



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 13, 2023

Process Name/Title:

Model Code/Part Number: 920B / 7R0115-7021

Customer:

TRMX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-643B

Purpose:


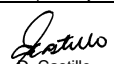

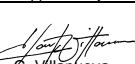
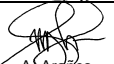
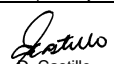

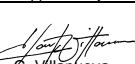
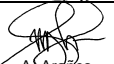
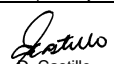

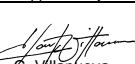
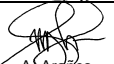
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PARTS:	1. Clamp 82711-52070 (W)				JIG:	1. Clamp assembly jig																																	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS																															
1	P2	Clamp setting	 <div>1. Get 1pc. of clamp 82711-52070 (W) using right hand then set to clamp location 1 using both hands.</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>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>																															
Revision History																																							
<table><tr><td></td><td></td><td></td><td></td><td></td><td></td><td>Prepared by</td><td>Reviewed by</td><td>Approved by</td><td>Noted by</td></tr><tr><td>03/13/23</td><td>0</td><td>Initial issue.</td><td></td><td></td><td></td><td> D. Castillo</td><td> J. Loterte</td><td> C. Villanueva</td><td> A. Arañes</td></tr><tr><td>Eff. Date</td><td>Rev. No</td><td colspan="4">Details of Change</td><td>Revised</td><td>Reviewed</td><td>Approved</td><td>Noted</td></tr></table>																Prepared by	Reviewed by	Approved by	Noted by	03/13/23	0	Initial issue.				 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
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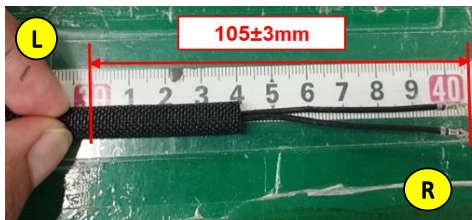
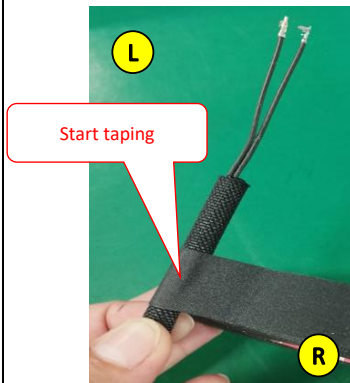
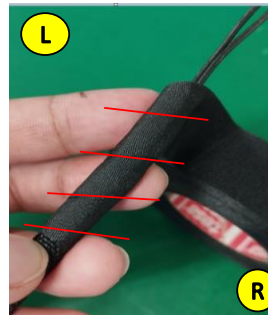


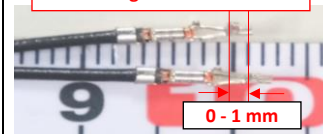
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PARTS:

1. Assy parts.
2. Black tesa tape (Tesa 51036)

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black twist tube 2420F to Wire near terminal	 <p>1. Measure from Black twist tube 2420F 105±3mm up to terminal tip.</p>  <p>2. Hold the assy parts using left hand. Get Black tesa (51036) using right hand.</p>  <p>3. Make 1 wind before shifting. 1/4 shifting until it reach the wire.</p>  <p>4. Measure from end of Black twisted tube up to terminal tip 66±3mm then continue the taping process using both hands.</p>	 <p>MEASURING TAPE</p>	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.  <p>Wire alignment tolerance 0 - 1 mm</p>

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PARTS:

1. Assy parts

JIG

1. Tape cutter

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

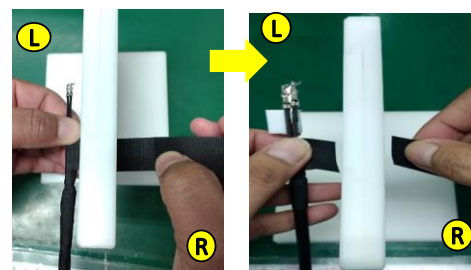
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P2

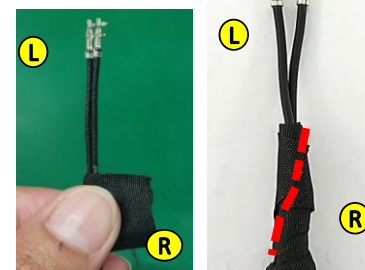
Taping 1
Black twist tube 2420F to
Wire near terminal
(Continuation)



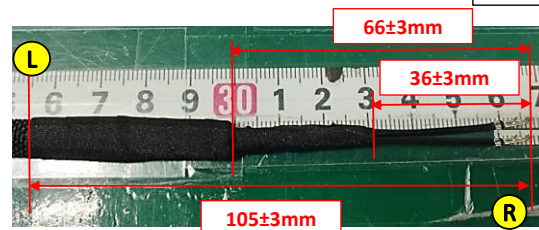
5. Measure from end of Black twisted tube up to terminal tip **36±3mm** then continue the taping process using both hands.



