


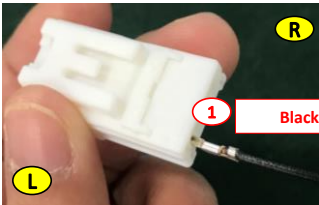
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	March 9, 2022		
	Process Name/Title:				Validity Date:	n/a		
	Model Code/Part Number: <b>200D/220D / 7R0126-7020</b>		Customer: <b>TRMX</b>		Document No.:	<b>WI-ENG-PDE-443</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5

<b>PARTS:</b>		1. Connector 6098-3802 (W) 2. AVSSf 0.3 B L=539mm±2mm [2pcs]		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	<div>  <p><b>CONNECTOR ORIENTATION</b></p> </div> <div>  <p><b>WIRE FACING</b></p> </div> <div>  <p><b>VISUAL REFERENCE</b></p> </div> <div>  <p>1. Hold the connector using left hand. Get the <b>first black wire</b> then insert to terminal slot <b>1</b> using right hand.</p> </div> <div>  <p>2. Get the <b>Black wire</b> and insert to terminal slot <b>2</b> using right hand.</p> </div>		<div> <p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>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> <p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p><b>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
03/9/22	0	Initial issue.		K. Doria	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change		Prepared	Checked	Approved	Noted
				Est. Date:	March 9, 2022		

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PROTOTYPE



PRE-LAUNCH



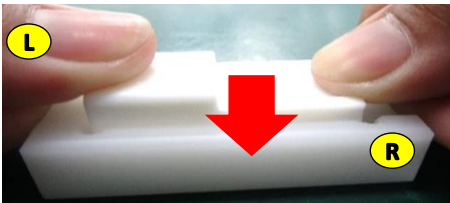









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PARTS:		1. Assy parts 2. Black Corrugated tube $\phi 5$ L= 472 $\pm$ 3mm (no slit)			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	Connector lock	 <div>1. Put the connector into locking jig using both hands then press <b>2x</b> 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></div>  		<div>Locking jig</div> 	<p><b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b></p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p> <div><div><b>GOOD</b>  Full Lock</div><div><b>NG</b>  Half Lock</div></div>	
3	Wire insertion to Black Corrugated tube $\phi 5$ L=472 $\pm$ 3mm (no slit)	 <div>1. Get the terminal cover jig using right hand then insert to <b>B/B wires</b>.</div>  <div>2. Get the corrugated tube (no slit) <math>\phi 5</math> L=472<math>\pm</math>3mm using right hand and insert to <b>B/B wires</b>.</div>  <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	<p>1. No wrong usage of parts 2. No deformed terminal</p>	

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☒ PRE-LAUNCH

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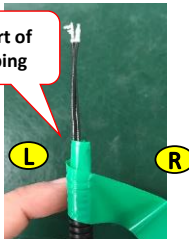

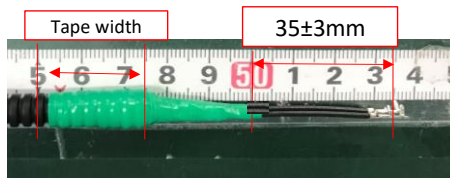

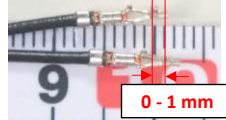
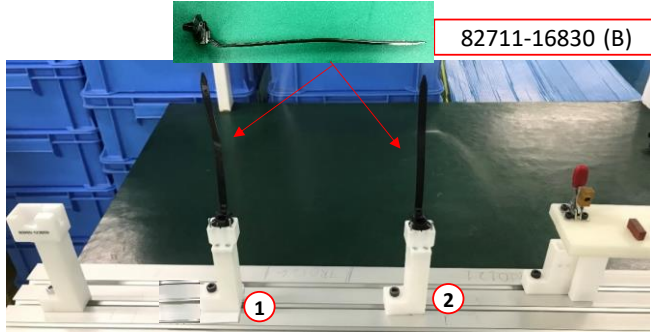
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PARTS:		1. Assy parts 2. Green tape		3.Clamp 82711-16830 (B) [2 pcs.]		JIG	1. Temporary Clamp Assembly Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4		Taping 1 Corrugated tube to wire near terminal	<div><div><div>Start of taping</div><div></div></div><div><div>1. Get the <b>Green tape</b>, hold the Corrugated tube using left hand then start pre-taping the COT to wire near terminal.</div><div></div><div>2. Measure the end of the Corrugated tube up to the terminal tip <b>60±3mm</b>. Then, continue the taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></div><div></div><div>3. After taping, check the dimension, taping condition and wire alignment.</div></div></div>			<div>Measuring tape</div> <div></div>	<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><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div><div>Wire alignment tolerance</div><div></div></div>
5	n/a	Clamp Setting	<div><div></div><div>1. Get 2 pcs. of band clamp <b>82711-16830 (B)</b> then attach to clamp location <b>1</b> and <b>2</b>.</div></div>			n/a	<div>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp</div>

