



WORK INSTRUCTION

Effectivity Date:

September 30, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

TP1 / 7L0091-7022

Customer:

TRQSS

Document No.:

WI-ENG-PDE-061B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

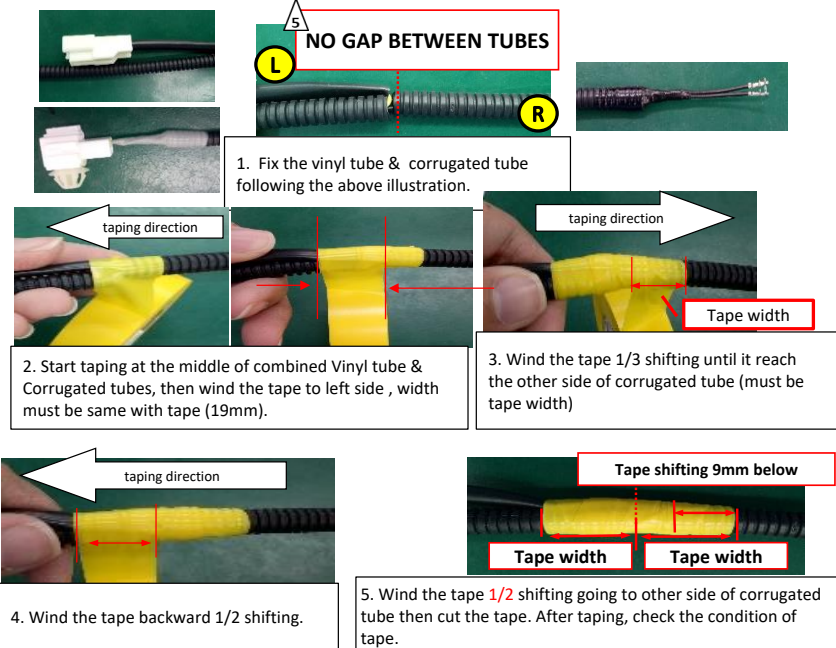
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PARTS:	1. Black tape 2. Assy part	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out	 <p>NO GAP BETWEEN TUBES</p> <p>1. Fix the vinyl tube & corrugated tube following the above illustration.</p> <p>2. Start taping at the middle of combined Vinyl tube & Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm).</p> <p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p> <p>4. Wind the tape backward 1/2 shifting.</p> <p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>MEASURING TAPE</p>	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE</p> <p>3. Do not exert excessive force during pulling & winding of tape.</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/30/22	5	Improve; Work procedure/illustration on process no. 1, 3 process no.4 visual/by/two's inspection and process no. 5 measurement. Quality pointers; Reminders/notes on pg. 1 to 7.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/19/21	4	Change part number due to design change. Install color sensor to clamp assembly jig.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes				
10/24/20	3	Remove cycle time.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes				
Est. Date:							M. Ariola	J. Loterte	C. Villanueva	A. Arañes
								October 2, 2021		

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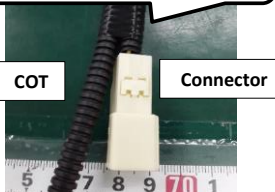




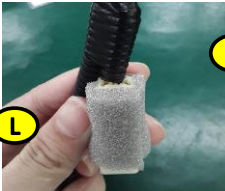
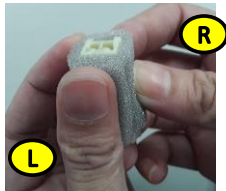
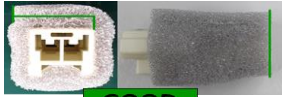


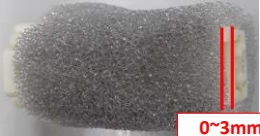
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PARTS:		1. Urethane foam (GR) t=4; 75mm X 30mm 2. Assy part	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Urethane foam manual attachment to connector 7282-1020	<p>Step 1: Identify the right facing to attached the foam</p>  <p>Step 2: Get the Urethane foam and begin the attachment.</p>  <p>Step 3: Attached the foam in all sides of the connector.</p>    <p>Step 4: Press the Urethane foam side by side after attachment.</p>  	n/a	<p>1. No damaged Urethane foam 2. No missing Urethane foam 3. No stretched Urethane foam</p> <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Foam and connector must be align2. Follow the attachment sequence based on the illustration.3. Do not stretch the Urethane foam.4. Tolerance from urethane foam to connector must be 0~3mm. <p>URETHANE FOAM CONDITION</p>    <p>NG</p> 

