

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

Effectivity Date:

**February 18, 2022**Model Code/Product Number: **200/220D / 7R0123-7020**Customer: **TRMX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Document No.:

**WI-ENG-PDE-406**

Revision No.:

0

Page No.:



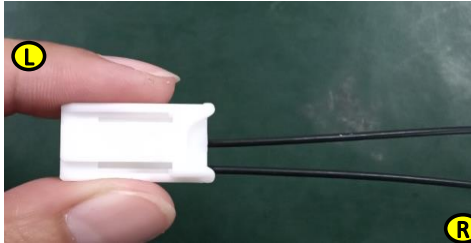
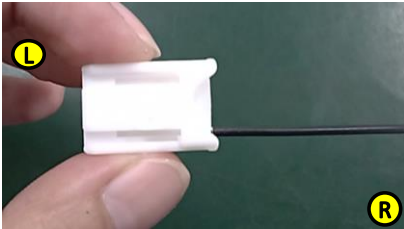
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**PARTS:**





1. Connector 6098-3810(W) 2. IRRAX A 0.3 L= 285±2mm (B) [2pcs]

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<div><p>Wire facing</p><p>Connector Orientation</p><p>1. Hold the connector using left hand. Get the <b>1st Black wire</b> and insert to connector using right hand.</p><p>2. Get the <b>2nd Black wire</b> and insert to connector using right hand.</p></div>	<div><b>Safety Instruction</b><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><b>Housekeeping</b><p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div> <div><b>Alert level</b><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>	<div><b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</b></div> <div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div><b>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></div> <div><b>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

## Revision History

Eff.Date	Rev.No	Details of Change	Revised	Checked	Approved	Noted	Prepared by:	Reviewed by:	Checked by:	Noted by:
02/18/22	0	Initial issue	M.Ariola	J. Loterte	C. Villanueva	A.Arañes	 M.Ariola	 J. Loterte	 C. Villanueva	 A.Arañes
							Est. Date:	February 18, 2022		

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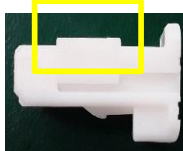
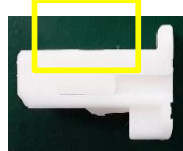





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PARTS:		1. Assy parts	2. Black Corrugated tube (No slit) $\Phi 5$ L=217 $\pm$ 3mm	JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector Lock	  <b>Before pressing</b>  <b>After pressing</b> <div>1. Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Touch the connector lock if properly locked. <i>Refer to GL-PRO-ASY-017 for locking verification.</i></div>		 <b>LOCKING JIG</b>	<b>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b>  1. Use provided jig tool per model 2. No unlock/half-locked connector
3	n/a	Wire insertion to Black Corrugated tube (No slit) $\Phi 5$ L=217 $\pm$ 3mm	  <div>1. Get the terminal cover jig using right hand then insert the <b>B-B wires</b> using left hand.</div> <div>2. Get the Black COT <math>\Phi 5</math> L=217<math>\pm</math>3mm using right hand and insert <b>B-B wires</b> using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div> 	 <b>Terminal Cover</b>	1. No wrong use of parts 2. No deformed terminal

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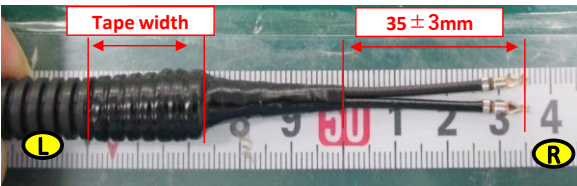

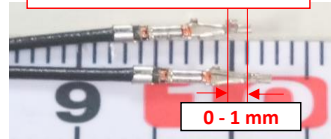
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## PARTS:

1. Assy parts
2. Black tape

## JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a Taping 2 COT to Wire	<div><div></div><div><div>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</div></div><div><div></div><div><div>2. Measure from end of COT up to terminal pointed tip <b>60±3mm</b> then continue the taping process using both hands.</div></div><div><div></div><div><div>3. After taping, check the measurement, terminal appearance and taping condition.</div></div></div></div></div>	<div><div>MEASURING TAPE</div></div>	<div><div><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</div><div><div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div></div><div><div><b>Wire alignment tolerance</b></div></div></div>

