

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

August 5, 2021

Product Name/Code: **370B / 7L0044-7022A**

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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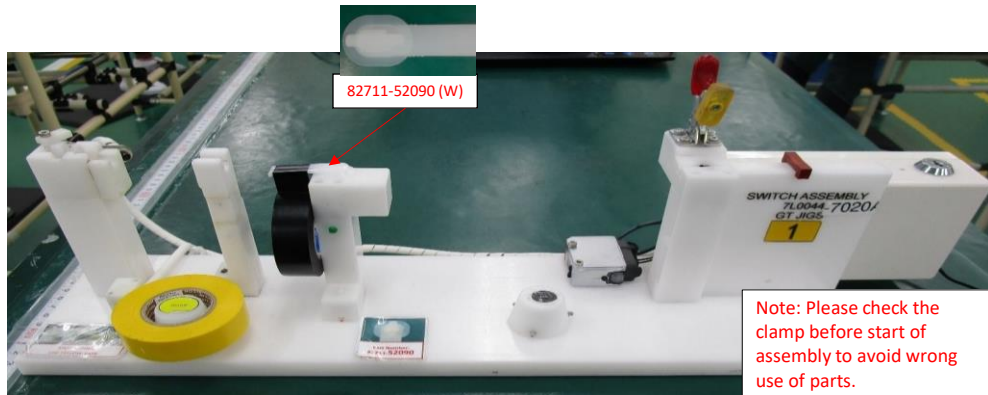
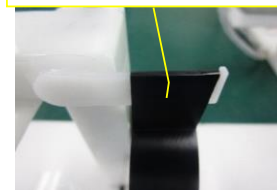
PARTS:

1. Clamp 82711-52090 (W)
2. Black tape

3. Yellow tape

JIG:

1. Clamp Assembly Jig

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS | | |
|------------------|--------------|---|---|--|--------------|-------------|
| 1 | P2 | <div>Clamp assembly setting</div> <div></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>STANDARD TAPING FOR CLAMP </div> <div>1. No wrong use of clamp 2. No damage clamp 3. No wrong use of tape</div> | | |
| Revision History | | | | | | |
| 08/05/21 | 2 | Transfer process owner from Production WI (WI-PRO-AST-071B) to Engineering WI (WI-ENG-PDE-292B). Improve process illustration and quality pointers. | J. Loterte | C. Villanueva | A. Shimamura | A. Arañes |
| 05/25/19 | 1 | Include distribution of process materials and use of tape. | J. S. S. S. | A. Morcozo/W. Carillon | C. S. S. S. | n/a |
| 12/01/17 | n/a | Previously established Engineering Instruction (EI-ENG-PDE-005). Initial issue. | J. Loterte | R. Alcantara | A. Arañes | T. Sugiyama |
| Eff. Date | Rev. No | Details of Change | Revised | Checked | Approved | Noted |
| | | | Est. Date: | September 24, 2018 | | |

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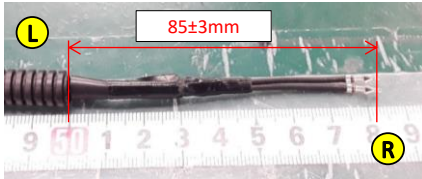
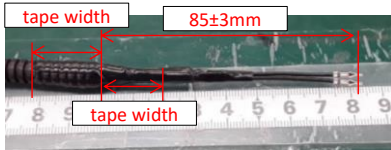


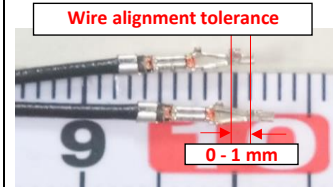
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| PARTS: | | 1. Black tape 2. Assy parts | | | JIG | n/a |
|--------|--------------|--|--|--|---|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P2 | <div><div><p>1. Hold the corrugated tube using left hand, measure from COT up to the terminal pointed tip <u>85mm</u> using both hands.</p></div><div><p>3. After taping, check the measurement and taping condition and wire alignment.</p></div></div> <div><p>2. Hold the corrugated using left hand then start taping using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> | | |  <p>MEASURING TAPE</p> |  <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape</p> <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> |