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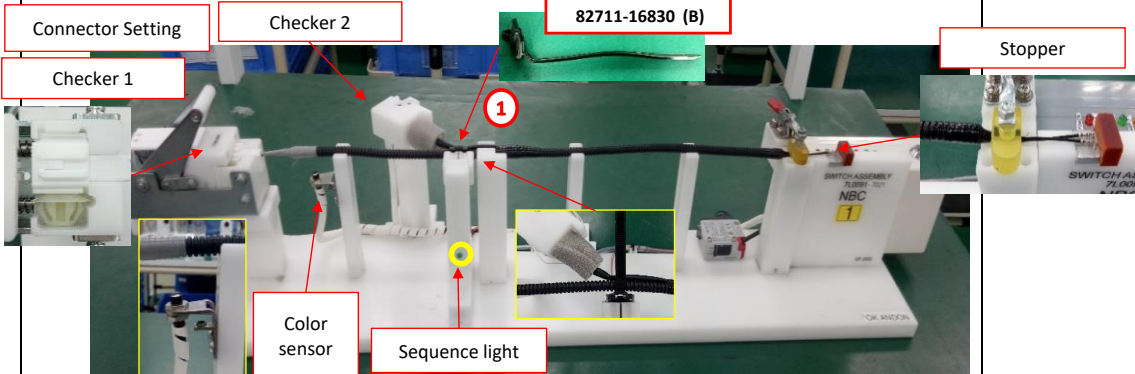


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PARTS:

1. Clamp 82711-16830 (B)
2. Assy part

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Clamp Assembly	<div></div> <div><p>1. Put the assy. First, set the connector to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector to Checker 2 for continuity checking. Third, get the clamp 82711-16830(B) and set to clamp location ① using both hands. Last, set the B-B wires with terminal end together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.</p><p>2. Check if all LED light for POWER ON, WIRE1 and WIRE2, CLAMP ON, and 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.</p><p>3. Initially tighten the band clamp on location ① using both hands.</p></div>	n/a	<div><p>1. No wrong use of clamp 2. No wrong set of clamp 3. No missing clamp 4. No loose band clamp 5. No super tight band clut</p><p>Important reminders/Note/s:</p><p>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</p><p>2. Make sure no gap between terminal and stopper jig.</p><p>3. Terminal should touch the aluminum to check the continuity and sequence light will ON if the color sensor detect the <u>GRAY TAPE</u>.</p><p>BAND CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-16830 (B)</div></div><div><div>NG</div><div>82711-34490 (B)</div></div></div>

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PARTS:

1. Clamp 82711-16830 (B)
2. Assy part

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

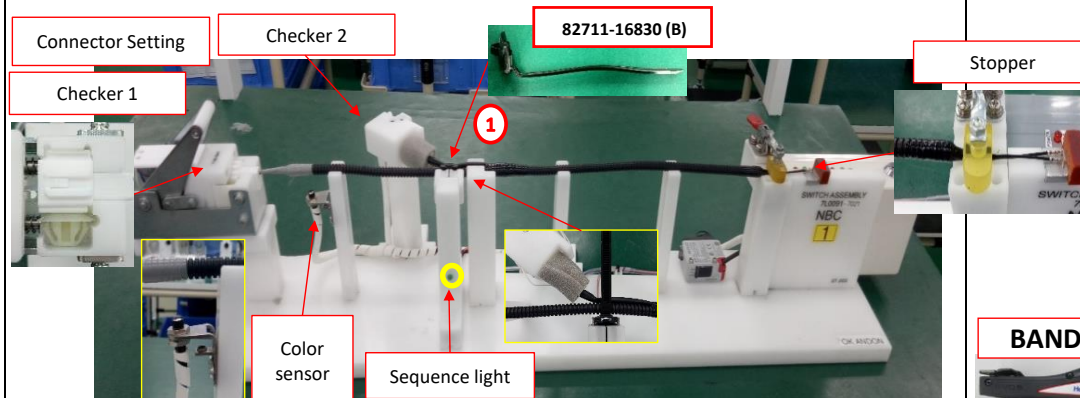
TOOLS/PPE

QUALITY POINTERS

3

P2

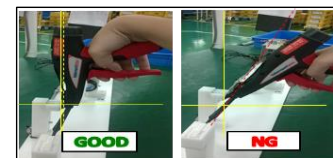
Clamp Assembly
(Continuation)



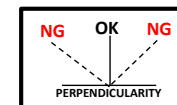
4. Get the bando gun and cut the band clamp (82711-16830) using right hand. Press the sequence light button after cutting. **Go** buzzer will be heard.

5. **CONDUCT POINT CHECKING** before removing from jig.

6. First, remove the connector to **Checker 1**. Second, pull the **Toggle clamp**. Last, remove the connector to **Checker 2** together with clamp.



