tape</p></div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/17/21	1	Transfer process owner from Production (WI-PRO-ASY-049) to Engineering (WI-ENG-PDE-310B). Improve process illustration and quality pointers. Change connector color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts).	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/10/17	0	Previously established as Production work instruction (WI-PRO-ASY-049). Initial issue	J. Montalvo	O. Merin	T. Sugiyama	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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DCC Stamp



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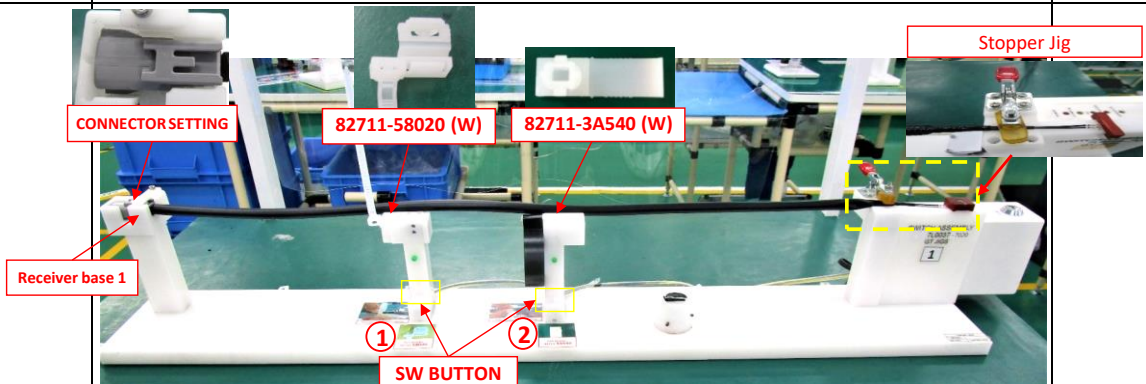
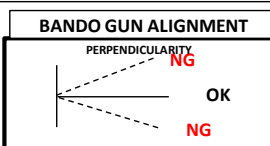

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PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp assembly	<div></div> <div><p>1. Get the assy parts and set into jig. (See above picture for the correct setting). 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.</p><p>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.</p><p>3. Initially tighten the band clamp on clamp location 1 using right hand.</p><p>4. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after taping. Continue if the sequence light on clamp location 2 was ON.</p></div> <div><div></div><div><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>	n/a	<div></div> <div><p>Note: Make sure there's no clearance between terminal and stopper jig.</p><p>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</p></div>

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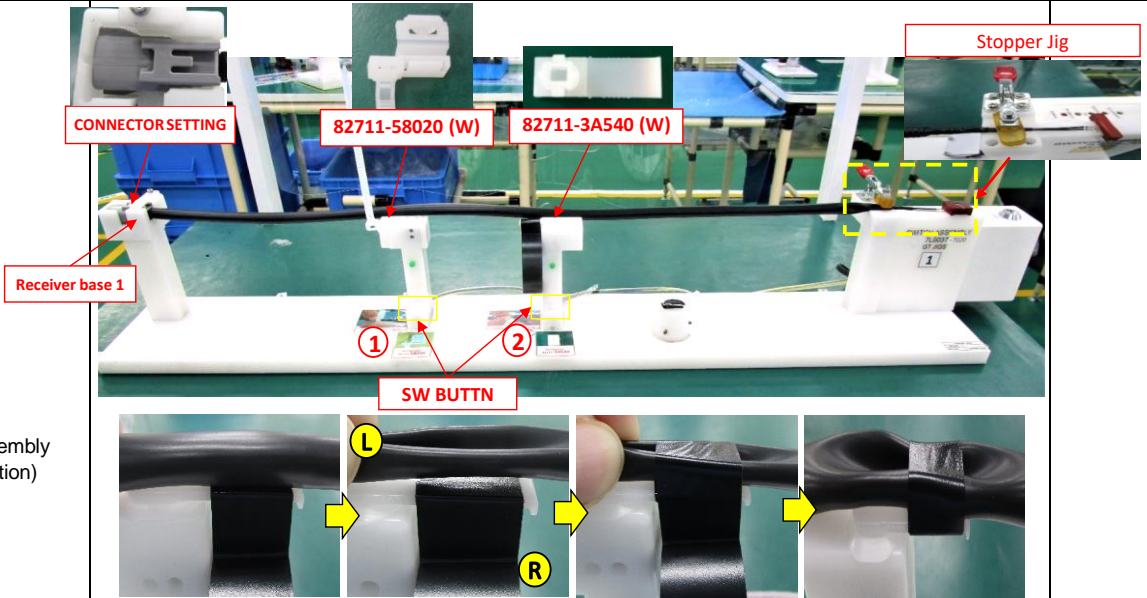

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Assembly (Continuation)	 <p>5. On clamp location 2, fold the vinyl tube. <i>(See above picture as guide)</i>. Make 3 windings before cutting of tape. Press the SW button after taping. Go sound will be heard.</p> <p>6. Conduct POINT CHECKING before removing the harness from jig.</p>	n/a	 <p>Note: Make sure there's no clearance between terminal and stopper jig.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No wrong insertion of connector5. Make sure no gap between terminal and stopper jig



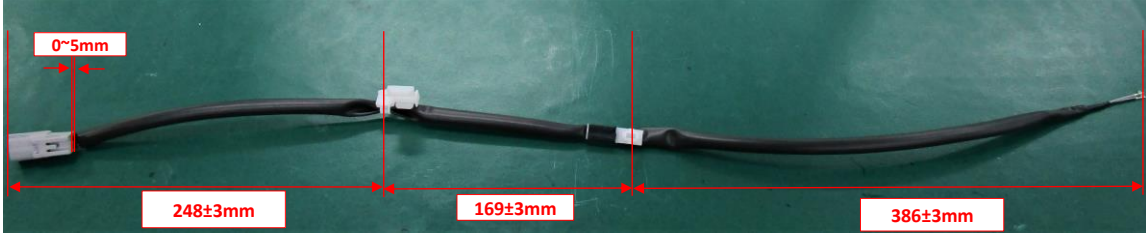
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PARTS: n/a		JIG n/a	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Visual/By Two's Inspection P2	<div> <div>1. Check the connector lock.</div> <div>3. Check the presence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

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