

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 25, 2021

Product Name/Code: **011B / 7M0369-7020A**Customer: **TRJ**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

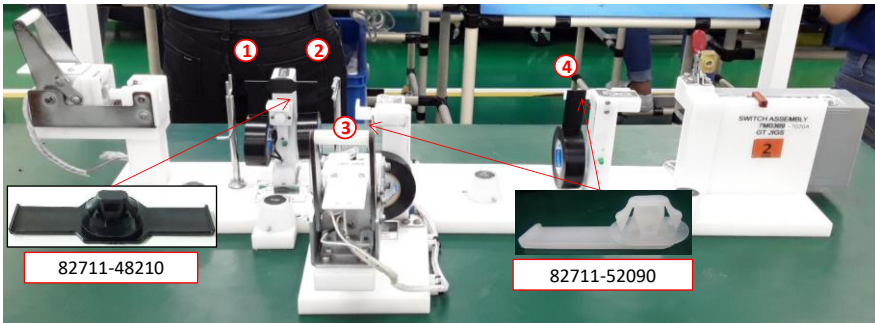
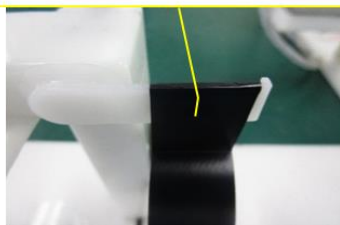
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS						
1	P3 Clamp assembly setting	<div><div><b>STANDARD TAPING FOR CLAMP</b> One side tape under clamp</div><div></div></div> <div><p>1. Get 1pc of Clamp <b>82711-48210 (B)</b> using right hand and set to location 1 using both hands.</p><p>2. Get 2pcs Clamp <b>82711-52090 (W)</b> using right hand and set to <b>location 3 and 4</b> using both hands.</p><p>3. Get Black tape using right hand and conduct pre-taping from <b>location 1, 2, 3 and 4</b>.</p></div>	<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<p>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. Taping should be one side under (taping side of clamp before taping with COT).</p>						
Revision History										
03/25/21	6	Change clamp color in accordance with color standardization for plastic parts refer to GL-COM-003 Add measuring tape illustration and instruction in measurement	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
09/17/20	5	Change process owner from Production (WI-PRO-ASY-064C) to Engineering (WI-ENG-PDE-175C); Apply some improvements/update pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
11/19/20	4	Remove marking/Include refer guidelines for By two's inspection	A. Roxas	W. Carbillon	O. Merin	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	January 29, 2018		

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**PARTS:**

1. Assy parts

**JIG**

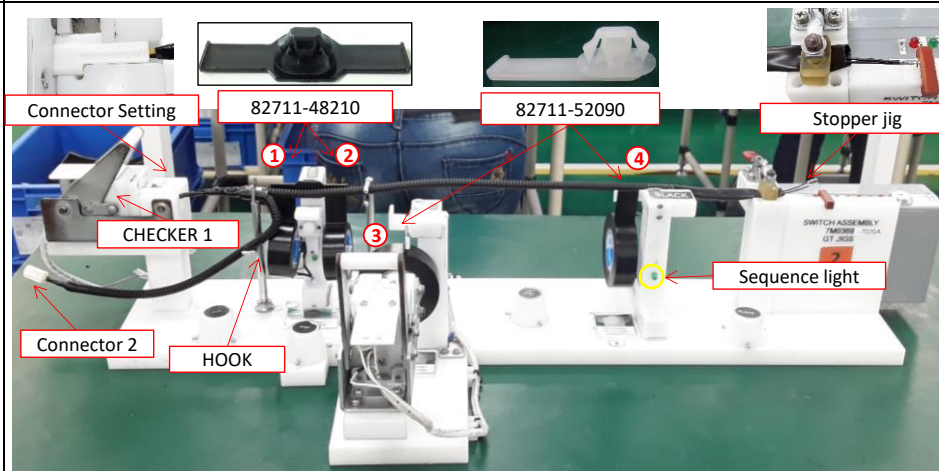
1. Clamp assembly jig

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

2

P3

Clamp Assembly



n/a

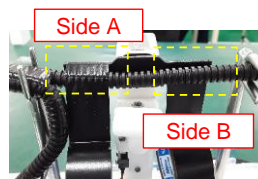
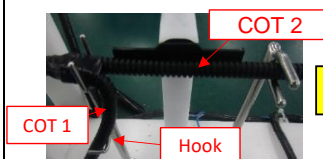
1. No wrong use of tape
2. No lacking and excess tape windings
3. No missing tape

1. Get the assy parts using right hand and set to jig using both hands. First, put the first Connector to checker 1, second, put the Sunprene tube to toggle clamp and last, . initially put the COT (with connector 2) in HOOK.

