

	WORK INSTRUCTION				Effectivity Date:		July 01, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Product Name/Code: 890B / 7L0100-7020		Customer: TRQSS		Document No.: WI-ENG-PDE-128B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.: 1 of 3

PARTS:	1. Clamp 82711-52090 (W) [2 pcs] 2. Black tape [3pcs]	3. Assy parts	JIG:	1. Clamp Assembly Jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp setting	<div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 45%;"> 1. Get 2 pieces of clamp 82711-52090 using both hands and set to location ① and ② using both hands. </div> <div style="width: 45%;"> 2. Initially attach Black tape on location ① and ② using both hands. </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> STANDARD TAPING FOR CLAMP </div> <div> 1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape </div>
2	Taping 2 COT to wire near connector	<div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 45%;"> 1. Get Black tape, hold corrugated tube using left hand then start pre-taping. </div> <div style="width: 45%;"> 2. Measure the end of the corrugated tube up to the edge of connector 25mm. Then continue taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i> 3. After taping, check the measurement and tape condition. </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> <div style="border: 1px solid black; padding: 5px;"> Measuring tape </div>	<div> 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i> </div>

Revision History				Prepared by:				Reviewed by:		Approved by:		Noted by:		
07/01/21	2	Remove validity date and add tape quantity.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes								
11/27/20	1	Change clamp color in accordance with color standardization for plastic parts. Remove cycle time.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes								
08/24/20	0	Initial issue.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes								
Eff. Date	Rev. No	Details of Change		Revised	Checked	Approved	Noted	Established Date:		August 24, 2020				

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PARTS:		1. Assy parts			JIG	1. Clamp Assembly
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp Assembly	<div><div>Connector setting</div><div>82711-52090</div><div><div>SEQUENCE LIGHT</div></div><div>Note: Make sure no clearance between terminal and stopper jig</div><div>1. Get the assy part and set to jig. (See above picture for correct setting). First, set the connector to Receiver base. Last, set the GR-B/W wires with terminal end together within the stopper then press by Toggle clamp.</div><div>2. Check if all LED light for POWER ON, CLAMP ON was ON. Check also if sequence light of location 1 is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div><div>3. Hold the clamp on location ① and start taping (3 windings) using both hands. Press the SW button after taping. Continue to location ② if light was on.</div><div>4. Hold the clamp on location ② and start taping (3 windings) using both hands. Press the SW button after taping. Go sound will be heard.</div><div>5. Conduct POINT CHECKING before removing of harness from jig.</div></div>		N/A	1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape

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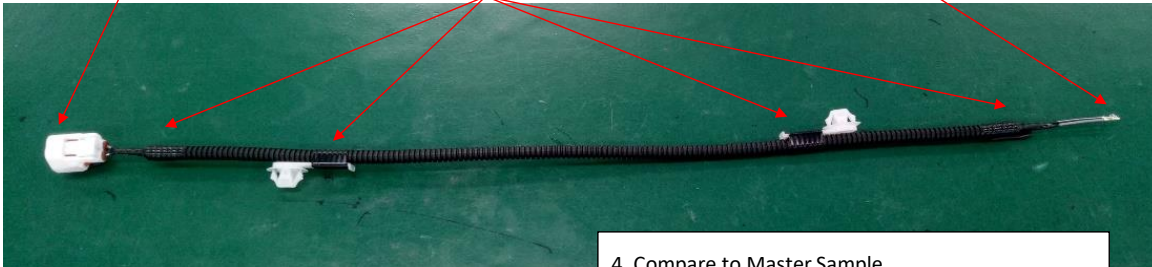



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PARTS:	N/A			JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P2 Visual Inspection	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment and taping condition.</div> <div>3. Check the terminal appearance.</div>  <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div>		<div>Master Sample</div> 	
5	Measurement	<div>Measuring tape</div>  <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div>122±3mm</div> <div>302±3mm</div> <div>154±3mm</div> <div>0~5mm</div> 		<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>	

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