



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 200D/220D / 7R0125-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

February 9, 2022

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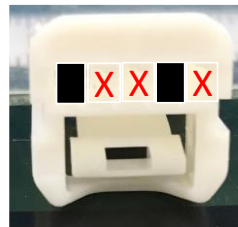
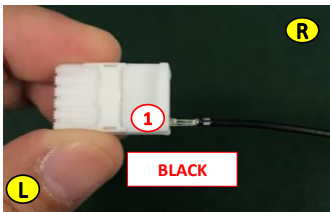
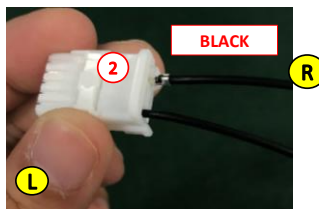
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PARTS:

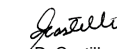

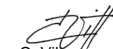

- Connector 6098-3810 (W)
- IRRAX A Rope-Lay 0.3 B L=242mm [2pcs]

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<div>Wire insertion to connector 6098-3810 (W)</div> <div><p>CONNECTOR ORIENTATION</p></div> <div><p>WIRE FACING</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>1. Hold the connector using left hand. Get the First Black wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Get the Second Black wire and insert to terminal slot 2 using right hand.</p></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>	<ol style="list-style-type: none">No wrong orientation of connectorNo wrong use of connectorNo damaged connectorNo wrong insertion of wiresNo loose insertionNo wrong insertionOne by one insertionNo deformed terminalNo wrong wire facing <div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Checked	Approved	Prepared by	Reviewed by	Reviewed by	Approved by
02/9/22	0	Initial issue	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes

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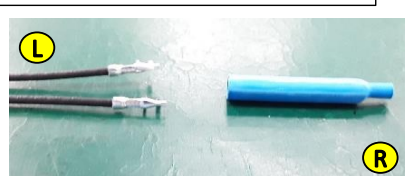

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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PARTS:		1. Assy parts 2. Black corrugated tube $\phi 5$ L= 170 \pm 2mm (no slit)		JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector lock	<div><p>1. Put the connector into locking jig using both hands then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p></div> <div><p>Before Pressing</p><p>After Pressing</p><p>GOOD Fully Locked</p><p>NG Unlocked</p></div>		<div>Locking jig</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</div> <div>1. Use the provided jig per connector 2. No unlock/half-locked connector</div>
3	Wire insertion to Black corrugated tube $\phi 5$ L=170 \pm 2mm (no slit)	<div><p>1. Get the terminal cover jig using right hand then insert to B/B wires.</p></div> <div><p>2. Get the Corrugated tube $\phi 5$ L=170\pm2mm using right hand and insert to B/B wires.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	<div>1. No wrong usage of parts 2. No deformed terminal</div>

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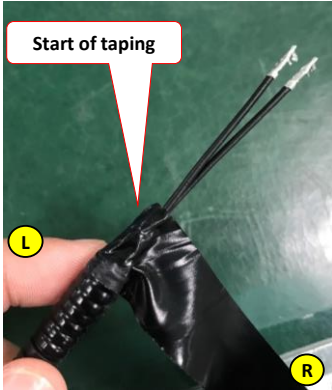
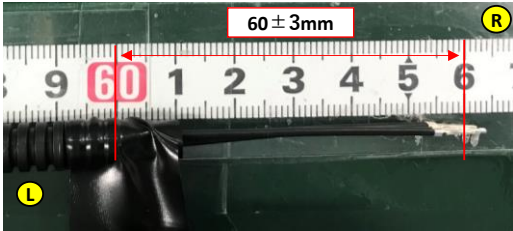
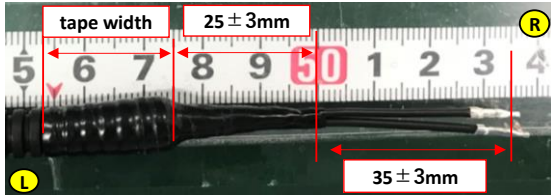

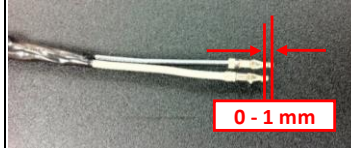
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PARTS:		1. Assy parts 2. Black tape [1pc]			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	n/a	<p>Taping 1 Black COT to wire near terminal</p>  <p>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands.</p>  <p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>				<p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <p>Wire alignment tolerance</p> 

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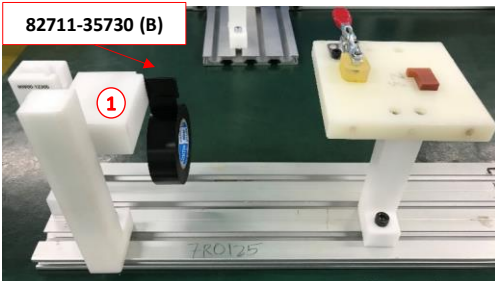
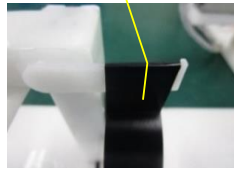

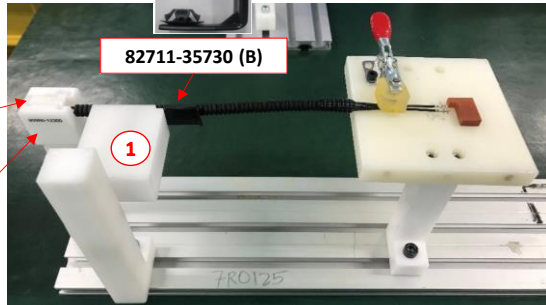

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PARTS:		1. Black tape [1pc] 2. 82711-35730 (B)			3. Assy part		JIG	1. Temporary jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
5	n/a	Clamp Setting (Temporary jig)	<div><div></div><div><p>82711-35730 (B)</p><div><p>STANDARD TAPING FOR CLAMP</p><p>One side tape under clamp</p></div></div><div><p>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</p></div><div><div>1. Get 1 pc of clamp 82711-35730 (B) then set to clamp location 1 using both hands.</div><div>2. Get the Black tape then attach to clamp location 1 using both hands.</div></div></div>			n/a		1. No loose clamp attached 2. No damage clamp 3. No wrong use of clamp 4. No damage clamp 5. No flip-out tape 6. No peel-off tape 8. No missing tape 9. No wrong use of tape
6		Clamp Assembly (Temporary jig)	<div><div></div><div><p>CONNECTOR SETTING</p><div><p>82711-35730 (B)</p><p>1</p><p>RECEIVER BASE</p></div></div><div><p>1. Get the assy parts then put into jig. (<i>See above picture for correct setting</i>). First, set the connector 6098-3810 (W) to Receiver base. Continue to set the harness in jig. Last, set the end of B/Bwire together within the stopper then press by Toggle clamp then</p><p>2. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands.</p><p>3. Conduct POINT CHECKING before removing the harness from jig.</p></div></div>			 <p>Make sure no gap between terminal and stopper jig</p> <div>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of clamp/tape</div>		

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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 Inspection	<div>1. Check the double lock connector.</div> <div>2. Check the taping condition, clamp attachment, sponge tape attachment and alignment.</div> <div>3. Check the terminal appearance, make sure no deformed terminal.</div>  <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div>				MASTER SAMPLE 
8	Measurement	 <div>MEASURING TAPE</div>				NOTE: FOR HATSUMONO AND OWARIMONO 1. No wrong dimension <i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i>

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