

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

Effectivity Date:

December 10, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: **086D / 7N0162-7020**Customer: **TRJ**

Document No.:

WI-ENG-PDE-529B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

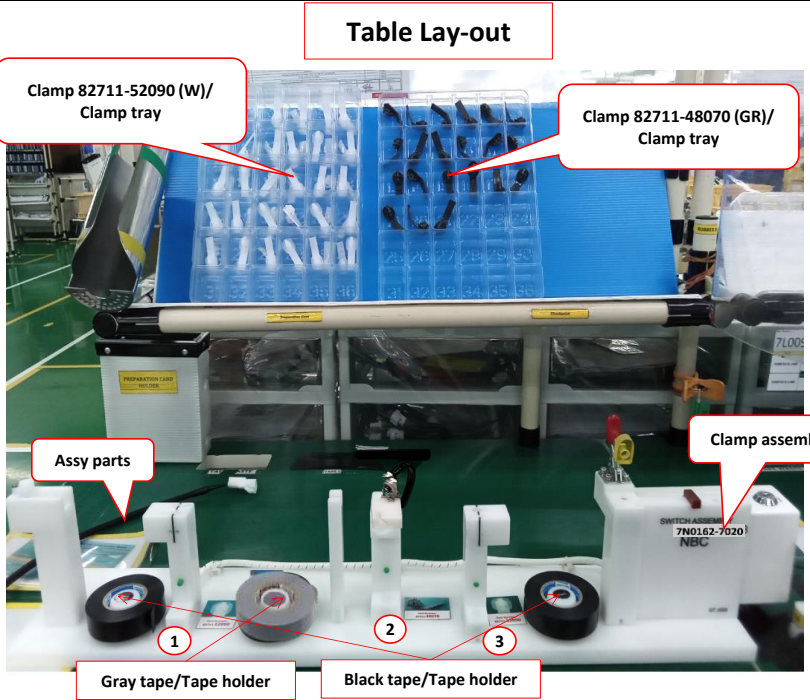
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PARTS:





1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [2pcs.]; Gray tape

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Reviewed by	Approved by
12/10/22	2	Improve quality pointers, notes reference in process no.2,3,4,5 and 6 as document improvement. Work procedure and illustration in process no.5 - visual/by two's inspection. Inclusion of quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
06/03/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
05/23/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					

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PARTS:

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

3. Black tape [2pcs.]
4. Gray tape [1pc.]

JIG

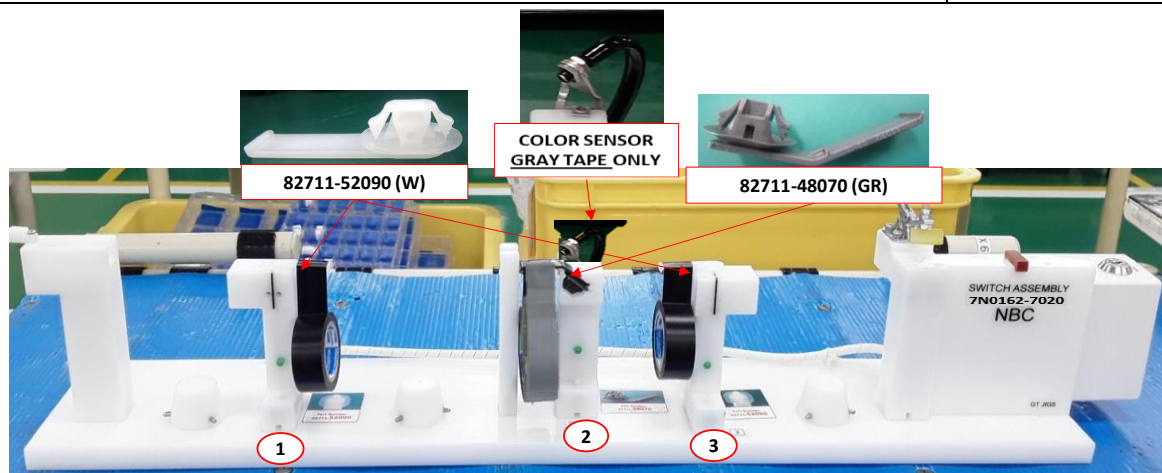
1. Clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****2 QUALITY POINTERS**

