



**WORK INSTRUCTION**  
**TAPING ASSEMBLY PROCESS**

Process Name/Title:			Effectivity Date:	September 30, 2021	
Model Code/Part Number:	660B / 7R0111-7020B	Customer:	TRMX	Validity Date:	n/a
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-323B		
			Revision No.:	1	Page No.: 1 of 5

**PARTS:**

1

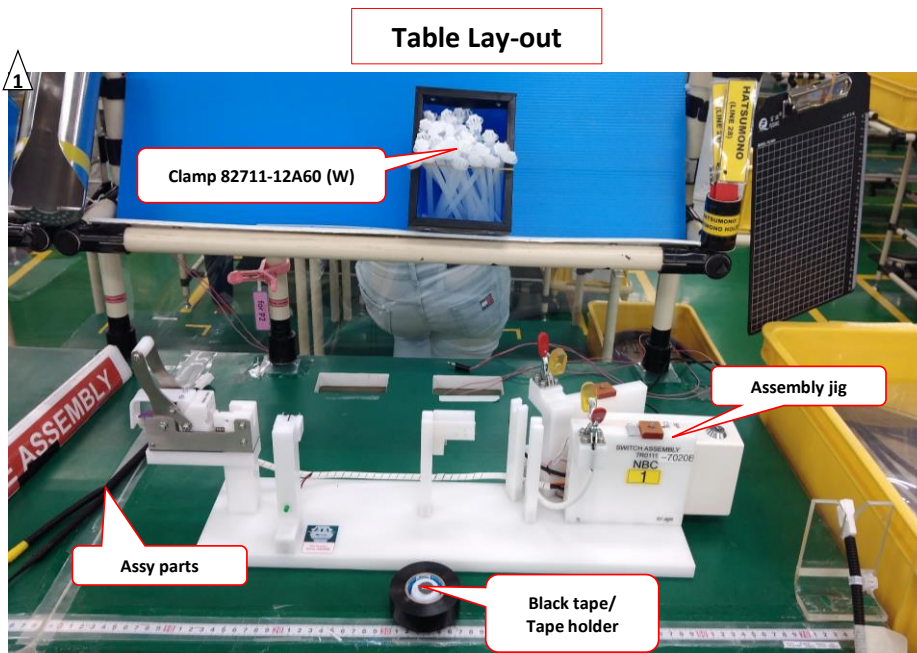
1. Assy parts
2. Black tape [1pc.]

3. Clamp 82711-12A60 (W)

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	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
09/30/21	1	Improve all process description and illustration; Change from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
08/10/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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**PARTS:**

**1**

1. Assy parts
2. Clamp 82711-12A60 (W) [1pc.]

**JIG**

1. Clamp assembly jig

**NO.**

**PROCESS NAME**

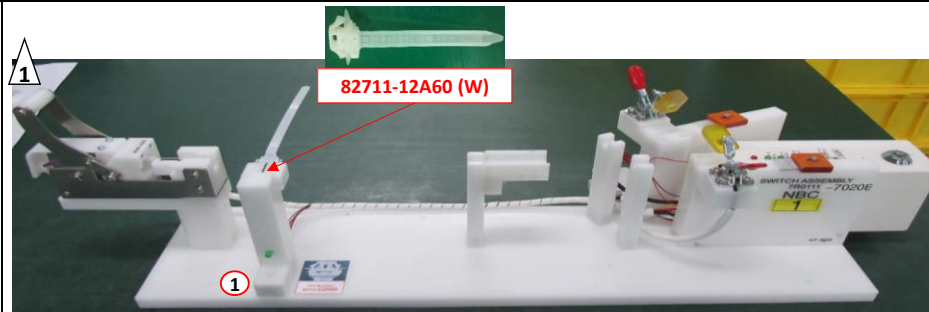
**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

**2**

Clamp setting



1. Get **1pc.** of clamp **82711-12A60 (W)** using right hand then set to clamp location **1** using both hands.

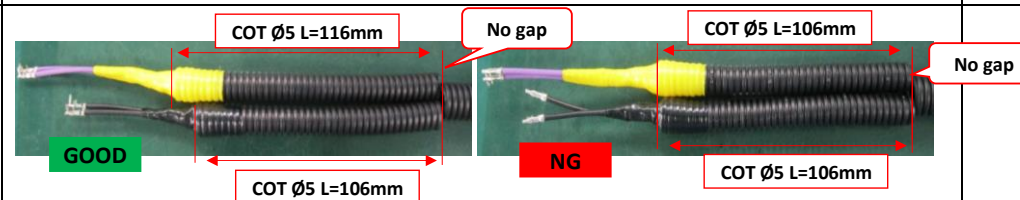
**Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.**

n/a

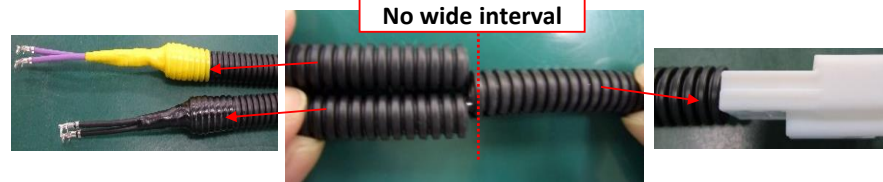
1. No wrong use of parts
2. No damaged clamp
4. No wrong clamp position

