

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 24, 2023

Model Code/Part Number:

780B / 7R0105-7023A

Customer:

TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-569B

Revision No.:

3

Page No.:

1 of 8

PARTS:

1. All parts: Clamp 82711-52090 (W); Clamp 82711-16830 (B); Clip type clamp 82711-1E360 (W);

JIG:

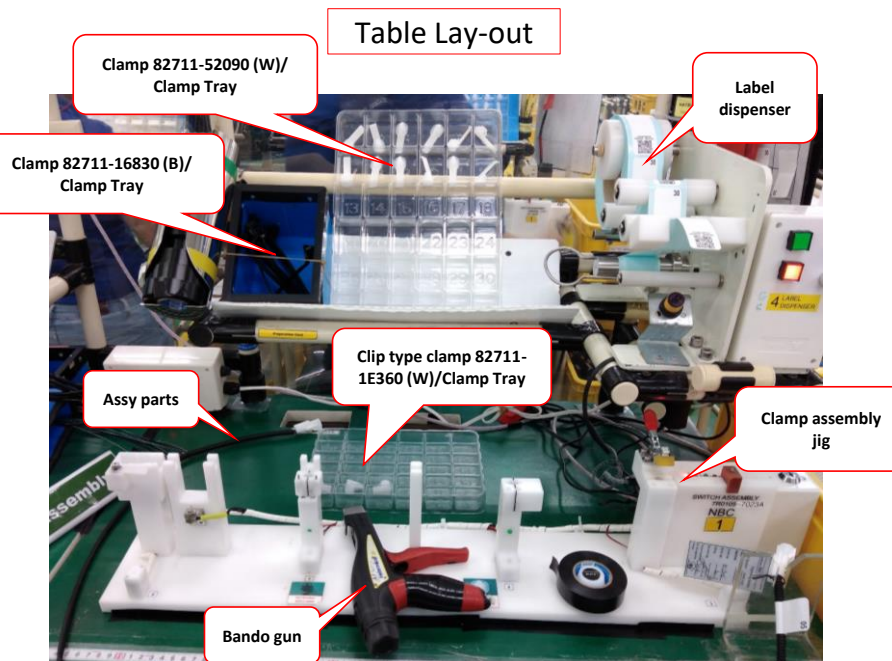
1. Clamp assembly jig
2. Label dispenser

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

1

P2

Table Lay-out

**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.

**Bando gun**

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/24/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a				
10/14/22	2	Improve: Quality pointers and notes in process no.6 and 7 a document improvement. Work procedure and illustration in process no.6 - visual/by two's inspection as process improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
07/26/22	1	Change: Document purpose from pre-launch to masspro. Table lay-out illustration. Additional process no.3 from P1 to P2. Transferring of Black COT to Black sunprene tube near terminal taping process to P1.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
07/20/22	0	Initial issue QR code label 7V3010-0020 direction	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	J. Loterte	C. Villanueva	A. Arañes	n/a
							Est. Date:	July 20, 2022		

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☐ PRE-LAUNCH

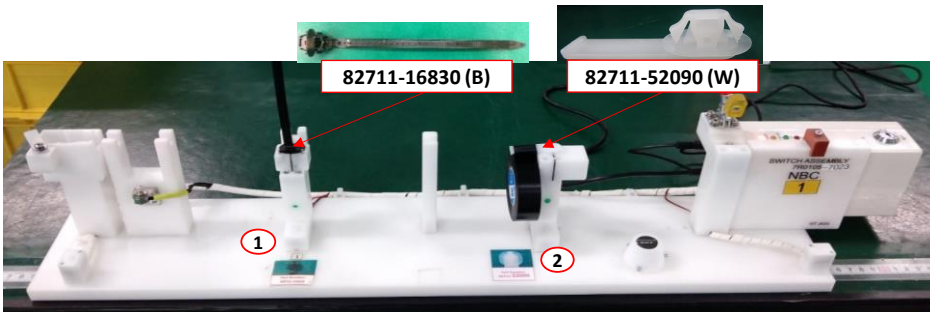
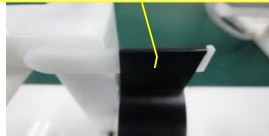
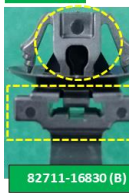