2

P2

Clamp setting



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

3. Initially attach **Gray tape** on clamp location **2** using both hands.

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

4. Initially attach **Black tape** on clamp location **1 and 3** using both hands.

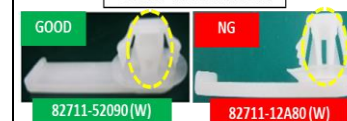
STANDARD TAPING FOR CLAMP

One side tape under clamp

**Important reminders/Note/s:**

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

CLAMP ILLUSTRATION

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

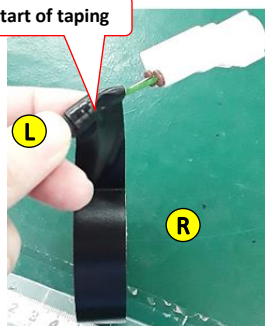
2 QUALITY POINTERS

3

P2

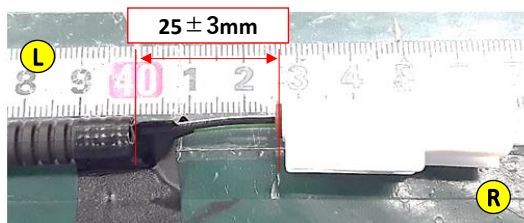
Taping 1
COT to wire near
connector

Start of taping

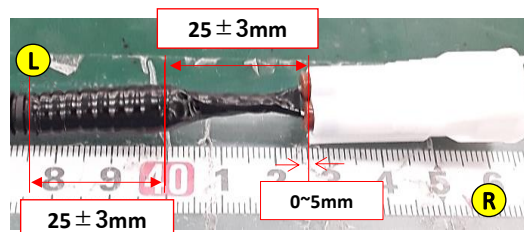


1. Hold the corrugated tube using left hand, get **Black tape** and start pre-taping using right hand.

MEASURING TAPE



2. Measure from end of corrugated tube up to the edge of connector **25±3mm** then continue the taping process using both hands



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

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

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TOOLS/PPE

2 QUALITY POINTERS

4

P2

Clamp assembly



1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector **6188-0407 (W)** to **Receiver base 1** then lock. Continue to set the harness then last, set the **G-B/W wires** together within the stopper then press by **Toggle clamp**. Continue 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. Press the **SW button** after taping. Continue the process if sequence light in location **2** was **ON**.

5. Hold the tape on clamp location **2**, make **3 windings** of tape then cut the tape. Press the **SW button** after taping. **Go** sound will be heard.

2. Check if all **LED light** for **POWER ON**, 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.

4. Hold the tape on clamp location **2**, make **3 windings** of tape then cut the tape. **Color sensor** light will beep/buzz if sensor detects **Gray tape**. Press the **SW button** after taping. Continue the process if sequence light in location **3** was **ON**.

6. Conduct **POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

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n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