**P2**

Y-Taping



**Note: 2 COT must not aligned before taping procedure. Refer above illustration as reference.**



1. Fix the corrugated tube.

n/a

1. No gap in between COT
2. No wrong orientation
3. No wrong dimension

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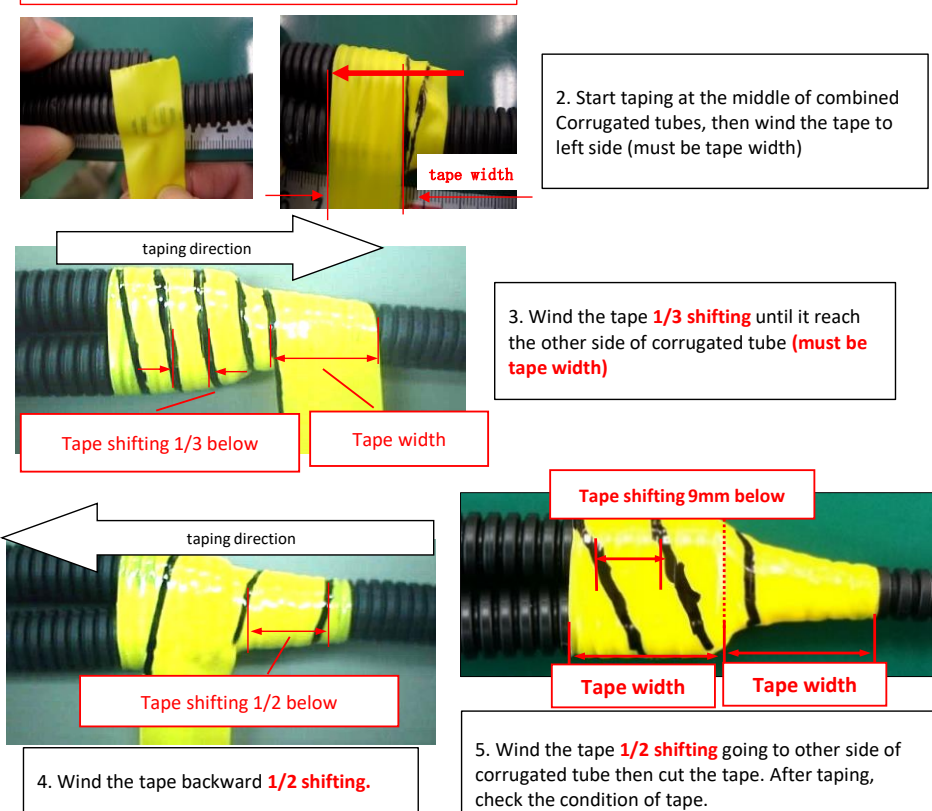

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Y-Taping (Continuation)	<p><b>Note:</b> Do not exert excessive force during pulling &amp; winding of tape</p>  <p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side (must be tape width)</p> <p>3. Wind the tape <b>1/3 shifting</b> until it reach the other side of corrugated tube (<b>must be tape width</b>)</p> <p>4. Wind the tape backward <b>1/2 shifting</b>.</p> <p>5. Wind the tape <b>1/2 shifting</b> going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p> <p><b>Tape shifting 1/3 below</b></p> <p><b>Tape shifting 1/2 below</b></p> <p><b>Tape shifting 9mm below</b></p> <p><b>taping direction</b></p> <p><b>tape width</b></p>	<p><b>MEASURING TAPE</b></p> 	<p><b>NOTE: USED <u>YELLOW TAPE</u> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</b></p> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

