



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	December 06, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-559B		
Revision No.:	1	Page No.:	1 of 7

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	920B / 7R0122-7020A	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts: Clamp 82711-52070 (W); Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
1	P2 1 Table Lay-out	<div>Table Lay-out</div> <div>Assy parts</div> <div>Clamp 82711-52070 (W)/ Connector box</div> <div>Clamp assembly jig</div> <div>Black tape</div>		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No missing parts/tools 2. No excess parts/tools</div>

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
12/06/22	1	Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
07/12/22	0	Initial issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 12, 2022		

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☐ PRE-LAUNCH

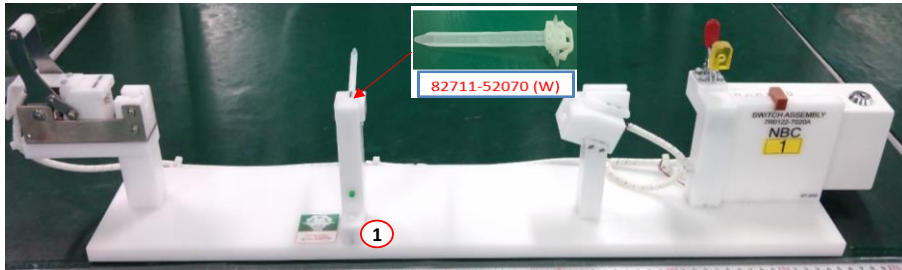
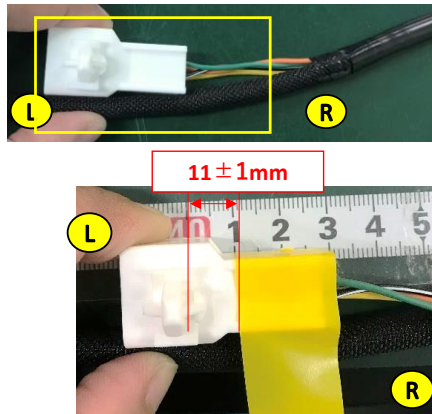

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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
2	1 Clamp setting	<div></div> <div>1. Get 2pcs. of clamp 82711-52090 (W) using right hand then set to clamp location 1 using both hands.</div>		n/a	<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div>
3	P2 1 Y-taping	<div></div> <div>1. Fix the Twisted tube to the side of the Connector.</div> <div>2. Measure from Connector to tape 11mm. Then, start taping the connector and twisted tube, make 2 winds before 1/3 shifting upward (must be tape width)</div>		<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s: 1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div>

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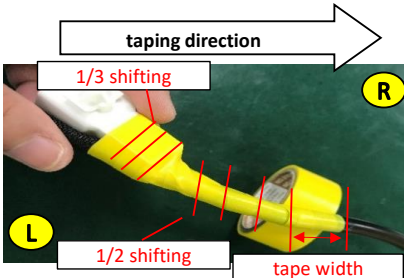
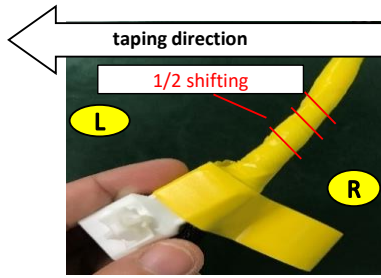
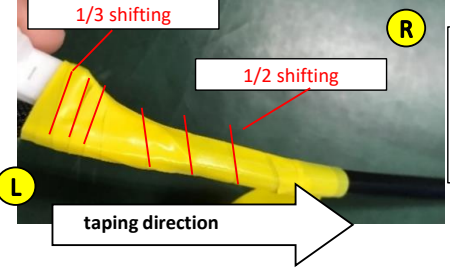
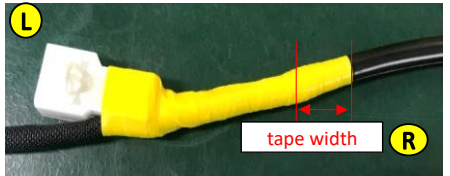

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NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
3	P2 Y-taping (Continuation)	<div><p>1. Wind the tape upward 1/3 shifting, then conduct 1/2 shifting upward until it reach the vinyl tube (must be tape width)</p></div> <div><p>2. Wind the tape backward 1/2 shifting.</p></div> <div><p>3. Wind the tape 1/3 shifting then 1/2 shifting, same shifting to no. 3, then cut the tape after 2 winds on vinyl tube.</p></div> <div><p>4. After taping, check the condition of tape, measurement and the connector facing.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
4	P2 Clamp Assembly	<div><div><div>CONNECTOR SETTING</div><div>82711-52070 (W)</div><div>CHECKER 1</div><div>1</div><div>Clip checker 1</div></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><div><div><div>GOOD</div><div>NG</div></div><div><div>Fixed setting of band clamp cutter: 3 ~ 4</div></div><div><div>BANDO GUN ALIGNMENT</div><div><div>PERPENDICULARITY</div><div>OK</div><div>NG NG</div></div></div><div><p>5. Conduct POINT CHECKING before removing from clamp assembly jig.</p></div></div></div>		<div><div>BANDO GUN</div><div></div></div>	<div><div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between stopper and terminals</div></div><div><p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun</p></div><div><div>BANDO GUN ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div><div>FLAT NOSEPIECE</div><div>EXTENDED NOSEPIECE</div></div></div></div>





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

BANDO GUN ILLUSTRATION



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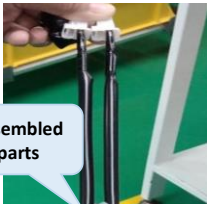

