



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 22, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code: 100B / 7M0594-7020D

Customer:

TRJ

Document No.:

WI-ENG-PDE-286D

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

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PARTS:

1. Clamp 82711-48210 (B)
2. Clamp 82711-3A640 (B)
3. Clamp 82711-35730 (B)

4. Clamp 82711-52090 (W)
5. Black tape [5pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

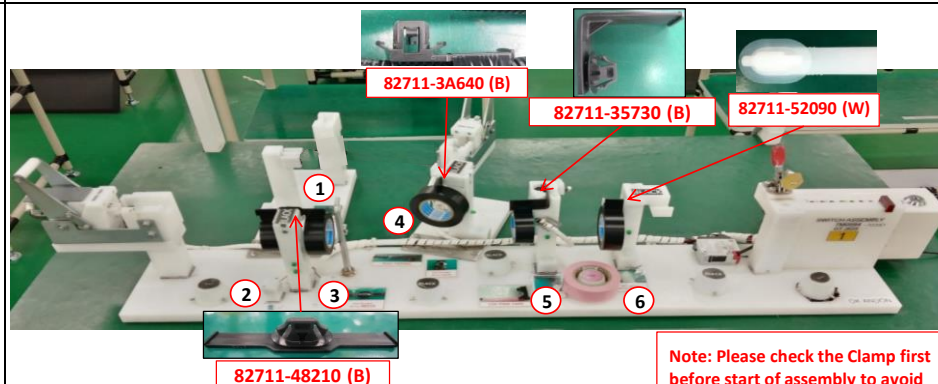
TOOLS/PPE

QUALITY POINTERS

1

P4

Clamp setting



1. Get 1pc. of clamp **82711-48210 (B)** using right hand then set to clamp location **2 and 3** using both hands.

2. Get 1pc. of clamp **82711-3A640 (B)** using right hand then set to clamp location **4** using both hands.

3. Get 1pc. of clamp **82711-35730 (B)** using right hand then set to clamp location **5** using both hands.

4. Get 1pc. of clamp **82711-52090 (W)** using right hand then set to clamp location **6** using both hands.

5. Initially attach **Black tape** on clamp location **2, 3, 4, 5 and 6** using both hands.

Safety Instruction

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

Housekeeping

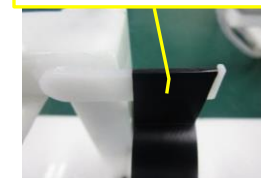
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

STANDARD TAPING FOR CLAMP

One side tape under clamp



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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/22/21	2	Transfer process owner from Production (WI-PRO-ASY-122A) to Engineering (WI-ENG-PDE-286A). Change clamp color in accordance with color standardization for plastic parts (Refer to GL-COM-003). Apply some improvements and update picture in all process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
03/17/20	1	Change process distribution/remove marker/markings/include hang of tape	J. Silang	A. Morcozo	O. Merin					
04/10/18	0	Previously established as Engineering instruction (EI-ENG-PDE-030). Initial issue	D. Castillo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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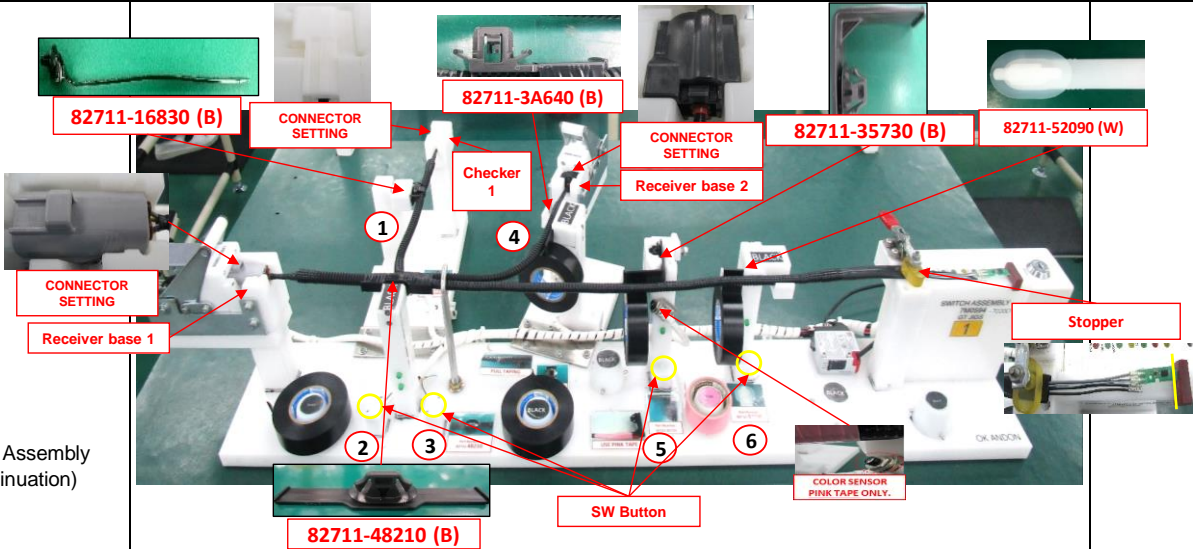