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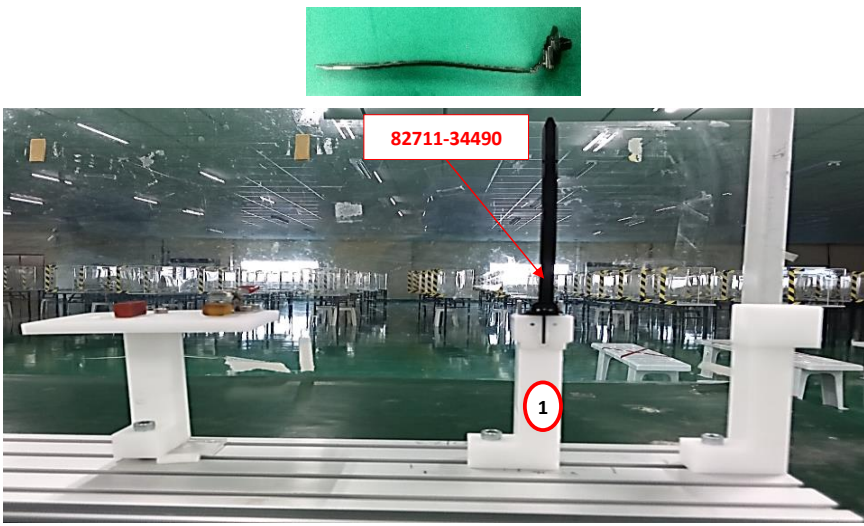
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**PARTS:**

1. Assy parts
2. Clamp 82711-34490(B)

**JIG**

Temporary clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	<div><p>1. Get <b>1 pc</b> of band clamp <b>82711-34490 (B)</b> using right hand and set to clamp location ① using both hands.</p></div>	n/a	<ol style="list-style-type: none"><li>1. No damaged clamp</li><li>2. No wrong use of clamp</li><li>3. No missing clamp</li></ol>

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### PARTS:

1. Assy parts
2. Clamp 82711-34490(B)

### JIG

Temporary clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

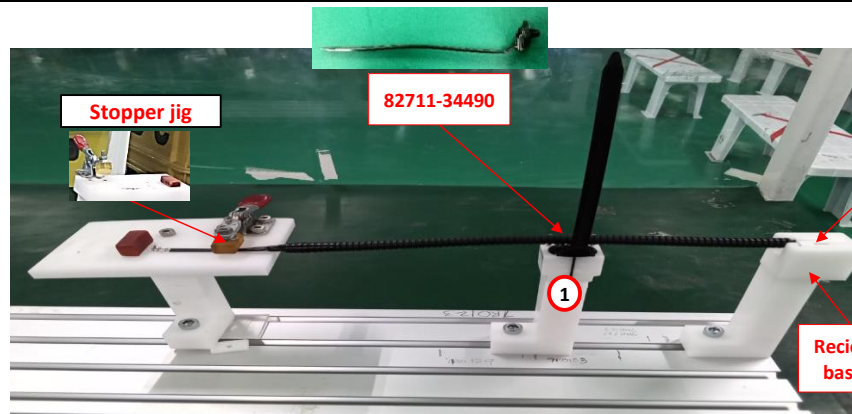
### TOOLS/PPE

### QUALITY POINTERS

6

n/a

Clamp Assembly  
(Continuation)



1. Put the assy parts into jig using both hands. First put the connector to receiver base using left hand and lock using right hand. Second, put the terminal into stopper jig using left hand and pull down the toggle clamp using right hand. **Refer to above illustration for the correct setting.**

2. Initially tighten the band clamp **82711-34490** on clamp location **1** using right hand.

3. Get the bando gun using right hand then cut the band clamp on Location **1**.

4. Check the **CLAMP**. If encountered abnormality, **STOP** the process, **CALL** the attention of the Leader and **WAIT** for instruction.



Connector  
setting

Receiver  
base 1

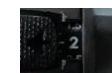
**BANDO GUN**



*Note:*  
Make sure no clearance between  
terminal and stopper jig

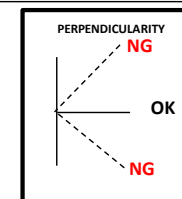


1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun



Fixed setting of  
band clamp  
cutter: 1 ~ 2

### BANDO GUN ALIGNMENT



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**PARTS:**

n/a

**JIG**

n/a

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

7

Visual/By two's Inspection

1. Check the connector lock.

2. Check the clamp attachment and taping condition.

3. Check the terminal appearance. Make sure no deformed terminal.



4. Using a steel rule, check if the band cut measurement is within the required dimension (**0~2mm**) and should not exceed the maximum value.



5. Compare to Master Sample  
*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy*

n/a

**MASTER SAMPLE**



n/a

8

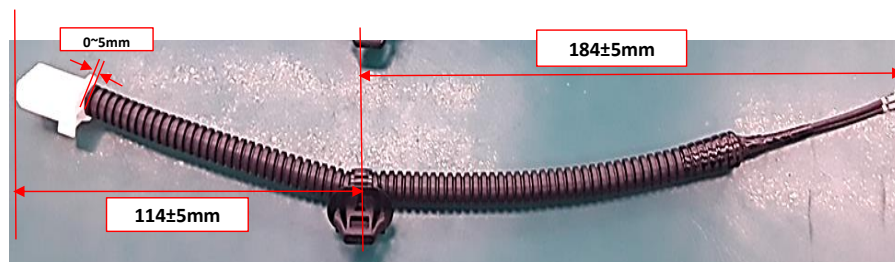
Measurement

**MEASURING TAPE**



**Note:**

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



**NOTE: FOR HATSUMONO AND OWARIMONO**

1.No wrong Dimension

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