

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**September 23, 2022**Model Code/Part Number: **200D/220D / 7R0131-7020**

Customer:

**TRMX**

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

**WI-ENG-PDE-442**

Revision No.:

2

Page No.:

1 of 7

**PARTS:**

1. Assy parts; Clamp 82711-16830 (B); Yellow tape

JIG:

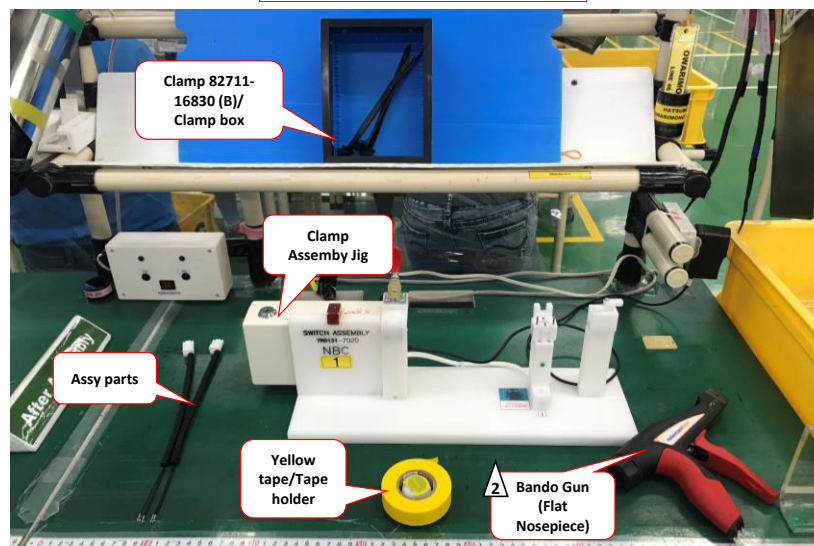
1. Clamp Assembly Jig

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

1

n/a

Table Lay-out

**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.

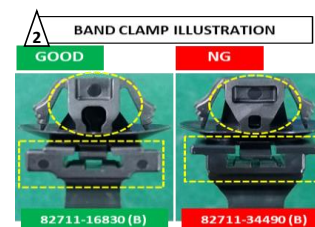
**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

**BANDO GUN**

FLAT NOSEPIECE

1. No missing parts/tools
2. No excess parts/tools

**Revision History**

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
09/23/22	2	Change of tolerance from 35+/-3mm to 35(+3/-1mm) as countermeasure of encountered NG dimension from end of tape to terminal tip. Improve: Work procedure/Illustration on process no.1, 2, 3, 4, 5 and 6: Quality pointers and notes on pg. no. 1, 2, 3, 4, 5, 6 and 7	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
06/16/22	1	Change purpose from Pre-launch to Masspro. Additional table lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes
03/9/22	0	Initial issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes

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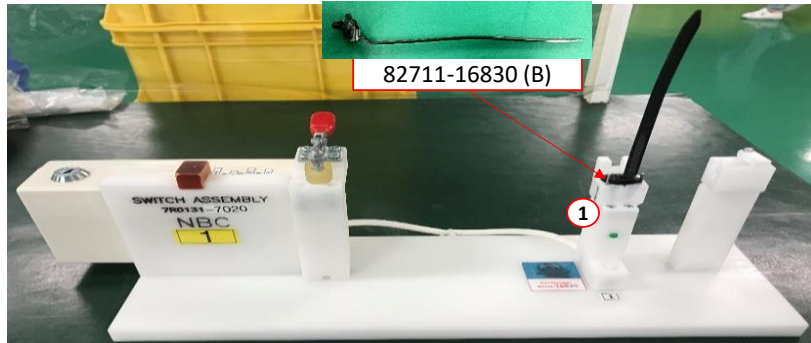

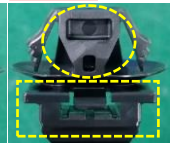
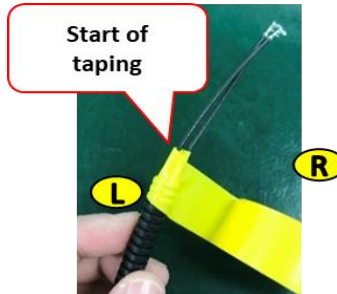
MASSPRO

