

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**September 27, 2022**Model Code/Part Number: **220D / 7R0128-7020**Customer: **TRMX**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-436**

Revision No.:

**2**

Page No.:

**1 of 6****PARTS:**

1. Assy parts: Clamp 82711-16830 (B); Blue tape [1pc.]

JIG:

1. Clamp Assembly jig

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

1

P1

Table Lay-out

**Table Lay-out**Clamp 82711-16830 (B)/  
Clamp box

Assy parts

Clamp assembly jig

Blue tape/Tape holder

**Safety Instruction**

Be sure to wear prescribed 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.

**BANDO  
GUN****Document references:** <sup>2</sup>

1. Refer to WI-ENG-PDE-544 7R0128-7020 - Offline Assembly Process

1. No missing parts/tools
2. No excess parts/tools


**Revision History**

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
09/27/22	2	Improve quality pointers: References in process no.1,2,3,4,5 and 6 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.5 - visual/by two's inspection.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
06/10/22	1	Change document purpose from pre-launch to masspro. Additional table layout	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
03/03/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	<b>2</b>	Page No.:	<b>2 of 6</b>	

<b>PARTS:</b>	1. Clamp 82711-16830 (B) [3pcs.]			<b>JIG</b>	1. Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Clamp setting <div data-bbox="598 429 1518 825" data-label="Image"> </div> <div data-bbox="857 852 1296 1010" data-label="Text"> <p>1. Get <b>3pcs.</b> of clamp <b>82711-16830 (B)</b> using right hand and set to clamp location <b>1, 2 and 3</b> using both hands.</p> </div>	n/a	<div data-bbox="1749 469 2107 588" data-label="Text"> <p><b>2 Important reminders/Note/s:</b>  <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></p> </div> <div data-bbox="1749 659 2004 762" data-label="List-Group"> <ul style="list-style-type: none"> <li>1. No damaged clamp</li> <li>2. No wrong use of clamp</li> <li>3. No wrong use of tape</li> <li>4. No missing clamp</li> </ul> </div> <div data-bbox="1778 828 2098 1169" data-label="Image"> <div> <div>BAND CLAMP ILLUSTRATION</div> <div> <div>GOOD</div> <div> </div> <div>82711-16830 (B)</div> </div> <div> <div>NG</div> <div> </div> <div>82711-34490 (B)</div> </div> </div> </div>


  

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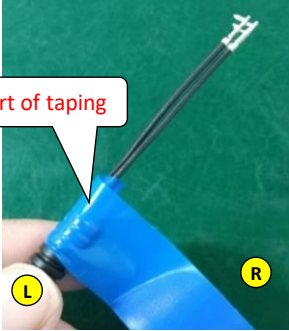
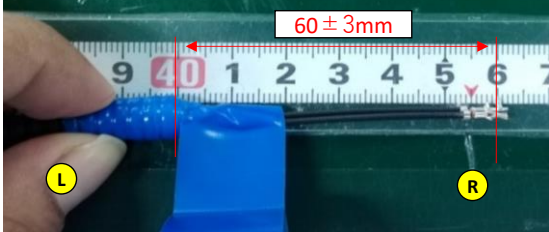
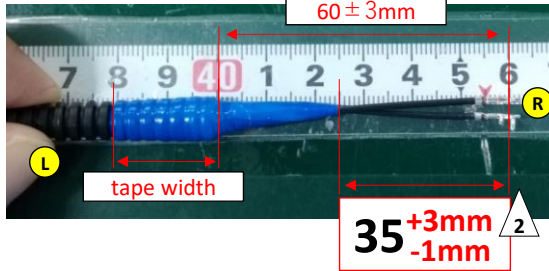