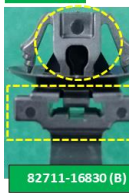



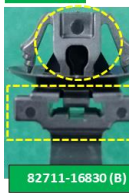



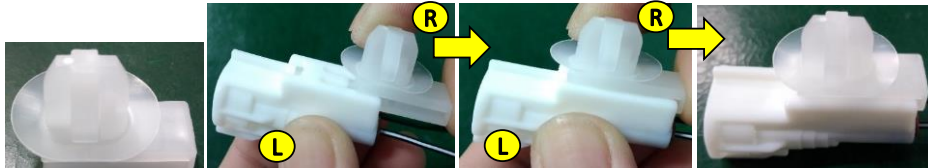






☒ MASSPRO

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PARTS:		1. Clamp 82711-16830 (B) 2. Clamp 82711-52090 (W)		3. Black tape 4. Clamp 82711-1E360 (W)		JIG	1. Clamp assembly jig											
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS											
2	P2	Clamp Setting	<div></div> <div><p>1. Get 1pc. of clamp 82711-16830 (B) using right hand then set to location 1 using both hands.</p></div> <div><p>2. Get 1pc. of clamp 82711-52090 (W) using right then set to location 2 using both hands.</p></div> <div><p>3. Initially attach Black tape on clamp location 2 using both hands.</p></div> <div><p>STANDARD TAPING FOR CLAMP</p><p>One side tape under clamp</p></div>		n/a	<div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><p>BAND CLAMP ILLUSTRATION</p><table><tr><td>GOOD</td><td>NG</td></tr><tr><td></td><td></td></tr><tr><td>82711-16830 (B)</td><td>82711-34490 (B)</td></tr></table><p>CLAMP ILLUSTRATION</p><table><tr><td>GOOD</td><td>NG</td></tr><tr><td></td><td></td></tr><tr><td>82711-52090 (W)</td><td>82711-12A80 (W)</td></tr></table></div>	GOOD	NG			82711-16830 (B)	82711-34490 (B)	GOOD	NG			82711-52090 (W)	82711-12A80 (W)
GOOD		NG																
																		
82711-16830 (B)	82711-34490 (B)																	
GOOD	NG																	
																		
82711-52090 (W)	82711-12A80 (W)																	
3	Clamp attachment (Clip type clamp) 82711-1E360 (W)	<div></div> <div><p>CLIP CLAMP ORIENTATION</p></div> <div><p>1. Hold the connector using left hand. Get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. <i>Note: Follow above instruction. Sound will be heard if properly inserted.</i></p></div>	n/a	<div>1. No wrong use of parts 2. Must be fully inserted</div> <div><p>CLIP CLAMP ILLUSTRATION</p><table><tr><td>GOOD</td><td></td></tr><tr><td></td><td>82711-1E360 (W)</td></tr><tr><td>NG</td><td></td></tr><tr><td></td><td>82711-12B10 (W)</td></tr></table></div>	GOOD			82711-1E360 (W)	NG			82711-12B10 (W)						
GOOD																		
	82711-1E360 (W)																	
NG																		
	82711-12B10 (W)																	

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp assembly

1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6188-0407 (W) to Receiver base then lock. Continue to set the harness in jig. Last, set the end of G-B/W hotmelted wires together within the stopper then press by Toggle clamp. Continue if the sequence light in location 1 was ON.

2. Check if all LED light for POWER ON, CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.

3. Initially tighten the band clamp on location 1 using both hands.

4. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 2 was ON.

Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$

Fixed setting of band clamp cutter: 3 ~ 4

BANDO GUN POSITION ON CLAMP LOCATION 1

BANDO GUN ALIGNMENT

PERPENDICULARITY

GOOD NG

OK NG

GOOD NG

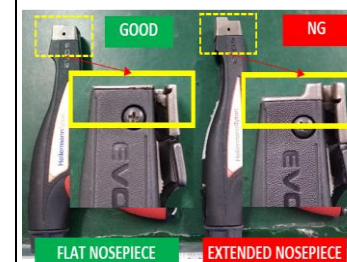
FLAT NOSEPIECE EXTENDED NOSEPIECE



Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig



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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp assembly
(Continuation)

