

	WORK INSTRUCTION				Effectivity Date:		June 16, 2022	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Product Number: 920B / 7R0116-7020A		Customer: TRMX		Document No.: WI-ENG-PDE-546	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 1 of 8

PARTS:	1. Connector 6098-0407(W) 2. TVSSf 0.3 B/W-G wires L=402±2mm			JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<div style="text-align: center;"> CONNECTOR ORIENTATION </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div style="text-align: center;"> 1 Black/White </div> <div style="text-align: center;"> 2 Green </div> </div> <div style="margin-top: 10px;"> <div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> 1. Get the Black/White wire and insert to connector using right hand. </div> <div style="border: 1px solid black; padding: 5px;"> 2. Hold the connector using left hand. Get the Green wire and insert to connector using right hand. </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="border: 1px solid red; padding: 10px; margin-bottom: 10px;"> <i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> </div> <div> 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing <i>Note: Please hold the wire near terminal during insertion.</i> Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. <i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> </div>

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
								M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
06/16/22	0	Initial Issue.													
Eff. Date	Rev.No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	June 16, 2022				

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☐ PROTOTYPE

☒ PRE-LAUNCH

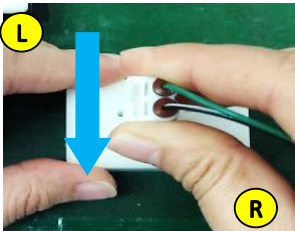





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PARTS:		1. Assy parts 2. Black Vinyl Tube Ø5 L=183±3mm			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Connector Lock	<div></div> <div>1. Put the connector into locking jig using right hand then press 2x to lock.</div> <div></div> <div></div> <div></div>			<div>LOCKING JIG</div> <div></div>	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</div> <div>1. Use the provided locking per model 2. No unlock/half-locked connector</div>
3	Wire insertion to Black Vinyl Tube Ø5 L=183±3mm	<div></div> <div>1. Get the Viny tube Ø5 L=183±3mm using right hand then insert the Green and Black/White wire.</div>			n/a	<div>1. No wrong use of parts 2. No deformed terminal</div>

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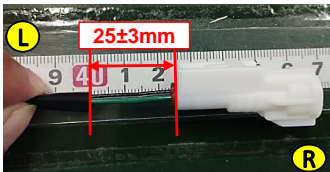
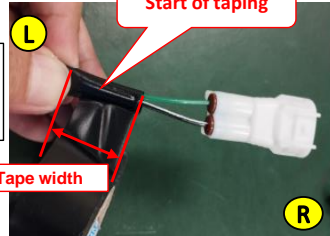
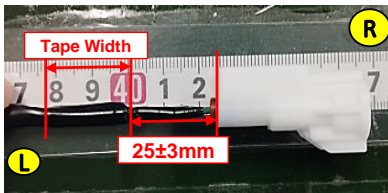


PARTS:

1. Assy parts
2. Black Sunprene tube Ø5 L=125±3mm

3. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Taping 1 Black Vinyl tube to Wire near connector n/a	 <p>1. Measure from end of Vinyl tube up to end of connector 25±3mm using both hands.</p>  <p>2. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping</p>  <p>3. After taping, check the measurement and taping condition.</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><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>
5	Wire Insertion to Black Sunprene tube Ø5 L=125±3mm	 <p>1. Get the Sunprene tube Ø5 L=125±3mm using right hand then insert the Green and Black/White wire.</p>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal

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PARTS:

1. Assy parts
2. White tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

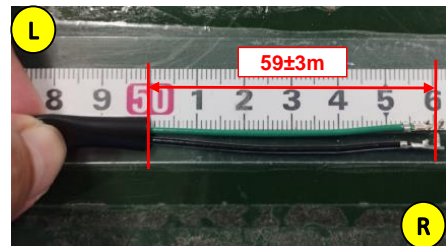
TOOLS/PPE

QUALITY POINTERS

6

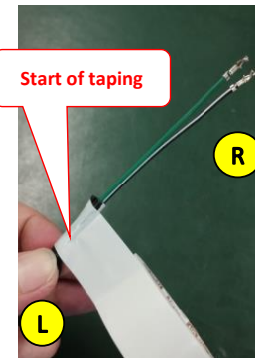
n/a

Taping 2
Black Sunprene tube to
Wire near terminal



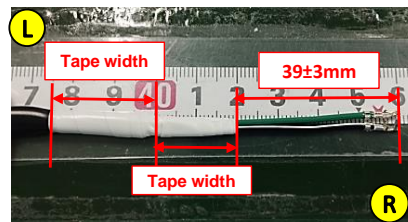
1. Measure the end of the sunprene tube up to the end of the terminal pointed tip 59mm using both hands.

Start of taping



2. Hold the sunprene tube using left hand then start taping using right hand.

Note: Refer to WI-PRO-ASY-001 for taping procedure.



3. After taping, check the measurement, alignment and tape condition.

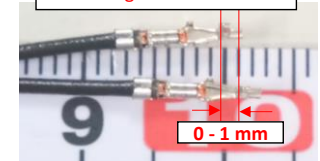
MEASURING TAPE



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

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

Wire alignment tolerance



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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

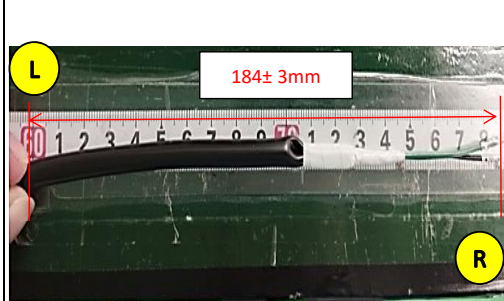
TOOLS/PPE

QUALITY POINTERS

7

n/a

Taping 3
Vinyl tube to Sunprene
tube



1. Measure the end of the corrugated tube up to the end of the terminal pointed tip **184mm**.

Note:
Make sure no gap
between Sunprene tube
and Vinyl tube

Start of taping

L

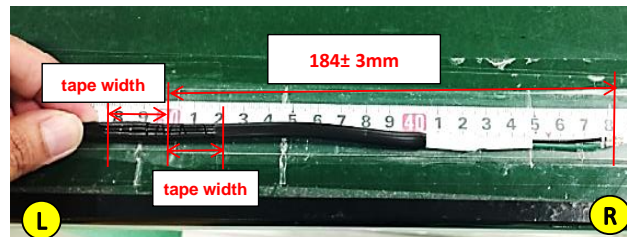
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2. Fix the Sunprene tube and the Vinyl tube using then start taping process using right hand.
Note: Refer to WI-PRO-ASY-001 for taping procedure

MEASURING TAPE



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



3. After taping, check the measurement, alignment and tape condition.

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

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PARTS:		1. Clamp 82711-12A80 (W) 2. Black tape 3. Clamp 82711-1E360 (W)			JIG	1. Temporary Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	n/a	<div></div>			n/a	<div> 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>
9	Clamp attachment (clip type clamp)	<div> 1. Hold the connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></div>			n/a	1. Must be fully inserted