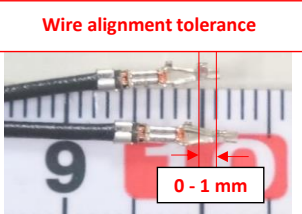
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<b>PARTS:</b>	1. Assy parts 2. Blue tape			<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P1  Taping 1 COT to wire near terminal	<div>  <p>Start of taping</p> <p>1. Hold the COT using left hand, get the <b>Blue tape</b> using right hand then start pre-taping using both hands.</p> </div> <div>  <p>60 ± 3mm</p> <p>2. Measure from end of COT up to terminal pointed tip <b>60±3mm</b> then continue the taping process using both hands.</p> </div> <div>  <p>60 ± 3mm</p> <p>tape width</p> <p>35+3mm -1mm</p> <p>3. After taping, check the measurement, taping condition and terminal appearance.</p> </div>	<div>  <p><b>MEASURING TAPE</b></p> </div>	<div>  <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> </div> <p>2</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 dimension</li> <li>6. No wrong use of tape</li> </ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"> <li>1. <b>USE BLUE TAPE ONLY</b></li> <li>2. <b>Please use calibrated/verified measuring tape when getting the measurement.</b></li> </ol> <p><b>Document references:</b></p> <ol style="list-style-type: none"> <li>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</li> </ol>	

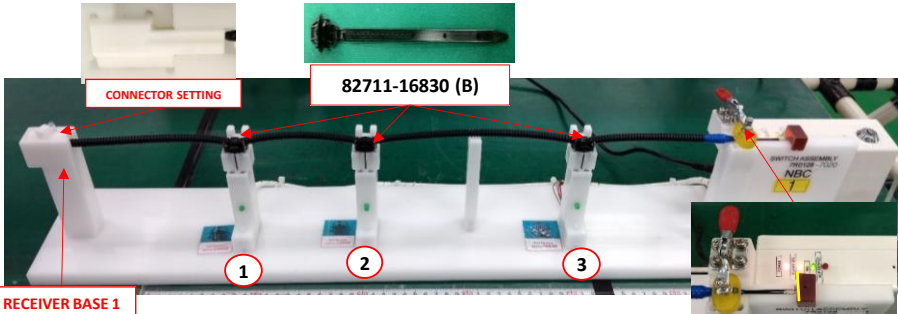



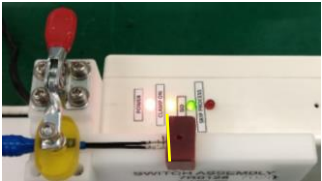
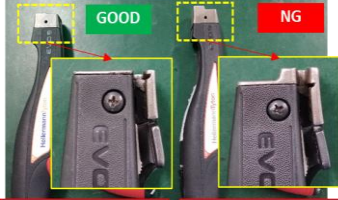
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<b>PARTS:</b>	1. Assy parts		<b>JIG</b>	1. Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Clamp assembly	<div>  </div> <div> <p>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.</p> <p>2. Check if all LED light for POWER ON, 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.</p> <p>3. Initially tighten the band clamp on location 1, 2 and 3 using both hands.</p> <p>4. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue the process if sequence light on clamp location 2 was ON.</p> <p>5. Cut the band clamp on location 2 using both hands. Press the SW button after cut. Continue the process if sequence light on clamp location 3 was ON.</p> <p>6. Cut the band clamp on location 3 using both hands. Press the SW button after cut. Go sound will be heard.</p> </div> <div>  <p><b>BANDO GUN POSITION ON CLAMP LOCATION 2</b></p> <p>GOOD NG</p> <p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p>  <p><b>BANDO GUN ALIGNMENT</b></p> <p>PERPENDICULARITY OK NG</p> <p>7. Conduct POINT CHECKING before removing the harness from jig.</p> </div>	 <p><b>BANDO GUN</b></p>	<div>  <p><b>Important reminders/Note/s:</b></p> <p>1. Make sure no gap between stopper and terminals</p> </div> <p>2</p> <div> <p>1. No loose attachment of clamp</p> <p>2. No damaged clamp</p> <p>3. No missing parts</p> </div> <div> <p><b>BANDO GUN ILLUSTRATION</b></p>  <p>GOOD NG</p> <p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p> </div>



