

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model code/Part number: **220D / 7L0134-7020**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 24, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-446C

Revision No.:

3

Page No.:

1 of 9**PARTS:**

1. Assy parts; Clamp 82711-52090(W); Clamp 82711-48070(GR); Black tape [5pcs.]

JIG:

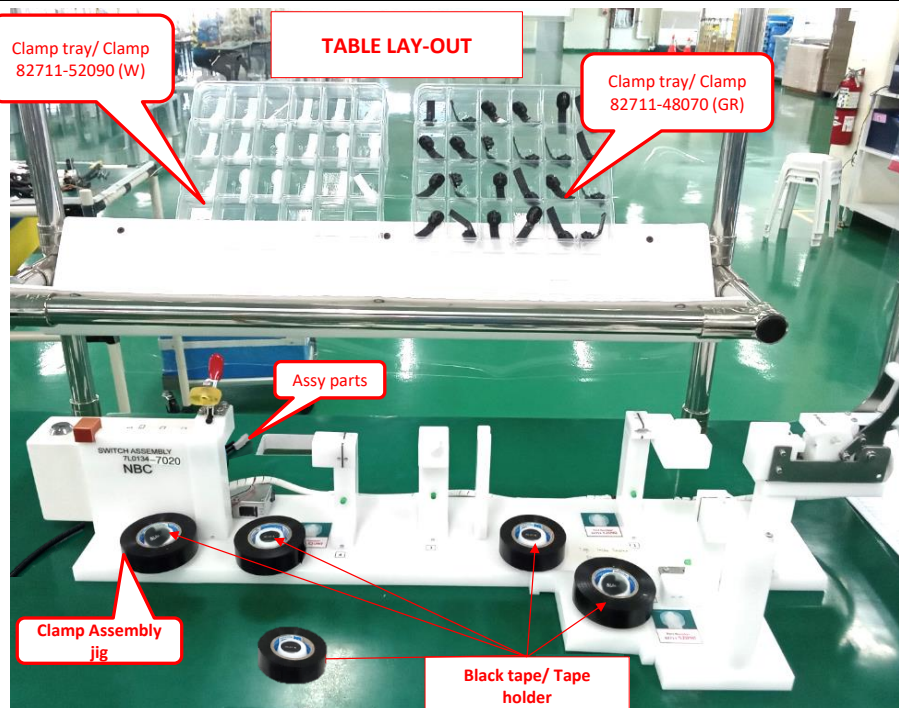
1. Clamp assembly jig

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

1

P3

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

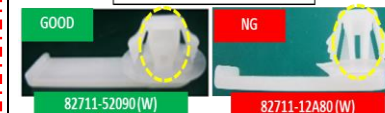
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

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
3. No wrong positions of parts/tools

CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/24/23	3	Inclusion of quality checkpoints	J.Loterte	C.Villanueva	A. Arañes	n/a				
09/23/22	2	Improve; Work procedure/Illustration on process no. 5 visual/by two's inspection and process no. 6 measurement. Quality pointers; Reminders/notes and references on pg. no. 1 to 8	M.Ariola	J.Loterte	C.Villanueva	A. Arañes				
03/28/22	1	Change Pre-launch to Masspro. Additional table Lay-out	M.Ariola	J.Loterte	C.Villanueva	A. Arañes				
03/09/22	0	Initial issue.	M.Ariola	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 9, 2022		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Product Number: **220D / 7L0134-7020**

Customer: **TRQSS**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Clamp 82711-52090(W) [3pcs]
2. Clamp 82711-48070 (GR)