BANDO GUN ALIGNMENT



BANDO GUN



FLAT NOSEPIECE

Important reminders/Note/s:

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

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

3. Setting of band cut cutter depends on the size of the COT/Vinyl tube.
For: ø5 - 1~2, ø7 - 3~4



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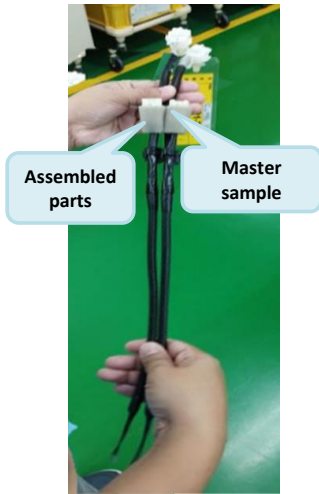
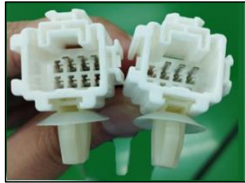






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PARTS:		1. Assembled parts 2. Master sample			JIG	n/a
NO.	PROCESS NAME		5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Visual Inspection/By Two's inspection	<div><div>ACTUAL PRODUCT</div></div>			<div><div>MASTER SAMPLE</div></div> <div>1. No skip checking during inspection.</div>
			<div><div><div><div>Assembled parts</div><div>Master sample</div></div><div></div><div></div><div><div>2. Check the terminal and insertion and taping condition.</div></div><div><div></div><div></div><div><div>3. Check the presence of all clamp attachment.</div></div></div></div></div>			<div><div>5 Important reminders/Note/s:</div><div>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</div><div><div>0 ~ 2mm</div></div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>82711-16830 (B)</div><div>82711-34490 (B)</div></div></div></div>

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PROTOTYPE



PRE-LAUNCH





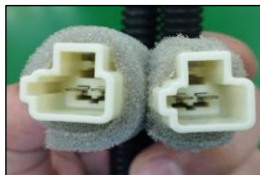

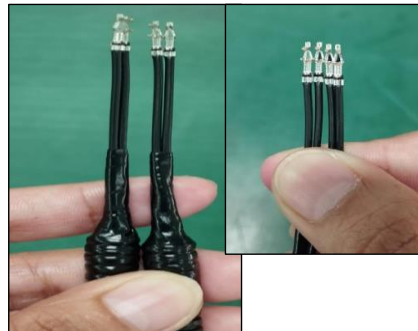

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PARTS:		1. Assembled parts 2. Master sample			JIG	n/a	
NO.	PROCESS NAME		5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P2	Visual Inspection/By Two's inspection (Continuation)	<div><div>ACTUAL PRODUCT</div></div> <div></div> <div><div>4. Check the terminal and insertion and taping condition.</div><div><div>5. Check the Y-TAPING condition.</div></div><div><div>6. Check the taping condition and terminal appearance. Must be no deformed terminal.</div></div></div>			<div><div>MASTER SAMPLE</div></div> <div>5</div> <div>1. No skip checking during inspection.</div>	

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PARTS:

n/a

JIG

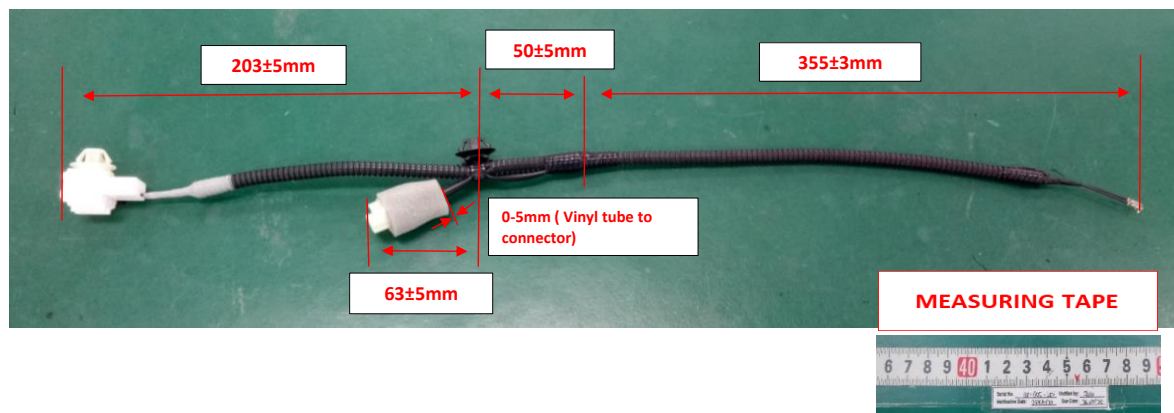
n/a

NO.**PROCESS NAME****5****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P2

Measurement



1. No wrong dimension

Important reminders/Note/s:

1. For Hatsumono and Owarimono.

2. Please use calibrated/verified measuring tape when getting the measurement.

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