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PARTS:		1. Assy parts 2. Yellow tape		3.Clamp 82711-16830 (B)	JIG	1. Clamp Assembly Jig
NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Setting		<div></div> <div>1. Get 1pc of band clamp <b>82711-16830 (B)</b> then attach to clamp location ①.</div>		n/a	<div>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp</div> <div>2 BAND CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>NG</div><div></div><div></div><div>82711-16830 (B)</div><div>82711-34490 (B)</div></div>
3	Taping 1 Corrugated tube to wire near terminal		<div><div>Start of taping</div></div> <div>1. Get the <b>Yellow tape</b>, hold the Corrugated tube using left hand then start pre-taping the COT to wire near terminal.</div>		n/a	<div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div> <div>2 Important reminders/Note/s: 1. Use <b>YELLOW TAPE</b> only.</div>

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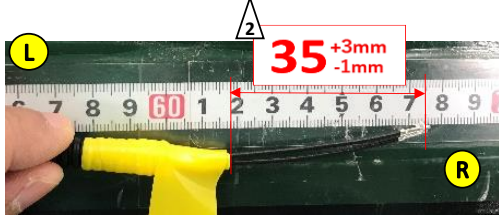
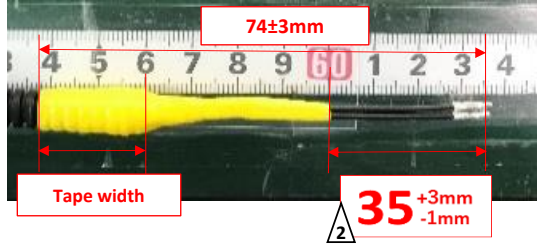
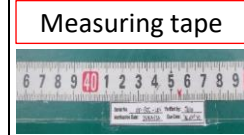
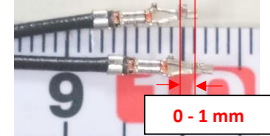
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#### PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Taping 1 Corrugated tube to wire near terminal (Continuation)	<div><p>2. Measure the end of the Corrugated tube up to the terminal tip <b>74±3mm</b>. Then, continue the taping process.</p></div> <div><p>3. Confirm measurement of <b>35 (+3/-1mm)</b> 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 dimension, taping condition and wire alignment.</p></div>	<div></div>	<div><p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p><p>2. <b>Important reminders/Note/s:</b></p><p>1. <b>Please use calibrated/verified measuring tape when getting the measurement.</b></p><p>2. <b>Use YELLOW TAPE only</b></p><p>2. <b>Wire alignment tolerance</b></p><div></div></div>

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**PARTS:**

1. Assy parts

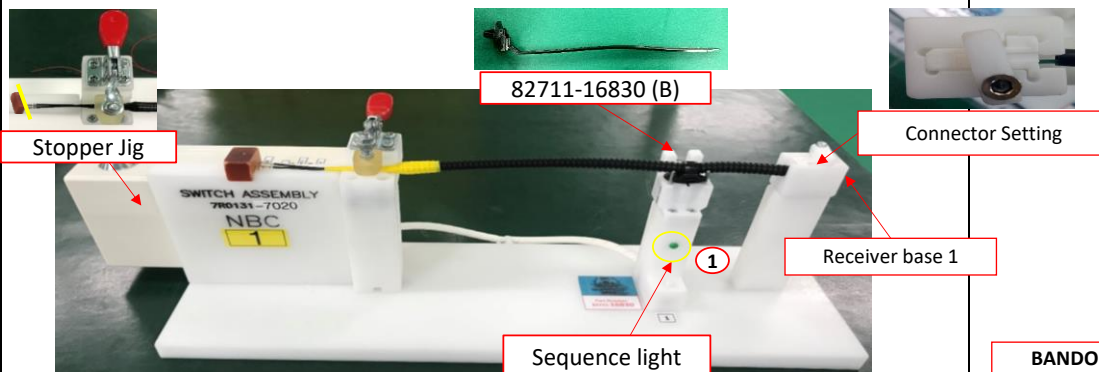
**JIG**

1. Clamp Assembly Jig

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

4

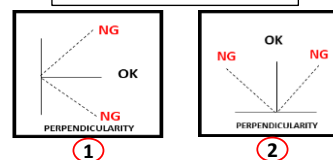
n/a

Clamp Assembly  
(Continuation)

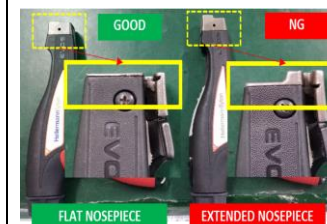
4. Get the bando gun using right hand then cut the band clamp on Location ①. Press the **SW button** after cutting. **GO** sound will be heard.

