



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 04, 2021

Product Name/Code:

011B / 7M0512-7020D

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-134C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

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PARTS:

1. Clamp 82711-52090 (W) [4pcs.]
2. Clamp 82711-3A540 (W)3. Clamp 82711-34490 (B)
4. Black tape [4pcs.]

5. Violet tape [1pc.]



JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

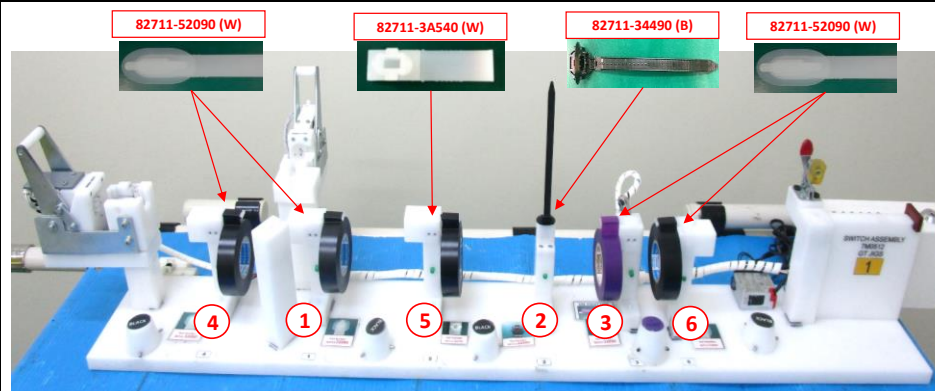
TOOLS/PPE

QUALITY POINTERS

1

P3

Clamp setting

1. Get **2pcs.** of clamp **82711-52090 (W)** using both hands and set to location **4** and **1** using both hands.2. Get **2pcs.** of clamp **82711-52090 (W)** using both hands and set to location **3** and **6** using both hands.3. Get 1pc. of clamp **82711-3A540 (B)** using right hand and set to location **5** using both hands.4. Get 1pc. of band clamp **82711-34490 (B)** using right hand and set to location **2** using both hands.**Note: Please check all clamp and band clamp before start of assembly to avoid wrong use of parts.**5. Initially attach **Black tape** on location **1, 4, 5, and 6** using both hands.6. Initially attach **Violet tape** on clamp location **3** using both hands. .**Safety Instruction**

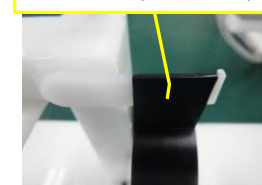
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping1. 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.

STANDARD TAPING FOR CLAMP

One side tape under clamp

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/04/21	3	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/22/20	2	Change effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
03/06/18	n/a	Previously established as Engineering Instruction (EI-ENG-PDE-021). Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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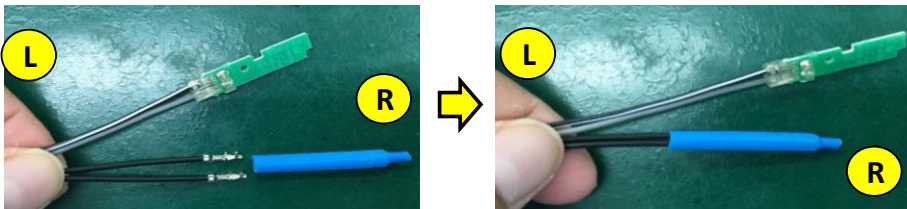
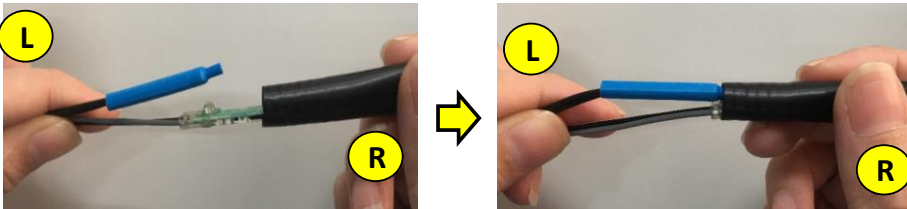
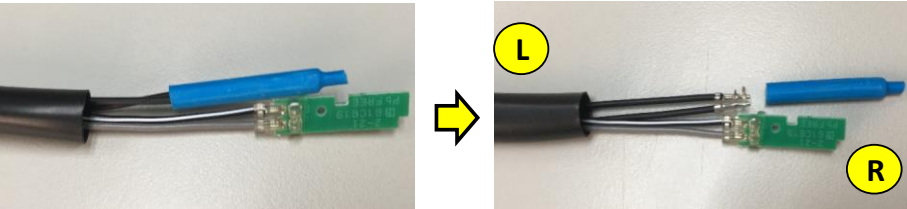