6. Cut the tape using provided tape cutter when reach the 1 1/2 wind using both hands.



7. After cut, conduct pressing of end tape using both hands.
Note: End tape appearance should be slanted.



8. Check the measurement, taping condition and wire alignment.

TAPE CUTTER



MEASURING TAPE



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

Important reminders/Note/s:

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

Wire alignment tolerance



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PARTS:		JIG		
1. Assy parts. 2. Black tesa tape (Tesa 51036)		1. Tape cutter		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Spot taping	<div>TAPE CUTTER</div> <div>MEASURING TAPE</div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>
		<div>170±3mm</div> <div>1. Measure from Black twisted tube up to terminal tip 170±3mm using both hands.</div> <div>Start taping</div> <div>2. Hold the assy parts using left hand. Get Black tesa (51036) using right hand. Make 1 wind of tape before cut.</div> <div>3. After cut, conduct pressing of end tape using both hands.</div> <div>20±3mm 150±3mm</div> <div>4. After taping, check the measurement and taping condition.</div>		

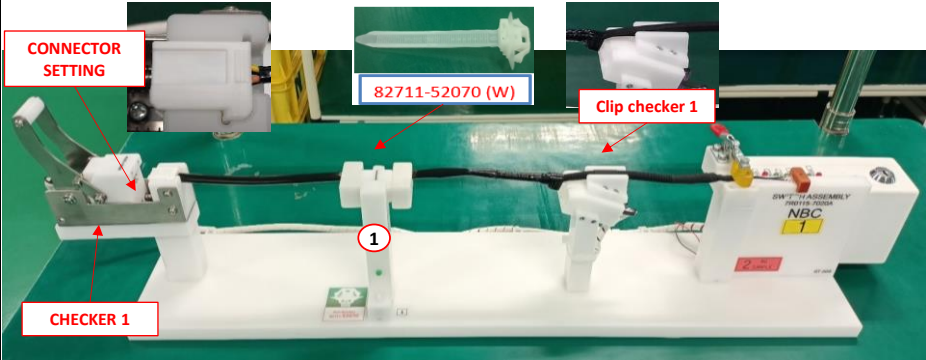
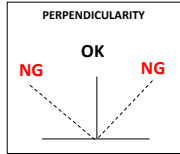

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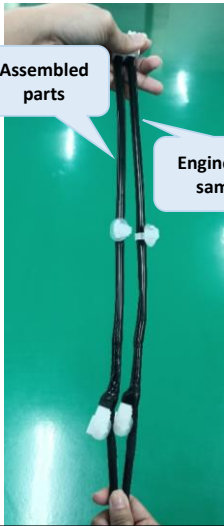






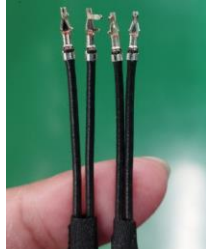
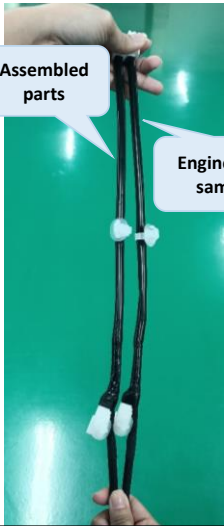

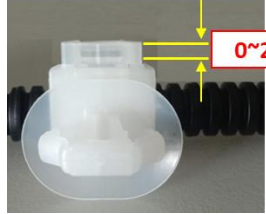
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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

PARTS:	1. Assy parts		JIG	1. Clamp assembly jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	<div>Clamp Assembly</div> <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 7189-0995 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6098-6653 (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>  <p>BANDO GUN ALIGNMENT</p> </div> <p>5. Conduct POINT CHECKING before removing from clamp assembly jig.</p> </div> <div>  <p>BANDO GUN ILLUSTRATION</p> </div>		

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PARTS:		1. Assy parts 2. Engineering sample	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By two's inspection <div> <div>  <p>ACTUAL PRODUCT</p> </div> <div>  <p>Assembled parts</p> </div> <div>  <p>Engineering sample</p> </div> <div>  <p>2. Check the terminal and wire insertion.</p> </div> <div>  <p>5. Check the terminal and presence of clip-clamp attachment.</p> </div> <div>  <p>3. Check the presence of clamp attachment and band clamp cut condition.</p> </div> <div>  <p>4. Check the Y-taping condition.</p> </div> <div>  <p>4. Check the spot taping condition and Tesa taping condition. Must be no missing spot tape.</p> </div> <div>  <p>6. Check the terminal appearance. Must be no deformed terminal.</p> </div> <div>  <p>1. Conduct alignment of harness (Engineering sample vs. assembled parts) using both hands.</p> </div> </div>		<div>  <p>MASTER SAMPLE</p> </div> <div>  <p>1. No skip checking during inspection</p> <p>0~2mm</p> </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>

