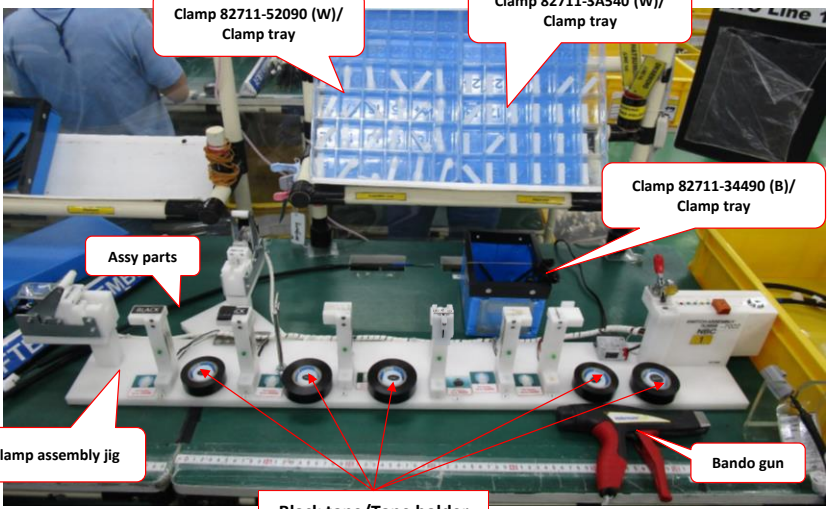

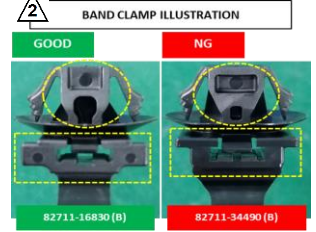


**WORK INSTRUCTION**

Process Name/Title: **TAPING ASSEMBLY PROCESS**  
Model Code/Part Number: **150B / 7L0059-7023** Customer: **TRQSS**  
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date: **December 20, 2022**  
Validity Date: **n/a**  
Document No.: **WI-ENG-PDE-435C**  
Revision No.: **2** Page No.: **1 of 9**

<b>PARTS:</b>		1. All parts: Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [5pcs.]		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	<div><b>TABLE LAY-OUT</b></div> 		<div><b>Safety Instruction</b> Be sure to wear required 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>1. No missing parts/tools 2. No excess parts/tools</div> <div><b>CLAMP ILLUSTRATION</b></div>  <div><b>BAND CLAMP ILLUSTRATION</b></div> 

**Revision History**

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
12/20/22	2	Improve Quality pointers; Reminders/notes and references on pages no.1 to 8. Improve Work procedure/illustration on process no.4-Visual/ by two's inspection. Inclusion of Quality checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
05/23/22	1	Jig modification due to improvement.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROPCESS

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n/a

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☐ PROTOTYPE

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### PARTS:

1. Clamp 82711-52090 (W) [4pcs.]
2. Clamp 82711-3A540 (W)

3. Clamp 82711-34490 (B)
4. Black tape [5pcs.]

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

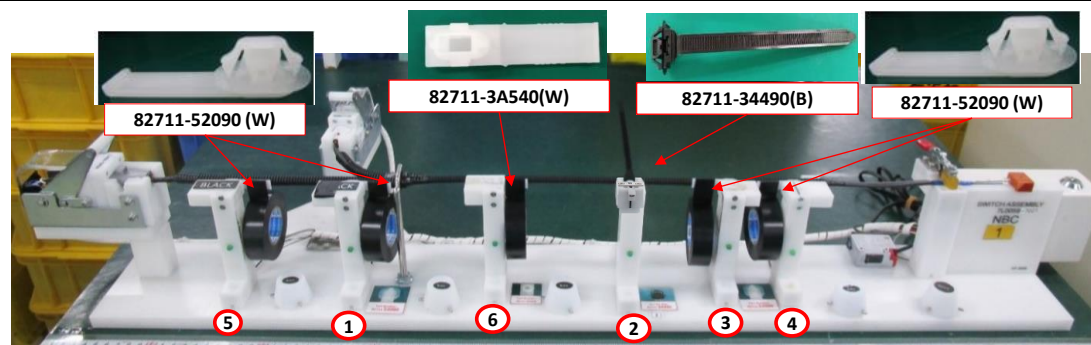
### TOOLS/PPE

### QUALITY POINTERS

2

P3

Clamp setting

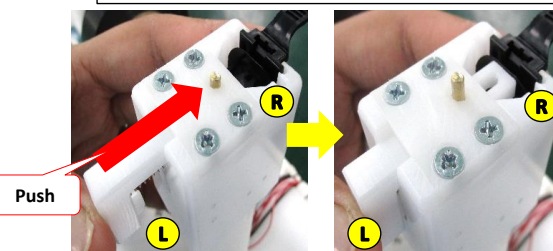


1. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **5 and 1** using both hands.

2. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **3 and 4** using both hands.

3. Get 1 pc. of clamp **82711-3A540 (W)** using right hand then insert to clamp location **6** using both hands.

4. Get 1 pc. of clamp **82711-34490 (B)** using right hand then insert to clamp location **2** using both hands. *(See below illustration for clamp setting)*



5. Get the **Black tape** then initially attach to clamp location **5, 1, 6, 3 and 4** using both hands.

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

### STANDARD TAPING FOR CLAMP

One side tape under clamp

### Important reminders/Note/s:

1. Please check the clamp first before start of assembly to avoid wrong use of clamp.

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

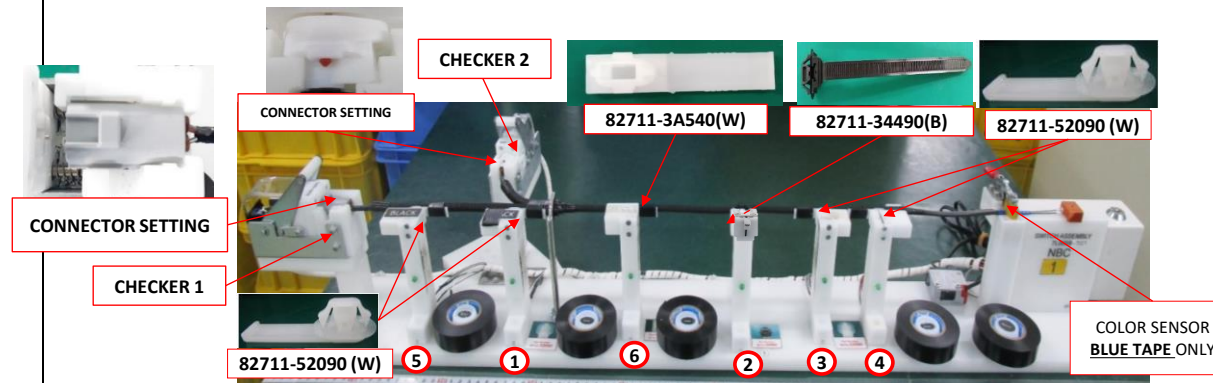
### TOOLS/PPE

### QUALITY POINTERS

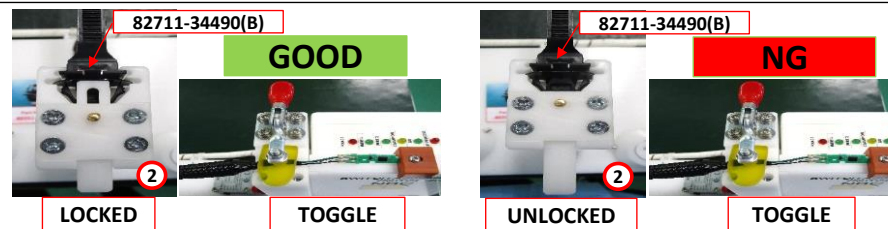
3

P3

Clamp assembly



1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector 6188-0066 (GR) to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to **Checker 2** then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON**.



