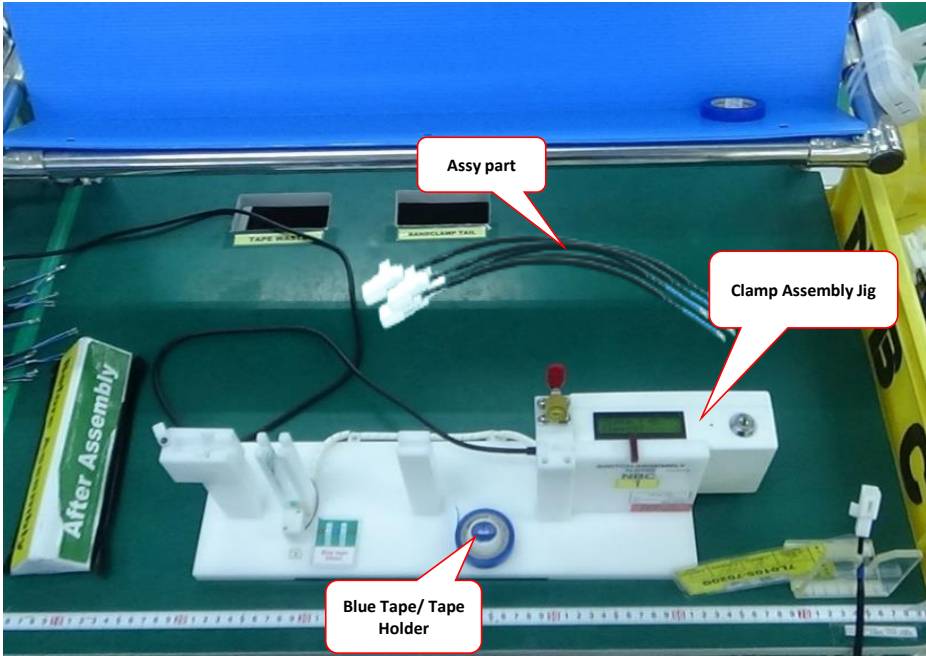
	WORK INSTRUCTION				Effectivity Date:		October 01, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: J34A / 7L0105-7020H		Customer: TRQSS	Car Model: MAZDA MX	Document No.:		WI-ENG-PDE-1076	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	1 of 4	

PARTS:		1. Assy parts; Blue Tape		JIG:		1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	CLAMP	Table Lay-out		<div>TABLE LAY-OUT</div>  <div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance</div> <div>1. No misisng parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools</div>	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change "pre-launch to mass pro".	A.Hernandez	C.Villanueva	A.Arañes	n/a	
09/24/24	0	Initial issue.	A.Hernandez	C.Villanueva	A.Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
							September 24 , 2024

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Purpose:



PROTOTYPE



PRE-LAUNCH



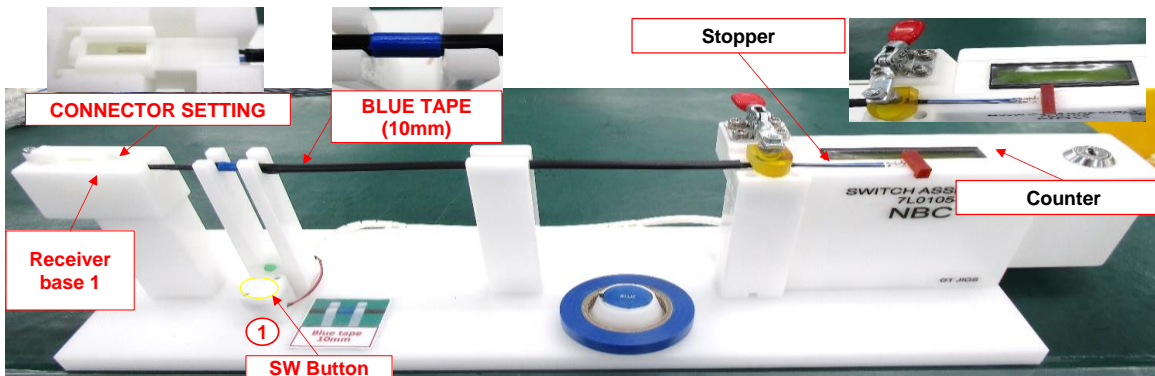
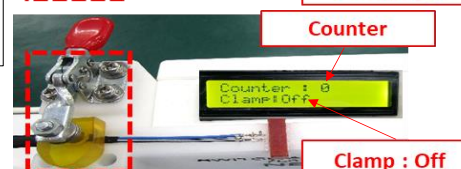
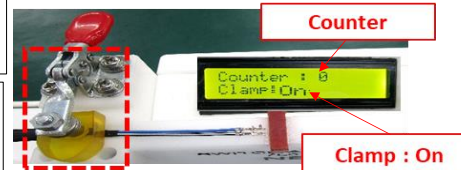

