



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

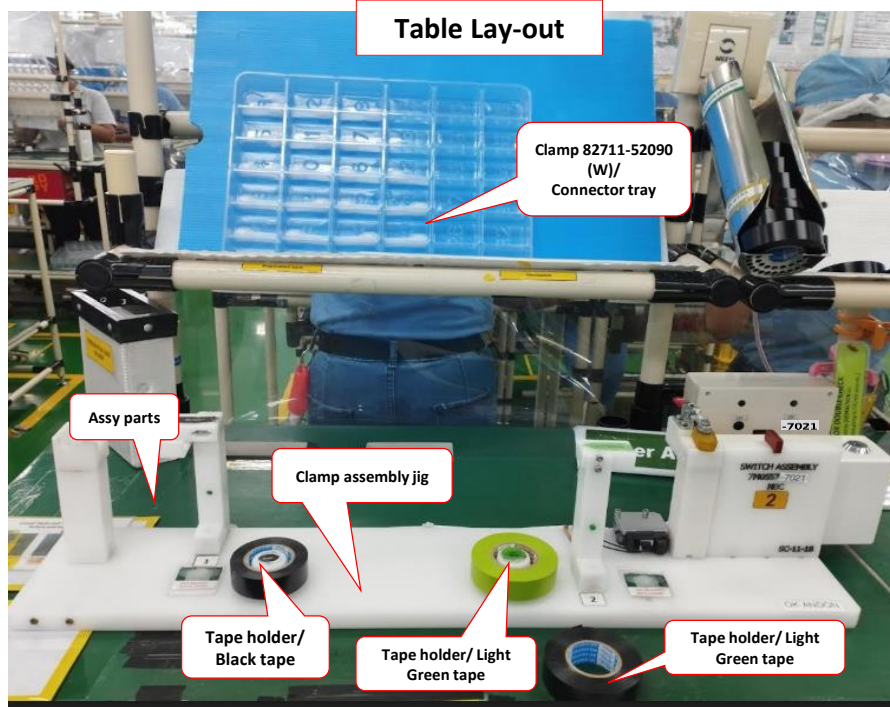
Effectivity Date:	November 25, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-415B		
Revision No.:	2	Page No.:	1 of 8

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	310B / 7M0557-7021	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS: 1. Assy parts: Clamp 82711-52090 (W); Black tape [2pcs.]; Light Green tape

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-52090 (W) 82711-12A80 (W)</p>



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
11/25/22	2	Change sequence process of clamp setting and taping of COT to Vinyl tube, to align in standard procedure of clamp Assembly. Improve Quality pointers; Reminders/Notes and references on pages no.1 to 8; Improve work procedure/Illustration on process no.5-Visual/by two's inspection due to document improvement; Additional Visual references on page no.8 as quality checkpoint.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
06/29/22	1	Remove process no.3 and 4 then transfer to P1, Transfer process no. 8 from P1 due to process improvement. Change table Lay-out	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
02/18/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
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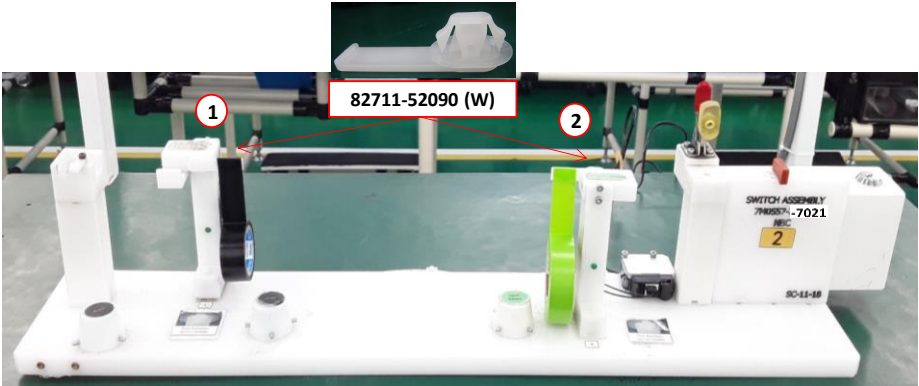
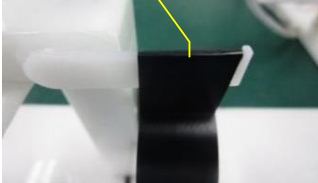
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Clamp 82711-52090 (W) [2pcs.] 2. Black tape 3. Light Green tape			JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Setting	 <div data-bbox="808 847 1283 1214"><p>1. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 1 and 2 using both hands.</p><p>2. Get BLACK TAPE using right hand and conduct pre-taping on clamp location 1 using both hands.</p><p>3. Get LIGHT GREEN TAPE using right hand and conduct pre-taping on clamp location 2 using both hands.</p></div>		n/a	<div data-bbox="1749 624 1800 679">2</div> Important reminders/Note/s: <i>1. Please check the clamp before start assembly to avoid wrong use of clamp.</i> <div data-bbox="1789 836 2114 884">STANDARD TAPING FOR CLAMP</div> <div data-bbox="1794 900 2110 948">One side tape under clamp</div> 