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PARTS:

1. Assy parts

JIG

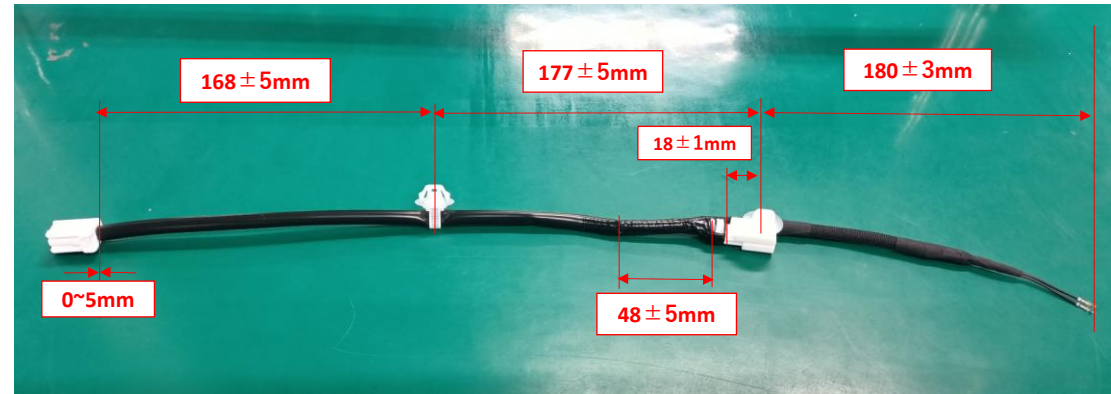
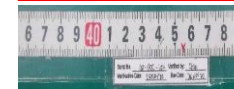
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P2

Measurement

**MEASURING TAPE****Important reminders/Note/s:**

1. **FOR HATSUMONO AND OWARIMONO**
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No wrong dimension

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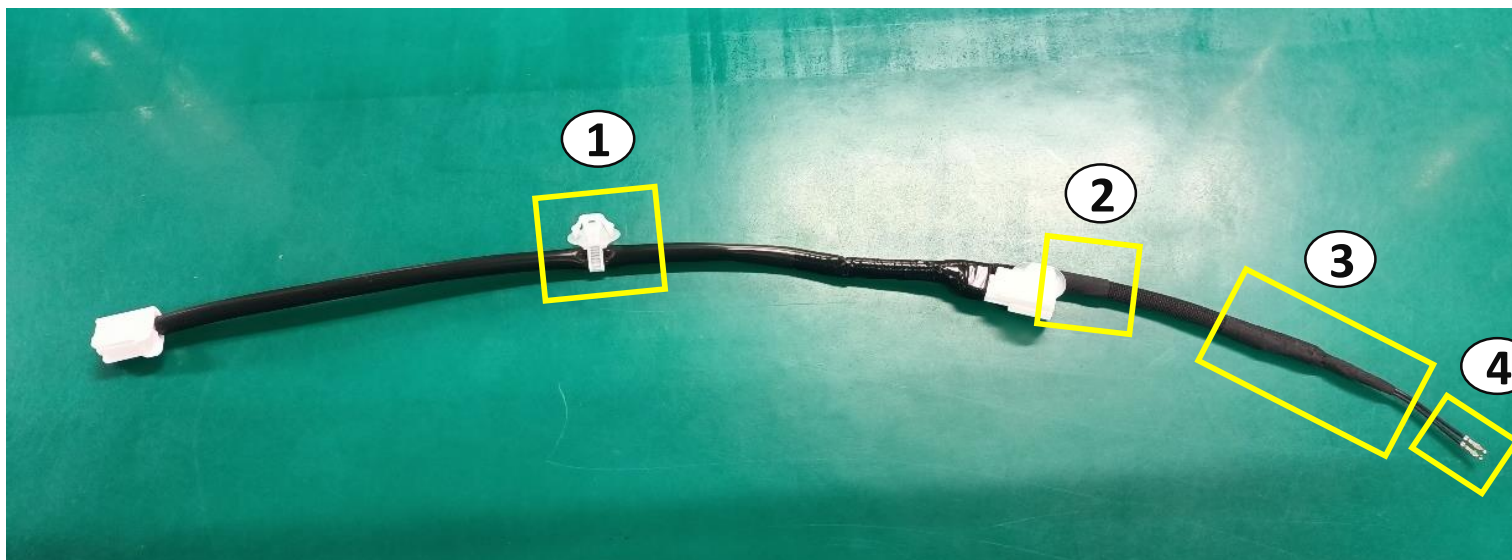
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PARTS:

1. Assy parts

JIG

n/a

QUALITY CHECKPOINTS**P2****7R0115-7021****①** No Missing Clamp**② ③** No Missing Tesa tape**④** No Deformed Terminal

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