3. Black tape [4pcs.]

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

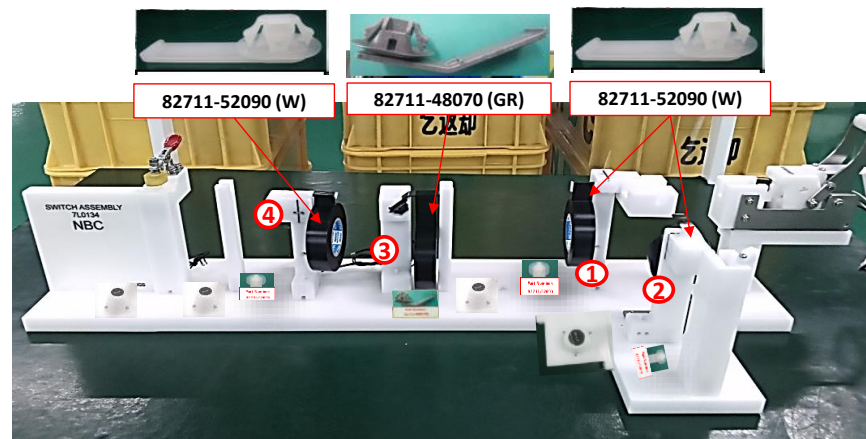
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp setting



1. Get **3pcs** of clamp **82711-52090 (W)** using right hand then set to clamp **location 1, 2 and 4** using both hands.

2. Get **1pc** of clamp **82711-48070 (GR)** using right hand then set to clamp **location 3** using both hands.

3. Initially attach **Black tape** to clamp **location 1, 2, 3 and 4** using both hands.

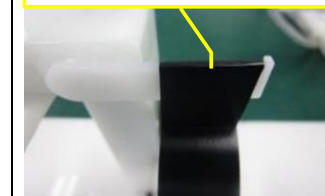
n/a

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Important reminders/Note/s:

1. Check the clamp first before start of assembly to avoid wrong use of clamp.

One side tape under clamp



CLAMP ILLUSTRATION



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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

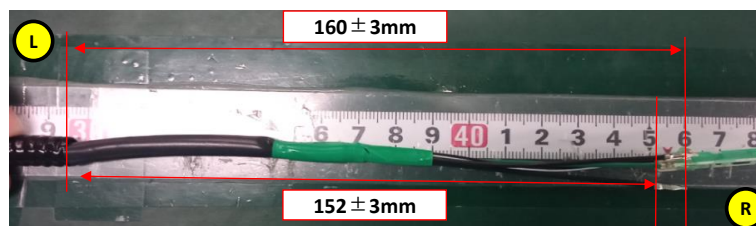
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

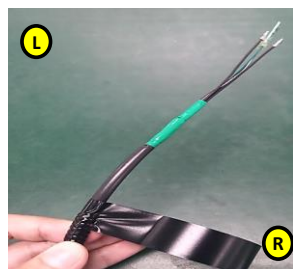
QUALITY POINTERS

3

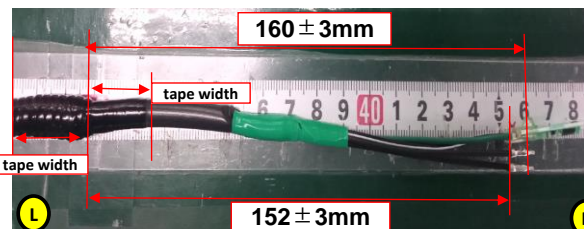
P3

Taping 5
Black COT to Sunprene
tube

1. Measure from end of sunprene tube up to edge of hotmelted wire **152±3mm** and up to terminal pointed tip **160±3mm** using both hands.



2. Get the **Black tape** using right hand then start taping process using both hands.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



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

Important reminders/Note/s:

1. Please use **calibrated/verified measuring tape when getting the measurement.**

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

WORK INSTRUCTION			
Process Name/Title:		TAPING ASSEMBLY PROCESS	
Model Code/Product Number: 220D / 7L0134-7020		Customer: TRQSS	
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

Effectivity Date:	April 24, 2023		
Validity Date:	n/a		
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PARTS:	1. Assy parts. 2. Black tape [4pcs]
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JIG	1.Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
-----	--------------	------------------------------	-----------	------------------

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape

Important reminders/Note/s:

1. Make sure no gap between the stopper jig and PCB

1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector 6188-0407 (W) to **Checker** then lock. Second, set the Y-taping into **Y-taping guide**. Third, set the connector 6098-3810 (W) to **Receiver base** then lock. Continue to set the harness in jig. Last, set the hotmelted wires and terminal end together within the stopper then press by **Toggle clamp**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2**, was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Check if the sequence light of **location 1** was **ON**.

