

	WORK INSTRUCTION						Effectivity Date:		March 29, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 220D / 7R0127-7020		Customer: TRMX		Document No.: WI-ENG-PDE-445	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO						Revision No.:		0 Page No.: 1 of 5	

PARTS:	1. Connector 6098-3810 (W) 2. AVSSf 0.3 B/B L=256±2mm				JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
1	n/a	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>CONNECTOR ORIENTATION</p> </div> <div style="text-align: center;"> <p>VISUAL REFERENCE</p> </div> <div style="text-align: center;"> <p>Wire facing</p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div style="text-align: center;"> <p>1 Black</p> <div style="border: 1px solid black; padding: 5px; font-size: 0.8em;"> 1. Hold the connector 6098-3810 (W) then get the first Black wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. </div> </div> <div style="text-align: center;"> <p>2 Black</p> <div style="border: 1px solid black; padding: 5px; font-size: 0.8em;"> 2. Hold the connector 6098-3810 (W) then get the second Black wire and insert to terminal slot of connector using right hand. Conduct 2x push pull after wire insertion. </div> </div> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<p style="color: red; font-style: italic;">Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <ol style="list-style-type: none"> 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 <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p style="color: red; font-style: italic;">Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
03/29/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes				
Eff. Date	Rev. No	Details of Change				Prepared	Reviewed	Approved	Noted	Est. Date:	March 29, 2022				

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Document No.:

WI-ENG-PDE-445Purpose: ☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0


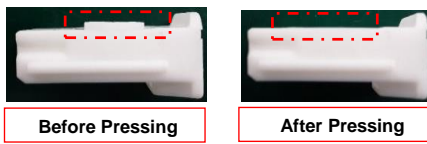
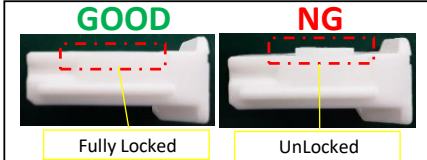





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1. Assy parts
2. Black Corrugated tube $\phi 5$ L=188 \pm 3mm (no slit)

JIG


1. Terminal cover jig
2. Locking jig

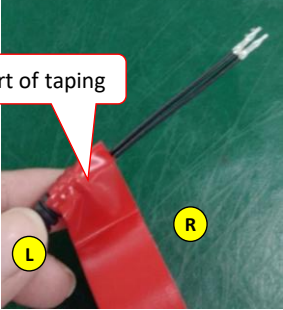
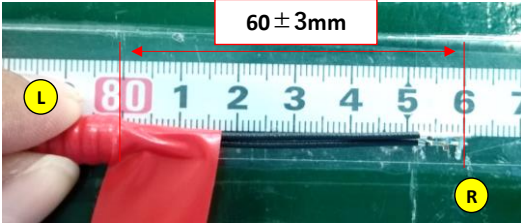
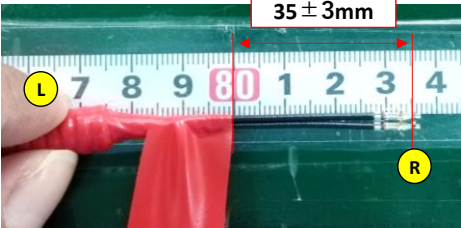
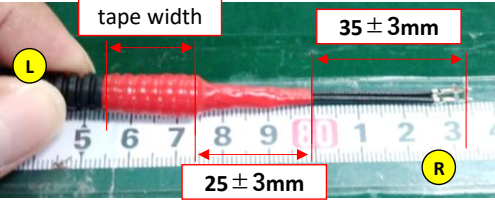

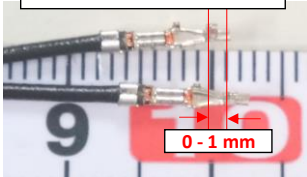
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Connector lock	   <p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector if it is properly locked. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p>	LOCKING JIG 	<p><i>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</i></p> <ol style="list-style-type: none">1. Use the provided jig per connector2. No unlock/half-locked connector
3	Wire insertion to black corrugated tube $\phi 5$ L=188 \pm 3mm (no slit)	   <p>1. Get the terminal cover jig using right hand then insert to wires.</p> <p>2. Get the Corrugated tube $\phi 5$ L=188\pm3mm (no slit) using right hand and insert to wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	TERMINAL COVER JIG 	<ol style="list-style-type: none">1. No deformed terminal2. No wrong usage of parts