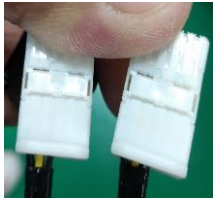



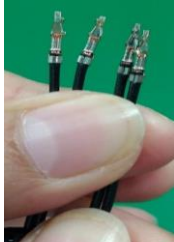
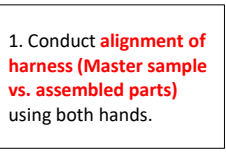
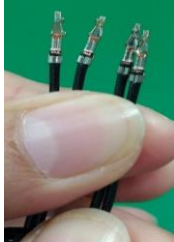


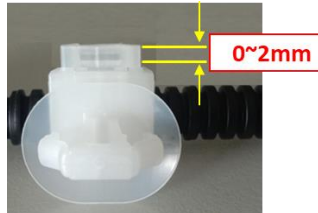
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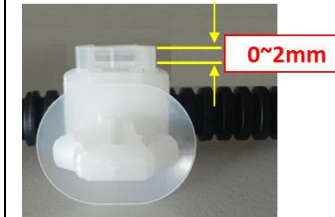
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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	P2	Visual/By two's inspection			
		<div><div><div></div><div></div></div><div><div><div></div><div></div><div></div></div><div><div></div><div></div></div><div><div></div><div></div></div></div><div><div></div><div></div></div></div>			
		1. No skip checking during inspection		<div></div> <div><p>Important reminders/Note/s:</p><p>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></div>	

MASTER SAMPLE



1. No skip checking during inspection



0~2mm

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.

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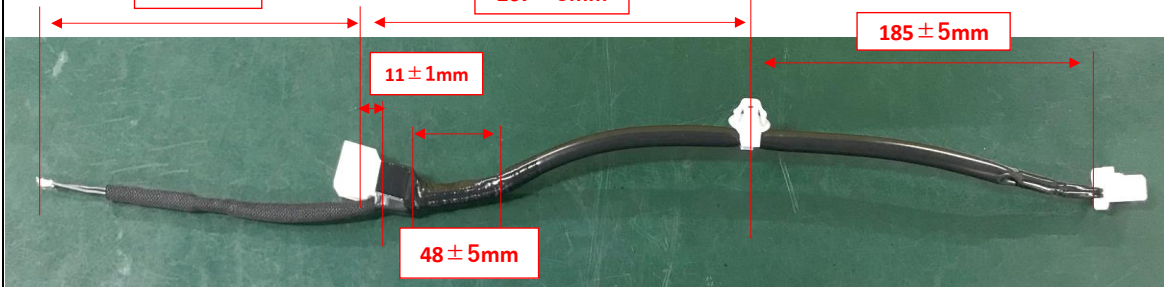
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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
6	P2 1 Measurement	<div><div>MEASURING TAPE</div><div></div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div></div>			<div>Important reminders/Note/s: 1. FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>

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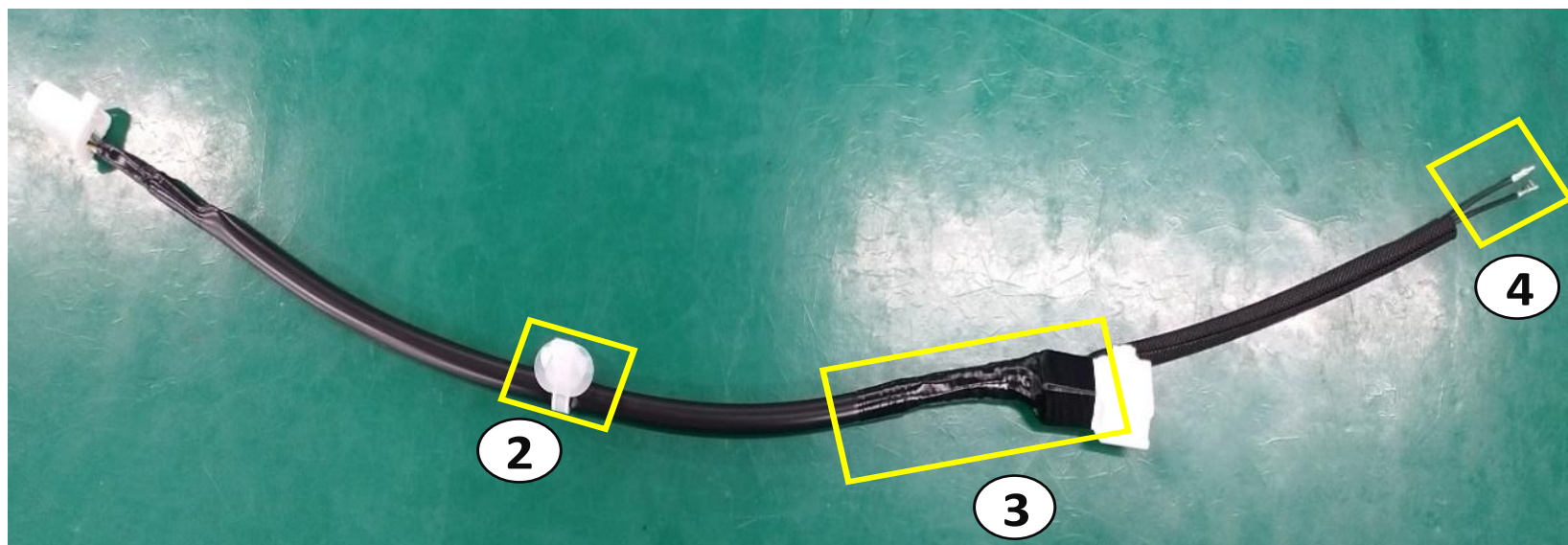
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PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS**P2****7R0122-7020A****GOOD****NO GOOD****① No Unlock/Halflocked Connector****② No Missing Clamp****③ No Missing Tape****④ No Deformed Terminal**

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