

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 05, 2022**

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: **096B / A7075D**

Customer:

**TRQSS**

Document No.:

**WI-ENG-PDE-590C**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

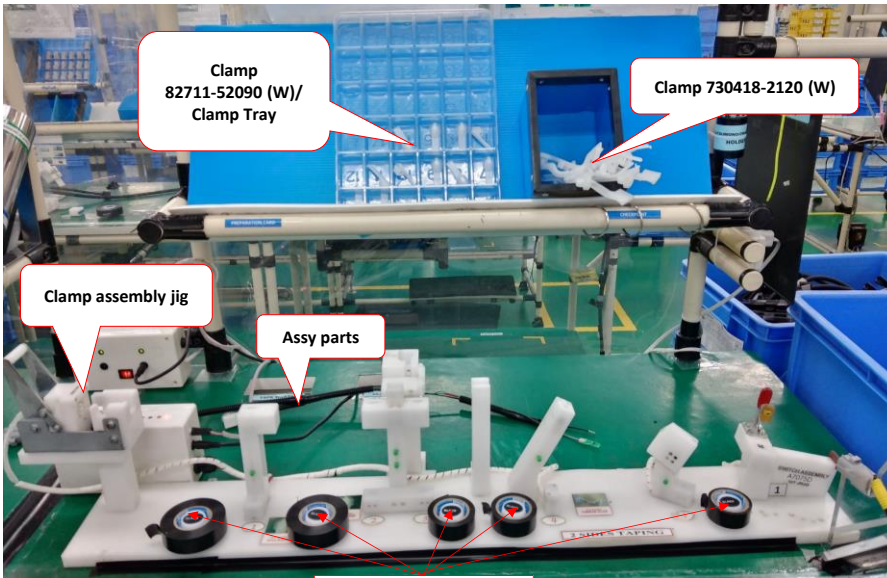
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**PARTS:**

1. Assy parts: Clamp Clamp 82711-52090 (W); Clamp 730418-2120 (W); Black tape [5pcs]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 1 Table lay-out	<p><b>Table Lay-out</b></p>  <p>Clamp 82711-52090 (W)/ Clamp Tray</p> <p>Clamp 730418-2120 (W)</p> <p>Clamp assembly jig</p> <p>Assy parts</p> <p>Black tape/Tape holder</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	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	Reviewed by	Approved by
10/05/22	1	Change document status from Pre-launch to masspro. Additional: Table-layout (Work illustration).	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/17/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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PARTS:		1. Clamp 82711-52090 [3pcs.] 2. Clamp 730418-2120 (W) (Protector)		3. Black tape [5pcs.]		JIG	1. Clamp assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
2	P3	Clamp setting	<div></div> <div>1. Get 3pcs. of clamp <b>82711-52090 (W)</b> using right hand then insert to clamp location <b>1, 2 and 3</b> using both hands.</div> <div>2. Get 1pc. of clamp <b>730418-2120 (W)</b> using right hand then insert to clamp location <b>4 and 5</b> using both hands.</div> <div>3. Get the <b>Black tape</b> then initially attach to clamp location <b>1,2 and 3</b> using both hands.</div>					<div><b>STANDARD TAPING FOR CLAMP</b></div> <div>One side tape under clamp</div> <div></div> <div><b>Important reminders/Note/s:</b> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div> <div>1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp</div>

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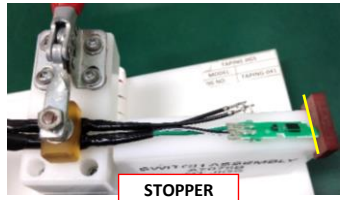
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PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly				
		<div></div> <div>1. Get the assy parts and set into jig. (<i>See above picture for correct setting</i>). First, set the connector <b>6098-3802 (W)</b> to <b>Checker 1</b> then pull the checker fixture. Continue to set the harness in jig. Next, set the connector <b>6098-3802 (W)</b> to <b>Receiver base 1</b>. Continue to set the harness in jig, put the <b>B-B wires and PCB</b> in stopper then press by <b>toggle clamp</b>. Continue if the sequence light in clamp location <b>1</b> was <b>ON</b>.</div> <div>2. Check if all <b>LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process.</div> <div>3. Hold the tape on clamp location <b>1</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>2</b> was <b>ON</b>.</div> <div>4. Hold the tape on clamp location <b>2</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>3</b> was <b>ON</b>.</div>			<div></div> <div>Important reminders/Note/s: <b>1. Make sure no gap between stopper and PCB</b></div>	1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape