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PARTS:		1. Assy parts 2. Clamp 82711-16830 (W) 2. Black tape		JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P4 Clamp Assembly (Continuation)	<div></div> <div>1. Put the assy into jig. (See above picture for the correct setting). First, set the connector 6188-0066 (GR) to Receiver base 1 then pull the checker fixture for continuity checking. Second, set the connector 6098-3802 (W) to Checker 1. Third, set the connector 6189-1161 (B) to Receiver base 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the hotmelted wire and B/B wires together within stopper then press by toggle clamp.</div> <div>2. Check if all LED light for POWER ON, WIRE1, WIRE2 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.</div> <div>3. Get 1pc. of clamp 82711-16830 (W) using right hand then set to clamp location 1 using both hands.</div>		n/a	<div></div> <div>Note: Make sure no gap between stopper jig and hotmelted terminals.</div> <div>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</div>

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

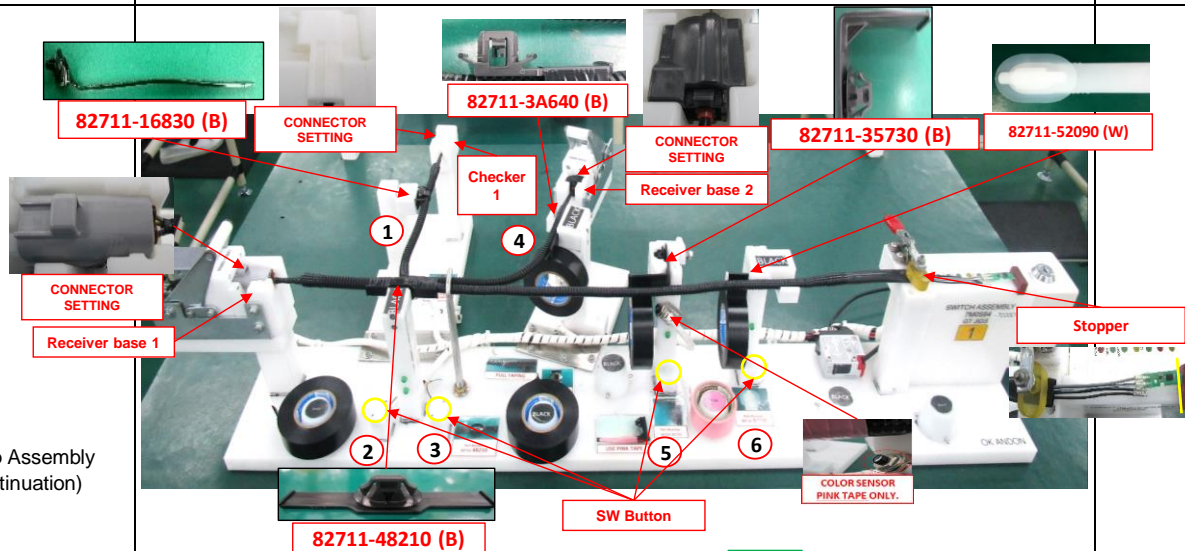
TOOLS/PPE

QUALITY POINTERS

2

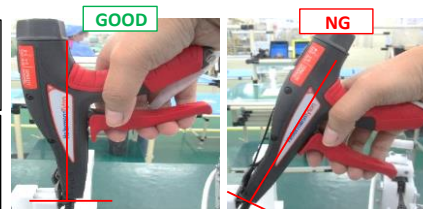
P4

Clamp Assembly
(Continuation)

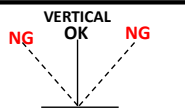


4. Initially tighten the band clamp on clamp location **1** using right hand.

5. Get the bando gun using right hand then cut the band clamp on location **1**. Press the **SW button** after taping. Continue if the sequence light on clamp location **2** was **ON**.



BANDO GUN ALIGNMENT



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$

n/a



Note: Make sure no gap between stopper jig and hotmelted terminals.

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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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

2

P4

Clamp Assembly
(Continuation)

n/a



Note: Make sure no gap between stopper jig and hotmelted terminals.