3. Hold the tape on clamp **location 1**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp **location 2** was **ON**.

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WORK INSTRUCTION

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PARTS:

1. Assy parts
2. Black tape [4pcs]

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

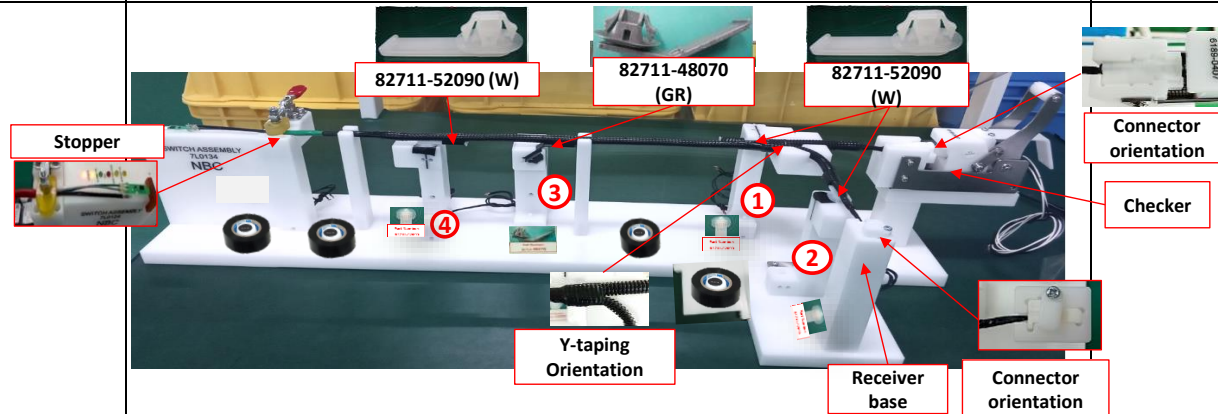
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Clamp Assembly
(Continuation)

4. Hold the tape on clamp **location 2**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp **location 3** was **ON**.

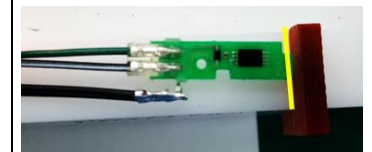
5. Hold the tape on clamp **location 3**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp **location 4** was **ON**.

6. Hold the tape on clamp **location 4**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **GO** sound will be heard.

7. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

8. For removal of harness from jig. First, remove the connector to Checker and Receiver base. Then, release the wire to toggle clamp. Last, remove the harness to Y-taping guide.

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape

**Important reminders/Note/s:**

1. **Make sure no gap between stopper jig and PCB.**

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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

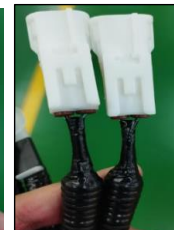
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P3

Visual/by two's
InspectionAssembled
partsMaster
sample

1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands

2. Check the **Connector lock, terminal and insertion and taping condition.**



3. Check the **Connector lock, terminal and insertion and taping condition.**



4. Check the **Y-Taping Condition**

n/a

1. No skip checking during inspection.

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7 of 9**PARTS:**

1. Assembled parts
2. Master sample

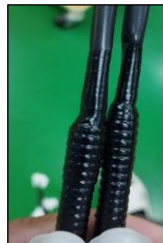
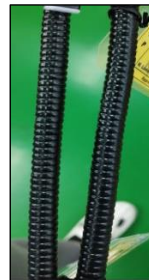
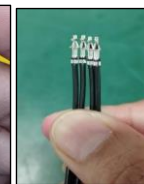
JIG

n/a

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

5

P3

Visual/by two's
Inspection (Continuation)5. Check the **presence of all clamp attachment** and **taping condition**.6. Check the **half-wrap taping condition**.7. Check the **taping condition, terminal** and **PCB appearance**. Must be **no deformed terminal**

n/a

1. No skip checking during inspection.

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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/Product Number: **220D / 7L0134-7020**Customer: **TRQSS**Purpose: **PROTOTYPE**☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

