

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

Effectivity Date:

December 03, 2022Model Code/Part number: **920B / 7R0116-7020B** Customer: **TRMX**

Validity Date:

n/aPurpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

WI-ENG-PDE-586B

Revision No.:

1

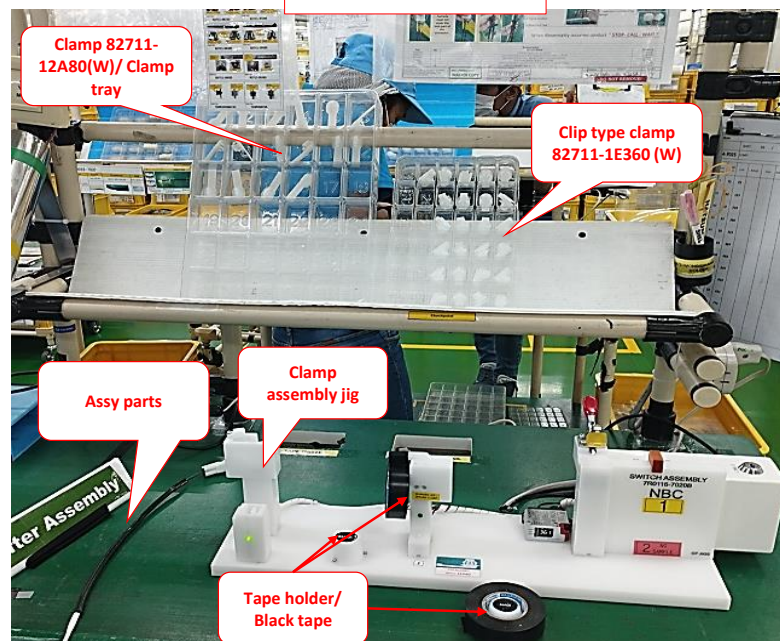
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1 of 8**PARTS:**

1. Assy parts; Clamp 82711-12A80(W); Clip type clamp 82711-1E360 (W); Black tape[2pcs]

JIG1. Clamp Assembly jig
2. Locking jig**NO.****PROCESS NAME****1 WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****1****P2**

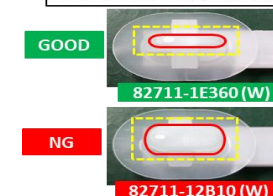
Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping1. 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.**CLAMP ILLUSTRATION****CLIP CLAMP ILLUSTRATION****Revision History**

| Eff. Date | Rev. No | Details of Change | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|--|-------------|-------------|---------------|-----------|
| 12/03/22 | 1 | Change document purpose from pre-launch to Masspro. Additional Table lay-out. Integrate connector lock to clamp assembly jig. Inclusion of Quality Pointers. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |
| 08/18/22 | 0 | Initial issue Wire length 402mm to 365mm; Vinyl tube (SV) length from 183mm to 146mm. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |

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2 of 8**PARTS:**

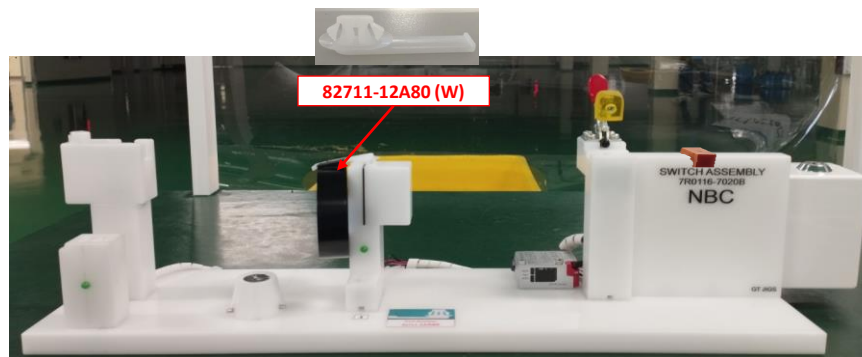
1. Clamp 82711-12A80 (W)
2. Black tape

JIG

1. Clamp Assembly jig
2. Locking jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2****P2**

Clamp setting



1. Get 1pc. of clamp **82711-12A80 (W)** using right hand and set to clamp location **1** using both hands.

2. Initially attach **Black tape** to clamp location **1** using both hands.

n/a

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

Important reminder/Note/s:

1. Please check the clamp first before start of assembly to avoid wrong use of Clamp.



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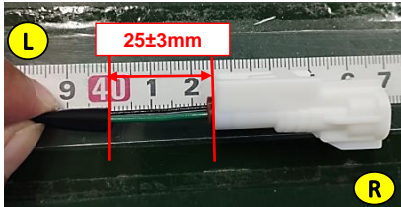
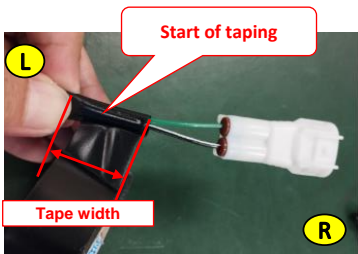
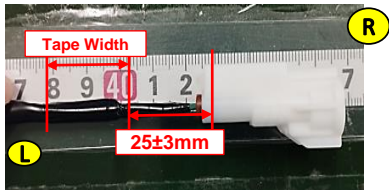

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|--|--|--|---|
| 3 | P2 Taping 3 Black Vinyl tube to Wire near connector | <div><p>1. Measure from end of Vinyl tube up to end of connector 25±3mm using both hands.</p></div> <div><p>2. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div> | <div>MEASURING TAPE</div>  | <p>Important reminder/s Note/s:</p> <p>1. Please check the clamp first before start of assembly to avoid wrong use of tape.</p> <p>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</p> |

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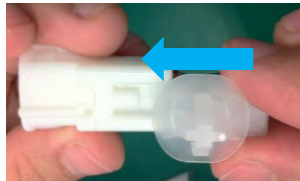




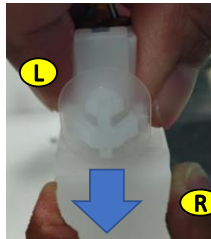

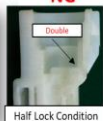




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PARTS:

1. Assy parts
2. Clip type clamp 82711-1E360 (W)

JIG

1. Clamp Assembly jig
2. Locking jig

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|---|---|---|---|
| 4 | Clamp attachment (clip type clamp) |    <p>1. Hold the connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></p> | n/a | <p>1. Must be fully inserted 2. No wrong use of clip clamp.</p> <p>CLIP CLAMP ILLUSTRATION</p> <p>GOOD </p> <p>NG </p> |
| 5 | Connector lock (integrate to Clamp Assembly jig) |  <p>1. Put the connector into locking jig using right hand then press 2x to lock.</p> <p>Coupler Cross Sectional View</p> <p>NG  NG  GOOD </p> <p>Before lock  After lock </p> | <p>LOCKING JIG</p>  | <p>Important reminder/s Note/s:</p> <p>1. Manual locking may cause damaged connector lock</p> <p>1. Use the provided locking per model 2. No unlock/half-locked connector</p> |

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Temporary Assembly jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P2

Clamp Assembly

RECEIVER BASE 1

CONNECTOR
ORIENTATION

82711-12A80 (W)

STOPPER JIG

LOCKING JIG

1. Put the assy into jig. *(See above picture for the correct setting).* First, set the connector **6188-0407 (W)** to **Receiver base 1**. Continue to set the harness in jig. Last, set the **Black/White and Green wires** together within stopper then press by toggle clamp. Continue if the sequence light of location **1** was **ON**.

3. Hold the tape on clamp location **1**, make **3 windings** of tape then cut the tape using both hands.

2. Check if all LED light for **Power ON, Clamp ON, Wire 1** was **ON**. If encountered abnormality, **STOP** and Immediately **CALL** the attention of the leader. **WAIT** for the further instruction then continue the process.

