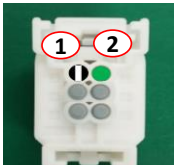


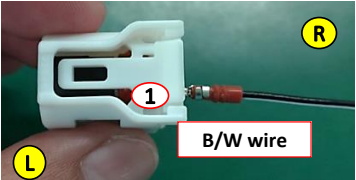
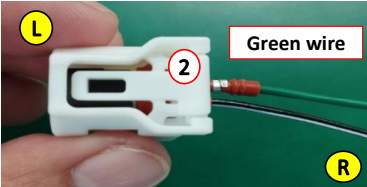



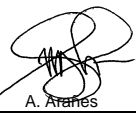
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:		February 24, 2023	
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	Model Code/Part Number: <b>920B / 7R0118-7022</b>		Customer: <b>TRMX</b>		Document No.:		<b>WI-ENG-PDE-641</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 9

<b>PARTS:</b> 1. Connector 6198-1142 (W) 2. TVSSf 0.3 wires B/W-G L=886±3mm		JIG:		n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	n/a Wire Insertion to connector 6198-1142 (W)	 <p><b>VISUAL REFERENCE</b></p>  <p><b>Wire facing</b></p>  <p><b>Connector Orientation</b></p>  <p><b>B/W wire</b></p>  <p><b>Green wire</b></p> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">         1. Hold the connector <b>6198-1142 (W)</b> then get the <b>Black/White wire</b> and insert to terminal <b>slot 1</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.       </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">         2. Get the <b>Green wire</b> and insert to terminal <b>slot 2</b> using right hand. Conduct 2x push-pull after wire insertion.       </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>          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;"> <b>Housekeeping</b>          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;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>	<b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b>  <b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
2/24/23	0	Initial issue. SAKI to Ato. Remove Y-OR wire, Connector 6198-1161 (B) and Clamp 12A60 (W); Additional 82711-3A640 (B); COT quantity from [3pcs] to [1pc]; Additional dummy seal from [2pcs] to [4pcs].				D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 24, 2023		

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**PARTS:**

1. Assy parts
2. Black Corrugated tube (No slit) Ø5 L=693±3mm

**JIG**

1. 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 and then press 2x using both hands. Check the connector lock if properly locked.</p>	n/a	<ol style="list-style-type: none"><li>1. use the provided jig per model</li><li>2. No unlock/ half-locked connector</li><li>3. No damaged lock.</li></ol> <p><b>Important reminders/Note/s:</b> <b>1. Manual locking may cause damaged connector lock.</b></p>
3	Wire insertion to Black Corrugated tube (No slit) Ø5 L=693±3mm	   <p>1. Get the cover jig using right hand then insert both terminals using right hand.</p> <p>2. Get the <b>Black Corrugated tube (No Slit) Ø5 L=693±3mm</b> using right hand then insert the wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	 <b>TERMINAL COVER JIG</b>	<ol style="list-style-type: none"><li>1. No wrong usage of parts.</li><li>2. No deformed terminal.</li></ol>

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## PARTS:


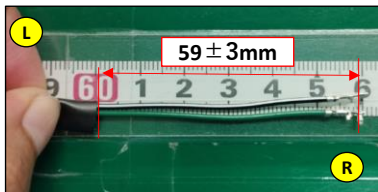
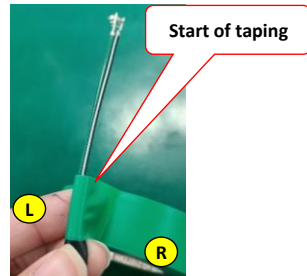
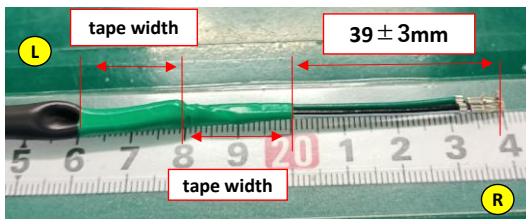

