



WORK INSTRUCTION

Effectivity Date:

April 27, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

011B / 7M0366-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-177C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:				JIG:	
1. Clamp 82711-52090 (W) [5pcs] 2. Clamp 82711-3A540 (W)		3. Clamp 82711-48210 (B) 4. Black tape [8pcs]			1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp Asembly setting	<div> <p>1. Get 2pcs of clamp 82711-52090 (W) using right hand then set to jig clamp 1 and 2 using both hands.</p> <p>2. Get 3pcs of clamp 82711-52090 (W) using right hand then set to jig location 5, 6 & 8 using both hands.</p> <p>3. Get 1pc of clamp 82711-3A540 (W) using right hand then set to clamp location 7 using both hands.</p> <p>4. Get 1pc of clamp 82711-48210 (B) using right hand then set to clamp location 3~4 using both hands.</p> <p>5. Get Black tape and start pre-taping on from location 1~8 <i>Note: See above pictures for pre-tape sequence reference.</i></p> </div>		<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 damaged clamp 2. No wrong use of clamp</p> <p>STANDARD TAPING FOR CLAMP ONE SIDE</p> <div> </div>

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/27/21	3	Change clamp colors in accordance with color standardization for plastic parts refer to GL-COM-003; Put Black tape qty in parts section; Put measuring tape illustration and instruction in measurement	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
09/30/20	2	Change process owner from Production (WI-PRO-ASY-020) to Engineering (WI-ENG-PDE-177C); Apply some improvements/update pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Initial issue.	J. Montealto/ J. Briones	O. Merin	T. Sugiyama	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	July 10, 2017		

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PARTS:

1. Assy parts

JIG

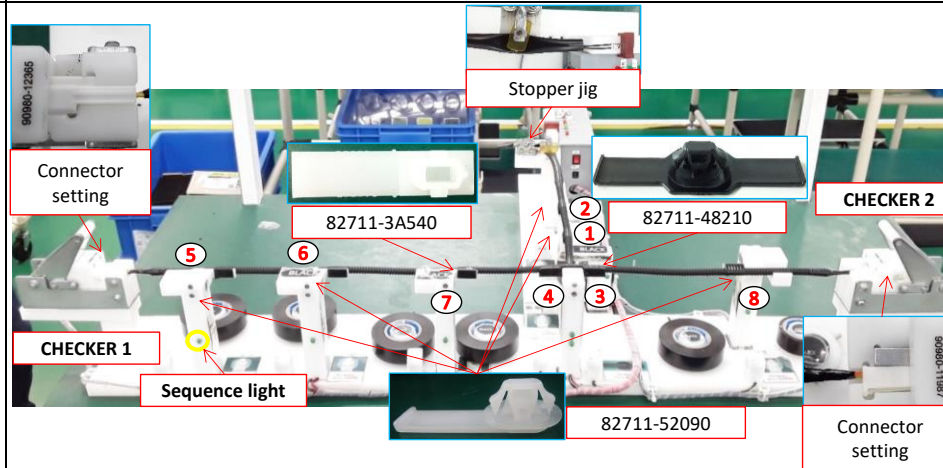
1. Clamp assembly jig

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

2

P3

Clamp Assembly



1. Get the assy part and set to jig using both hands. First, put the connector 6098-3802 to checker 1. Second, put the connector 6098-2220 and last, put the sunprene tube to toggle clamp.
Refer to above illustration for correct setting.

2. Check the LED light for **POWER, CLAMP, WIRE1&2** and **SEQUENCE** light is **ON**. If encountered abnormality, **STOP** the process, **CALL** the attention of Leaders and **WAIT** for instruction.

3. Proceed to taping process from clamp **location 1~8 (make 3 winds)** using both hands. Press the SW button after taping. Go sound will be heard after pressing SW button on location 8.

4. Conduct **POINT CHECKING** before removing from jig.

n/a



Make sure no clearance between terminal and stopper jig

1. No loose attachment of clamp
2. No peel-off tape
3. No flip out tape
4. No missing tape/clamp

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

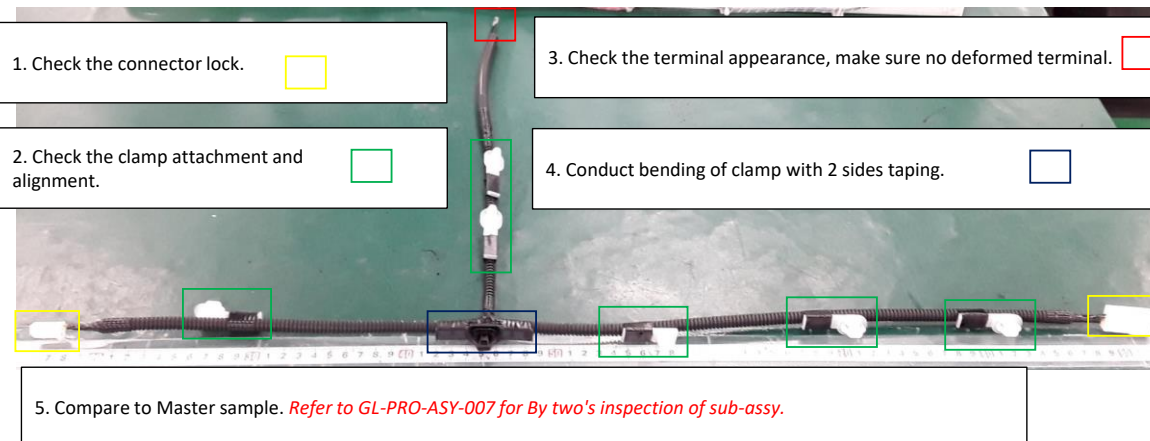
TOOLS/PPE

QUALITY POINTERS

3

Visual/By two's inspection

P3

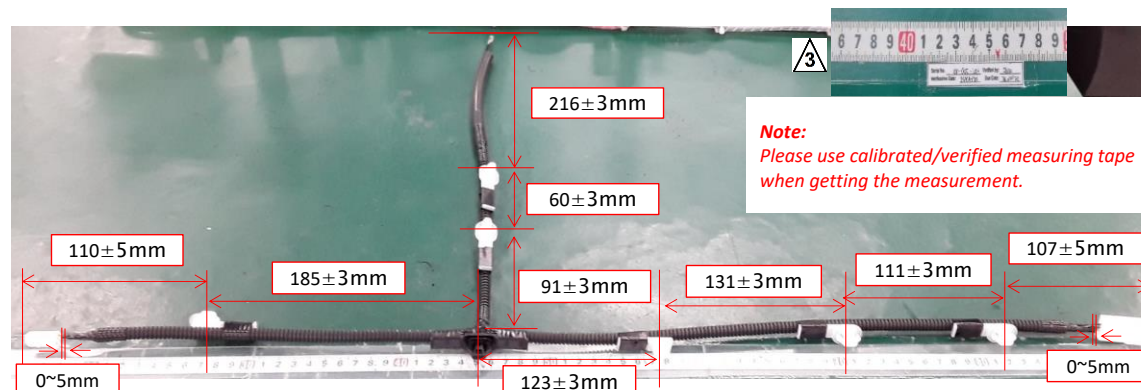


MASTER SAMPLE



4

Measurement



For HATSUMONO/OWARIMONO ONLY

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