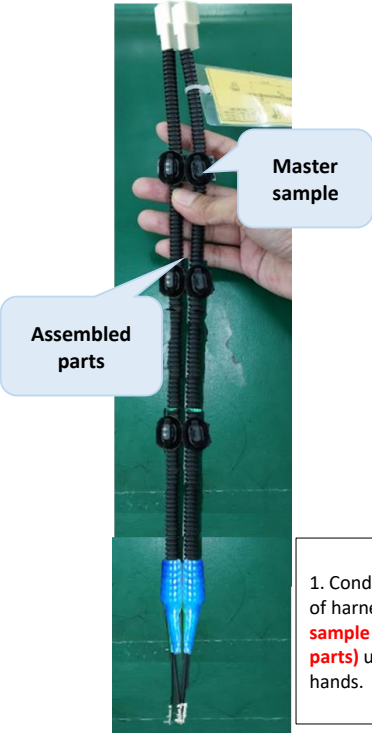
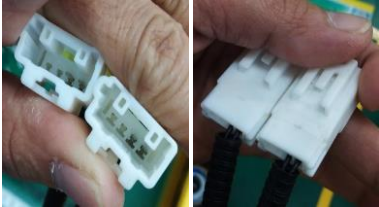
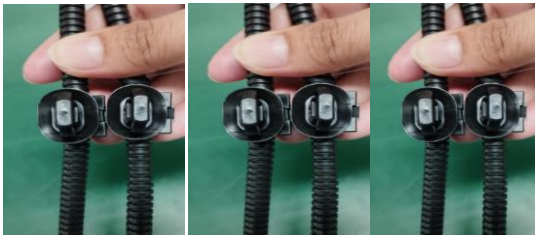

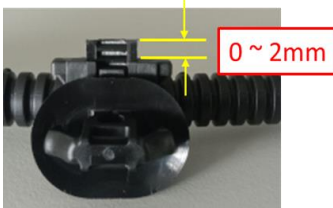
  

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<b>PARTS:</b>		1. Assy parts			<b>JIG</b>	1. Clamp Assembly jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>2 WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>				
5	P1	Visual/By Two's Inspection	<div>  <p><b>ACTUAL PRODUCT</b></p> </div> <div>  <p><b>MASTER SAMPLE</b></p> </div> <div>  <p><b>Master sample</b></p> <p><b>Assembled parts</b></p> </div> <div>  <p>2. Check the <b>terminal, connector lock</b> condition and <b>insertion</b>.</p> </div> <div>  <p>3. Check the <b>presence of clamp attachment</b>.</p> </div> <div>  <p>4. Check the <b>taping condition</b> and <b>terminal appearance</b>. Must be <b>no deformed terminal</b>.</p> </div> <div>  <p>1. No skip process</p> <p>0 ~ 2mm</p> </div> <div> <p><b>Important reminders/Note/s:</b></p> <p>1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p> </div>					

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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P1

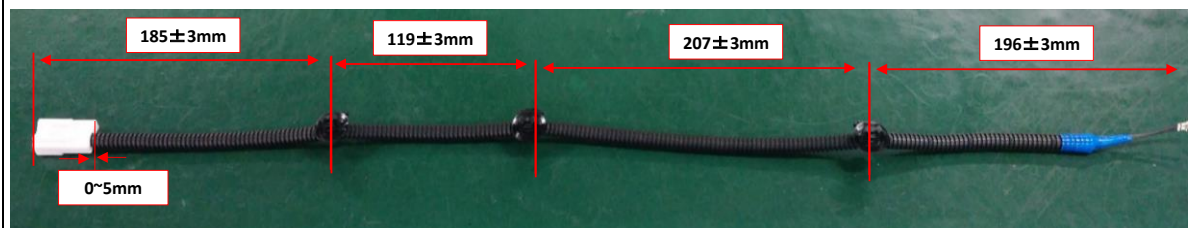
Measurement

### MEASURING TAPE



Note:

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



2 Important reminders/Note/s:  
1. FOR HATSUMONO AND  
OWARIMONO

1. No wrong dimension

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