2 QUALITY POINTERS

5

P2

Visual/By two's inspection

ACTUAL PRODUCT

Assembled parts

Master sample

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

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

3. Check the **presence of all clamp attachment, taping condition and presence of undertape.**

4. Conduct **bending of COT and tube** then check the **taping condition.**

5. Check the **terminal appearance.** Must be **no deformed terminal.**

MASTER SAMPLE

1. No skip checking during inspection.

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JIG

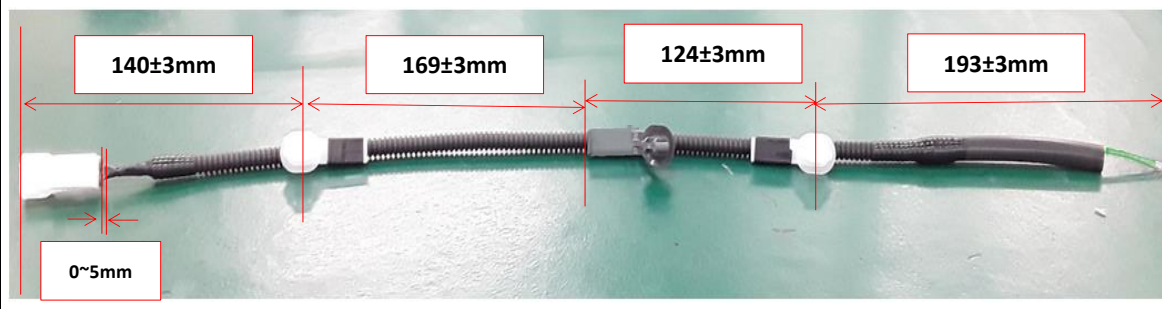
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****2 QUALITY POINTERS**

6

P2

Measurement

MEASURING TAPE**Note:***Please use calibrated/verified measuring tape when getting the measurement.***Important reminders/Note/s:**
1. FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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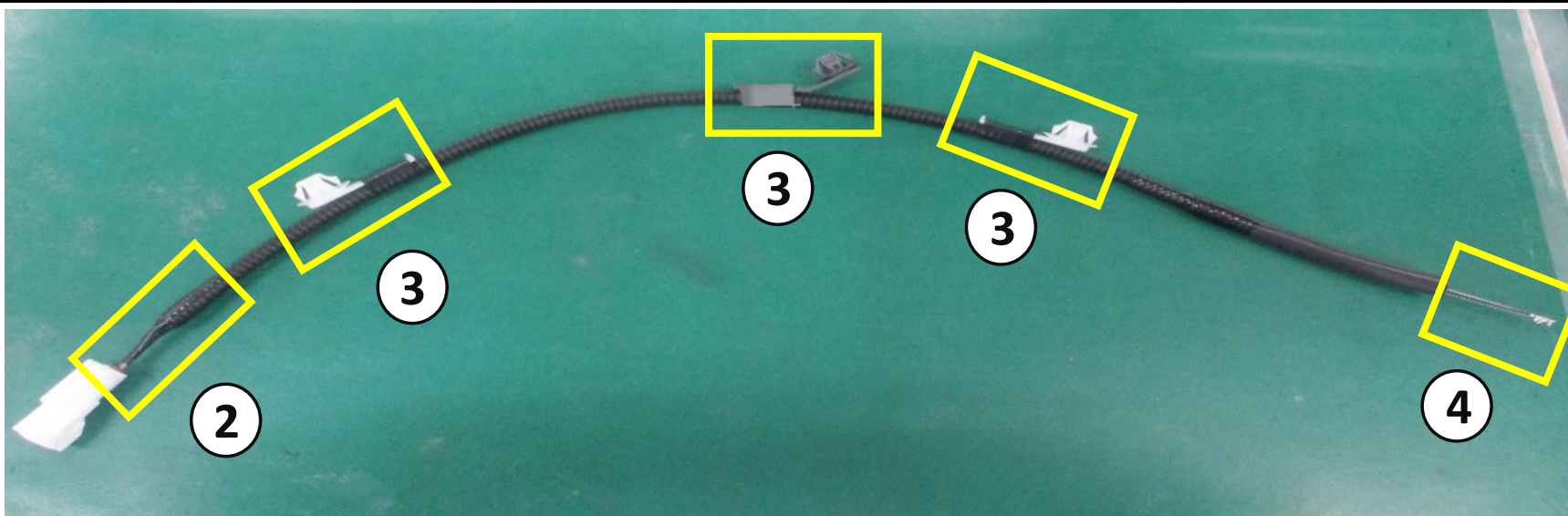
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n/a

JIG

n/a

2 QUALITY CHECKPOINTS**P2****7N0162-7020****GOOD****NO GOOD****1** No **Unlock Connector****2** No **Missing Tape****3** No **Missing Clamp (3pcs.)****4** No **Deformed Terminal****5** **Checking of Clamp Alignment**

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