

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model Code/Part Number: **920B / 7R0117-7021**

Customer:

TRMX

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

March 10, 2023

Validity Date:

n/a

Document No.:

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0

Page No.:

1 of 6**PARTS:**

1. Clamp 82711-12A80 (W)
2. Clamp 82711-58020 (W)
3. Clamp 82711-3A640 (B)

4. Clamp 82711-12A60 (W)
5. Black tape (2pcs.)

JIG:

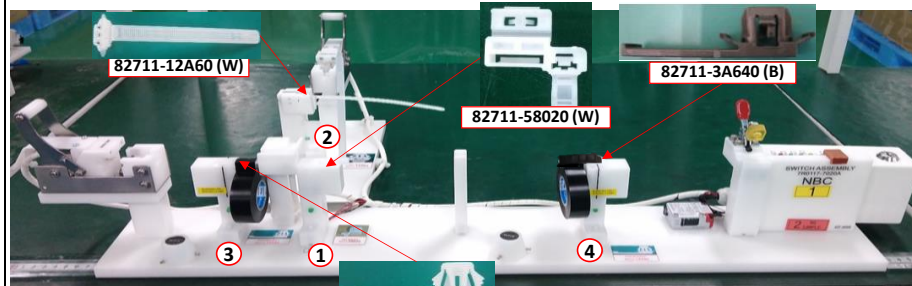
1. Clamp assembly jig

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

1

P3

Clamp setting



1. Get **1pc.** of clamp **82711-12A80 (W)** then set to clamp location **3** using both hands.

2. Get **1pc.** of clamp **82711-3A640 (B)** then set to clamp location **4** using both hands.

3. Get **1pc.** of clamp **82711-58020 (W)** then set to clamp location **1** using both hands.

4. Get **1pc.** of clamp **82711-12A60 (W)** then set to clamp location **2** using both hands.

5. Initially attach **Black tape** on clamp location **3 and 4** using both hands.

Safety Instruction

Be sure to wear prescribed 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.

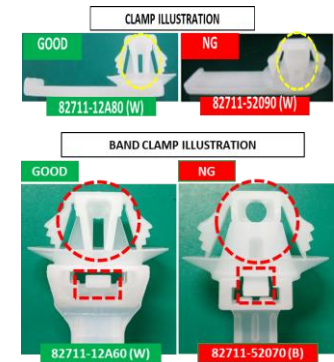
Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

Important reminders/Note/s:

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

**Revision History**

03/10/23 0 Initial issue. Clamp 82711-12A80 (W) quantity from [2pcs] to [1pc]. Clamp 82711-3A640(B).

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Reviewed by

J. Loterte

Approved by

C. Villanueva

Noted by

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

March 10, 2023

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TAPING ASSEMBLY PROCESS

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Model Code/Part Number: **920B / 7R0117-7021** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:	1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp assembly	<div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6189-1142 (W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Clamp assembly jig will beep/buzz if sensor detects Blue tape. Set the end of PCB within the stopper jig then press the toggle clamp. Last, set the connector 6189-1161 (B) to Checker 2 then pull the checker fixture for continuity checking. Continue if the clamp location 1 was ON.</p><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, Color sensor 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 on clamp location 1 and 2 using both hands.</p><p>4. Get the Bando gun (FLAT NOSEPIECE) using right hand then cut the clamp on location 1 using both hands. Press the SW button after cut. Continue if the clamp location 2 was ON.</p></div> <div><p>BANDO GUN POSITION ON CLAMP LOCATION 1</p><p>GOOD NG</p><p>BANDO GUN PERPENDICULARITY</p><p>NG OK NG</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div> <div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p><p>Fixed setting of band clamp cutter: 1~ 2</p></div>		<p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and PCB</p> <p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p>

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Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Clamp assembly (Continuation)	<div></div> <div><div><p>6. Get the Bando gun (EXTENDED NOSEPIECE) using right hand then cut the clamp on location 2 using both hands. Press the SW button after cut Continue if the clamp location 3 was ON.</p><div><p>GOOD</p></div><div><p>NG</p></div></div><div><p>7. Hold the tape on clamp location 3 then start taping using both hands. Make 3 windings of tape then cut the tape. Continue in clamp location 4.</p></div><div><p>8. Hold the tape on clamp location 4 then start taping using both hands. Make 3 windings of tape then cut the tape.</p></div><div><p>9. After taping, conduct POINT CHECKING before removing the harness from the jig.</p></div><div><div><p>BANDO GUN POSITION ON CLAMP LOCATION 2</p></div><div><p>BANDO GUN ALIGNMENT</p><div><p>PERPENDICULARITY</p><div><p>NG</p><p>OK</p><p>NG</p></div></div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: $\phi 5 - 1 \sim 2$, $\phi 7 -$</p></div><div></div></div></div></div> <div><div></div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and PCB</p></div> <div><p>1. No loose attachment of clamp</p><p>2. No damaged clamp</p><p>3. No missing parts</p><div><p>BANDO GUN ILLUSTRATION</p><div><p>GOOD</p></div><div><p>NG</p></div><div><p>EXTENDED NOSEPIECE</p></div><div><p>FLAT NOSEPIECE</p></div></div></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

3

P3

Visual/By two's inspection



ACTUAL PRODUCT

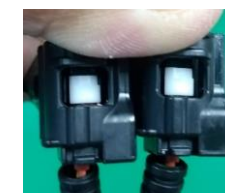


Assembled parts

Engineering sample

2. Check the **connector lock** condition, **insertion** and **taping condition**.

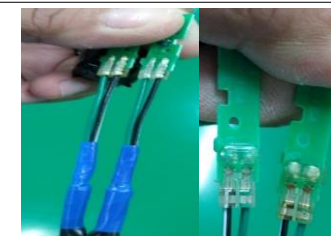
1. Conduct alignment of harness (**Master sample** sample vs. **assembled parts**) using both hands.



