



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	November 12, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-184B		
Revision No.:	4	Page No.:	1 of 6

Process Name/Title:

Model Code/Part Number: 150B / 4 7L0060-7022

Customer:

TRQSS

Purpose:



PROTOTYPE



PRE-LAUNCH



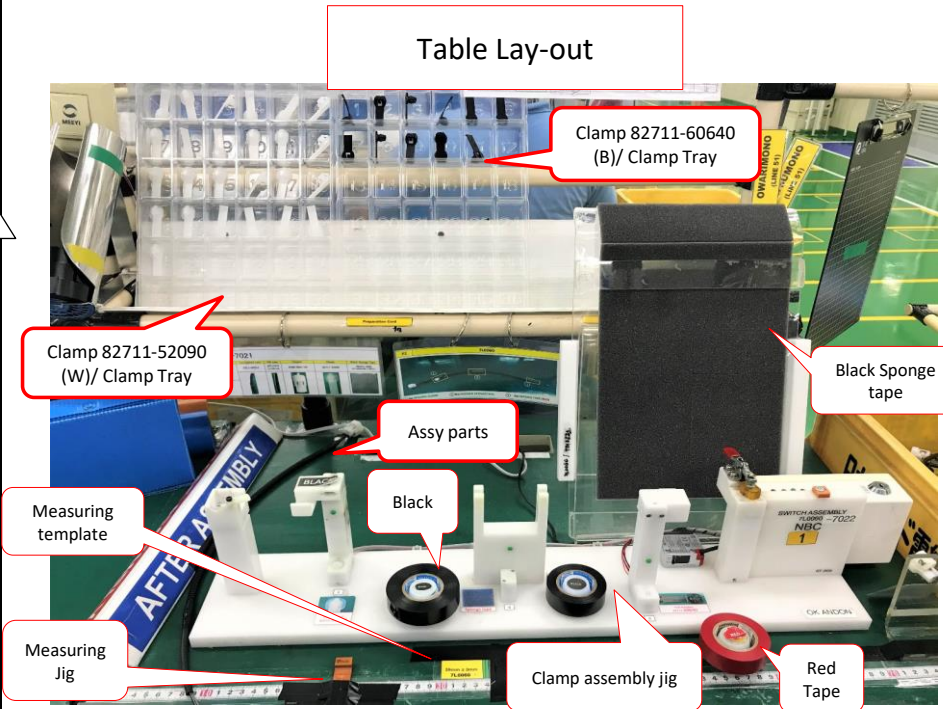
MASSPRO

PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-60640 (B); Black Sponge tape

JIG:

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	Revise	Check	Approve	Noted	Established Date:	Prepared by:	Checked by:	Approved by:	Noted by:
11/12/21	4	Change part number from 7L0060-7021 to 7L0060-7022 due to additional clamp (82711-60640 (B) ; Improve work procedure and illustration. Additional table lay-out, checkpoint in checking of wire tolerance.	K. Doria	J. Loterte	C. Villanueva	A. Arañes		K. Doria	J. Loterte	C. Villanueva	A. Arañes
05/18/21	3	Remove validity date. Add tape quantity.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes					

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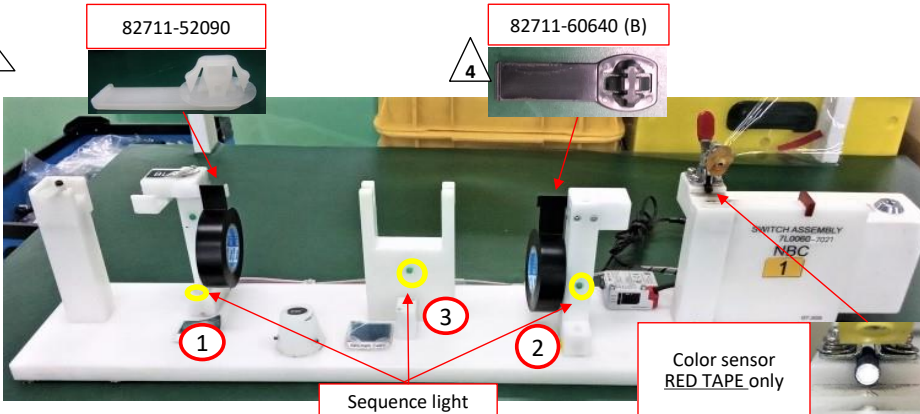
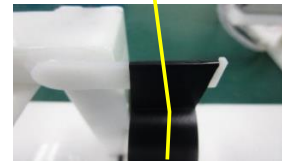
PARTS:

1. Clamp 82711-52090 (W)
 2. Clamp 82711-60640 (B) 4

3. Black tape [2pcs.]

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Setting	<div><div>4</div><div></div><div>1</div><div>2</div><div>3</div><div>Color sensor RED TAPE only</div><div>1. Get 1pc. of clamp 82711-52090 (W) using right hand then set to clamp location 1 using both hands.</div><div>2. Get 1pc. of clamp 82711-60640 (B) using right hand then set to clamp location 2 using both hands.</div><div>3. Initially attach Black tape on clamp location 1 and 2 using both hands.</div><div>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</div></div>	n/a	<div><div>One side tape under clamp</div><div></div><div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape 4. No wrong insertion of clamp</div></div>

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PARTS:

3. Assy parts
4. Red tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

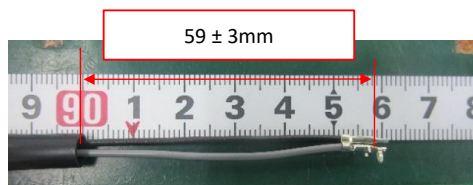
TOOLS/PPE

QUALITY POINTERS

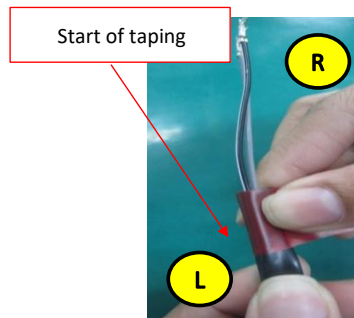
3

P2

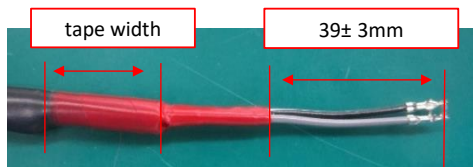
Taping 3
Sunprene to wire near
terminal



1. Hold the sunprene tube using left hand and measure from end of sunprene tube up to terminal pointed tip **59mm**.



2. Hold the Sunprene tube using left hand. Get the **Red tape** using right hand and begin taping process.
Note: Please refer to WI-PRO-ASY-001 for taping procedure.



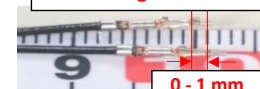
3. After taping, check the measurement, terminal alignment and taping condition.

MEASURING TAPE



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

Wire alignment tolerance



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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

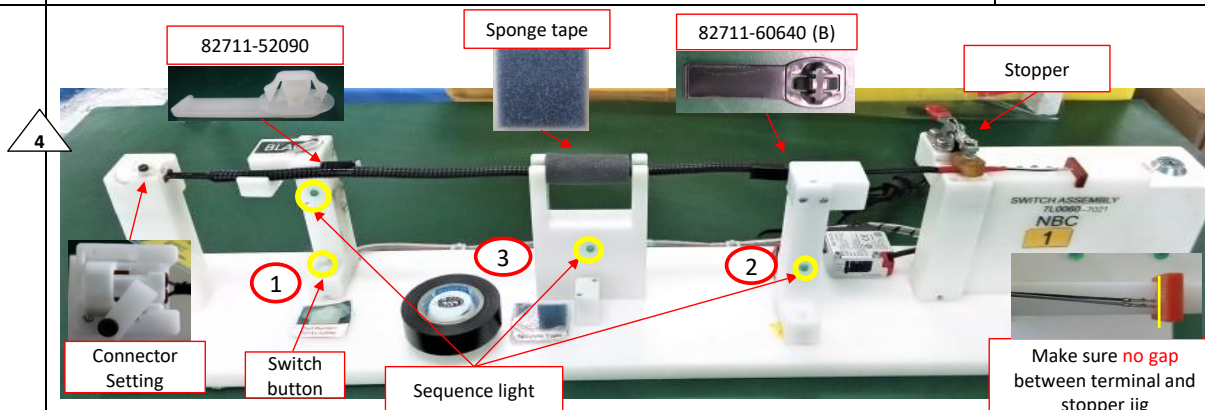
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly



1. Get the assy part and set to jig. (See below picture for correct setting). First, set the connector to Receiver base and lock. Last, set the GR-B/W wires with terminal end together within the stopper and Color sensor will beep/buzz if sensor detects the Red tape then press the Toggle clamp.

2. Check if all LED light for POWER ON, CLAMP ON, COLOR SENSOR was ON. Check also if clamp location ① sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light of location ① was ON.