**NOTE:** On clamp location 2, if clamp 82711-34490 (B) is **locked** and the **toggle clamp** is **set**, the proces will **proceed**. If **clamp 82711-34490 (B)** is **unlock** and the **toggle clamp** is **set**, the process will **not proceed** and **NG buzz** will be heard.



### Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB.

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

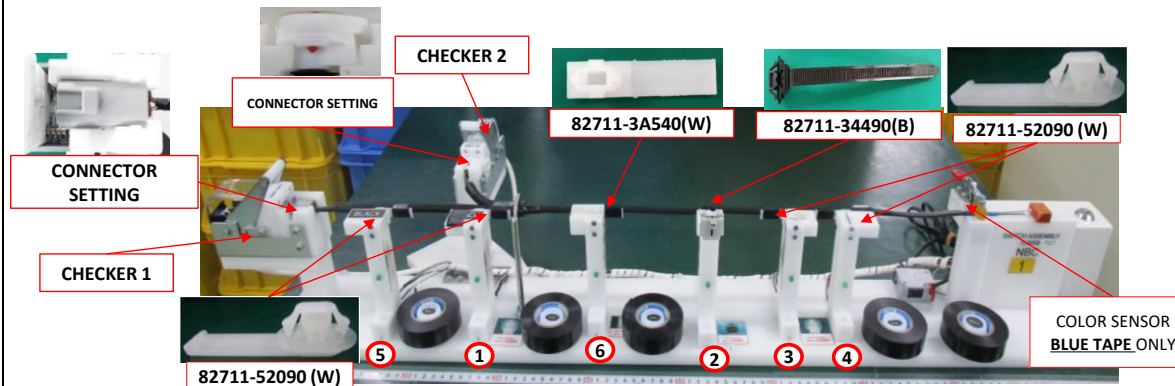
### TOOLS/PPE

### QUALITY POINTERS

3

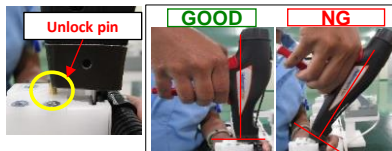
P3

Clamp assembly  
(Continuation)



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 on clamp location **2** was **ON**.



**NOTE:** Pin must be hit during cutting of bando gun.

4. Initially tighten the band clamp on clamp location **2** using both hands.

5. Get the bando gun using right hand then cut the band clamp on location **2** using both hands. Press the **SW button** after cut. Continue the process if sequence light on clamp location **3** was **ON**.



### Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB.
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).
3. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For:  $\phi 5 - 1 \sim 2$ ,  $\phi 7 - 3 \sim 4$

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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### PARTS:

1. Assy parts
2. Black tape

3. White tape

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

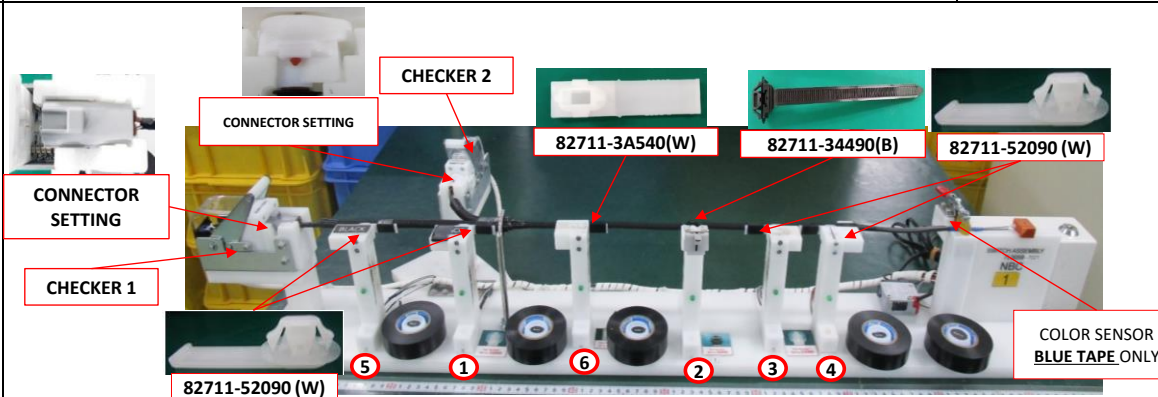
### TOOLS/PPE

### QUALITY POINTERS

3

P3

Clamp assembly  
(Continuation)



6. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Color sensor light will beep/buzz if sensor detects White tape. Press the SW button after taping. Continue the process if sequence light on clamp location 4 was ON.

7. 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 on clamp location 5 was ON.

8. 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 on clamp location 6 was ON.

9. 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. Go sound will be heard.

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

### Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminal.

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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## PARTS:

1. Assembled parts
2. Master sample

**JIG**

**n/a**

**NO.**

**PROCESS NAME**



**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

**4**

**P3**

**Visual/ By two's inspection**



**ACTUAL PRODUCT**



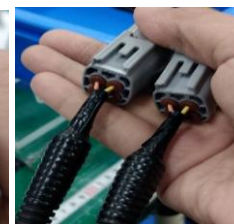
**Master sample**

**Assembled parts**

1. Conduct alignment of harness (**Master sample vs. assembled parts**) using both hands.



3. Check the **presence of clamp** and **taping condition**.



2. Check the **terminal, connector lock** condition, **insertion** and **taping condition**.



4. Check the **terminal, connector lock** condition and **insertion**.

**MASTER SAMPLE**



1. No skip checking during inspection.



**CLAMP ILLUSTRATION**



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**n/a**Model Code/Part Number: **150B / 7L0059-7023**

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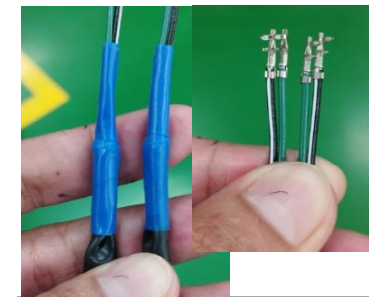
1. Assembled parts
2. Master sample

**JIG****n/a****NO.****PROCESS NAME****2****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****4****P3**Visual/ By two's inspection  
(Continuation)**ACTUAL PRODUCT**

5. Check the **presence of clamp in Y-Taping** condition.



6. Check the **presence of clamp, color of tape, taping condition** and **band clamp cut condition**.



7. Check the **taping condition, color of tape (Must be Blue tape only)** and **terminal appearance. Must be no deformed terminal**

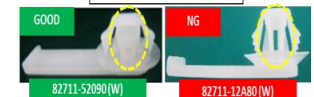
**MASTER SAMPLE**

1. No skip checking during inspection.

**2****Important reminders/Note/s:**

1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).

