



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	August 12, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-317B		
Revision No.:	1	Page No.:	1 of 6

Process Name/Title:

Product Name/Code: D01L / 7M0649-7020B

Customer: TRJ

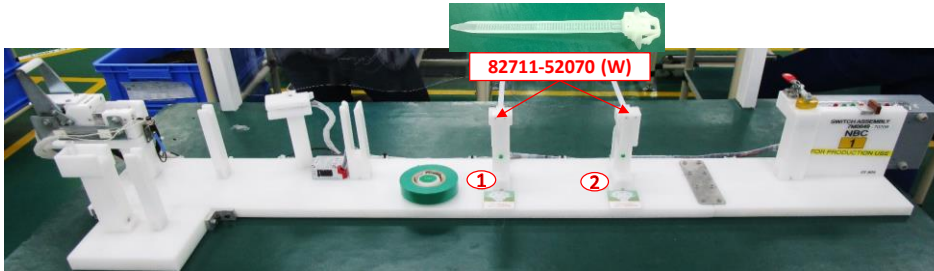

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

- PARTS:**
1. Clamp 82711-52070 (W) [2pcs.]
 2. Green tape [1pc.]
 3. Black tape

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp setting	 <p>1. Get the 2pcs. of clamp 82711-52070 (W) using right hand then insert to clamp location 1 and 2 using both hands.</p> <p>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p>	<p>Safety Instruction</p> <p>Be sure to wear prescribed 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>	<ol style="list-style-type: none">1. No damaged clamp2. No wrong use of parts3. No wrong use of tape4. No wrong insertion of clamp
2	Y-taping	 <p>1. Fix the connector and vinyl tube before taping (must be aligned).</p>	<p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> <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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/12/21	1	Transfer process owner from Production (WI-PRO-ASY-177B) to Engineering (WI-ENG-PDE-317B). Change connector color in accordance with color standardization for plastic parts (Refer to GL-COM-003). Update and improve process illustration and description.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
12/06/19	0	Previously established as production work instruction (WI-PRO-ASY-177B). Initial issue	J. Silang	A. Morcoso/ W. Carballo	O. Merin	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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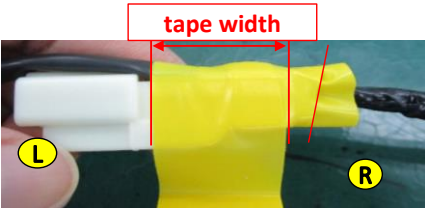
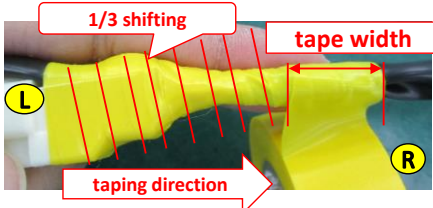
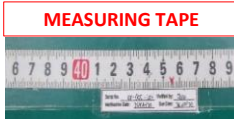
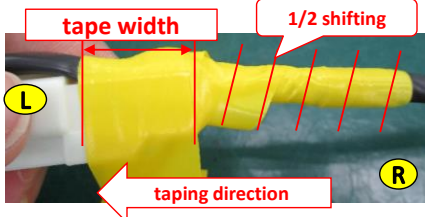
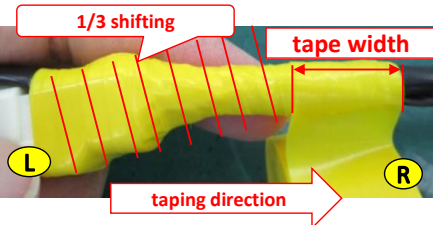
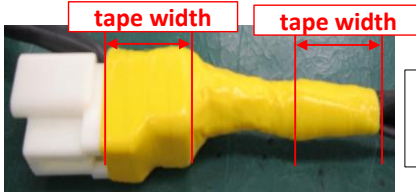

