

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

Effectivity Date:

June 07, 2021Product Name/Code: **101D / 7N0096-7020**Customer: **TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-238C

Revision No.:

1

Page No.:

1 of 6**PARTS:**

1. Clamp 82711-52090 (W) [4pcs.]
2. Clamp 82711-33380 (B)

JIG:

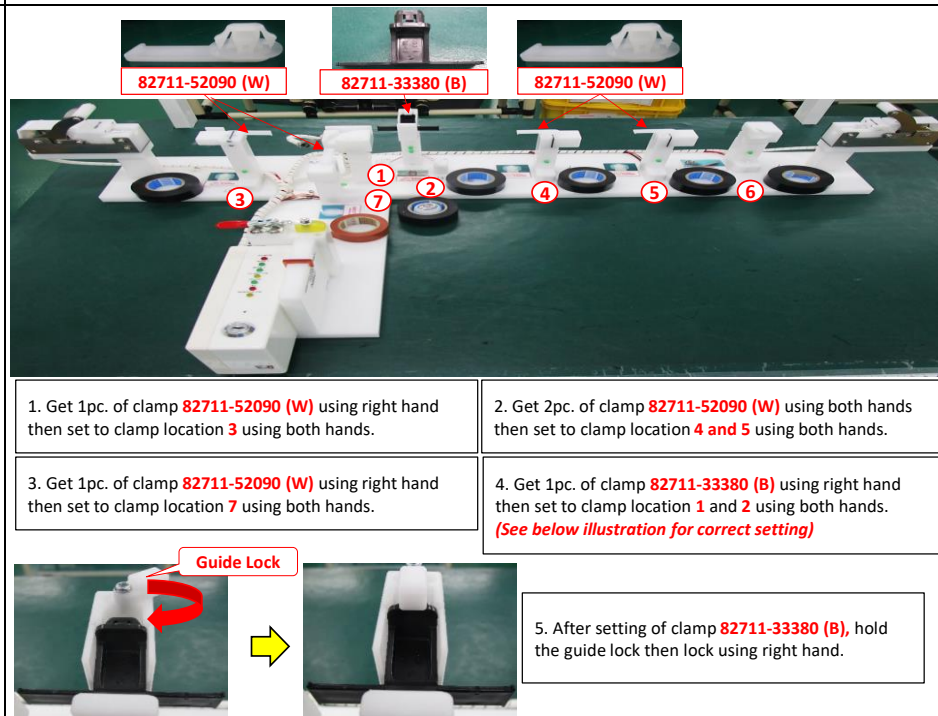
1. Clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P3

Clamp Setting



1. Get 1pc. of clamp **82711-52090 (W)** using right hand then set to clamp location **3** using both hands.

2. Get 2pc. of clamp **82711-52090 (W)** using both hands then set to clamp location **4 and 5** using both hands.

3. Get 1pc. of clamp **82711-52090 (W)** using right hand then set to clamp location **7** using both hands.

4. Get 1pc. of clamp **82711-33380 (B)** using right hand then set to clamp location **1 and 2** using both hands.
(See below illustration for correct setting)

5. After setting of clamp **82711-33380 (B)**, hold the guide lock then lock using right hand.

Safety Instruction

Be sure to wear required 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 wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/07/21	1	Removal of validity date. Apply some improvements in parts.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
03/06/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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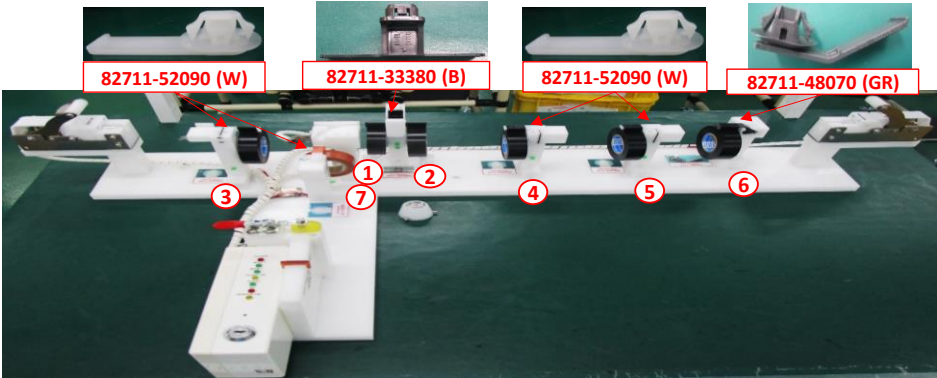
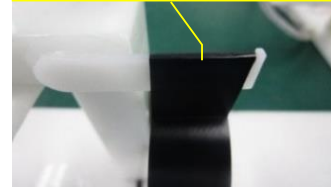
PARTS:

1

1. Clamp 82711-48070 (GR)
2. Black tape [6pcs.]
3. Brown tape [1pc.]

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Clamp Setting (Continuation)	 <p>6. Get 1pc. of clamp 82711-48070 (GR) using right hand then set to clamp location 6 using both hands.</p>  <p>7. Initially attach Black tape on clamp location 1, 2, 3, 4, 5 and 6 using both hands.</p> <p>8. Initially attach Brown tape on clamp location 7 using both hands.</p>	n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div>  <ol style="list-style-type: none">1. No wrong use of parts2. No wrong use of tape3. No damaged clamp4. No wrong clamp position <div>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div>

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

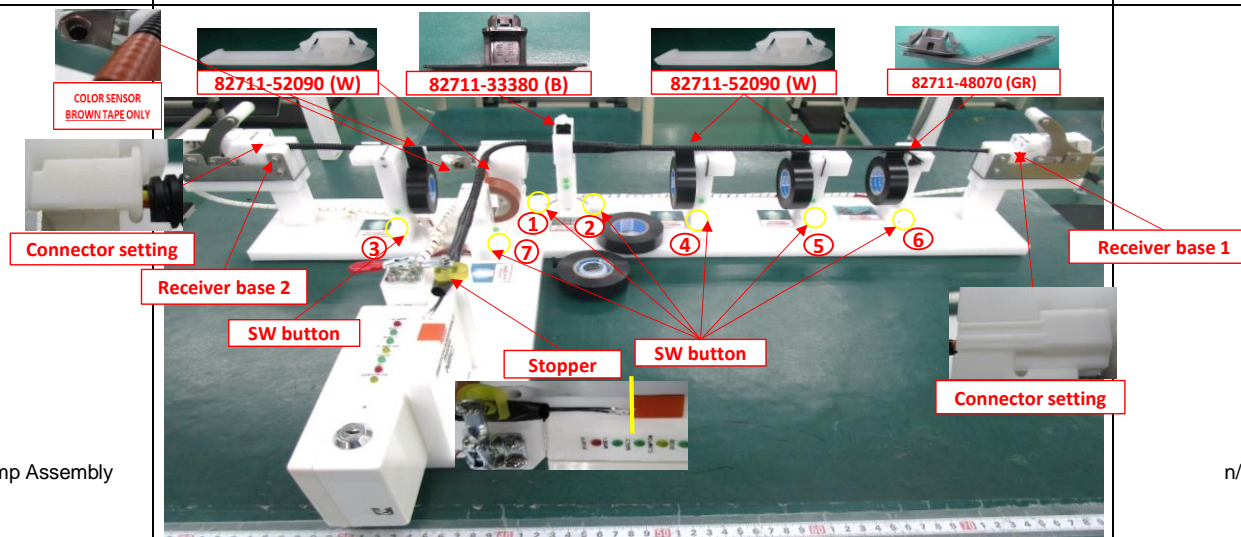
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly



1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector **6098-3802 (W)** to **Receiver base 1** then pull the checker fixture for continuity checking. Second, set the connector **6098-2220 (W)** to **Receiver base 2** then pull the checker fixture for continuity checking. Last, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then press by **Toggle clamp**. Check if the sequence light of location **1** was **ON**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was On. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

3. Hold the tape on clamp location **1**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **2** was **ON**.

4. Hold the tape on clamp location **2**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **3** was **ON**.

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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1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

