



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 26, 2022

Model Code/Part Number:

N/A / 7H0399W7021

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-470C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

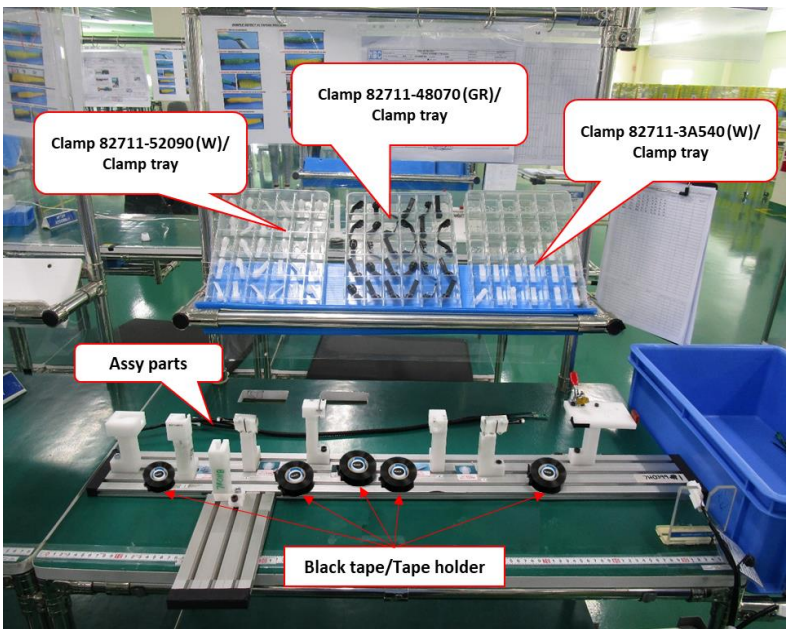
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PARTS:

1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-3A540 (W); Black tape [5pcs.]

JIG:

1. Temporary clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out 	Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. 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.	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/25/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/08/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				

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2 of 5**PARTS:**

1. Clamp 82711-52090 (W) [2pcs.]
2. Clamp 82711-48070 (GR) [2pcs.]

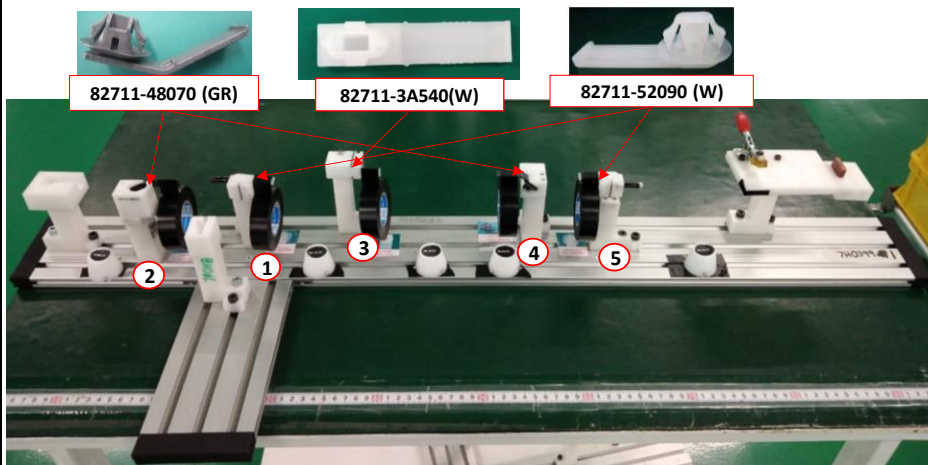
3. Clamp 82711-3A540 (W)
4. Black tape [5pcs.]

JIG

1. Temporary clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2****P3**

Clamp setting



1. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **1 and 5** using both hands.

3. Get 1 pc. of clamp **82711-3A540 (W)** using right hand then insert to clamp location **3** using both hands.

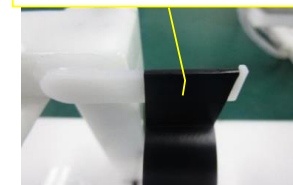
2. Get 2pcs. of clamp **82711-48070 (W)** using right hand and set to clamp location **2 and 4** using both hands.

