

	WORK INSTRUCTION				Effectivity Date:		July 19, 2022	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:			Model Code/Part Number: 200D/220D / 7R0123-7021			Customer: TRMX	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.: WI-ENG-PDE-560		Revision No.: 1		Page No.: 1 of 6

PARTS:	1. Assy parts; Clamp 82711-34490 (B); Black tape			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P1	Table Lay-out			<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> 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>	1. No missing parts/tools. 2. No excess parts/tools.

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
07/19/22	1	Change from Pre-launch to Masspro. Additional table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	July 12, 2022							

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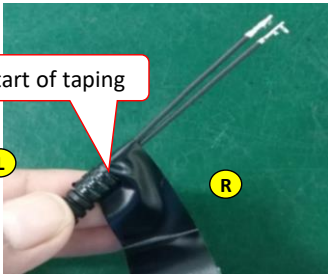
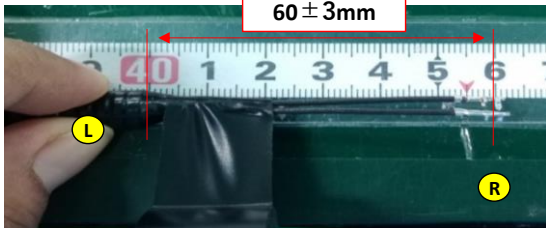
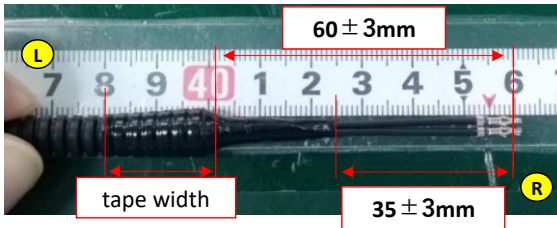

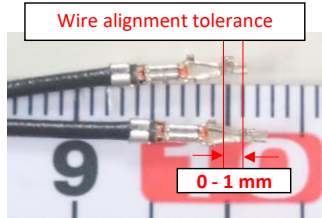
WI-ENG-PDE-560

Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Taping 1 COT to wire near terminal			
		<div><div><p>Start of taping</p><p>L R</p></div><div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div></div> <div><div><p>60 ± 3mm</p><p>L R</p></div><div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div></div> <div><div><p>60 ± 3mm</p><p>tape width</p><p>35 ± 3mm</p><p>L R</p></div><div><p>3. After taping, check the measurement, taping condition and terminal appearance.</p></div></div>		<div><p>MEASURING TAPE</p></div>	<div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <div><p>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</p><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div>

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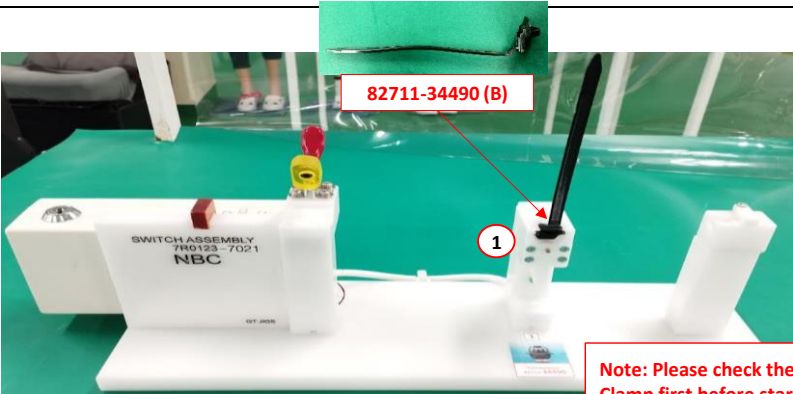
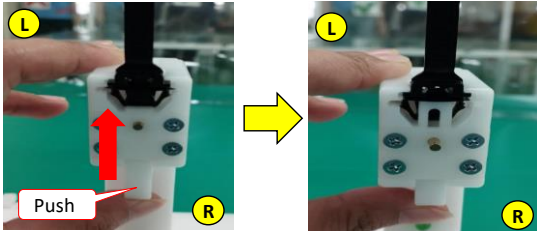
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Revision No.:

1

Page No.:

3 of 6

PARTS:		1. Assy parts 2. Clamp 82711-34490 (B)			JIG	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Clamp setting	<div></div> <div><div>1. Get 1 pc of band clamp 82711-34490 (B) using right hand and set to clamp location ① using both hands.</div><div></div></div>		n/a	1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp

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WI-ENG-PDE-560

Revision No.:

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Page No.:

4 of 6

PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Clamp assembly	<div><div>No gap between stopper and terminals</div><div><div>STOPPER</div><div>82711-34490 (B)</div><div>CONNECTOR SETTING</div><div>1</div><div>RECEIVER BASE 1</div></div><div>SWITCH ASSEMBLY 7R0123-7021 NBC QT J055</div></div> <div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6089-6663 (B) in Receiver base 1 then lock using right hand. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was ON, the CLAMP ON.</p><div><div><div>82711-34490 (B)</div><div>GOOD</div><div>LOCKED ①</div></div><div><div>TOGGLE</div></div><div><div>82711-34490(B)</div><div>NG</div><div>UNLOCKED ①</div></div><div><div>TOGGLE</div></div></div></div> <div><p>NOTE: On clamp location 2, if clamp 82711-34490 (B) is locked and the toggle clamp is set, the proces will proceed. If clamp 82711-34490 (B) is unlock and the toggle clamp is set, the process will not proceed and NG buzz will be heard.</p></div>	n/a	<div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-34490(B)</div></div><div><div>NG</div><div>82711-16830(B)</div></div></div> <div><p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p></div>

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Revision No.:

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Page No.:

5 of 6

PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Clamp assembly (Continuation)	<div><div>No gap between stopper and terminals</div><div>STOPPER</div><div>82711-34490 (B)</div><div>CONNECTOR SETTING</div><div>RECEIVER BASE 1</div><div>1</div><div>SWITCH ASSEMBLY 7R0123-7021 NBC</div></div> <div><div>2. Initially tighten the band clamp 82711-34490 on clamp location 1 using right hand.</div><div>3. Get the bando gun using right hand then cut the band clamp on Location ①.</div><div>4. Check if LED light for POWER, CLAMP, and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction</div><div>5. Conduct POINT CHECKING before removing the harness from jig.</div></div> <div><div>UNLOCKED PIN</div><div>GOOD</div><div>NG</div><div>VERTICAL LINE OK</div><div>NG</div><div>NG</div><div>NOTE: Pin must be hit during cutting of bando gun.</div><div>Fixed setting of band clamp cutter: 1 ~ 2</div></div>		<div>BANDO GUN</div> <div>FLAT NOSEPIECE</div>	<div>BANDO GUN ILLUSTRATION</div> <div>GOOD</div> <div>NG</div> <div>FLAT NOSEPIECE</div> <div>EXTENDED NOSEPIECE</div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp 5. No wrong use of bando gun.</div>

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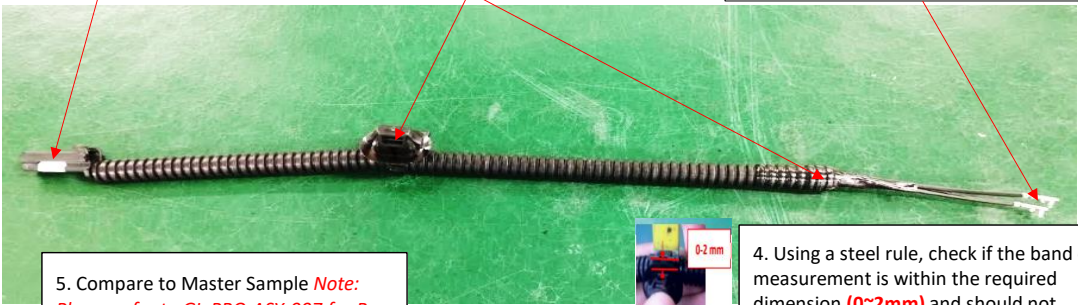


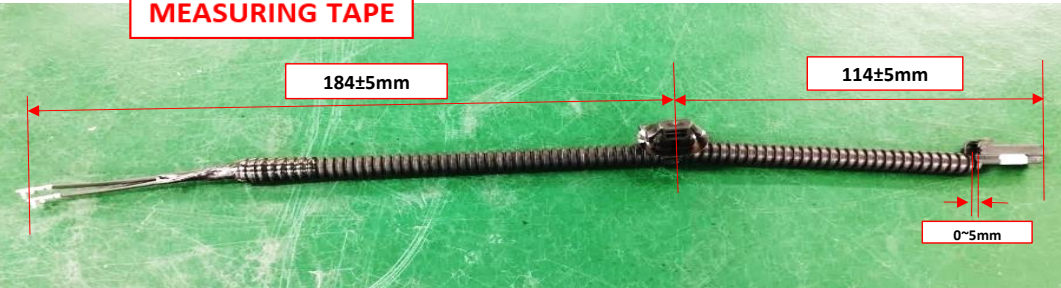
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Revision No.:

1

Page No.:

6 of 6

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

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