



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

October 6, 2021

Process Name/Title:

Validity Date:

n/a

Model code/Part number: **500B / 7L0084-7021**Customer: **TRQSS**

Document No.:

WI-ENG-PDE-043C

Purpose:

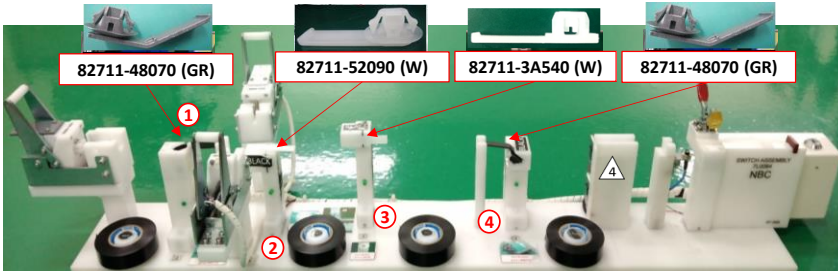
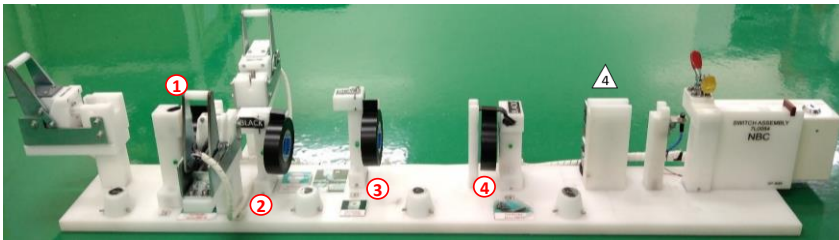

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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<b>PARTS:</b>	1. Black tape [4pcs] 2. Clamp 82711-48070 [2pcs]	3. Clamp 82711-52090 [1pc] 4. Clamp 82711-3A540 [1pc]	JIG:	1. Clamp Assembly jig						
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>						
1	P3 Clamp setting	<div><p>1. Get <b>2pcs.</b> of clamp <b>82711-48070 (GR)</b> using right hand then set to clamp location <b>1 and 4</b> using both hands.</p><p>2. Get <b>1pc.</b> of clamp <b>82711-52090 (W)</b> using right hand then set to clamp location <b>2</b> using both hands.</p><p>3. Get <b>1pc.</b> of clamp <b>82711-3A540 (W)</b> using right hand then set to clamp location <b>3</b> using both hands.</p></div> <div><p>1. Get the <b>Black tape</b> the initially attach to clamp location <b>1, 2, 3 and 4</b> using both hands.</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>	<div><b>STANDARD TAPING FOR CLAMP</b></div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div><b>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div>						
Revision History										
10/06/21	4	Change part number from 7L0084-7020A to 7L0084-7021 due to change of tape color from Black tape to Blue tape on COT to sunprene tube. Installation of additional color sensor into clamp assembly jig.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
02/20/21	3	Remove cycle time; Change clamp colors in accordance with color standardization for plastic parts; (Please refer to GL-COM-003); Put calibrated measuring tape illustration and instruction on measurement	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/28/19	0	Initial issue	J. Loterte	A. Shimamura	A. Arañes	-				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 28, 2019		

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#### PARTS:

$\triangle$  4

1. Assy parts
2. Blue tape [1pc]

#### JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

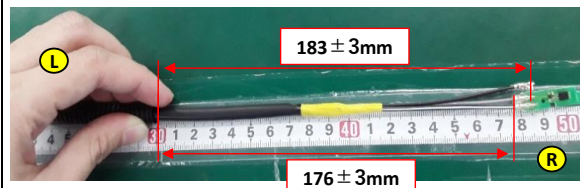
TOOLS/PPE

QUALITY POINTERS

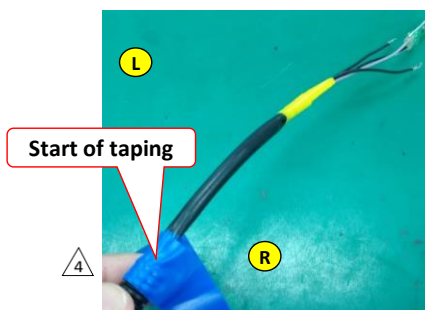
2

P3

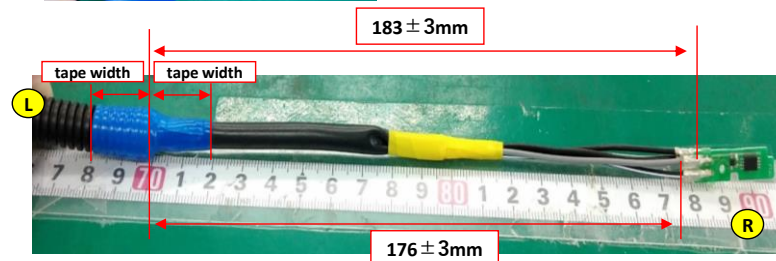
Taping 1  
Corrugated tube to  
Sunprene tube



1. Hold corrugated tube then measure from end of COT up to end of hotmelted wire  $176 \pm 3\text{mm}$ , from COT to terminal pointed tip  $183 \pm 3\text{mm}$ .

