



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 13, 2023

Model Code/Part Number:

920B / 7R0122-70201

Customer:

TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Document No.:

WI-ENG-PDE-644B

Revision No.:

0

Page No.:

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PARTS: 1. Clamp 82711-52070 (W)

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

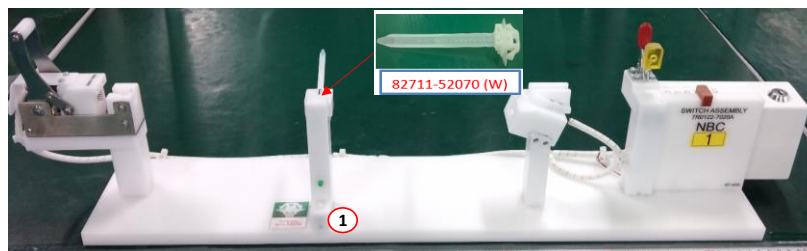
TOOLS/PPE

QUALITY POINTERS

1

P2

Clamp setting



1. Get 1pc. of clamp 82711-52070 (W) using right hand then set to clamp location 1 using both hands.

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.

Important reminders/Note/s:

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

1. No miss1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp positionng 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
03/13/23	0	Initial issue.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes

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☒ PRE-LAUNCH

☐ MASSPRO

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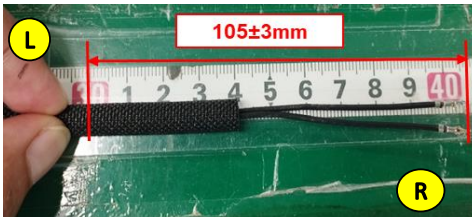
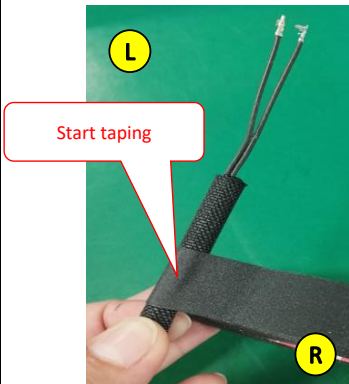
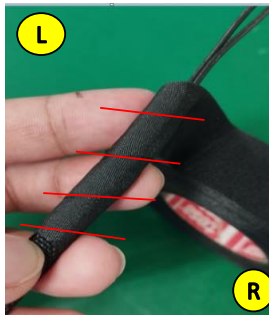


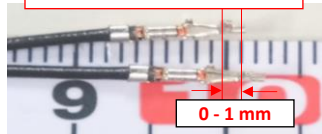
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PARTS:

1. Assy parts.
2. Black tesa tape (Tesa 51036)

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black twist tube 2420F to Wire near terminal	 <p>1. Measure from Black twist tube 2420F 105±3mm up to terminal tip.</p>  <p>2. Hold the assy parts using left hand. Get Black tesa (51036) using right hand.</p>  <p>3. Make 1 wind before shifting. 1/4 shifting until it reach the wire.</p>  <p>4. Measure from end of Black twisted tube up to terminal tip 66±3mm then continue the taping process using both hands.</p>	 <p>MEASURING 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 <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.  <p>Wire alignment tolerance 0 - 1 mm</p>

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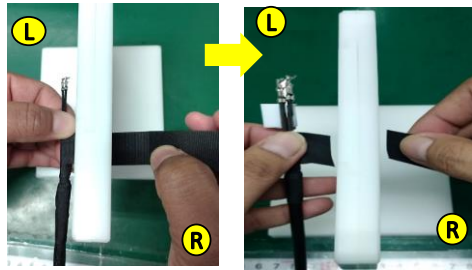
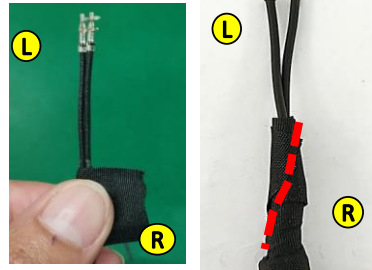
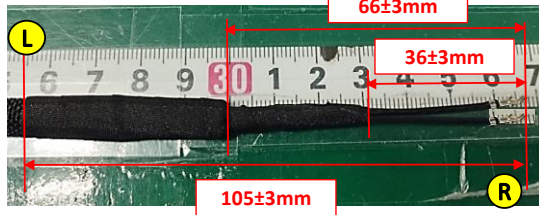


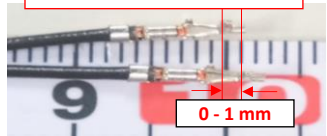
☐ MASSPRO

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PARTS:		1. Assy parts	JIG	1. Tape cutter
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black twist tube 2420F to Wire near terminal (Continuation)	<div><p>5. Measure from end of Black twisted tube up to terminal tip 36±3mm then continue the taping process using both hands.</p></div> <div><p>6. Cut the tape using provided tape cutter when reach the 1 1/2 wind using both hands.</p></div> <div><p>7. After cut, conduct pressing of end tape using both hands. <i>Note: End tape appearance should be slanted.</i></p></div> <div><p>8. Check the measurement, taping condition and wire alignment.</p></div>	<div><p>TAPE CUTTER</p></div> <div><p>MEASURING TAPE</p></div>	<div><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><p><i>Important reminders/Note/s:</i></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><div><p>Wire alignment tolerance 0 - 1 mm</p></div></div>