4. Conduct **POINT CHECKING** before removing the harness from jig.



1 Important reminders/Note/s:

1. Make sure no gap between terminal and stopper jig

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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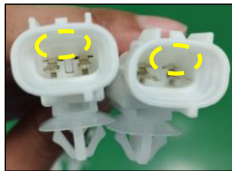



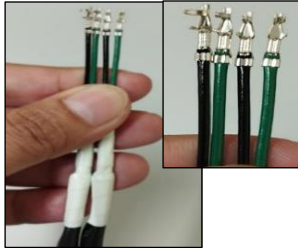





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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|--------------|------------------------------|-----------|------------------|
| 7 | P2 | Visual/ By two's inspection | | |
| <div><div><p>ACTUAL PRODUCT</p></div><div><div><p>Assembled parts</p><p>Master sample</p></div><div><p>2. Check the connector lock, insertion, taping condition.</p></div><div><p>3. Check the Clip type clamp attachment.</p></div><div><p>4. Check the taping condition of Vinyl to Sunprene tube.</p></div><div><p>5. Check the clamp attachment and taping condition.</p></div><div><p>6. Check the taping condition, Color of tape (White tape only) and terminal appearance. Must be no deformed terminal.</p></div></div><div><div><p>MASTER SAMPLE</p></div><div><p>1. No skip checking during inspection.</p></div><div><p>CLIP CLAMP ILLUSTRATION</p><div><p>GOOD  82711-1E360 (W)</p><p>NG  82711-12B10 (W)</p></div><p>CLAMP ILLUSTRATION</p><div><p>GOOD  82711-52090 (W)</p><p>NG  82711-12A80 (W)</p></div></div></div></div> | | | | |

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PARTS:

n/a

JIG

n/a

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

8

P2

Measurement

**MEASURING TAPE****Important reminder/s Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsunomo and Owarimono.

1. No wrong dimesion.

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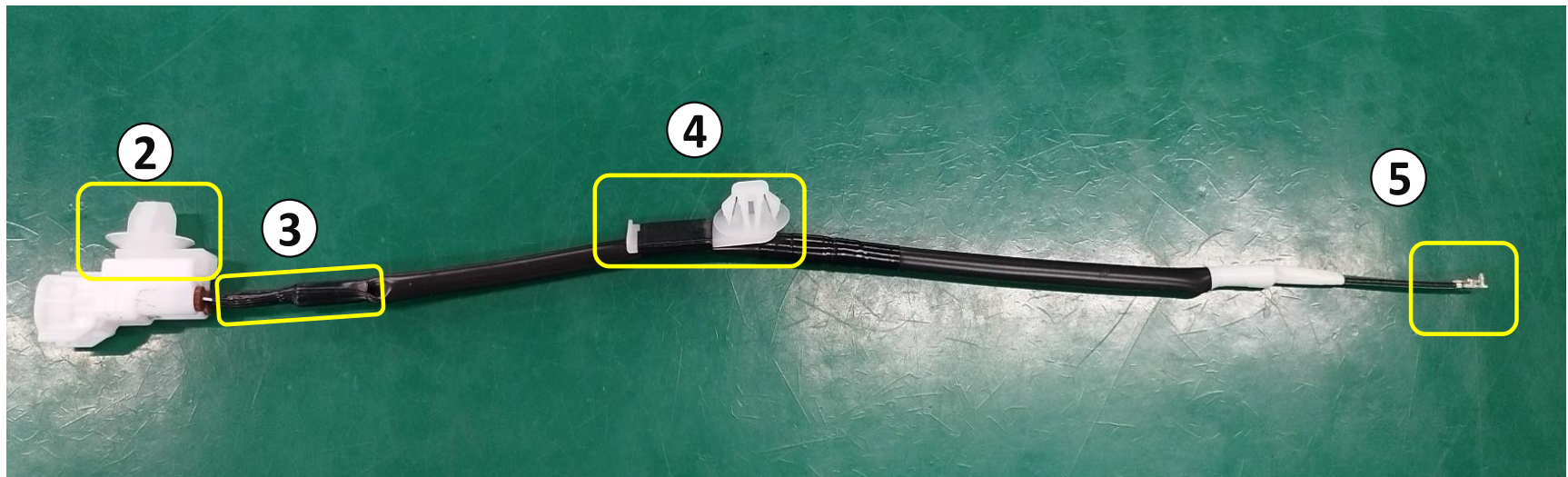
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n/a

JIG

n/a

QUALITY CHECKPOINTS**P2****7R0116-7020B****GOOD****NO GOOD****① No Unlock/Halflocked Connector****② No Missing Clip type clamp****④ No Missing Clamp****③ No Missing/Wrong Used of Tape****⑤ No Deformed Terminal**

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