CLAMP ILLUSTRATION



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n/a

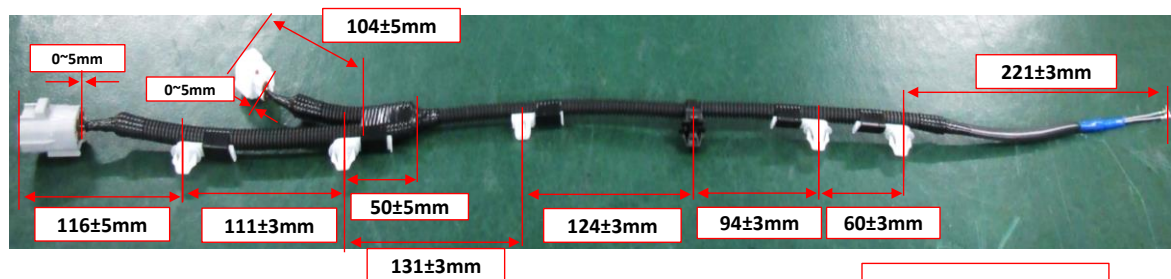
**JIG**

n/a

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

5

Measurement

**MEASURING TAPE****MASTER SAMPLE**

1. No wrong dimension

**Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

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JIG

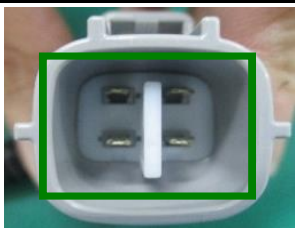
n/a



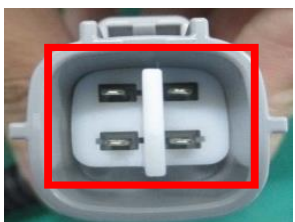
## QUALITY CHECKPOINTS

**P3**

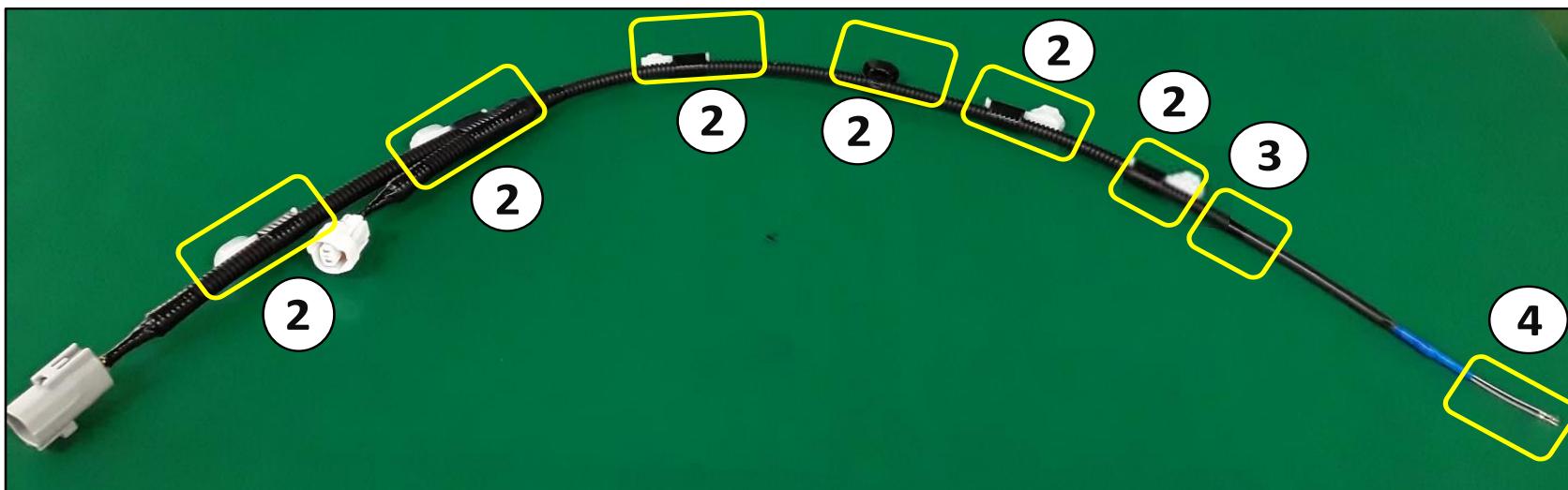
**7L0059-7023**



**GOOD**



**NO GOOD**



**1**

**No Unlock/Halflock Connector (on 2 connector)**

**2**

**No Missing Clamp (6pcs.)**

**3**

**Conduct Bending on COT to VT**

**4**

**No Deformed Terminal**

**5**

**Checking of Clamp Alignment**

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