

	WORK INSTRUCTION						Effectivity Date:		February 14, 2022										
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a										
	Process Name/Title:				Model Code/ Part Number: 550B / 7L0081-7023		Customer: TRQSS		Document No.: WI-ENG-PDE-408B										
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revis 0										
PARTS:		1.All Parts; Assy parts; Clamp 82711-34490 (B); Clamp 82711-48070 (GR); Clamp 82711-60640 (B); Black tape [2pcs.]						JIG:		1. Clamp Assembly jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS									
1	P2	<div style="display: flex; align-items: center;"> <div style="flex: 1;"> <p>Table Lay-out</p> </div> <div style="flex: 2;"> </div> <div style="flex: 1;"> <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 work place 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> </div> </div>						<p>1. No missing parts/tools 2. No excess parts/tools</p>											
Revision History						Prepared by				Reviewed by		Approved by							
02/14/22 0 Initial Issue.						M. Ariola J. Loterte C. Villanueva A. Arañes				M. Ariola J. Loterte		C. Villanueva A. Arañes							
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted		Est. Date		February 14, 2022	
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PARTS:		1. Clamp 82711-34490 (B) 2. Clamp 82711-48070 (GR) 3. Clamp 82711-60640 (B)		4. Black tape [2pcs.]	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp setting	<div></div> <div>1. Get 1 pc. Band clamp 82711-34490 (B) using right hand then set to clamp location 1 using both hands.</div> <div>2. Get 1 pc clamp 82711-48070 (GR) using right hand and set to clamp location 2 using both hands.</div> <div>3. Get 1 pc clamp 82711-60640 (B) using right hand and set to clamp location 3 using both hands.</div> <div>4. Initially attach Black tape to clamp location 2 and 3.</div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div></div> <div>1. No loose attachment of clamp 2. No wrong use of clamp 3. No wrong use of tape</div>

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1. Assy parts

JIG

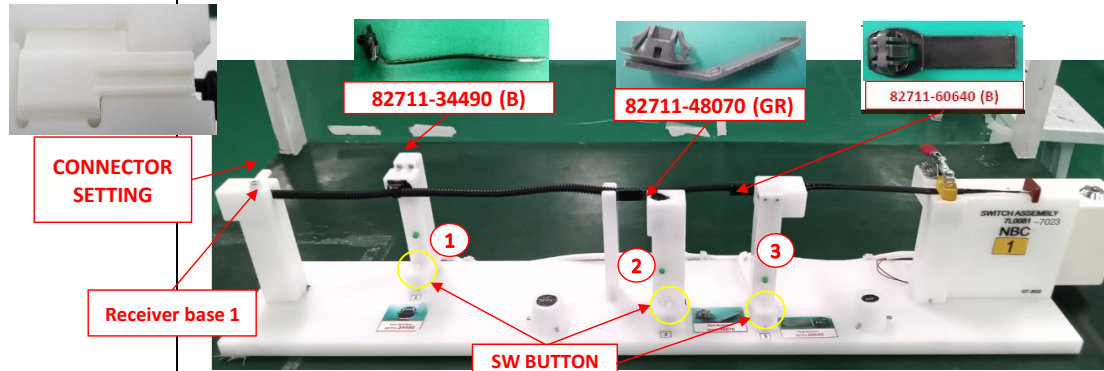
1. Clamp Assembly jig

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

3

P2

Clamp Assembly

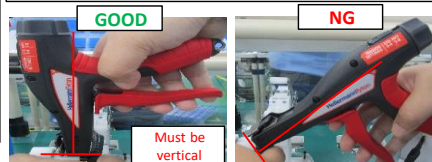
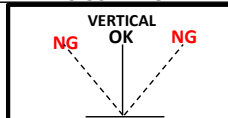


1. Get the assy parts and then put into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the B/B wires together within the stopper jig and then press by toggle clamp. Continue the process if sequence 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. Initially tighten the band clamp on clamp location 1 using right hand.

4. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after cut. Continue if the sequence light on location 2 was **ON**.

**BANDO GUN ALIGNMENT**

Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$

Bando Gun

Make sure no gap between terminal and stopper jig.

1. No missing tape
2. No damaged clamp
3. No missing clamp
4. No loose/tight clamp
5. No wrong attachment of clamp
6. No wrong use of clamp

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PARTS:

1. Assy parts
2. Black tape

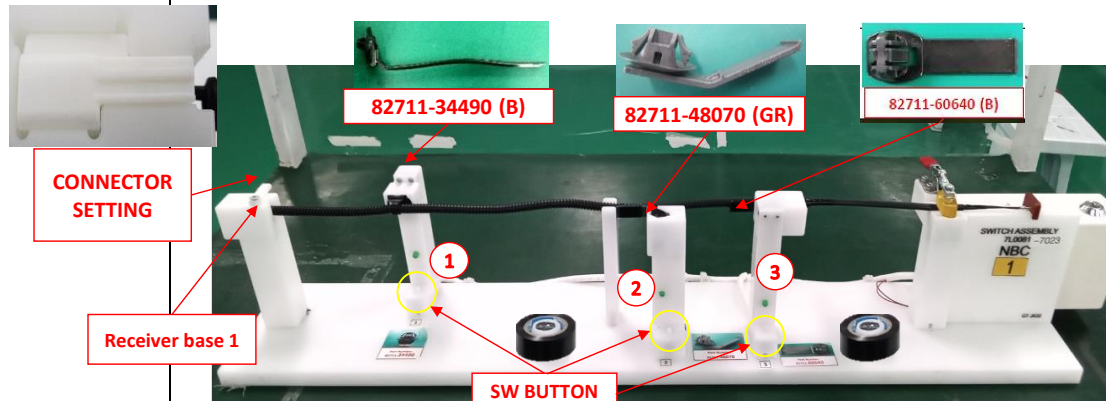
JIG

1. Clamp Assembly jig

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

4

P2

Clamp Assembly
(Continuation)

4. Hold the tape on clamp location **2**. Make **3** windings of tape then cut the tape. Press the **SW button** after every taping. Continue the process on clamp location **2**.

5. Hold the tape on clamp location **3**. Make **3** windings of tape then cut the tape. Press the **SW button** after taping. **Go** sound will be heard.

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

n/a



Make sure no gap between terminal and stopper jig.

1. No missing tape
2. No damaged clamp
3. No missing clamp
4. No loose/tight clamp
5. No wrong attachment of clamp
6. No wrong use of clamp

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Visual/By Two's Inspection

1. Check the connector lock.

3. Check the clamp attachment and taping condition.

4. Check terminal appearance. Make sure no deformed terminal.



0 - 2 mm



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

5. Compare to Master Sample
Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

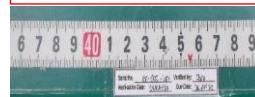
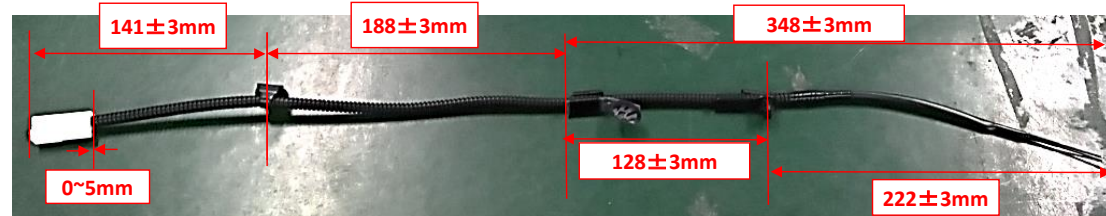
MASTER SAMPLE



6

Measurement

MEASURING TAPE

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

NOTE: FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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