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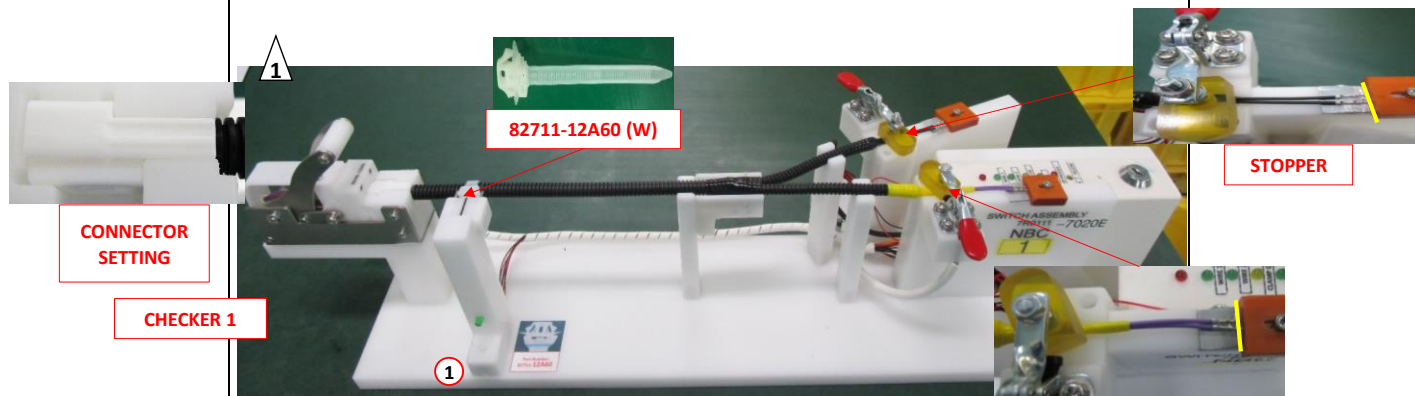




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PARTS:		1. Assy parts			JIG	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly	<div><div></div><div><p>1. Get the assy parts and set into jig. (See above illustration for correct setting). First, set the connector 6098-3802 (W) to <b>Checker 1</b> then pull the checker fixture for continuity checking. Continue to set the harness in jig. Set the <b>V/V wires</b> together within the stopper jig then press by toggle clamp. <b>Color sensor</b> light will beep/buzz if sensor detects <b>Yellow tape</b>. Set the <b>B/B wires</b> together within the stopper jig then press by toggle clamp. Continue if the sequence light in location <b>1</b> was <b>ON</b>.</p><p>2. Initially tighten the band clamp on clamp location <b>1</b> using both hand.</p><p>3. Get the bando gun using right hand then cut the band clamp on location <b>1</b>. Press the <b>SW button</b> after cut. <b>Go</b> sound will be heard.</p><p>4. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</p></div><div><div></div><div><p><b>BANDO GUN ALIGNMENT</b></p><div><p><b>PERPENDICULARITY</b></p><div><div>NG</div><div>OK</div><div>NG</div></div></div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div></div></div></div>		<div><div></div><div></div></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. No gap between terminal and stopper</div>

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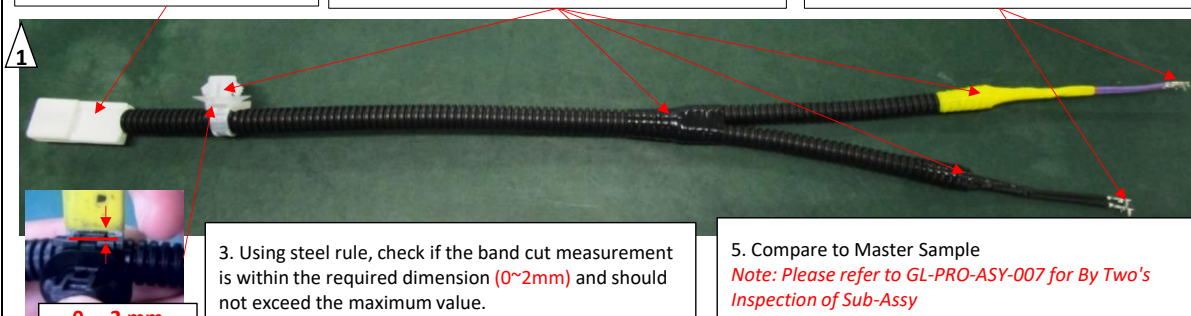

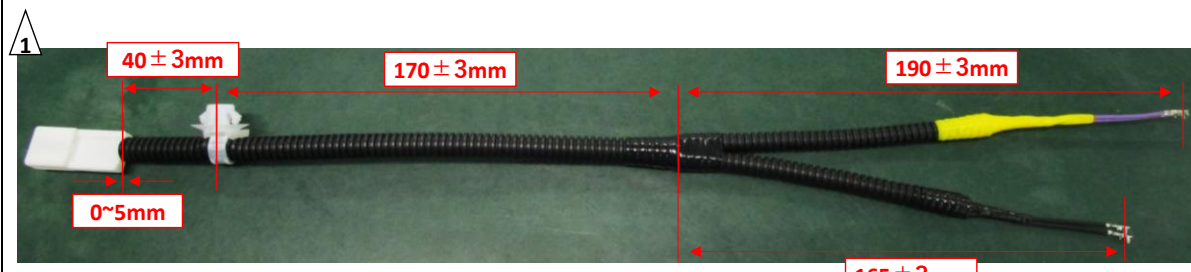
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2 Visual/By Two's Inspection	<div>1. Check the connector lock</div> <div>2. Check the taping condition, clamp attachment and alignment.</div> <div>4. Check the terminal appearance, make sure no deformed terminal.</div> <div>3. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div> <div>5. 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> 
6		Measurement	<div>MEASURING TAPE</div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> 		

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