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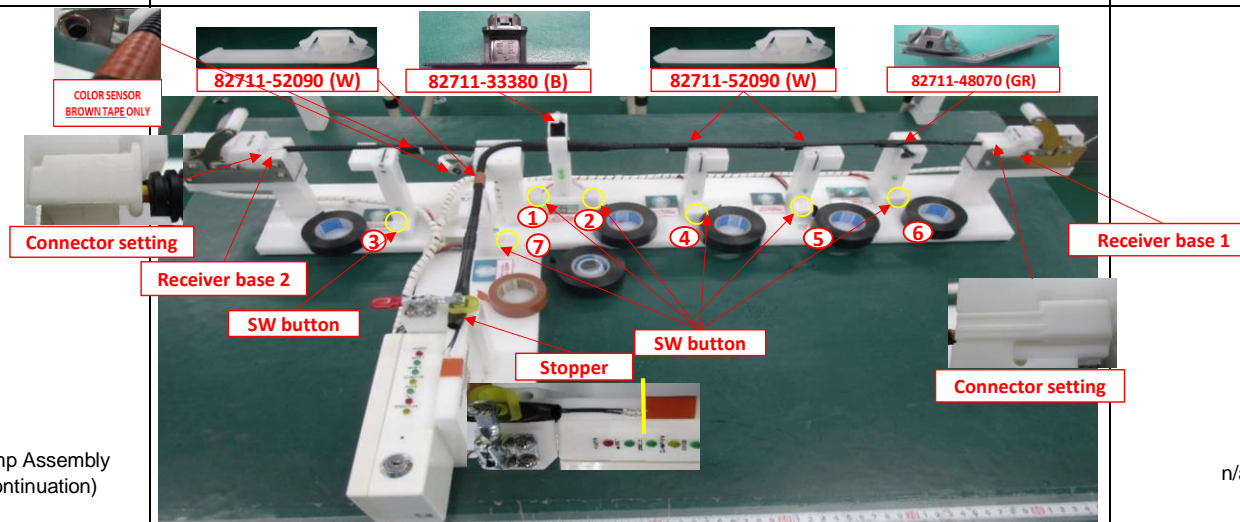
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly
(Continuation)



5. Hold the tape on clamp location **3**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **4** was **ON**.

6. Hold the tape on clamp location **4**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **5** was **ON**.

7. Hold the tape on clamp location **5**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **6** was **ON**.

n/a



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

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2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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JIG

1. Clamp assembly jig

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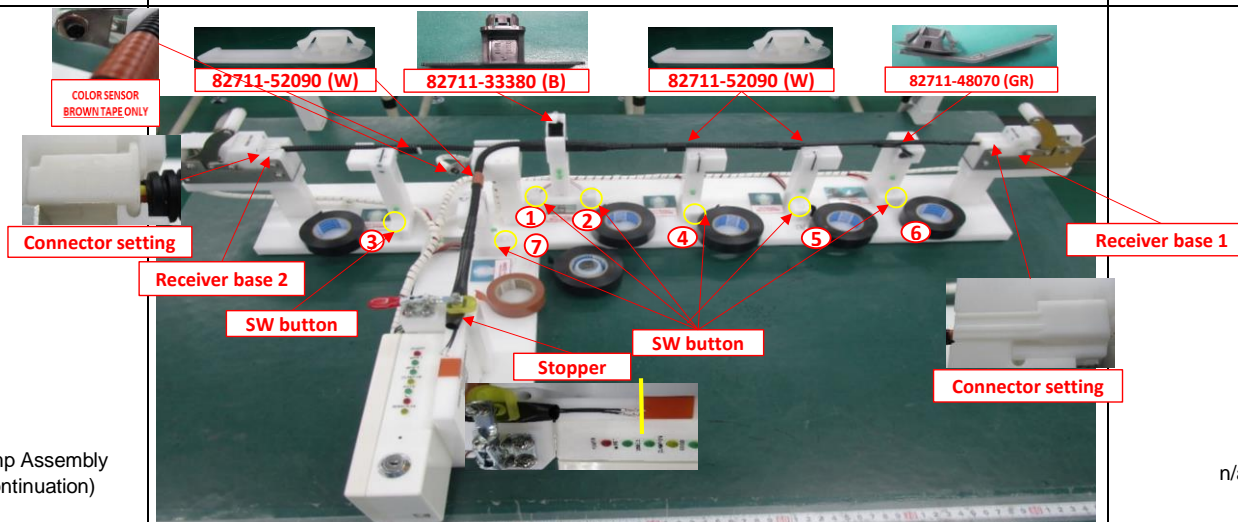
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp Assembly
(Continuation)



8. Hold the tape on clamp location **6**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **7** was **ON**.

9. Hold the tape on clamp location **7**. Make **3 windings** of tape then cut the tape using both hands. (**Note: Color sensor light will beep/buzz if sensor detects Brown tape during taping**). Press the **SW button** after taping. **Go** sound will be heard.