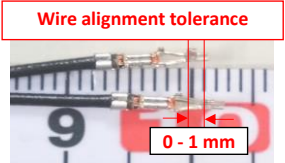
1. Assy parts

2. Black VM tube (Sunprene) Ø5 L=125±3mm

3. Green tape

## JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black VM tube (Sunprene) Ø5 L=125±3mm		n/a	1. No wrong use of parts. 2. No deformed terminals.
5	n/a  Taping 1 Black corrugated tube to wire near terminal	  		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  <b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>  

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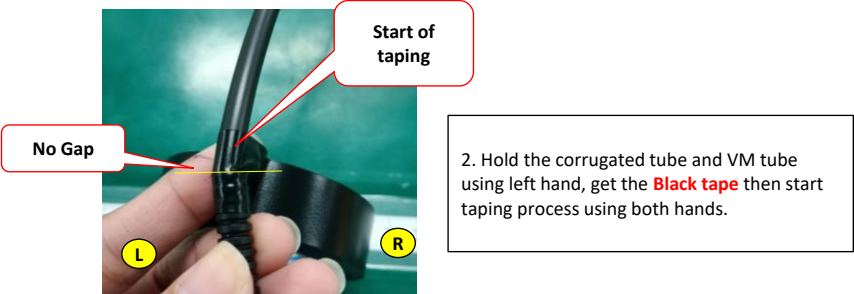
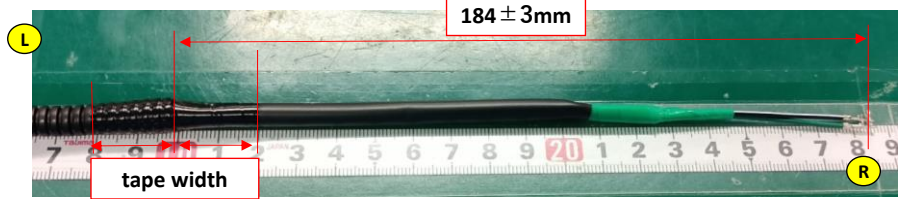

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## PARTS:

1. Assy parts
2. Black tape

## JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a Taping 2 COT to Black VM tube (Sunprene)	 <p>1. Measure from end of corrugated tube up to terminal pointed tip <b>184±3mm</b> using both hands.</p>  <p>2. Hold the corrugated tube and VM tube using left hand, get the <b>Black tape</b> then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</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> <b>Important reminders/Note/s:</b> <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i>

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**PARTS:**

1. Clamp 82711-12A60(W) [4pcs]
2. Clamp 82711-3A640 (B)

3. Black tape [1pc]

**JIG**

1. Temporary Clamp assembly jig

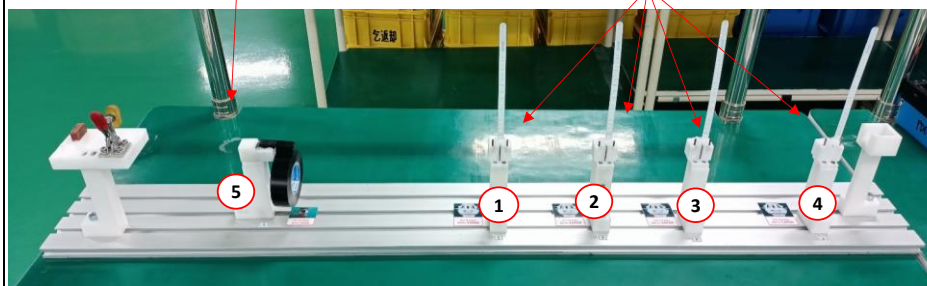
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	n/a	Clamp setting	n/a	<ol style="list-style-type: none"><li>1. No damaged clamp</li><li>2. No wrong use of clamp</li><li>3. No wrong use of tape</li><li>4. No missing clamp</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</li></ol> <p><b>BAND CLAMP ILLUSTRATION</b></p> <p>GOOD NG</p> <p>82711-12A60 (W) 82711-52070 (B)</p>



82711-3A640 (B)



82711-12A60 (W)



