

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**April 29, 2023**Product Name/Code: **920B / 7R0119-7020**Customer: **TRMX**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-637B**

Revision No.:

**1**

Page No.:

**1 of 9****PARTS:**

1. Assy parts: Clamp 82711-3A640 (B); Clamp 82711-26380 (BR); Black tape

JIG:

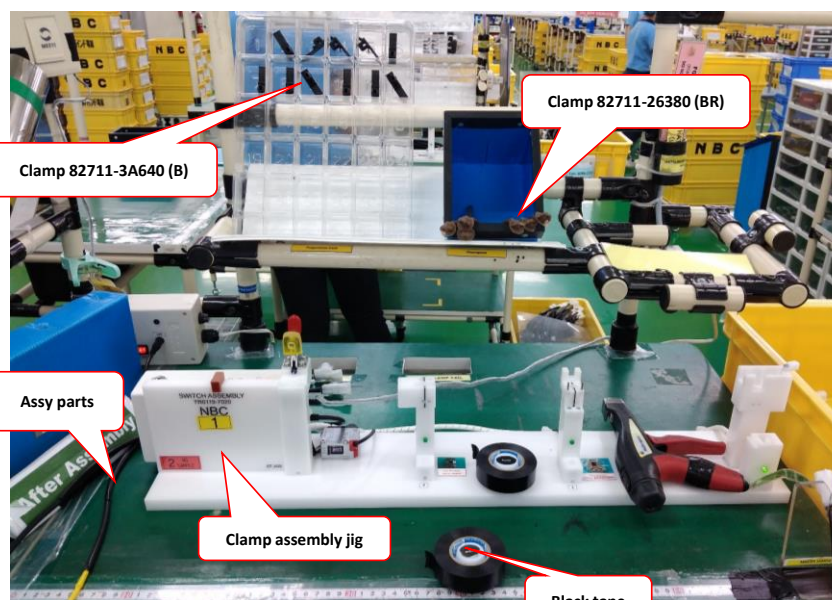
1. Clamp assembly jig

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

1

P2

Table Lay-out

**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.

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

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/29/23	1	Document purpose from prelaunch to masspro. Improve table lay-out. Improve work procedure and illustration due to improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
02/22/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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### PARTS:

1. Clamp 82711-3A640 (B)
2. Clamp 82711-26380 (BR)

3. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

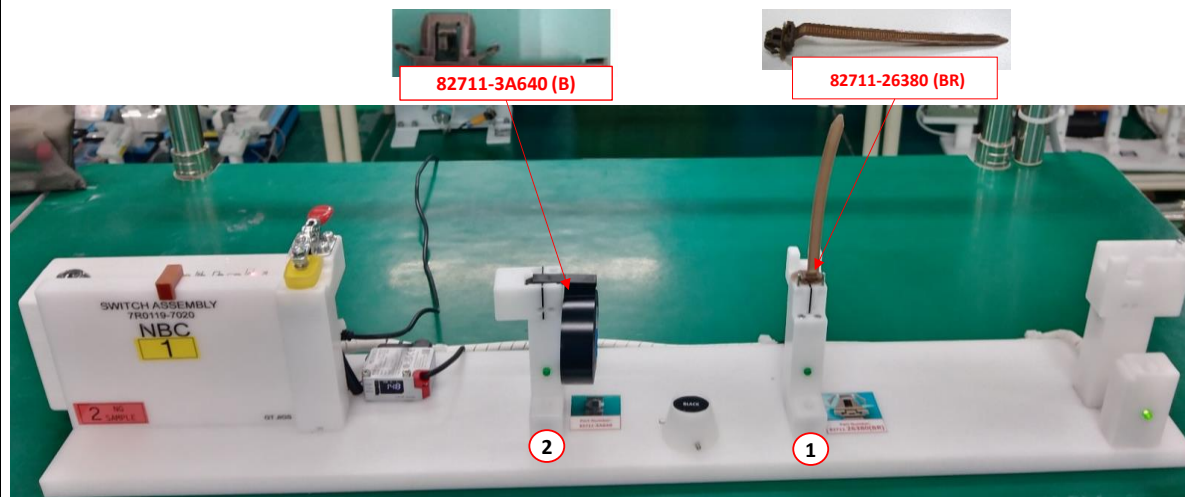
QUALITY POINTERS

2

P2

Clamp setting

1



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

2. Get 1pc. of clamp **82711-26380 (BR)** using both hands then set to clamp location **1** using both hands.

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

### STANDARD TAPING FOR CLAMP

One side tape under clamp

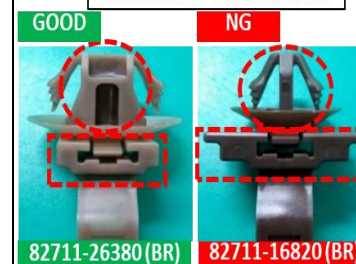


1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

### Important reminders/Note/s:

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

### BAND CLAMP ILLUSTRATION



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## PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