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2 of 7**PARTS:**

1. Black Sunprene tube $\varnothing 9$ L=73 \pm 3mm
2. Assy parts

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Wire insertion to Black Sunprene tube $\varnothing 9$ L=73 \pm 3mm	 <div>1. Get the terminal cover jig using right hand then insert the terminal B/B wires using left hand.</div>  <div>2. Hold the Black Sunprene tube $\varnothing 9$ L=73\pm3mm using right hand then Insert first the hotmelted wires and then next the B/B wires with cover jig using left hand.</div>  <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<div>TERMINAL COVER JIG</div> 	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal3. No wires left during insertion

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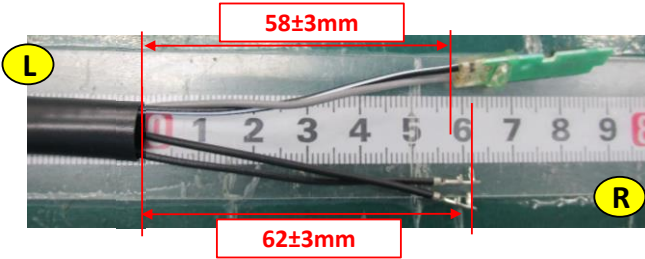

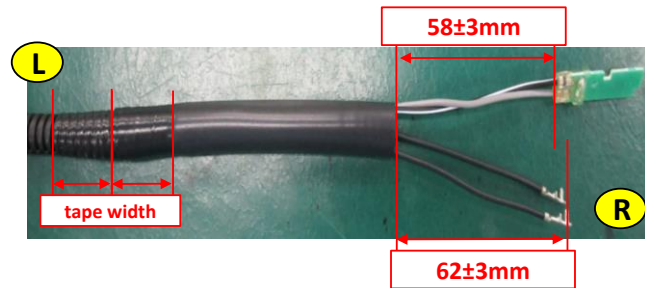

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3 of 7**PARTS:**

1. Black tape
2. Assy parts

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Taping 1 Black Sunprene tube to Black Corrugated tube	<div></div> <div></div> <div></div>	<div>MEASURING TAPE</div> 	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>

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PARTS:

1. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

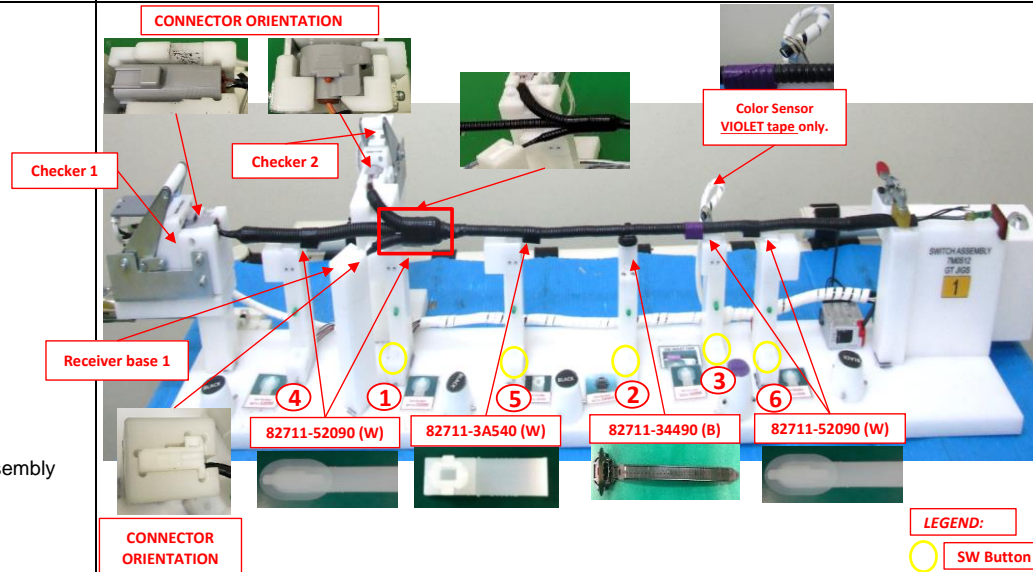
TOOLS/PPE

QUALITY POINTERS

4

P3

Clamp Assembly

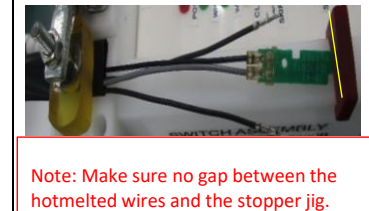


1. Get the assy parts and set into jig. (See above picture for the correct setting). First, set the connector **6188-0066 (GR)** to **Checker 1** and then pull the checker fixture for continuity checking. Second, set the connector **6189-0249 (GR)** to **checker 2** then pull the checker fixture for continuity checking. Third, set the connector **6098-3810 (W)** to **Receiver base 1** then lock. Last, set the hotmelted wire and **B/B wires** together within the stopper then press by toggle clamp. Continue if the sequence light in location **1** was **ON**.

2. Check if all **LED light** for **POWER ON, WIRE1, WIRE2 and CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.

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

n/a



1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3 Clamp Assembly (Continuation)	<div><div>CONNECTOR ORIENTATION</div><div></div><div>CONNECTOR ORIENTATION</div><div>LEGEND: SW Button</div><div><div>GOOD</div><div>NG</div><div>Must be perpendicular</div></div><div><div>BANDO GUN ALIGNMENT</div><div>NG OK NG</div><div>PERPENDICULARITY</div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2; ø7 - 3~4</div></div></div>		<div><div>Bando Gun</div><div></div></div>	<div><div></div><div>Note: Make sure no gap between the hotmelted wires and the stopper jig.</div><div><div>1. No loose/tight clamp attached</div><div>2. No damage clamp</div><div>3. No missed tape</div><div>4. No missing parts</div><div>5. Make sure no clearance between PCB and stopper jig</div></div></div>

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PARTS:		1. Assy parts	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 3 Clamp Assembly (Continuation)	<p>6. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape. Color sensor light will beep/buzz if sensor detects Violet tape. Press the SW button after taping. Continue the process if sequence light on location 4 was ON. NOTE: Use VIOLET tape only.</p> <p>7. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 5 was ON. NOTE: Use BLACK tape only.</p> <p>8. Hold the tape on clamp location 5. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 6 was ON. NOTE: Use BLACK tape only.</p> <p>9. Hold the tape on clamp location 6. Make 3 windings of tape then cut the tape. Press the SW button after taping. Go sound will be heard.</p> <p>10. After taping, conduct POINT CHECKING before removing the harness from jig.</p>	n/a	<p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</p>

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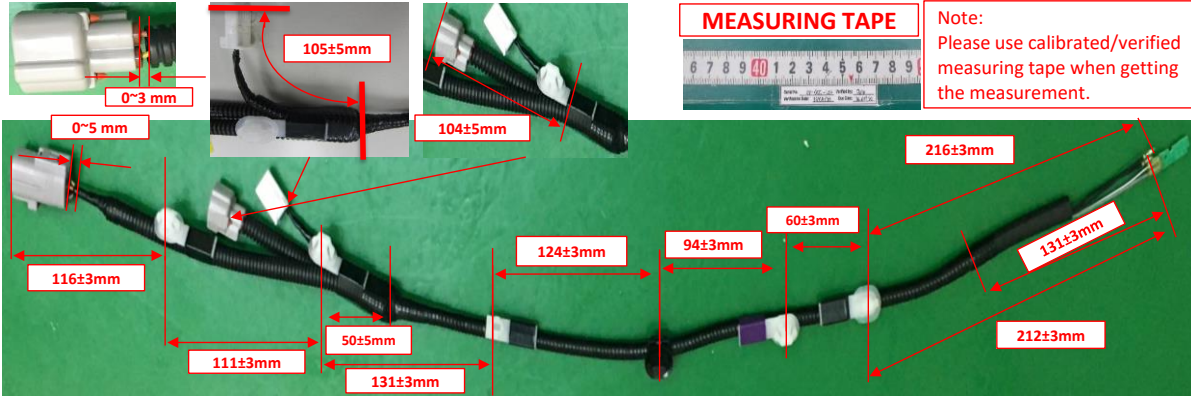
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a	JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Visual Inspection	<p>1. Check all the connector lock.</p> <p>2. Check the clamp attachment, alignment & tape condition.</p> <p>3. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p> <p>4. Check if no damaged terminal tip.</p> <p>5. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></p>	<p>0-2 mm</p> 	<p>MASTER SAMPLE</p>
6	Measurement	<p>MEASURING TAPE</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> 	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>	<p>NOTE: FOR HATSUMONO AND OWARIMONO</p> <p>1. No wrong dimension</p>

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