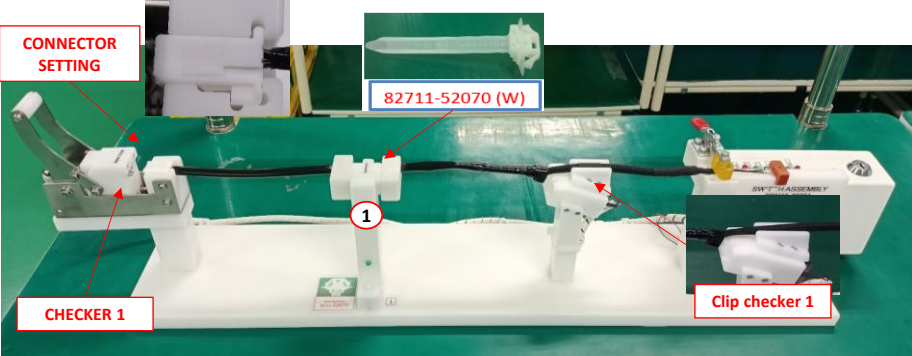
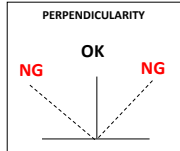

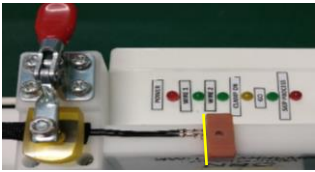

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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

PARTS:	1. Assy parts		JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	<div>Clamp Assembly</div> <div>  <p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6098-3909 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 7188-0996 (W) to Clip Checker 1 for continuity checking. Last, set the terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>3. Initially tighten the band clamp from location 1 using both hands.</p> <p>4. Get the bando gun and cut the band clamp on location 1 using both hands. Press the SW button after cut. GO sound will be heard.</p> <div>  <p>BANDO GUN ALIGNMENT</p> </div> <p>5. Conduct POINT CHECKING before removing from clamp assembly jig.</p> </div>	<div>  <p>BANDO GUN</p> </div>	<div>  <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun</p> <div>  <p>BANDO GUN ILLUSTRATION</p> </div> </div>

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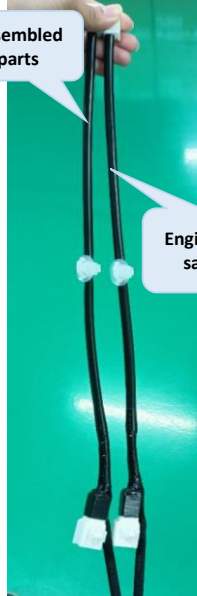
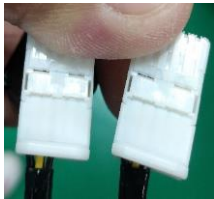

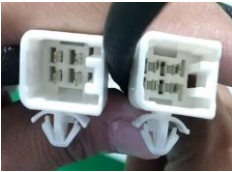





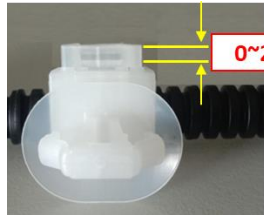
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PARTS:		1. Assy parts 2. Engineering sample	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Visual/By two's inspection		
		 <p>ACTUAL PRODUCT</p>  <p>Assembled parts</p>  <p>Engineering sample</p>  <p>2. Check the insertion and connector lock.</p>  <p>5. Check the terminal appearance.</p>  <p>6. Check the Tesa taping condition. Must be no missing spot tape.</p>  <p>3. Check the presence of clamp attachment and band clamp cut condition.</p>  <p>4. Check the Y-taping condition.</p>  <p>7. Check the terminal appearance. Must be no deformed terminal.</p>		 <p>ENGINEERING SAMPLE</p> <p>1. No skip checking during inspection</p>  <p>0~2mm</p> <p>Important reminders/Note/s: 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>

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☒ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