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

Fixed setting of  
band clamp  
cutter: 1 ~ 2

**BANDO GUN ALIGNMENT****BANDO GUN****FLAT NOSEPIECE****Important reminders/Note/s:**

1. Make sure no gap between  
stopper jig and terminal

**BANDO GUN ILLUSTRATION**

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**PARTS:**

1. Assy parts

**JIG**

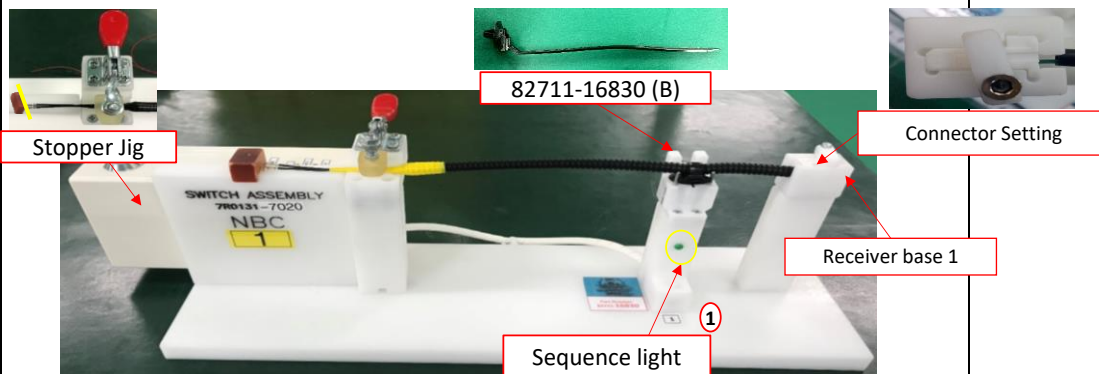
1. Clamp Assembly Jig

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

4

n/a

Clamp Assembly



1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector **6098-3810(W)** to **Receiver base 1**. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of **location ①** was on.

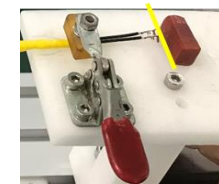
2. Check if all **LED light** for **POWER ON**, and **CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.

3. Initially tighten the band clamp on **location 1** using both hands.

n/a

**Important reminders/Note/s:**

1. Make sue no gap between stopper jig and terminal.



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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

n/a

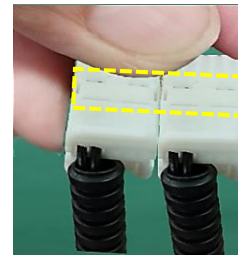
Visual/By two's  
Inspection



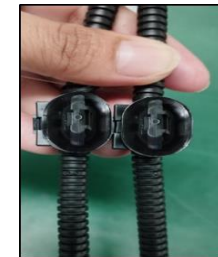
1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



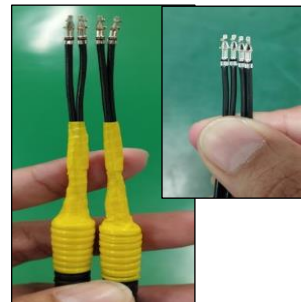
ACTUAL PRODUCT



2. Check the **connector lock condition** and **insertion**.



3. Check the **presence of clamp attachment**.



4. Check the **taping condition** and **terminal appearance**. Must be **no deformed terminal**.

**MASTER SAMPLE**



1. No skip checking during inspection

2

**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)**.

2



**BAND CLAMP ILLUSTRATION**



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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

n/a

Measurement



1. No wrong dimension



**Important reminders/Note/s:**

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

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