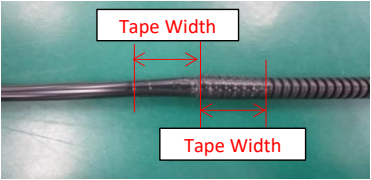

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PARTS:	1. Black tape 2. Assy parts			JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
<div> <div>3</div> <div> <div>2</div> </div> </div>	P2 Taping 1 COT to Vinyl tube	<div> <div> NO GAP between COT and Vinyl </div>  <div> 1. Hold the corrugated tube using left hand then start taping process using both hands. </div>  <div> 2. After taping, check the taping condition. </div> </div>	<div> <div>MEASURING TAPE</div>  </div>	<div> <div> <div>1. No flip-out tape</div> <div>2. No peel-off tape</div> <div>3. No loose tape</div> <div>4. No missing tape</div> <div>5. No wrong dimension</div> <div>6. No wrong use of tape</div> </div> <div> <div>2</div> <div> Important reminders/Note/s: </div> <div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. Make sure no gap between COT and vinyl tube.</div> </div> </div> </div>

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PARTS:

1. Assy parts
2. Black tape
3. Light Green tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly



n/a

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

2 Important reminders/Note/s:

1. Make sure no gap between terminal and stopper jig



1. Get the assy parts and set to jig using both hands. First, put the connector 6189-0451 (W) into connector receiver base and lock. Second, put the terminal into stopper jig and pull down the toggle clamp.
Refer to above illustration for the correct setting.

2. Check if LED light for **POWER**, **CLAMP** and **SEQUENCE** light was **ON**. If encountered abnormality **STOP** the process, **CALL** the attention of the leaders and **WAIT** for instructions.

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

3. Hold the clamp on **location 1** and begin taping using right hand. Make **3 windings of tape** and cut the tape. Press the SW button after taping. Continue to clamp location **2**.
TAPE COLOR MUST BE BLACK.

4. Hold the clamp on **location 2** and begin taping using right hand. Make **3 windings of tape** and cut the tape. Press the SW button after taping. **Go** sound will be heard.
TAPE COLOR MUST BE LIGHT GREEN.

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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Visual/ By two's
Inspection

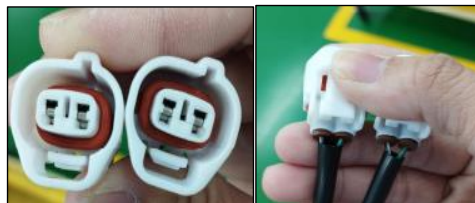
ACTUAL PRODUCT



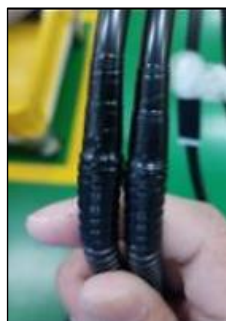
Assembled
parts

Master
sample

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



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



4. Check the **Taping condition.** Conduct **slightly pulling of VT** during bending of part with COT to VT taping **to avoid overlook of missing tape.**



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



5. Check the **presence of clamp attachment and taping condition.**

MASTER SAMPLE



1. No skip checking during inspection.

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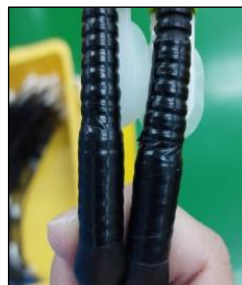
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6 of 8**PARTS:**

1. Assembled parts
2. Master sample

JIG**n/a****NO.****PROCESS NAME****2****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****5****P2**Visual/ By two's
Inspection (Continuation)**ACTUAL PRODUCT**