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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Y-taping (Continuation)	<div><div><p>2. Make 1/3 shifting going to connector then make 2 windings of tape before shifting (must be tape width).</p></div><div><p>3. Wind the tape 1/3 shifting until it reach the vinyl tube tape. Make 2 windings of tape before shifting.</p></div></div>		<div></div>	<div><div>1</div><p>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p><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 use of tape</div><div>6. No wrong dimension</div></div><div><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div></div>
		<div><div><p>4. Wind the tape backward 1/2 shifting then make 2 windings of tape before final shifting.</p></div><div><p>5. Wind the tape 1/3 shifting going to vinyl tube then make 3 windings of tape before cut.</p></div></div> <div><div><p>6. After taping, check the measurement and taping condition.</p></div><div><p>ACTUAL ASSY PARTS AND CORRECT FACING</p></div></div>			

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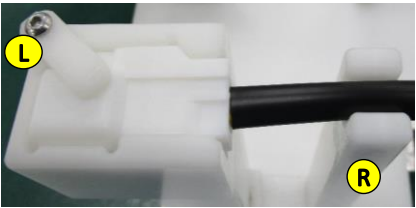


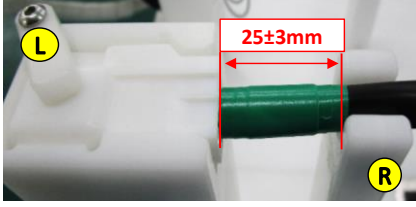
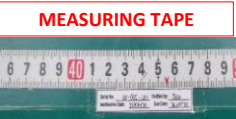
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PARTS:

1. Assy parts
2. Green tape

JIG

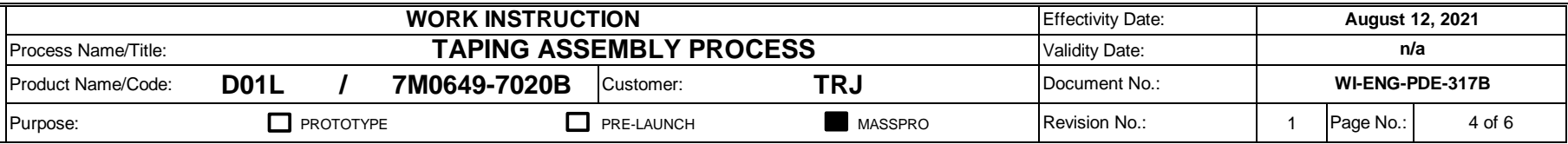
1. Spot taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Spot taping	<div><p>1. Put the connector 4G5400-000 (W) into Receiver base using both hands.</p></div> <div><p>2. Get the Green tape then attach to tube using both hands (must be follow the guide).</p></div> <div><p>3. Continue taping process using both hands then make 3 windings of tape before cut..</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>NOTE: USE GREEN TAPE only.</p></div> <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> <div><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></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	P2	<div><div>1</div><div><div><div>Clip checker 1</div><div>82711-52070 (W)</div><div>1</div><div>2</div><div>COLOR SENSOR GREEN TAPE only</div><div>STOPPER</div></div><div><div>CONNECTOR SETTING</div><div>CHECKER 1</div></div></div></div>		<div><div>STOPPER</div><div>Note: Make sure no gap between stopper jig terminals.</div></div>	
		<div><div>3. Initially tighten the band clamp on clamp location 1 using right hand.</div><div>4. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after taping. Continue if the sequence light on clamp location 2 was ON.</div><div>5. Cut the clamp on clamp location 2 using both hands. Press the SW Button after cut. Go sound will be heard.</div><div>6. Conduct POINT CHECKING before removing the harness from jig.</div></div> <div><div><div>BANDO GUN ALIGNMENT</div><div><div>NG</div><div>VERTICAL OK</div><div>NG</div></div></div><div><div>GOOD</div><div>NG</div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$</div></div></div> <div><div>BANDO GUN</div></div>		<div><div>1</div><div>1. No loose 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 terminal and stopper jig.</div></div>	

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PARTS:	n/a		JIG	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Visual/By Two's Inspection 				

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