



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 920B / 7R0120-7021

Customer:

TRMX

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

February 22, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-639B

Revision No.:

0

Page No.:

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PARTS:

1. Clamp 82711-3A640 (B)
2. Black tape

JIG:

1. Temporary clamp assembly jig

NO.

PROCESS NAME

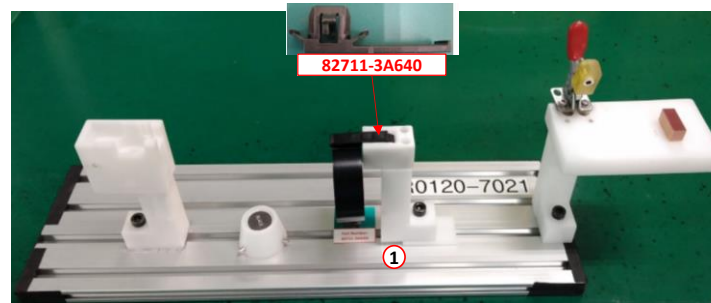
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

Clamp setting



1. Get 1pc. of clamp **82711-3A640 (B)** using both hands then set to clamp location **1** using both hands.

2. Initially attach **Black tape** on clamp location **1** using both hands.

Safety Instruction

Be sure to wear required 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.

STANDARD TAPING FOR CLAMP

One side tape under clamp



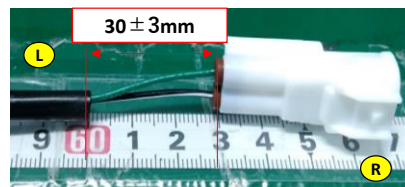
1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

Important reminders/Note/s:

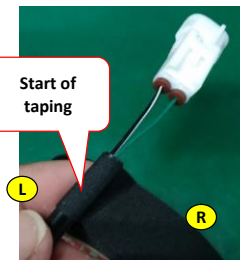
1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

2

Taping 1
Black tesa tape 51036 to wire near connector



1. Measure from end of Black SV tube (Vinyl) up to edge of connector **30±3mm** using both hands.



2. Hold the tube using left hand, get the **Black tesa tape 51036** using right hand then start taping process using both hands.

Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/22/23	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Prepared	Reviewed	Approved	Noted	Est. Date:	February 22, 2023

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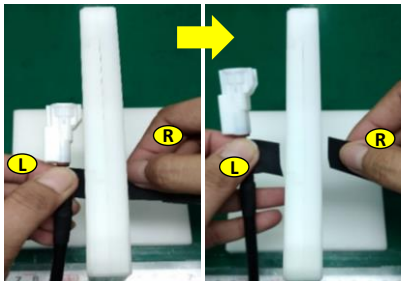
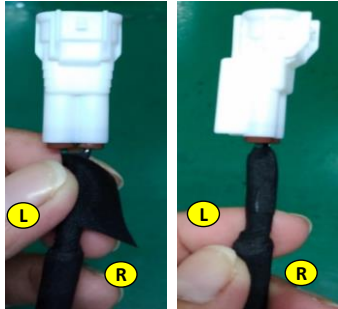
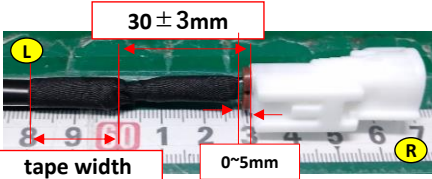
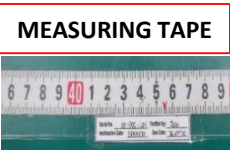


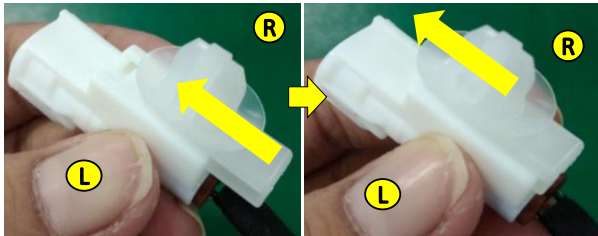
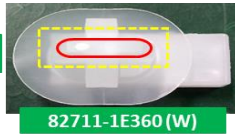
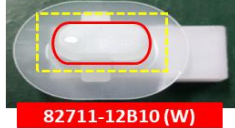
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PARTS:

1. Assy parts
2. Black tesa tape 51036

JIG

1. Tape cutter

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Taping 1 Black tesa tape 51036 to wire near connector (Continuation)	 3. Cut the tape using tape cutter using both hands.  4. After cut, conduct pressing of end tape using both hands.  5. Check the taping condition, measurement and wire alignment.	 	<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: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>
3	Clip attachment 82711-1E360 (W)	 CLAMP ORIENTATION  1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.	n/a	<p>CLIP CLAMP ILLUSTRATION</p> <p>GOOD</p>  <p>82711-1E360 (W)</p> <p>NG</p>  <p>82711-12B10 (W)</p> <ol style="list-style-type: none">1. No wrong use of parts2. No loose attachment