*Note: Refer to above illustration for correct setting*

2. Wrap the **COT2 & Side A** of the clamp (**2 windings**) using both hands.

3. Wrap the **COT2 & Side B** of the clamp (**2 windings**) using both hands.



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## PARTS:

1. Assy parts

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

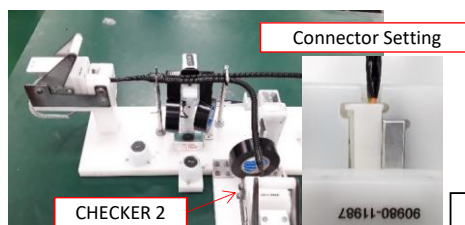
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

2

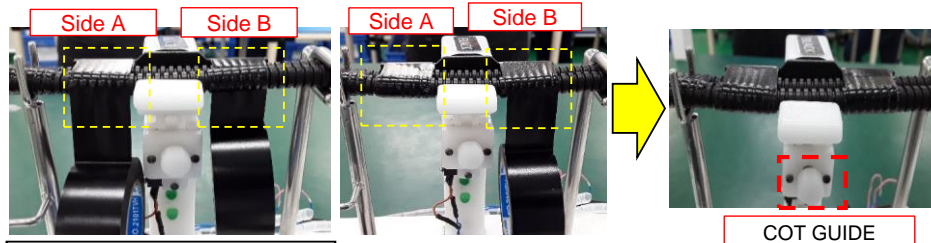
P3

Clamp Assembly  
(continuation)

4. Put the Connector 2 to checker 2 using both hands.  
*Refer to above illustration for correct setting.*



5. Check the LED light for **POWER, CLAMP, WIRE1** and **WIRE2** and **sequence light** is **ON**. If encountered abnormality, **STOP** the process, **CALL** the attention of Leaders and **WAIT** for instructions.



6. Combine the **COT1** and **COT2** from clamp **side A** (3 windings). Press the SW button after taping.

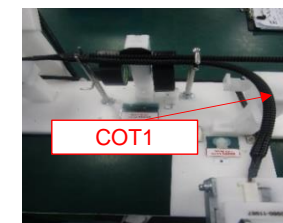
7. Combine the **COT1** and **COT2** from clamp **side B** (3 windings). Press the SW button after taping.

6

8. Tape clamp **82711-52090 (W)** location **3 & 4** (3 windings). Press the SW button after taping Go sound will be heard.

9. Press the COT guide using right thumb and conduct **POINT CHECKING** before removal from jig.

n/a



1. No wrong use of tape
2. No lacking and excess tape windings
3. No missing tape

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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

1. Check the connector lock.

2. Check the taping on COT to Sunprene. Conduct bending for verification.

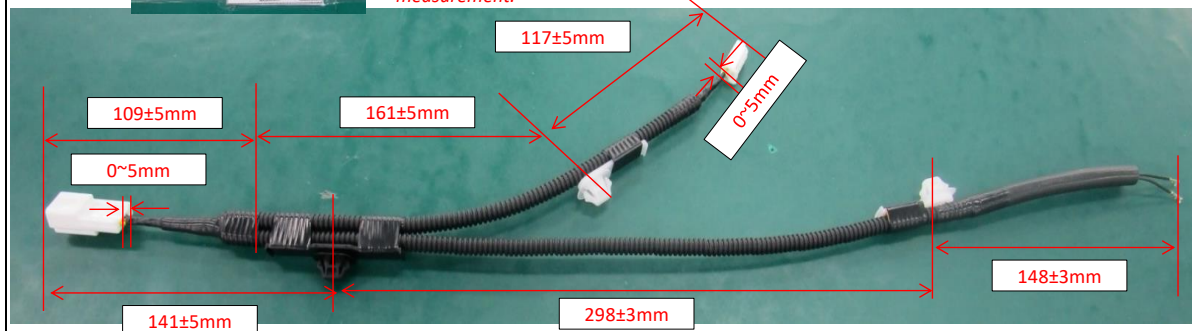
3. Check the terminal appearance.

4. Check the clamp attachment and taping condition.

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

4

Measurement

*Note:  
Please use calibrated/verified measuring tape when getting the measurement.***FOR HATSUMONO/OWARIMONO ONLY****CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.**NBC (Philippines)  
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