3. Hold the clamp on location ① using left hand and start taping using right hand. Press the SW button after taping. Continue to location ② if light was ON.

4. Hold the clamp on location ② using left hand and start taping using right hand. Press the SW button after taping. Continue to location ③ if light was ON.

5. Attach sponge tape. (Refer to the next page for detailed process) Press the SW button after attachment. GO sound will be heard.

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

1. No damaged clamp
2. No missed tape
3. No missing clamp
4. Taping should be one side under (taping side of clamp before taping with COT)
5. No loose attachment of clamp

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PARTS:

1. Black sponge tape (7M0531-0021) t=5; width=50; L=50±1mm

JIG

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Black sponge tape (7M0531-0021) t=5; width=50; L=50±1mm Attachment	<div><div>Guide</div><div>Corrugated tube (φ5)</div><div>Size of sponge tape should fit the jig</div><div>Standard attachment</div><div>1 Get sponge tape then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape. <i>Note: Do not stretch or pull the sponge tape</i></div><div>2 After attachment of sponge tape, make 5 times slowly pushing from left to right using left thumb. <i>(See below illustration for reference.)</i></div><div>3 Press the SW button after attachment.</div><div>4 Press the sponge tape using both palm and roll 3 times to make sure that the sponge tape attachment is GOOD.</div><div>5</div><div>L R</div></div>	N/A	<div>1. No peel-off attachment 2. No loose/tight attachment 3. No wrong attachment 4.No missing sponge 5.No wrong use of sponge 6.No damage sponge</div> <div>NO GOOD ATTACHMENT OF</div> <div>With gap on guide of jig.</div> <div>Peel-off Sponge</div> <div>Tight Attachment 1.6-1.7 Wrap</div>

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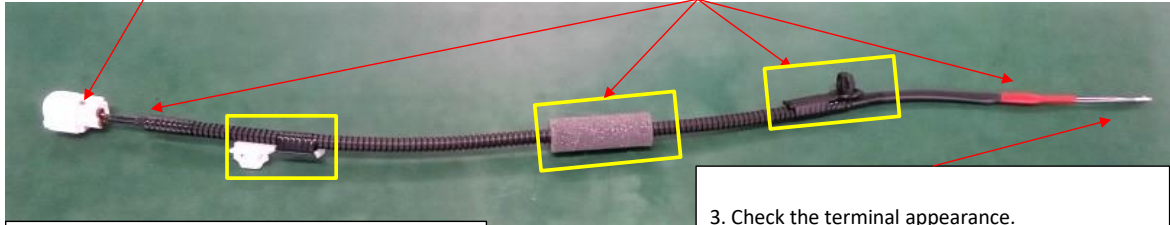

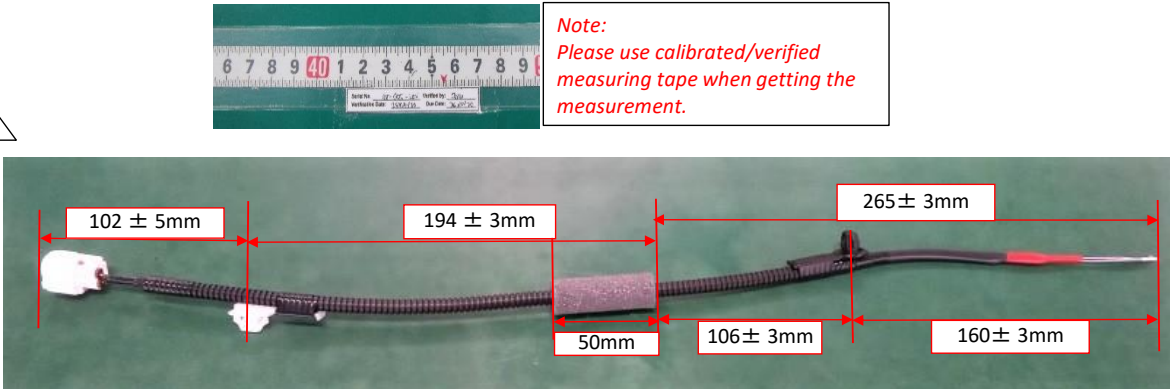
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PARTS:	n/a		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Visual/By Two's Inspection <div>4</div>	<div>1. Check the connector lock.</div> <div>2. Check the presence of all clamp and tape condition. Check also the clamp attachment & sponge tape.</div> <div></div> <div>3. Check the terminal appearance.</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>MASTER SAMPLE</div> <div><div>4</div></div>
7	Measurement <div>4</div>	<div></div>		<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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