1. Get 1pc. of clamp **82711-3A640 (B)** then set to clamp location **5** using both hands.

2. Get 2pcs. of clamp **82711-12A60 (W)** then set to clamp location **1 and 2** using both hands.

3. Get 2pcs. of clamp **82711-12A60 (W)** then set to clamp location **3 and 4** using both hands.

4. Get the **Black tape** then initially attach to clamp location **5** using both hands.

**STANDARD TAPING FOR CLAMP**

One side tape under clamp



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### PARTS:

1. Assy parts

### JIG

1. Temporary Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

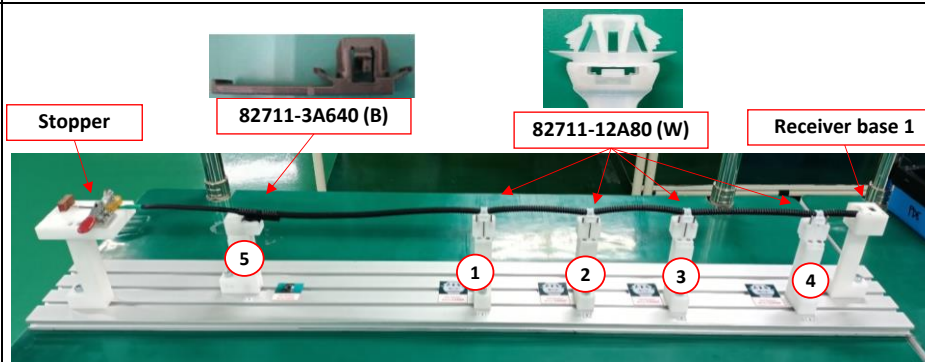
### TOOLS/PPE

### QUALITY POINTERS

8

n/a

Clamp Assembly



1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector **6189-1142 (W)** in **Receiver base 1**. Continue to set the harness then last, set the **B/W-G wires** together within the stopper then press by **Toggle clamp**.

2. Initially attach the Band clamp on location **1, 2, 3** and **4** using both hands.

3. Get the Bando Gun (USE FLAT NOSEPIECE) using right hand then cut the clamp on location **1** using both Hands. Repeat to process 2, 3 and 4.

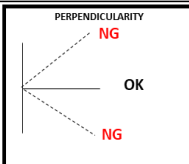
4. Hold the tape on location **5** then start taping using both hands. Make **3 windings** of tape and then cut the tape.

5. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

BANDO GUN POSITION ON CLAMP LOCATION 1



BANDO GUN ALIGNMENT



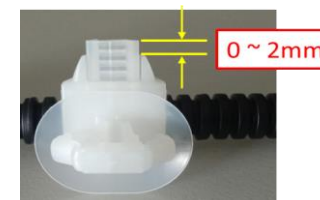
Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For:  $\phi 5 - 1 \sim 2$ ,  $\phi 7 - 3 \sim 4$



1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape
4. No missing clamp

#### Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).



BANDO GUN ILLUSTRATION



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## PARTS:

1. Assembled parts
2. Engineering sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

9

n/a

Visual/ By two's inspection



1. Conduct alignment of harness (**Engineering sample vs. Assembled parts**) using both hands.



2. Check the **Connector lock condition, insertion and terminal**.



5. Check **taping condition from COT to Black VM tube (Sunprene)**. Conduct **slightly bending of part with COT to Black VM tube (Sunprene) taping to avoid overlook of missing tape**.



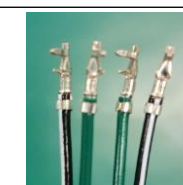
3. Check **presence of Band clamp attachment (4pcs) and band clamp cut**.



6. Check the tapping condition and Color of tape (Must be **GREEN TAPE** only)



4. Check the **presence of clamp attachment and taping condition**.



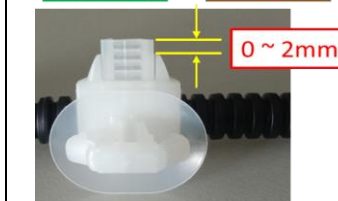
7. Check the **terminal appearance**. Must be **no deformed terminal**.