4. Initially attach **Black tape** to clamp location **1, 2, 3, 4 and 5** using both hands.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp



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

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

PARTS:		1. Assy parts 2. Black tape		JIG	1. Temporary clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P3 Clamp assembly	<p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6188-0407 (W) to Receiver base 1. Continue to set the harness in jig. Second, set the connector 6098-3810 (W) to Receiver base 2. Last, set the terminal and PCB end within the stopper then press by Toggle clamp.</p> <p>2. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 2.</p> <p>3. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 3.</p>	n/a	<p><i>Make sure no gap between terminal and stopper jig</i></p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape	

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PARTS:		1. Assy parts 2. Black tape		JIG	1. Temporary clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp assembly (Continuation)	<p>CONNECTOR SETTING</p> <p>RECEIVER BASE 1</p> <p>RECEIVER BASE 2</p> <p>ø7 Vinyl 1</p> <p>ø5 Vinyl 2</p> <p>CONNECTOR SETTING</p> <p>STOPPER</p>		n/a	<p>Make sure no gap between terminal and stopper jig</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape
		<div>4. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 4.</div> <div>5. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 5.</div> <div>6. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands.</div> <div>7. Conduct POINT CHECKING before removing the harness from jig.</div>			

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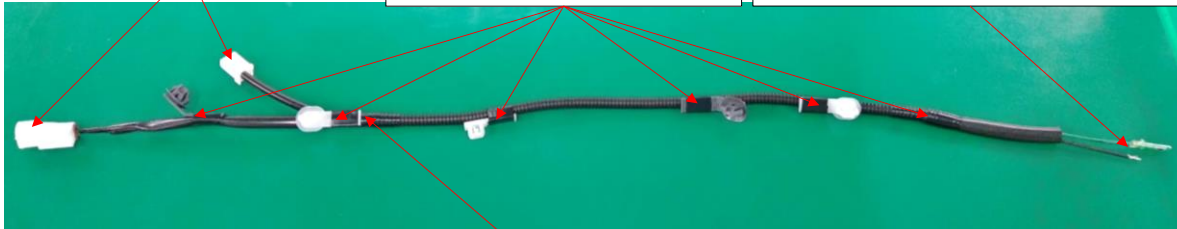


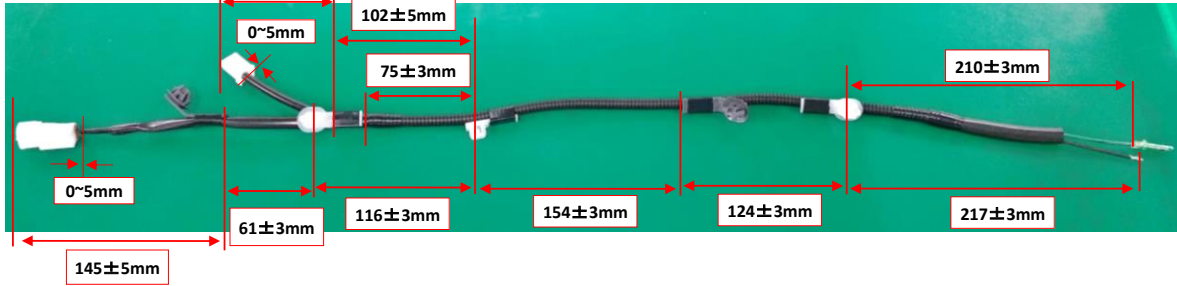
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PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Visual/By Two's Inspection	<div>1. Check the double lock connector.</div> <div>2. Check the taping condition, clamp attachment and alignment.</div> <div>3. Check the Y-taping condition.</div> <div>4. Check the terminal and PCB appearance, make sure no deformed terminal.</div> 			ENGINEERING SAMPLE 
4	P3 Measurement	 <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>  <div>96±5mm</div> <div>0~5mm</div> <div>102±5mm</div> <div>75±3mm</div> <div>210±3mm</div> <div>0~5mm</div> <div>61±3mm</div> <div>116±3mm</div> <div>154±3mm</div> <div>124±3mm</div> <div>217±3mm</div> <div>145±5mm</div>			<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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