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

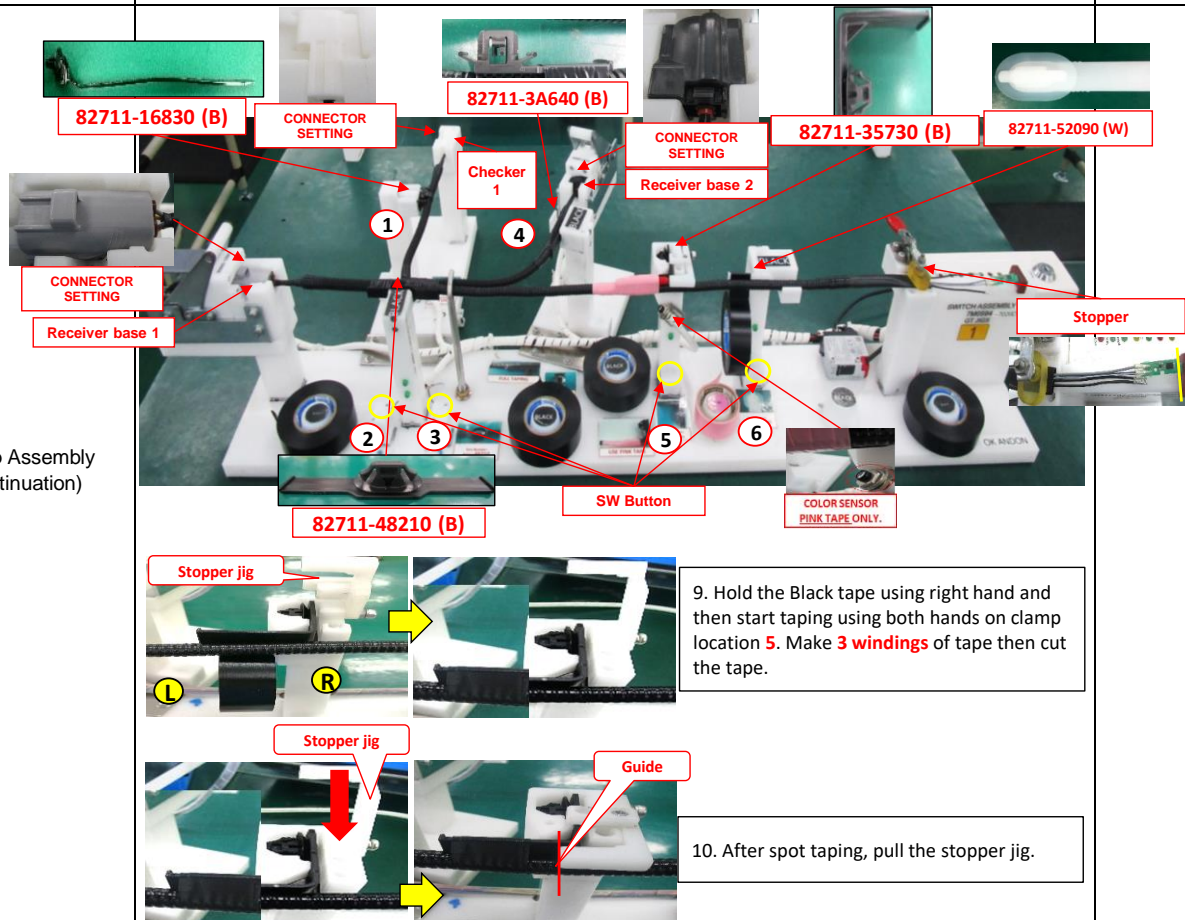
TOOLS/PPE

QUALITY POINTERS

2

P4

Clamp Assembly
(Continuation)



n/a



Note: Make sure no gap between stopper jig and hotmelted terminals.

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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PARTS:

1. Assy parts
2. Shaft Webbing stopper 7H0738-0200
3. Black tape

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

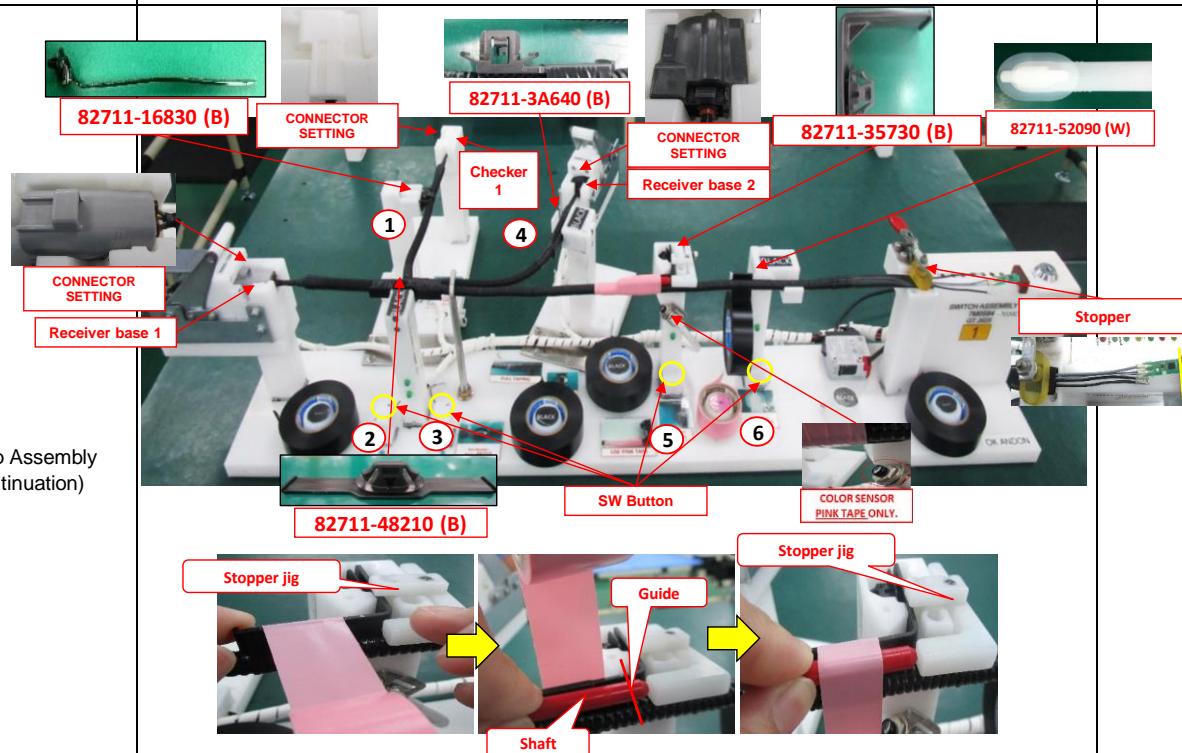
TOOLS/PPE

QUALITY POINTERS

2

P4

Clamp Assembly
(Continuation)



n/a



Note: Make sure no gap between stopper jig and hotmelted terminals.

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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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
2	P4 Clamp Assembly (Continuation)	<div><p>12. Make 1/3 shifting going to corrugated tube until it reach tape width then make 3 windings of tape before cut. Press the SW button after taping. Continue if the sequence light on location 6 was ON.</p></div>		n/a	<div><p>Note: Make sure no gap between stopper jig and hotmelted terminals.</p><ul style="list-style-type: none">1. No loose/tight clamp attached2. No damage clamp3. No missed tape4. No missing parts5. Make sure no clearance between PCB and stopper jig</div>