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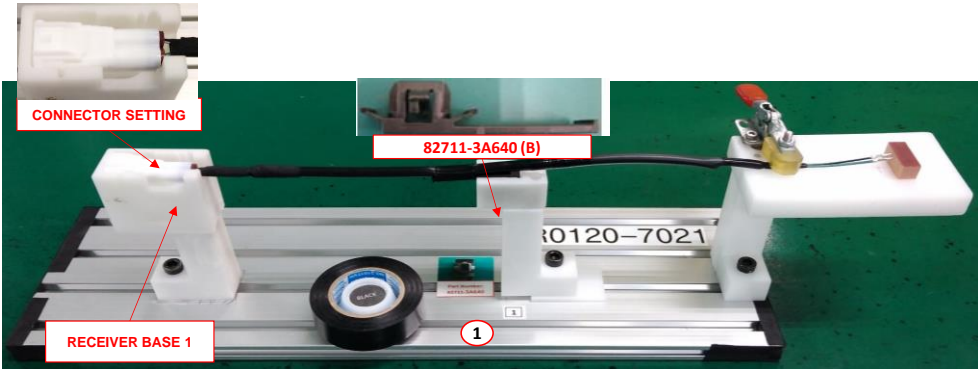

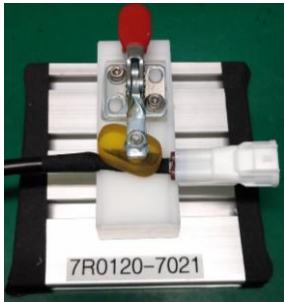

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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PARTS:		1. Assy parts 2. Clamp 82711-1E360 (W) 3. Black tape			JIG	1. Temporary clamp assembly jig 2. Pressing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Clamp assembly	<div></div> <div>1. Get the assy parts then set into jig. (<i>See above illustration</i>). First, set the connector 6098-0407 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the G-B/W wires to stopper then press by toggle clamp.</div> <div>2. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands.</div> <div>3. Conduct POINT CHECKING before removing the harness from jig.</div>				Important reminders/Note/s: 1. Make sure no gap in stopper and terminals
5	Pressing jig	<div></div> <div>1. Conduct pressing of end tape by putting the assy parts into pressing jig, make sure that end tape must be pressed.</div>			<div></div> <div>PRESSING JIG</div>	Important reminders/Note/s: 1. Removal of assy parts from pressing jig will be done after producing the next assy parts.
					1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong set-up

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

n/a

Visual/By two's inspection

Engineering sample

Assembled parts

ACTUAL PRODUCT

1. Conduct **alignment of harness (Engineering sample vs. assembled parts)** using both hands.

2. Check the **terminal, insertion** and the **presence of Clip clamp**

3. Check the **taping condition of tesa tape.**

4. Check the **presence of clamp** attachment and **taping condition.**

5. Conduct **bending on 2 tubes** and check the **taping condition.**

6. Check the **tape, taping condition and terminal appearance.** Make sure no **deformed terminal.**

1. No skip checking during inspection.

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PROTOTYPE



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PARTS:

1. Assy parts

JIG

n/a

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

7

n/a

Measurement

MEASURING TAPE**Note:****Please use calibrated/verified measuring tape when getting the measurement.****368±5mm****183±5mm****160±3mm****0~5mm****Important reminders/Note/s:****1. FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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1. Assy parts

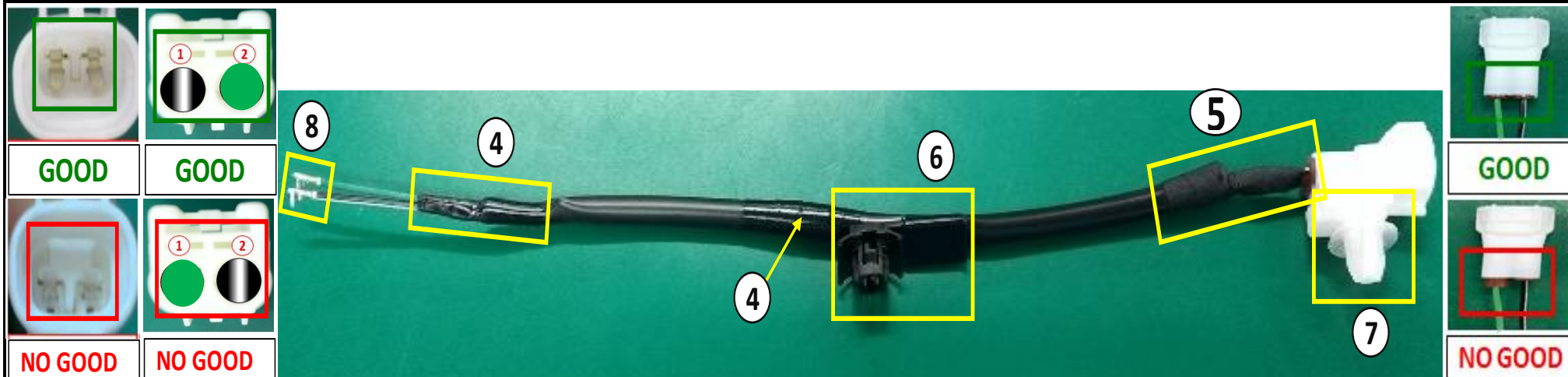
JIG

n/a

QUALITY CHECKPOINTS

P2

7R0120-7021



① No Unlock/ Halflocked Connector

④ No Missing tape

⑥ No Missing clamp (1pc.)

② No Wrong Insert

⑤ No Wrong use of tape (Tesa tape)

⑦ No Missing clip clamp (1pc.)

③ No Terminal Backing Out

⑧ No Deformed Terminal

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