CONNECTOR SETTING

RECEIVER BASE



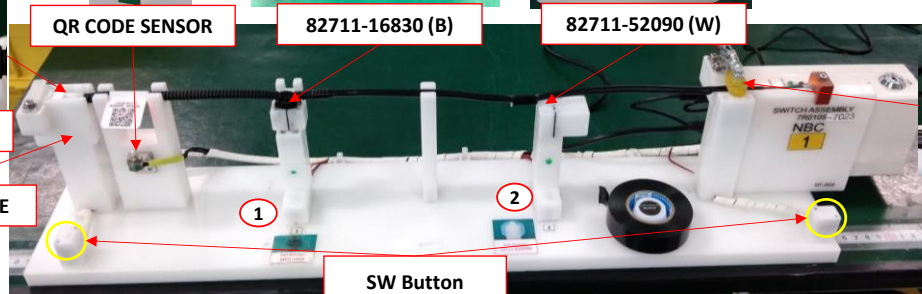
QR CODE SENSOR



82711-16830 (B)



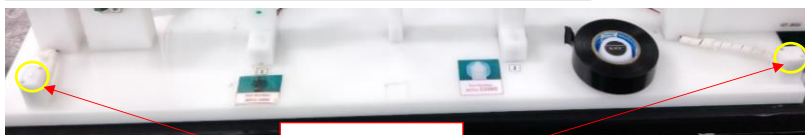
82711-52090 (W)

SW Button
For LABEL only

5. Hold the tape on clamp location **2** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue on label attachment (*Refer to next page for label attachment procedure*)

6. For label attachment, **label sensor** will beep/buzz if detects the **label code**. After attachment, press the **SW button** using both index finger (**same timing**). **Go** sound will be heard.

7. Conduct **POINT CHECKING** before removing the harness from jig.

SW Button
For LABEL only

STOPPER

n/a



Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

1. No loose/tight clamp attached
2. No damage clamp
3. No missed tape
4. No missing parts
5. Make sure no clearance between PCB and stopper jig

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PARTS:		1. Assy parts 2. Label 7V3010-0020			05	JIG	1. Clamp Assembly jig 2. Label Dispenser																			
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS																		
5	P2	Label attachment	<table border="1"><thead><tr><th>Model</th><th>Items</th><th>Item Name</th></tr></thead><tbody><tr><td>7R0102</td><td>73240-0C140</td><td>Driver Manual</td></tr><tr><td>7R0103</td><td>73240-0C150</td><td>Driver Power</td></tr><tr><td>7R0104</td><td>73240-0C160</td><td>Driver PWR-MEM</td></tr><tr><td>7R0105</td><td>73230-0C170</td><td>Passenger Manual</td></tr><tr><td>7R0106</td><td>73230-0C180</td><td>Passenger Power</td></tr></tbody></table> <div><div><div>05</div><div>Model code</div></div><div><div>73230 0C170 PASSENGER MANUAL</div><div>Item no. & name</div></div><div><div>1. Get the label. Note: Check the model code, item no. & name</div></div></div> <div><div><div>2.Align the end part of label in the jig.</div><div><div>3.Fold the center part of the label</div></div></div><div><div><div>4. Align both end part of label .</div><div><div>5.After alignment , Press the label with both fingers .</div></div></div><div><div><div>6. Press the label upside down using finger.</div><div><div>Acceptable overlap 0~1mm</div><div>GOOD</div></div></div><div><div><div>NG</div></div></div></div></div></div>				Model	Items	Item Name	7R0102	73240-0C140	Driver Manual	7R0103	73240-0C150	Driver Power	7R0104	73240-0C160	Driver PWR-MEM	7R0105	73230-0C170	Passenger Manual	7R0106	73230-0C180	Passenger Power	n/a	<div><div>1. No bubbles 2. No damage 3. No peel off 4. No wrong use of label 5. No missing parts 6. No loose attachment 7. No wrong usage of label</div><div></div></div>
Model	Items	Item Name																								
7R0102	73240-0C140	Driver Manual																								
7R0103	73240-0C150	Driver Power																								
7R0104	73240-0C160	Driver PWR-MEM																								
7R0105	73230-0C170	Passenger Manual																								
7R0106	73230-0C180	Passenger Power																								

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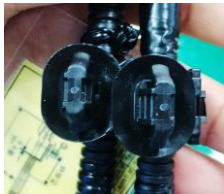