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PRE-LAUNCH



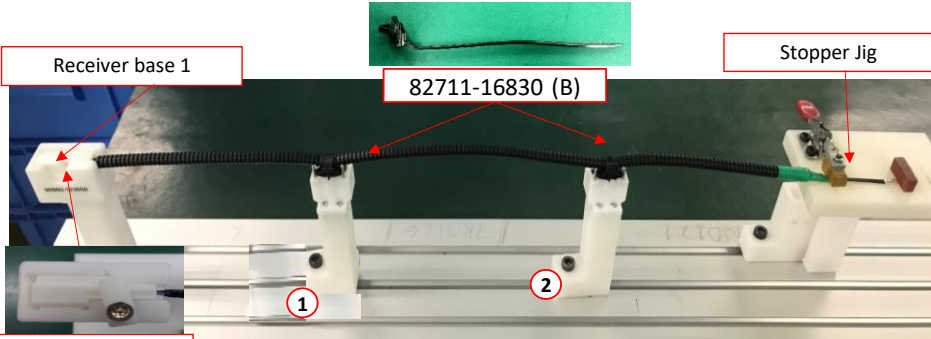





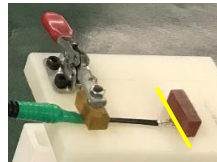
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PARTS:		1. Assy parts		JIG	1. Temporary Clamp Assembly Jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Clamp Assembly	<div><div><div></div><div><div>Connector setting</div><div>1</div><div>2</div></div></div><div><div>1. Put the assy parts into jig using both hands. First put the connector into receiver base using left hand and lock using right hand. Second, put the terminal to stopper jig using left hand and pull down the toggle clamp using right hand. <i>Refer to above illustration for the correct setting.</i></div><div>2. Initially tighten the 2 clamps <b>82711-16830 (B)</b> using right hand.</div></div><div><div>3. Get the bando gun using right hand then cut the band clamp on Location <b>1 and 2</b>.</div><div></div></div></div> <div><div><div>Bando Gun</div></div><div><div>Fixed setting of band clamp cutter: 1 ~ 2</div></div><div><div>BANDO GUN ALIGNMENT</div><div><div></div><div></div></div></div></div>		<div><div>Make sure no gap between terminal and stopper jig</div></div> <div><div>1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun</div></div>	

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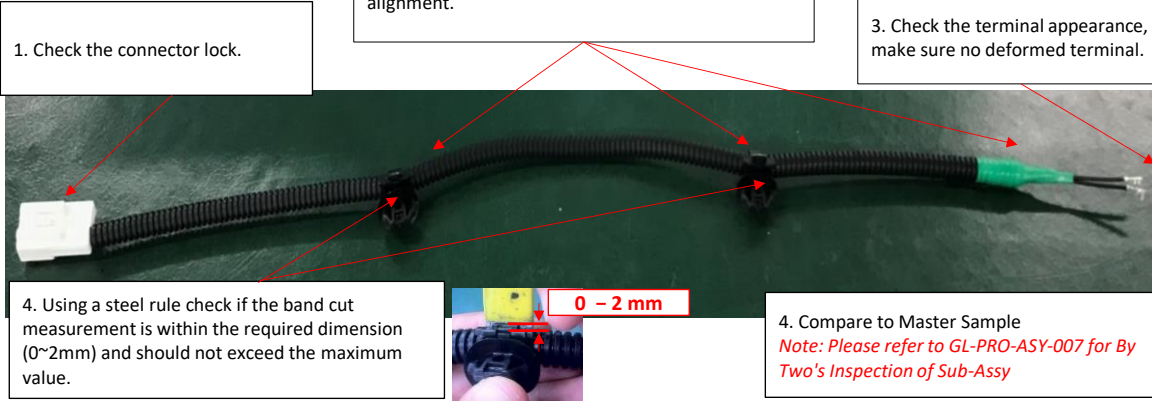

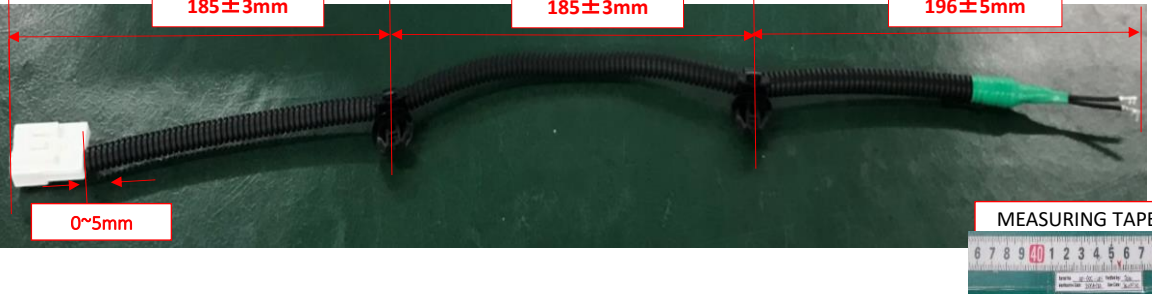
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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
7	Visual/By Two's Inspection	<p>1. Check the connector lock.</p> <p>2. Check the taping condition, clamp attachment, and alignment.</p> <p>3. Check the terminal appearance, make sure no deformed terminal.</p> <p>4. 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> <p>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></p>		<p><b>MASTER SAMPLE</b></p> 	
8	Measurement	<p>185±3mm</p> <p>185±3mm</p> <p>196±5mm</p> <p>0~5mm</p> <p>MEASURING TAPE</p> 		<p><b>NOTE: FOR HATSUMONO AND OWARIMONO</b></p> <p>1. No wrong dimension</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>	

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