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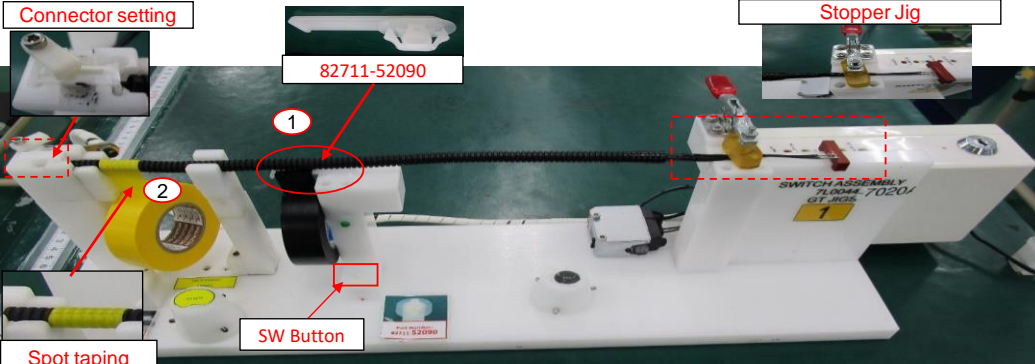
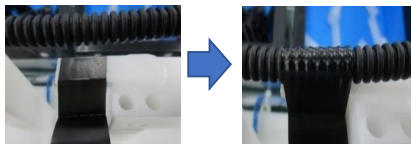
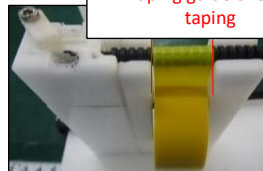

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| PARTS: | | 1. Assy parts | | JIG | 1. Clamp Assembly Jig |
|--------|--------------|------------------------------|--|-----------|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | P2 | Clamp Assembly | <div><p>Connector setting</p><p>Spot taping</p><p>1. Put the assembly on the jig. Put first the connector in receiver base using right hand then lock. Second, put the terminal into stopper jig using right hand then pull down the toggle clamp using left hand. Make sure no clearance between the terminal and stopper jig. <i>(See above picture for the correct setting)</i></p><p>2. Get the yellow tape and begin taping the spot tape of COT on location 2. Make 3 winds then cut.</p><p>3. Start taping the clamp with tape under to COT on location 1 and make 3 windings. Press the SW button after taping.</p><p>4. Conduct POINT CHECKING of taping (COT to vinyl), spot taping & clamp before removing to Clamp Assembly Jig.</p></div> <div><p>Tape the clamp side before COT</p><p>Taping guide of Spot taping</p></div> | n/a | <p>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between terminal and stopper jig.</p>  <p>Make sure no gap between terminal and stopper jig</p> |

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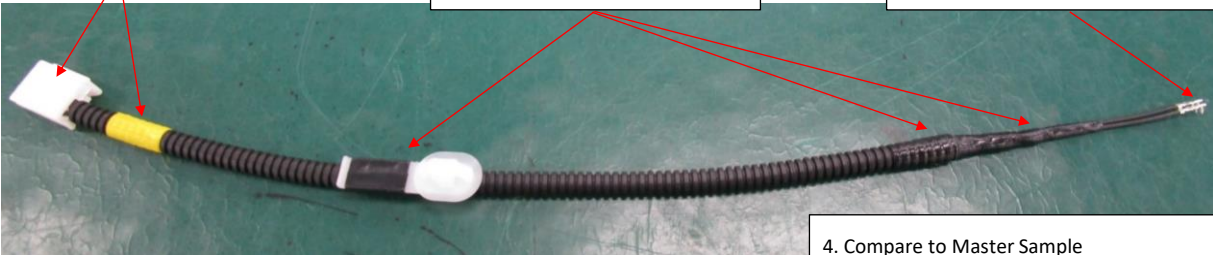

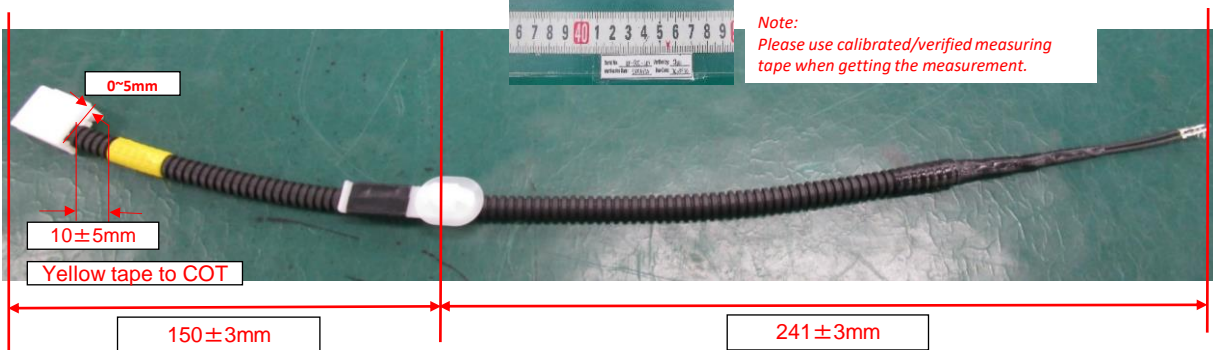
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| PARTS: | | n/a | JIG | | n/a |
|--------|----------------------------|---|-----|---|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Visual/By two's inspection | <div>1. Check the connector lock and presence of spot tape.</div> <div>2. Check the clamp attachment and taping condition</div> <div>3. Check the terminal appearance and wire alignment. 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>  | |  | |
| 5 | Measurement |  <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> | | | <div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div> |

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