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

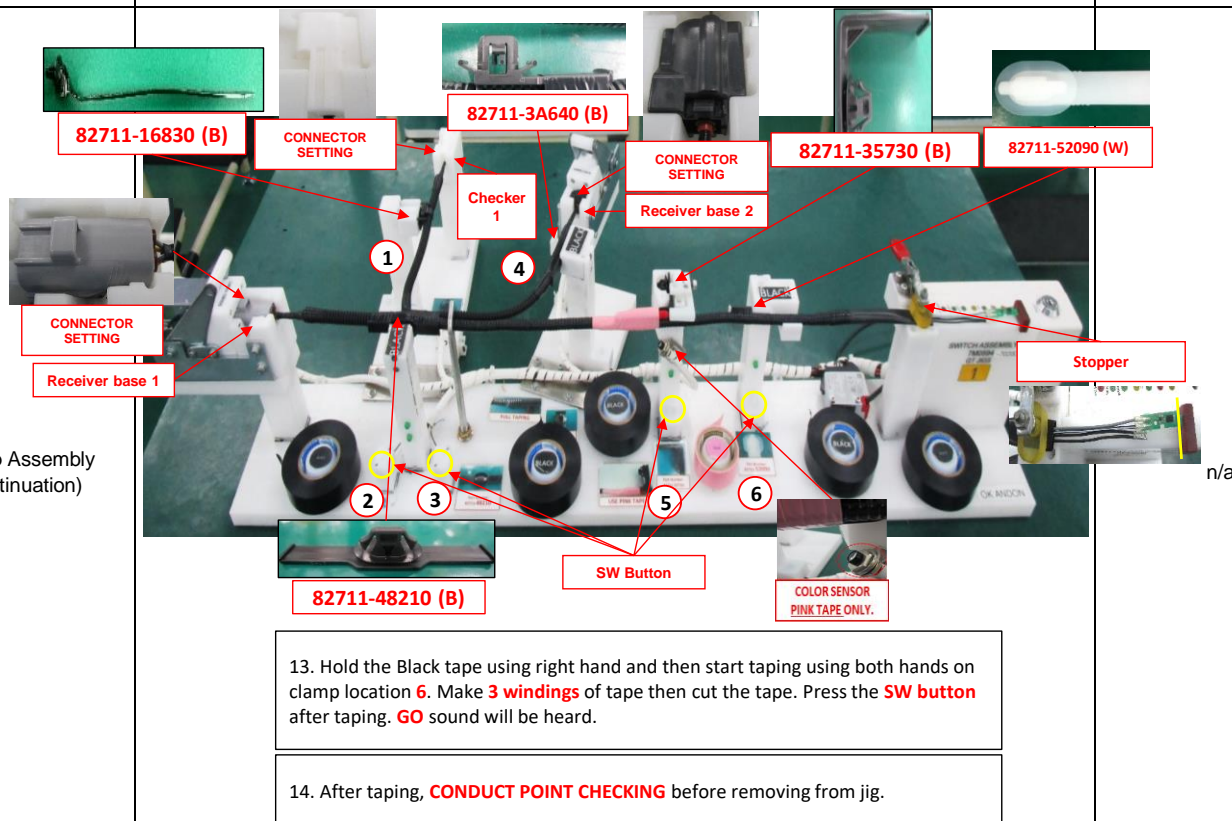
TOOLS/PPE

QUALITY POINTERS

2

P4

Clamp Assembly
(Continuation)



1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
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5. Make sure no clearance between PCB and stopper jig

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

2

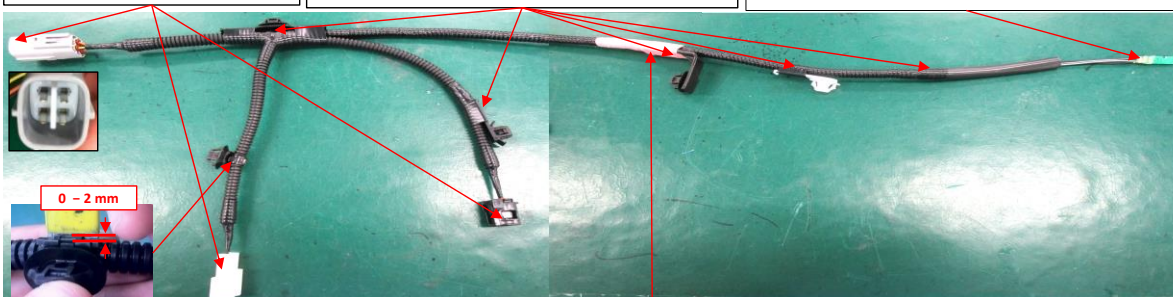
Visual/By Two's Inspection

P4

1. Check the connector lock

2. Check the presence of all clamp attachment and taping condition.