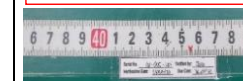


2. Get the **Blue tape** using right hand then start taping process using both hands.  
*Note: Please refer to WI-PRO-ASY-001 for taping procedure.*



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

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

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PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp Assembly	<div><p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector <b>6188-0066 (GR)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>6189-0451 (W)</b> to <b>Checker 2</b> then pull the checker fixture for continuity checking. Third, set the connector <b>6098-3810 (W)</b> to <b>Receiver base 1</b> then lock. Continue to set the harness in jig. <b>Color sensor 1</b> will beep/buzz if sensor detects <b>Blue tape</b>. <b>Color sensor 2</b> will beep/buzz if sensor detects <b>Yellow tape</b>. Last, set the hotmelted wires and terminal end together within the stopper then press by <b>Toggle clamp</b>.</p><p>2. Check if all LED light for <b>Power On, Clamp On, Wire1 &amp; Wire2, Color sensor 1 and Color sensor 2</b> 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. Continue if the sequence light of location <b>1</b> was <b>ON</b>.</p></div>	n/a	<div><p><b>Make sure no gap between stopper and PCB</b></p></div> <div><p><b>Stopper</b></p></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>

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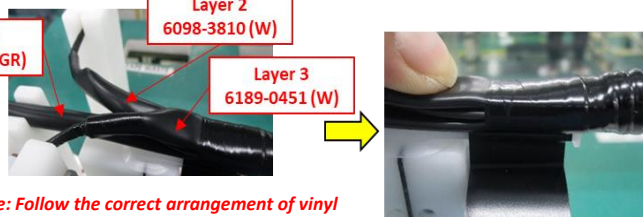
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NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3	Clamp Assembly (Continuation)	<div><div><div>Layer 1 6188-0066 (GR)</div><div>Layer 2 6098-3810 (W)</div><div>Layer 3 6189-0451 (W)</div></div><div></div><p><i>Note: Follow the correct arrangement of vinyl tubes before taping.</i></p><div>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light in clamp location 2 was <b>ON</b>.</div><div>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light in clamp location 3 was <b>ON</b>.</div><div>5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light in clamp location 4 was <b>ON</b>.</div><div>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. <b>GO</b> sound will be heard.</div><div>7. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</div></div> <td>n/a</td> <td>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</td>	n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position	

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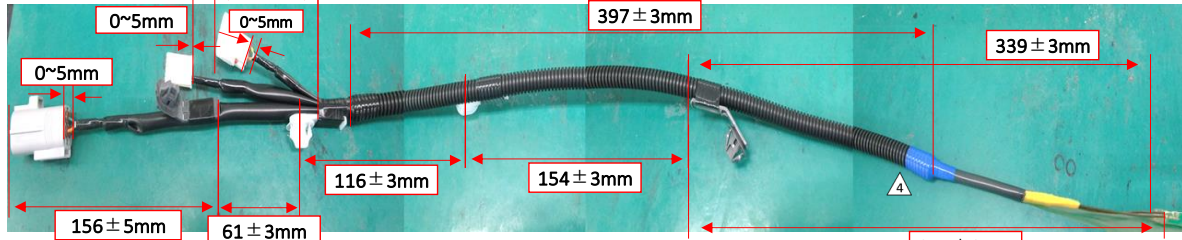
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PARTS:		n/a	JIG		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Visual Inspection/By Two's inspection	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment and taping condition</div> <div>3. Check the terminal and hotmelted wire appearance. Make sure no deformed terminal.</div>  <div>4. Compare to MASTER SAMPLE. <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div>		<div>4</div> <div>MASTER SAMPLE</div> 
5			<div>100 ± 5mm</div> <div>86 ± 5mm</div> <div>0~5mm</div> <div>0~5mm</div> <div>0~5mm</div> <div>156 ± 5mm</div> <div>61 ± 3mm</div> <div>116 ± 3mm</div> <div>154 ± 3mm</div> <div>397 ± 3mm</div> <div>339 ± 3mm</div> <div>347 ± 3mm</div>  <div>MEASURING TAPE</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> 		<div>NOTE: HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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