1. No Skip checking during inspection

MASTER SAMPLE



BAND CLAMP ILLUSTRATION



## Important reminders/Note/s:

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

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**PARTS:**

n/a

**JIG**

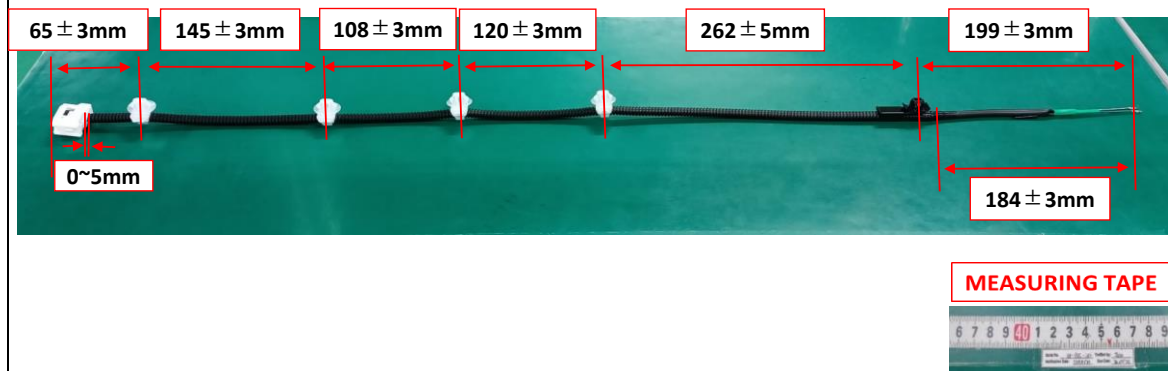
n/a

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

10

n/a

Measurement



1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape
4. No missing clamp

**Important reminders/Note/s:**

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

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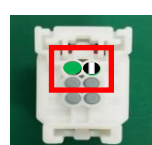
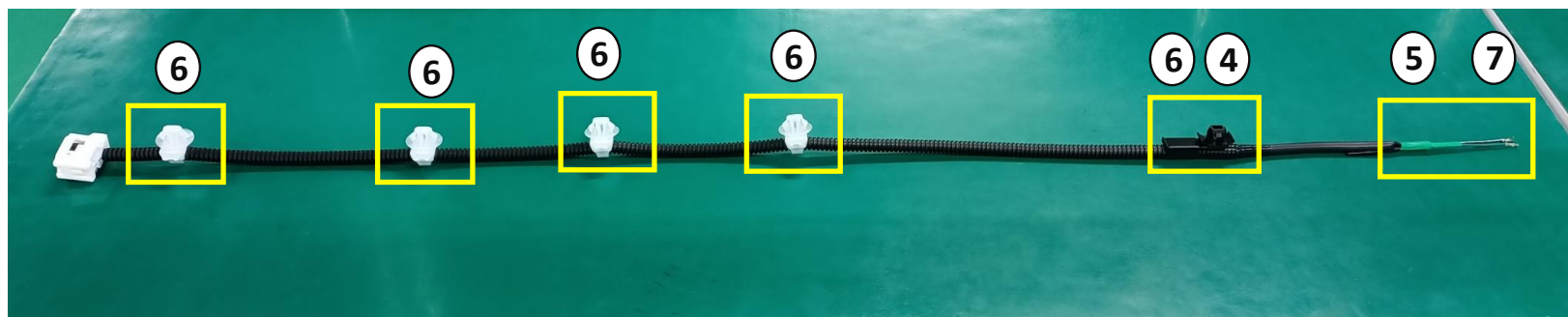
n/a

JIG

n/a

**QUALITY CHECKPOINTS**

n/a

**7R0118-7022****GOOD****GOOD****NO GOOD****NO GOOD**

- ① No Unlock/ Halflocked Connector    ④ No Missing tape    ⑥ No Missing clamp (5pcs.)  
② No Wrong Insert    ⑤ No Wrong use of tape (Green tape)    ⑦ No Deformed Terminal  
③ No Terminal Backing Out

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