5. Check the **presence of clamp attachment** and **taping condition**.



6. Check the **taping condition** of COT to sunprene tube. Conduct **slightly bending**.



7. Check the **terminal appearance**. Must be **no deformed terminal**.

**MASTER SAMPLE****2**

1. No skip checking during inspection.

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7 of 8**PARTS:**

n/a

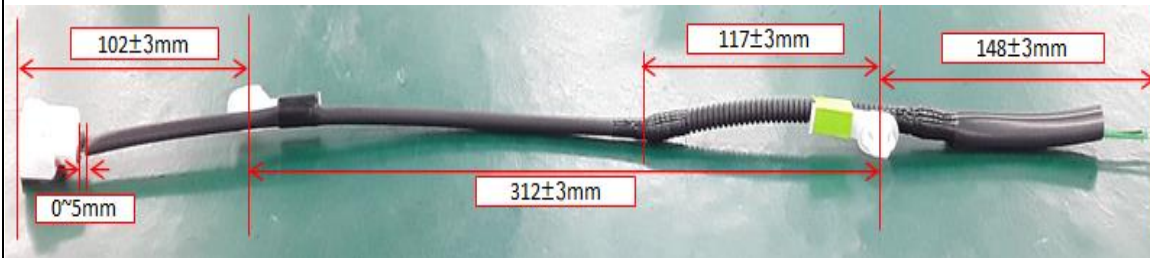
JIG

n/a

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

6

Measurement

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

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

1. No wrong dimension.

P2

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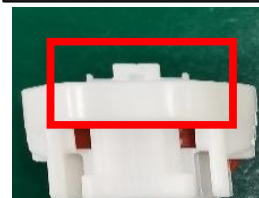
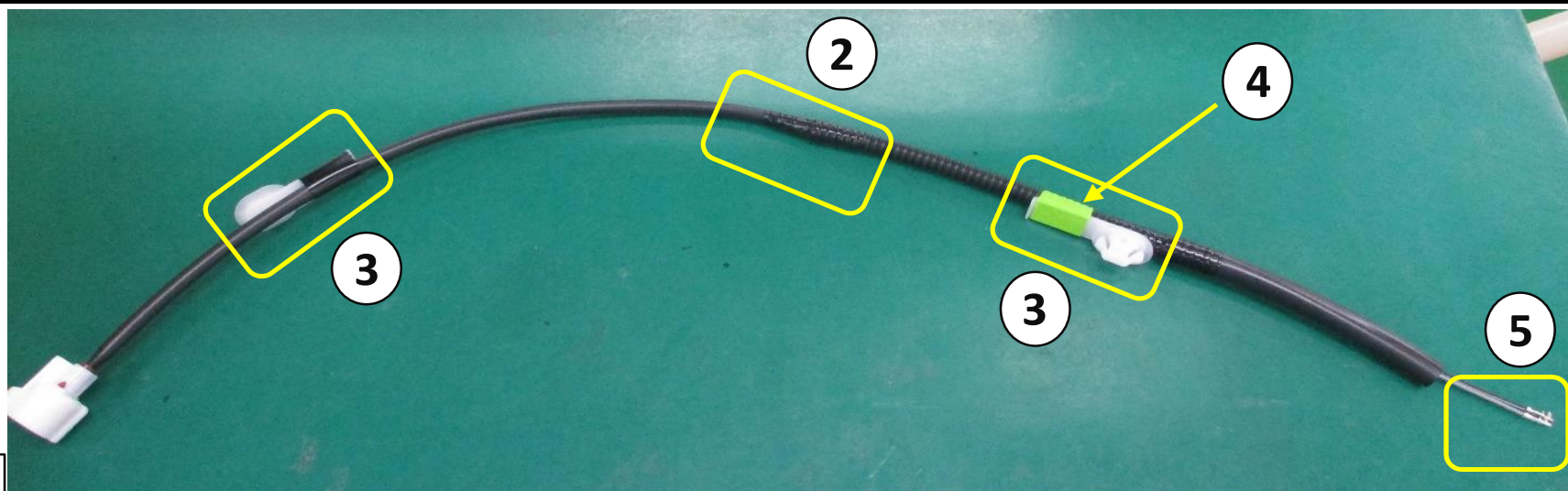
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PARTS:

n/a

JIG

n/a

2 QUALITY CHECKPOINT**P2****7M0557-7021****GOOD****NO GOOD****1 No Unlock/Halflock Connector****2 No Missing Tape****4 No Wrong Used of Tape (light green tape)****3 No Missing Clamp(2pcs.)****5 No Deformed Terminal**

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