5. Check the terminal appearance, make sure no deformed terminal.



3. Using a steel rule, check if the band cut measurement is within the required dimension (**0~2mm**) and should not exceed the maximum value.

4. Check the presence of shaft.

6. Compare to Master Sample
Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy.

MASTER SAMPLE



4

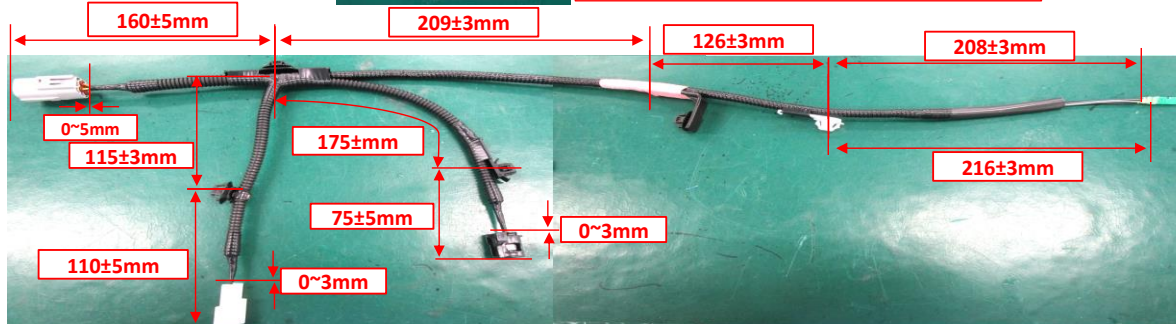
2

Measurement

MEASURING TAPE

Note:

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



NOTE: FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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