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PARTS:		1. Assy parts 2. Red tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a Taping 1 COT to wire near terminal	<div>  <p>Start of taping</p> </div> <div>  <p>60 ± 3mm</p> </div> <div> <p>1. Hold the COT using left hand, get the Red tape using right hand then start pre-taping using both hands.</p> </div> <div>  <p>35 ± 3mm</p> </div> <div> <p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p> </div> <div>  <p>tape width 35 ± 3mm 25 ± 3mm</p> </div> <div> <p>3. Confirm measurement of 35±3mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p> </div> <div> <p>4. After taping, check the measurement, taping condition and terminal appearance.</p> </div>	<p>MEASURING TAPE</p> 	<div>  <p>Wire alignment tolerance 0 - 1 mm</p> </div> <ol style="list-style-type: none"> No flip-out tape No peel-off tape No loose tape No missing tape No wrong dimension No wrong use of tape <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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☐ PROTOTYPE

☒ PRE-LAUNCH

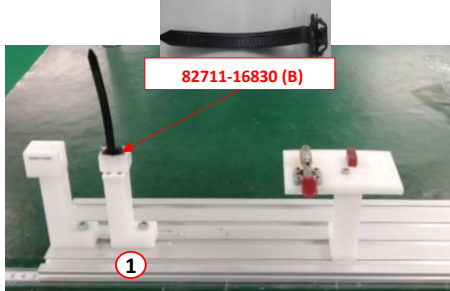



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PARTS:	1. Assy parts 2. Clamp 82711-16830 (B)			JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Clamp setting	 <p>Note: Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.</p> <p>1. Get 1pc. of clamp 82711-16830 (B) using right hand and set to clamp location 1 using both hands.</p>		n/a	<p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p>
6	Clamp assembly	 <p>1. Get the assy parts and set to jig using both hands. First, put the connector 6089-3810 (W) into connector receiver base. Second, put the terminal into stopper jig and pull down the toggle clamp. <i>Refer to above illustration for the correct setting.</i></p> <p>2. Initially tighten the band clamp on location 1 using both hands.</p> <p>3. Get the bando gun using right hand then cut the band clamp on location 1 using both hands.</p> <p>4. Conduct POINT CHECKING before removing the harness from jig.</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>BANDO GUN POSITION ON CLAMP LOCATION 2</p> <p>BANDO GUN ALIGNMENT</p> <p>GOOD NG</p> <p>OK HORIZONTAL</p> <p>NG</p>		 <p>BANDO GUN</p>	 <p>No gap between stopper and terminals</p> <p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p>

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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG

n/a

NO.

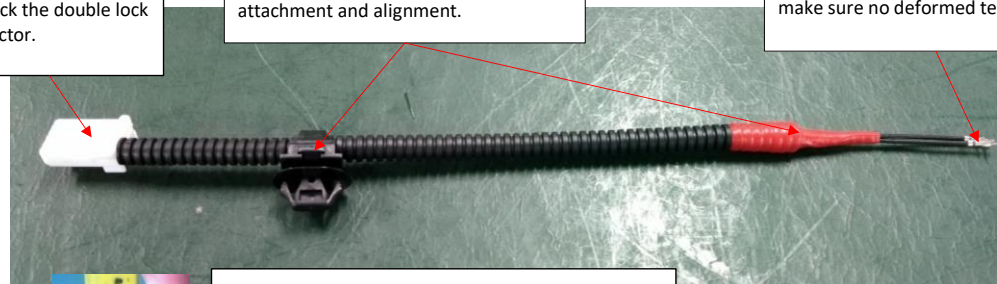
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

Visual/By Two's
Inspection1. Check the double lock
connector.2. Check the taping condition, clamp
attachment and alignment.4. Check the terminal appearance,
make sure no deformed terminal.

0 - 2 mm

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

ENGINEERING SAMPLE



8

Measurement



Note:

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

1. No wrong dimension

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