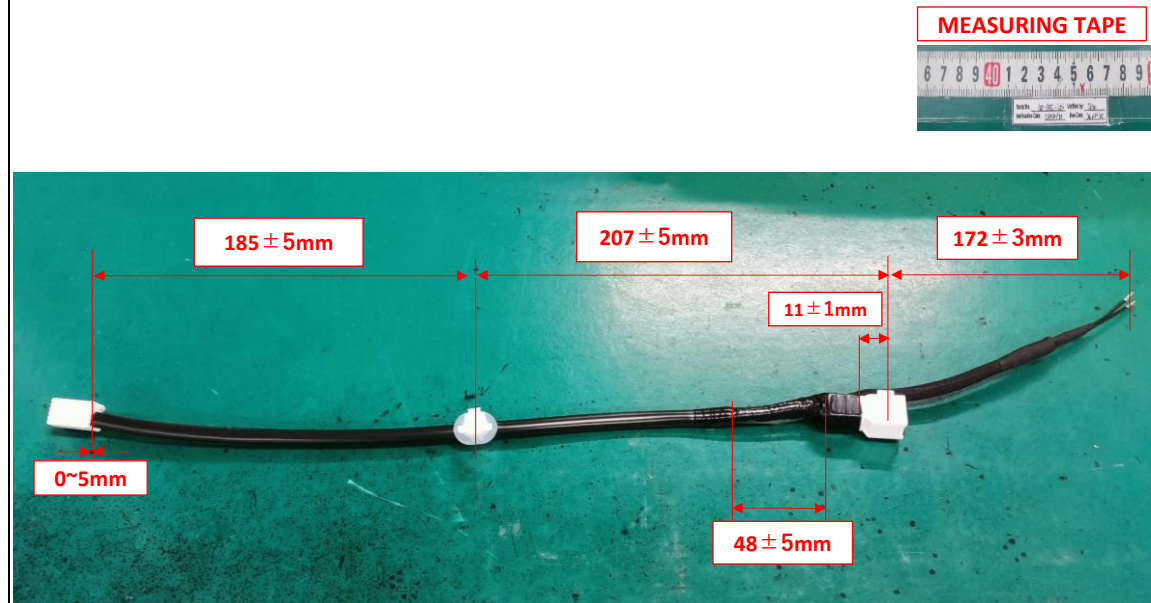
TOOLS/PPE

QUALITY POINTERS

5

P2

Measurement



Important reminders/Note/s:

1. FOR HATSUMONO AND OWARIMONO
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No wrong dimension

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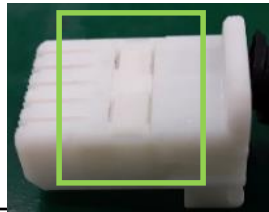
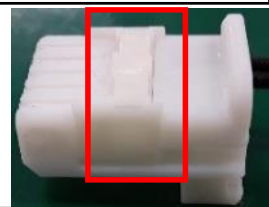
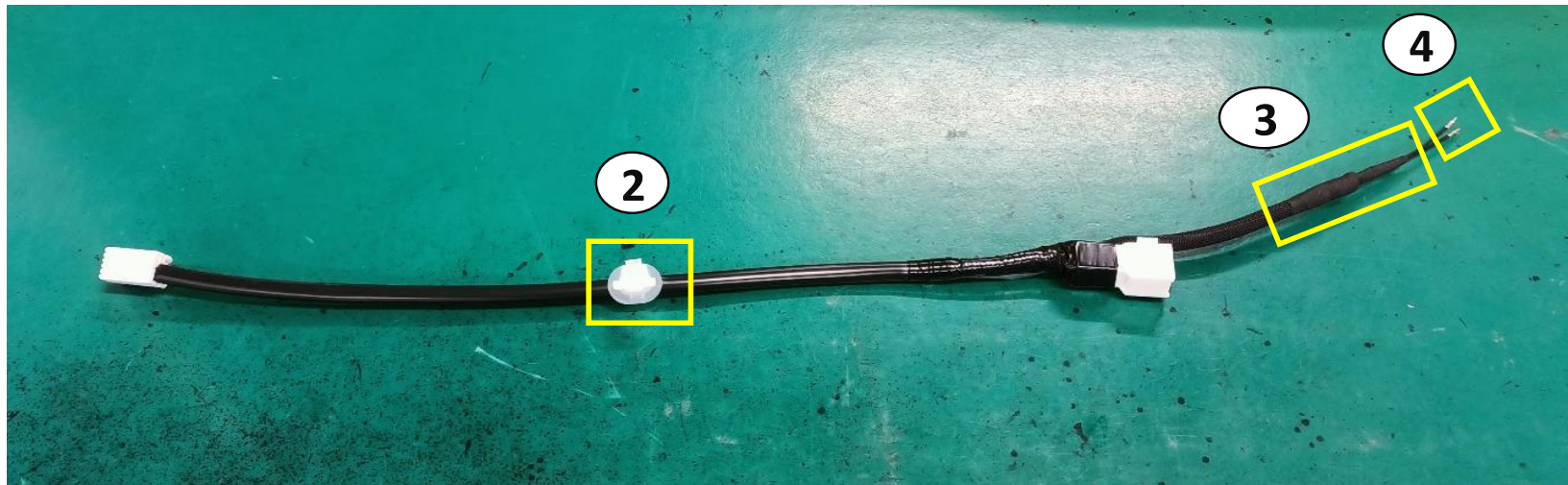
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PARTS:

1. Assy parts

JIG

n/a

QUALITY CHECKPOINTS**P2****7R0122-7021****GOOD****NO GOOD****① No Unlock/Halflocked Connector****② No Missing Clamp****③ No Missing Tesa Tape****④ No Deformed Terminal**

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