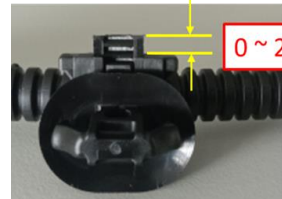
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PARTS:		n/a	JIG		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Visual/By two's inspection	<div><p>ACTUAL PRODUCT</p><p>Master sample</p><p>Assembled parts</p><p>2. Check the terminal, insertion and the presence of Barcode attachment.</p><p>05</p><p>3. Check the presence of clamp attachment.</p><p>4. Check the presence of clamp attachment and taping condition.</p><p>5. Conduct bending and check the taping condition from COT to tube.</p><p>6. Check the taping condition and the terminal appearance.</p></div>		 <p>1. No skip checking during inspection</p>  <p>0 ~ 2mm</p> <p>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.</p>

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PARTS:

n/a

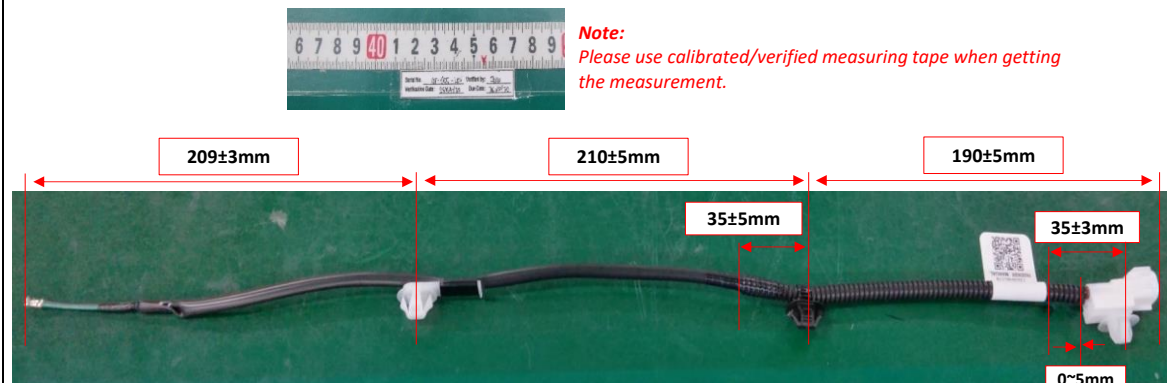
JIG

n/a

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

7

Measurement

**Important reminders/Note/s:**
1. FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

P2

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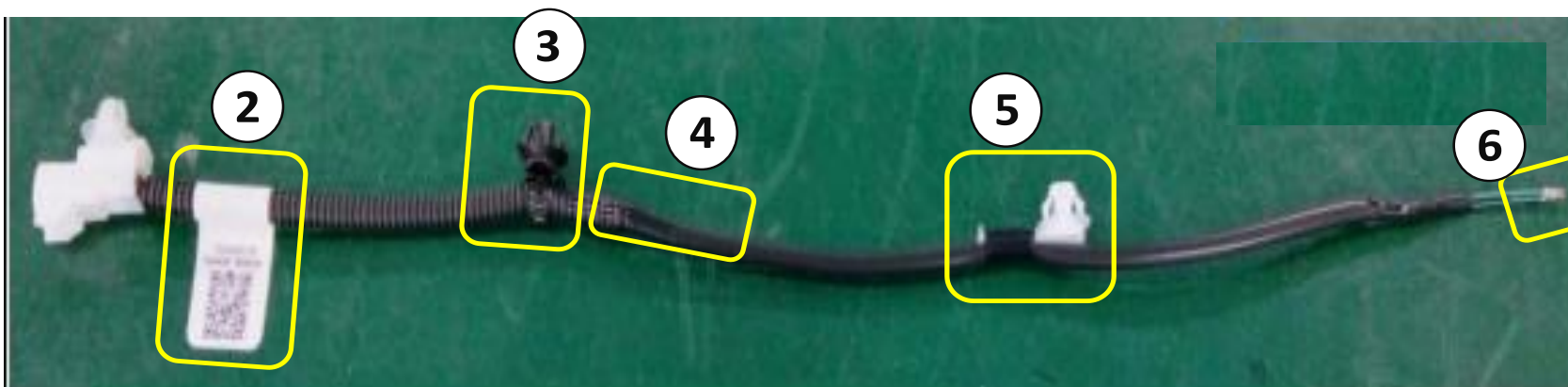
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PARTS:

1. Assy parts

JIG

n/a

**QUALITY CHECKPOINTS****P2****7R0105-7023A****GOOD****NO GOOD****2** No Missing Tape/ Wrong use of Barcode**6** No Deformed Terminal**1** No Unlock Connector**3** **5** No Missing Common/Band Clamp**7** Checking of loose/tight band clamp attachment**4** No Missing Tape

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