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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3 Clamp assembly (Continuation)	<p>5. On clamp location <b>3</b>, conduct alignment of <b>COT1</b> and <b>COT2</b>. Hold the tape then make <b>3 windings</b> of tape before shifting. Make <b>1/2 shifting</b> going to other side until it reach the <b>Guide for end tape</b>. Make <b>3 windings</b> of tape then cut using both hands.</p>		<p><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between stopper and PCB</b></p> <p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p>	

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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	P3 Clamp assembly (Continuation)	 <p>6. process. Attach the tape using guide then make <b>3 windings</b> of tape before shifting. Make <b>1/3 shifting</b> going to other side until it reach the <b>Guide for end tape</b>. Make <b>3 windings</b> of tape then cut using both hands.</p>		<p><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between stopper and PCB</b></p> <p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p>	

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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	P3 Clamp assembly (Continuation)	      <p>7. On clamp location <b>3</b>, hold the tape then start taping process. Attach the tape using guide then make <b>3 windings</b> of tape before shifting. Make <b>1/3 shifting</b> going to other side until it reach the <b>Guide for end tape</b>. Make <b>3 windings</b> of tape then cut using both hands.</p> <p>8. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</p>		 <b>Important reminders/Note/s:</b> <b>1. Make sure no gap between stopper and PCB</b>  1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape	

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Visual/by two's inspection

**ACTUAL PRODUCT**

**Assembled parts**

**Master sample**

1. Conduct alignment of harness (**Engineering sample vs. assembled parts**) using both hands.

2. Check the **terminal and connector lock**.

3. Check the **insertion, presence of spot taping in wires and taping condition**.

4. Check the **presence of clamp and taping condition**.

**ENGINEERING SAMPLE**



1. No skip inspection process

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PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Visual/by two's inspection (Continuation)	<div><p>5. Check the <b>terminal, connector lock and presence of clamp</b></p></div> <div><p>6. Check the <b>insertion, presence of spot taping in wires and taping condition</b></p></div> <div><p>7. Check the <b>clamp and taping condition</b></p></div> <div><p>8. Check the <b>presence of tape in COT to tube and color of tape.</b></p></div> <div><p>9. Check the <b>taping condition, terminal and PCB appearance.</b></p></div>			<div><b>ENGINEERING SAMPLE</b></div>  <p>1. No skip inspection process</p>

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

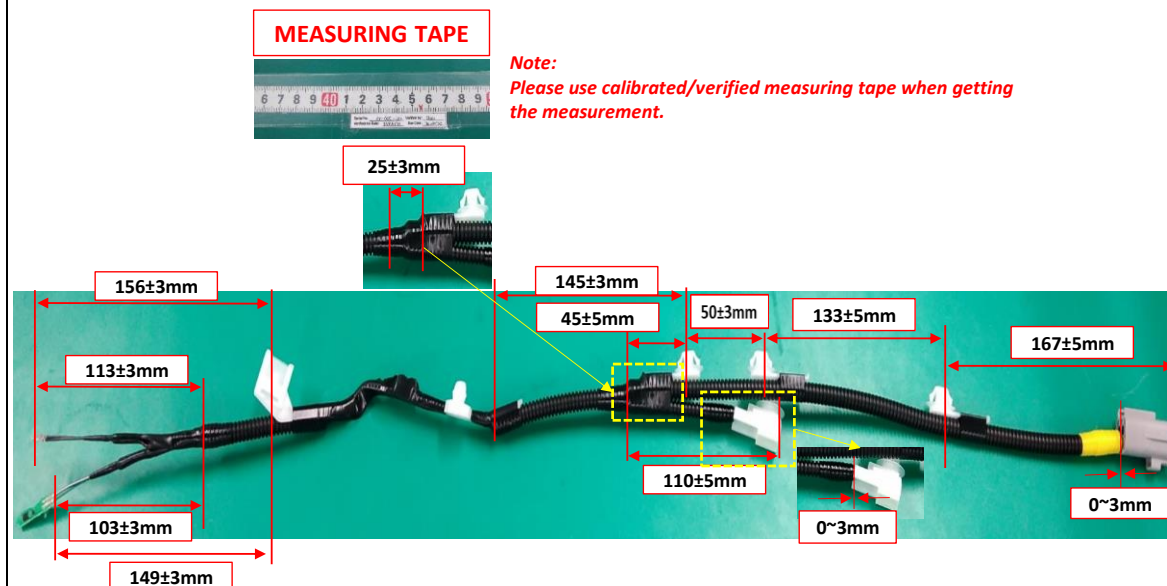
TOOLS/PPE

QUALITY POINTERS

5

P3

Measurement



Important reminders/Note/s:  
1. FOR HATSUMONO AND  
OWARIMONO

1. No wrong dimension

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