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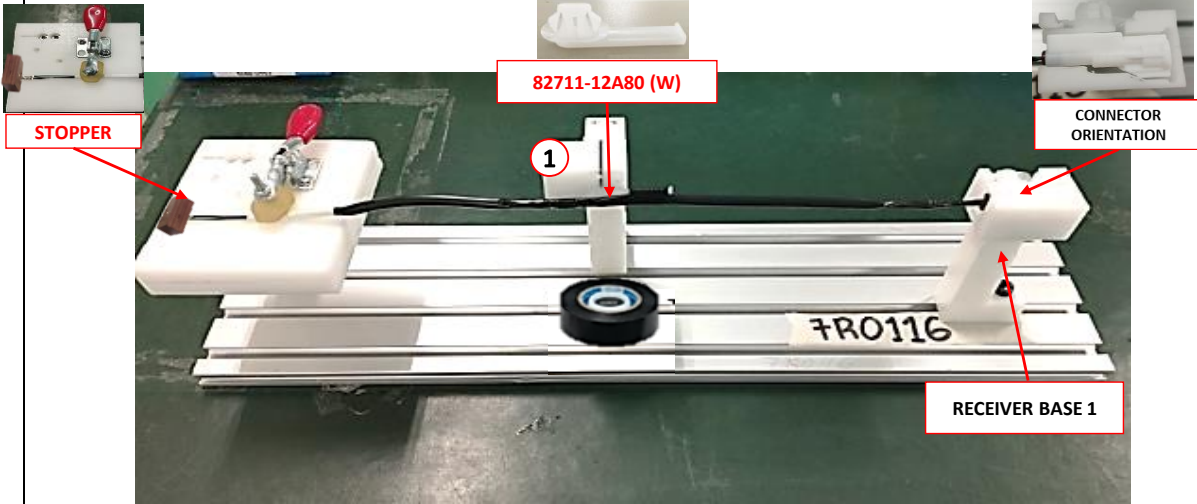

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PARTS:	1. Assy parts 2. Black tape			JIG	1. Temporary Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	n/a Clamp Assembly	 <p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6098-0407 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the Black/White and Green wires together within stopper then press by toggle clamp.</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>		 <p>Make sure no gap between terminal and stopper jig</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape	

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

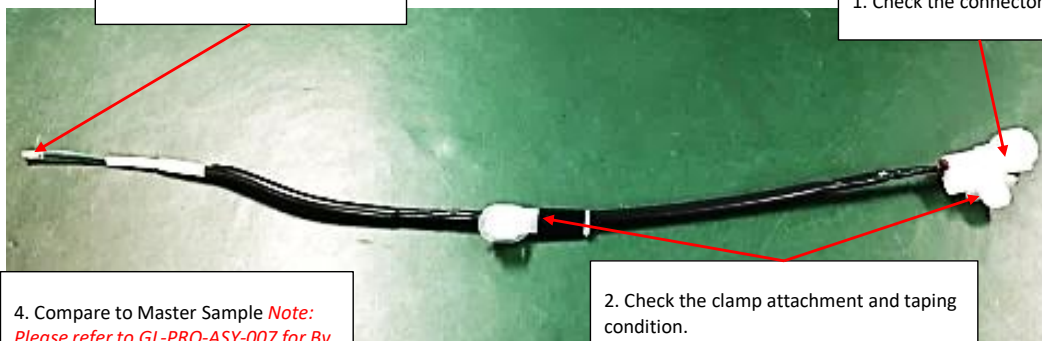
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Visual/ By two's inspection

n/a

3. Check the terminal condition.
Make sure no deformed terminal.

1. Check the connector lock.



4. Compare to Master Sample *Note:*
Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy.

2. Check the clamp attachment and taping condition.

MASTER SAMPLE



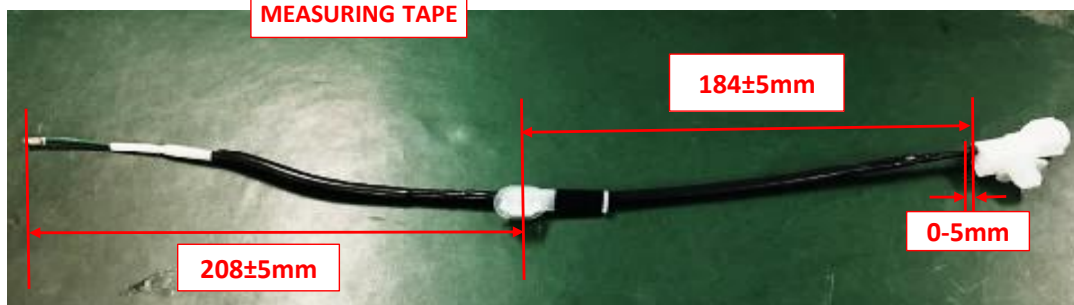
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Measurement



MEASURING TAPE

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



NOTE: FOR HATSUNOMO
OWARIMONO

1. No wrong Dimension

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