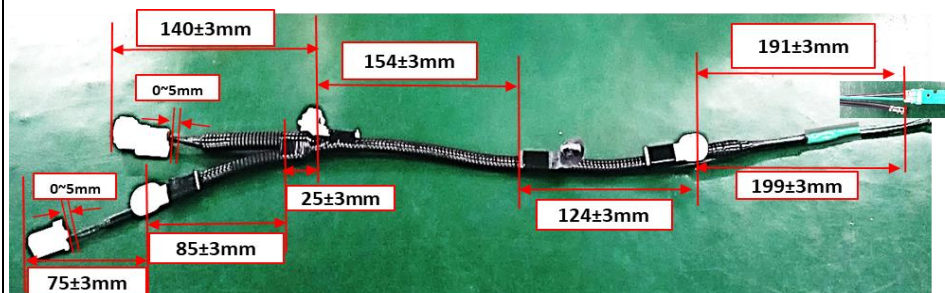
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

Measurement



MEASURING TAPE



1. No wrong dimension.

Important reminders/Note/s:**1. Please use calibrated/ verified measuring tape when getting the measurement.****2. For Hatsumono and owarimono**

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Model Code/Product Number: 220D / 7L0134-7020		Customer: TRQSS	Document No.:	WI-ENG-PDE-446C	
Purpose: PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	3	Page No.: 9 of 9

PARTS: n/a

JIG n/a

3 QUALITY CHECKPOINTS

P3

7L0134-7020



GOOD



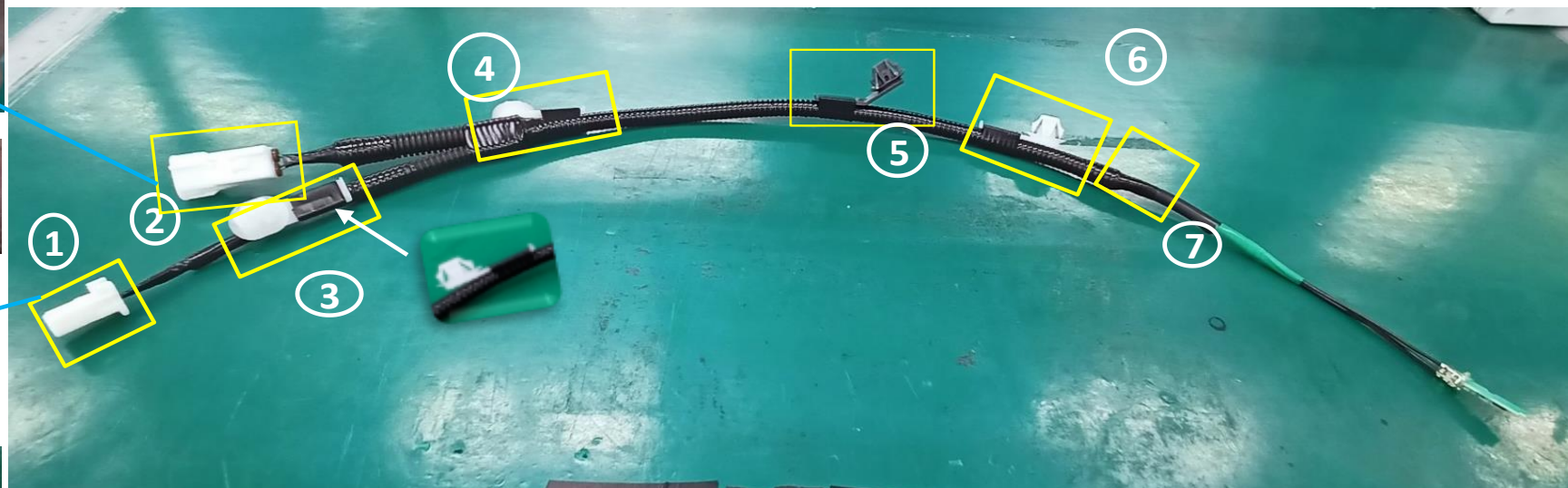
NO



GOOD



NO



① ② NO UNLOCKED/HALFLOCKED CONNECTOR

⑦ ⑧ No MISSING TAPE

③ ④ ⑤ ⑥ No MISSING CLAMP

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