

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 29, 2021

Product Name/Code:

164B**/****7M0610-7020B**

Customer:

TRJ

Document No.:

WI-ENG-PDE-159C

Purpose:


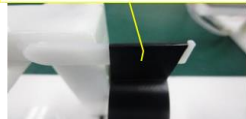
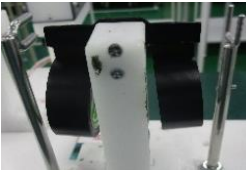

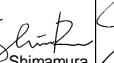


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Clamp 82711-48210 (B) 2.Clamp 82711-3A640 (B)				4		3. Clamp 82711-35730 (B) 4. Clamp 82711-52090 (W)		4		JIG:	1. Clamp assembly jig								
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS									
1		P3 Clamp assembly setting		<div><div>4</div><div></div><div>1. Get the clamp 82711-48210 (B) using right hand and set to location 1, 82711-3A640 (B) set to location 3, 82711-35730 (B) set to location 4 and 82711-52090 (W) set to location 5 using right hand.</div><div>2. Get Black tape using right hand and conduct pre-taping on location 1~5 using both hands.</div><div><div>STANDARD TAPING FOR CLAMP</div><div>One side tape under clamp</div><div></div><div></div></div></div>						n/a		1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts									
Revision History														Prepared by		Reviewed by		Approved by		Noted by	
03/29/21		4		Change clamp color in accordance with color standardization for plastic parts refer to GL-COM-003 Put measuring tape illustration and instruction in Measurement						J. Loterte		C. Villanueva		A. Shimamura		A. Arañes		<div></div> <div>J. LoterteC. VillanuevaA. ShimamuraA. Arañes</div>			
09/15/20		3		Transferred process owner from Production (WI-PRO-ASY-88C) to Engineering (WI-ENG-PDE-159C); Apply some improvements; Added Cycle time						J. Loterte		R. Peñaloza		A. Shimamura		A. Arañes					
Eff. Date		Rev. No		Details of Change						Revised		Checked		Approved		Noted		Est. Date:		09/24/2018	

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

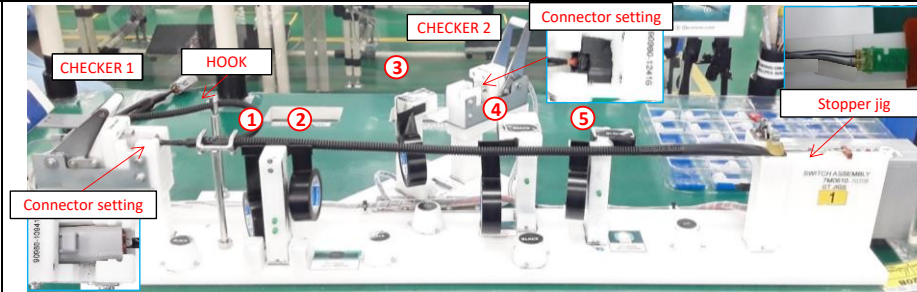
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

2

P3

Clamp assembly



1. Get the assy parts and set to jig. Put first the Gray connector to checker 1. Secondly, put the checker 2 to hook beside the checker 1. Lastly, put the hotmelted wire into stopper jig.



2. Tape the clamp in location 1 & 2 to COT 1 (make 2 winds).



3. Remove the harness part from hook and then set to checker 2. Push both checker to lock. Same timing. Check the LED light for **POWER ON, CLAMP ON, WIRE1 and WIRE 2, SEQUENCE LIGHT is ON**. If encountered abnormality, apply **STOP** the process, **CALL** the leader and **WAIT** for instruction

4. Attach the COT 2 to the COT 1 (make 3 winds) then cut. Press the SW button after taping.

5. Hold the clamp in location 3 using left hand and begin taping using right hand. Press the SW button after taping. Repeat the process for location 4 and 5 press the switch button after taping. Go sound will be heard.

6. Conduct **POINT CHECKING** before removing from jig.

n/a

Make sure no clearance between PCB and stopper jig



1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

4

Visual/By two's inspection

P3

1. Check the connector lock.

2. Check the clamp attachment and taping condition.

3. Check the clamp alignment.

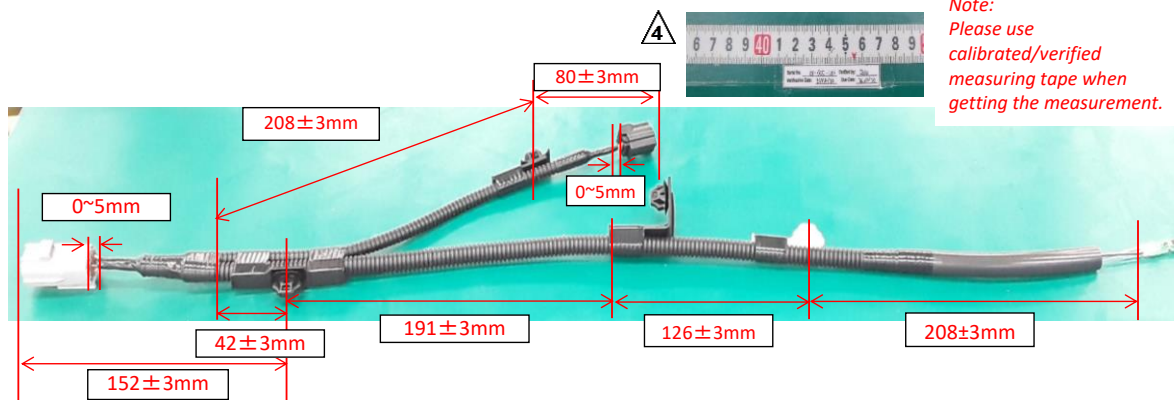
4. Compare to MASTER SAMPLE. *Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.*

MASTER SAMPLE



4

Measurement



FOR HATSUMONO AND OWARIMONO.

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