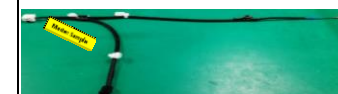
4. Check the **terminal**, **connector lock** condition and **insertion**.



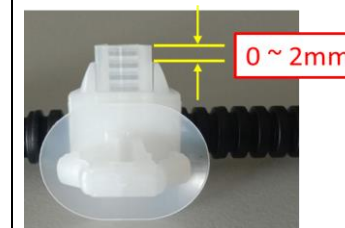
3. Check the **presence of ALL clamp attachment**, **cut appearance** and **taping condition**.



5. Check the **tape color**, **taping condition** and **PCB appearance**.



1. No skip process



Important reminders/Note/s:

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.

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PARTS:

n/a

JIG

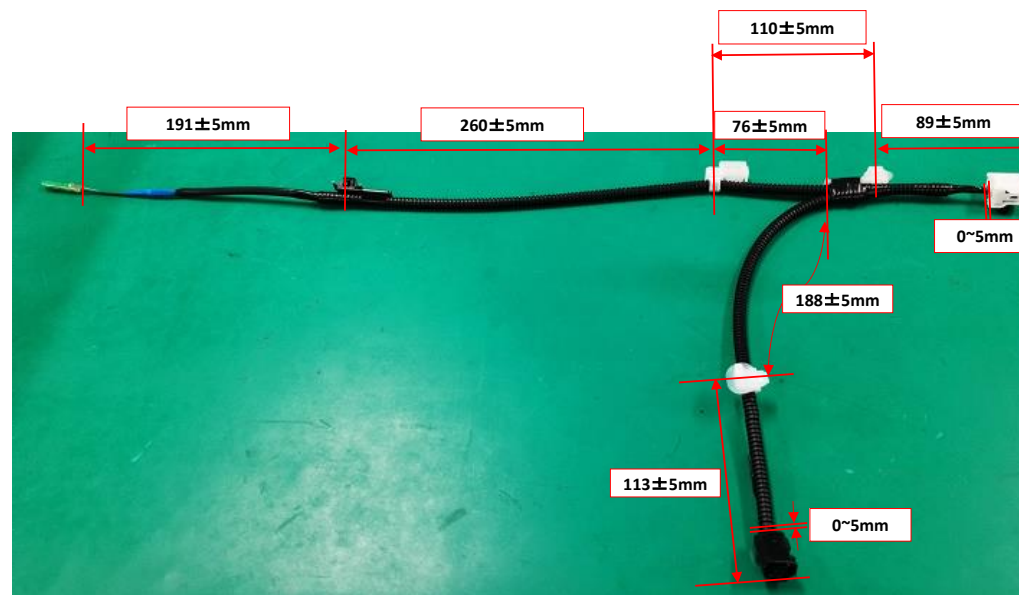
n/a

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

4

P3

Measurement

**MEASURING TAPE****Note:****Please use calibrated/verified measuring tape when getting the measurement.****Important reminders/Note/s:****1. FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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PARTS:

n/a

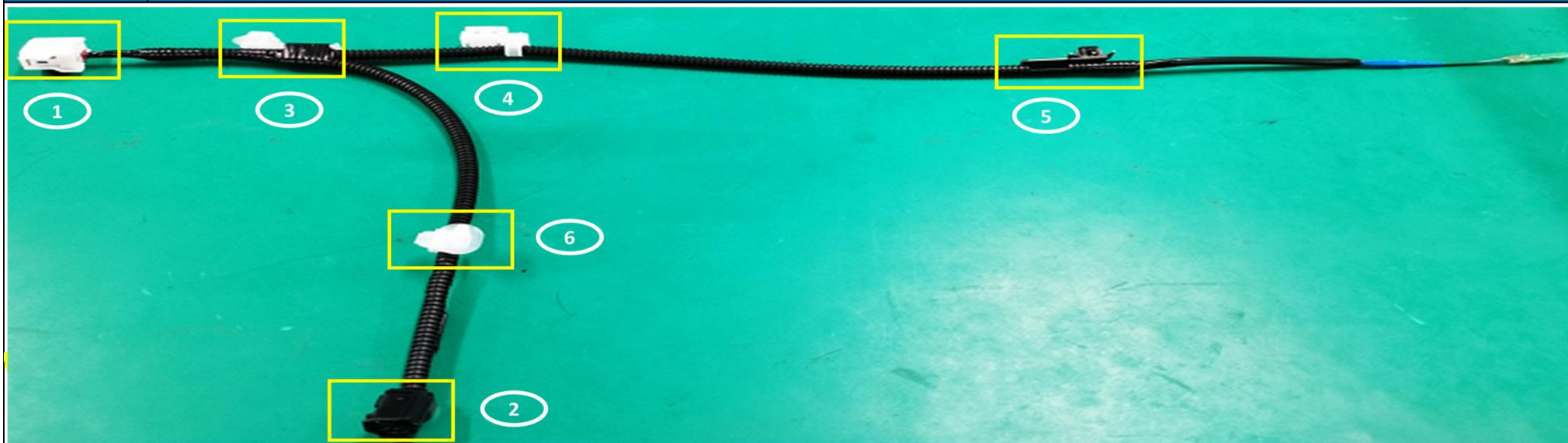
JIG

n/a

QUALITY CHECKPOINTS

P3

7R0117-7021



① ② No **UNLOCKED/HALFLOCKED CONNECTOR**

⑦ **CORRECT FACING OF CLAMP**

③ ④ ⑤ ⑥ No **MISSING CLAMP/BAND CLAMP**

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