10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

n/a



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

1. No wrong use of parts
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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

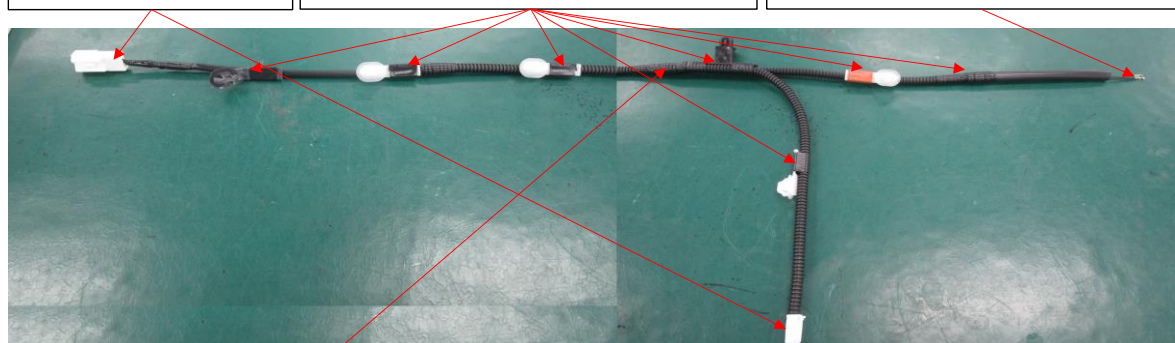
P3

Visual/By Two's Inspection

1. Check the connector lock.

2. Check the clamp attachment and taping condition.

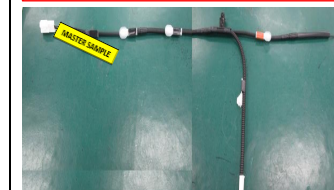
3. Check the terminal appearance. Make sure no deformed terminal.



4. Check the Y-taping condition.

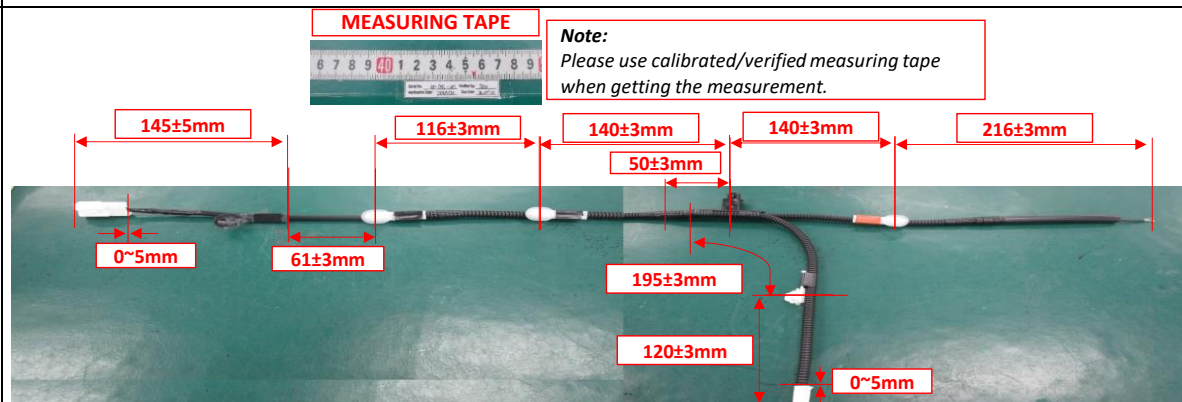
5. Compare to Master Sample
Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

MASTER SAMPLE



4

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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