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PARTS:		1. Assy parts 2. Blue tape (10mm) [1pc.]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP	Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set to tester jig using both hands. <i>(See above picture for correct setting)</i>. First, set the <b>7182-8049 (W)</b> to <b>Receiver base 1</b> then lock. Continue to set the harness, last set the <b>L-B/W wires</b> together within the stopper jig then press by toggle clamp. Continue if the sequence light in location <b>1</b> was <b>ON</b>.</p><p>2. Check if the Clamp is <b>ON</b>. Check if location <b>1</b> sequence light 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 then continue the process.</p><p>3. Get the <b>Blue tape (10mm)</b> using right hand then conduct spot taping using both hands on location <b>1</b>. Make <b>2~3 windings</b> then cut the tape. Press the <b>SW button</b> using right index finger. <b>Go</b> sound will be heard.</p><p>4. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</p></div> <div><p><b>Make sure no gap between terminal and stopper jig.</b></p></div>	 <p><b>Important reminders/Note/s:</b></p> <p>1. Make sure no gap between stopper jig and Terminal</p> <p>2. Counter will be the basis of quantity of harness per box. Only <b>LEADER</b> are allowed to reset the counter.</p> <p>1. No wrong insert</p> <p>2. Make sure no gap between terminal and stopper jig</p> <p>3. No wrong use of tape</p> <p>4. No excess windings</p> <p>5. No missed tape</p>	

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PROTOTYPE



PRE-LAUNCH



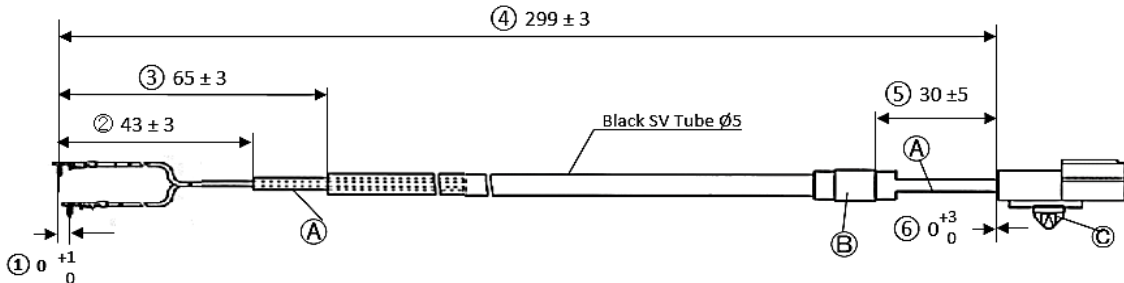
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP	Measurement	<div><p>④ 299 ± 3</p><p>③ 65 ± 3</p><p>② 43 ± 3</p><p>⑤ 30 ± 5</p><p>⑥ 0<sup>+3</sup><sub>0</sub></p><p>① 0<sup>+1</sup><sub>0</sub></p><p>Black SV Tube Ø5</p><p>Ⓐ</p><p>Ⓑ</p><p>Ⓒ</p></div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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PROTOTYPE

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PRE-LAUNCH

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PARTS:

n/a

JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7L0105-7020H



- 1 No Missing Tape (Black Tape)
- 2
- 3 No Missing Spot Tape (Blue Tape)

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