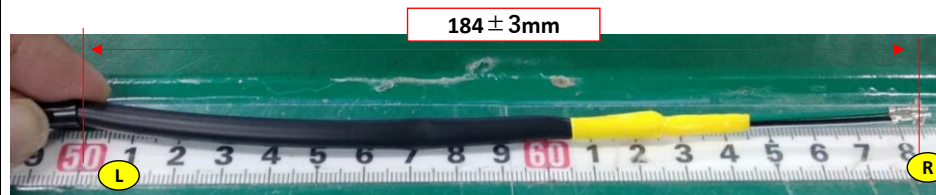
TOOLS/PPE

QUALITY POINTERS

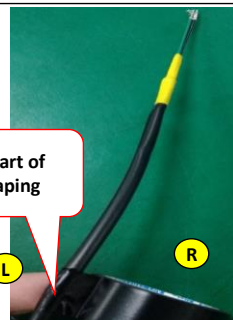
3

P2

Taping 1  
Black SV tube (Vinyl) to  
Black VM tube  
(Sunprene) near terminal



1. Measure from end of corrugated tube up to terminal pointed tip  $184 \pm 3\text{mm}$  using both hands.

Start of  
taping

2. Hold the corrugated tube and sunprene tube using left hand, get the **Black tape** then start taping process using both hands.



tape width

tape width

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

## MEASURING TAPE



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

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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2 1 Connector lock	<div>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</div> <div><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Double Double Double</p><p>Unlock Condition Half Lock Condition Full Lock Condition</p><p>Before lock After lock</p></div>			<div>LOCKING JIG</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided locking jig per model</p> <p>2. No unlock/half-locked connector</p> <p>3. No skip of locking process</p>

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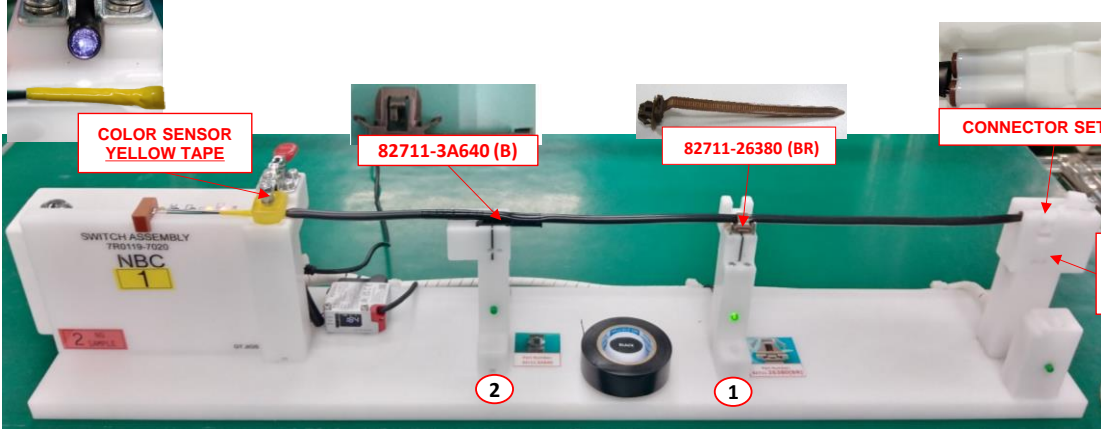

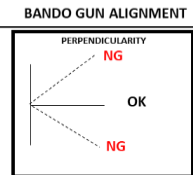

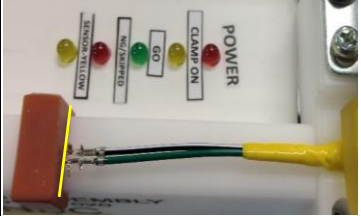

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

<b>PARTS:</b>		1. Assy parts 2. Black tape	<b>JIG</b>	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>1 WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P2 1 Clamp assembly	<div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Yellow tape. Last, set the terminal end together within the stopper then press by Toggle clamp.</p><p>2. Check if all LED light for Power On, Clamp ON, Sensor ON 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 location 1 using both hands.</p><p>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.</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 POSITION ON CLAMP LOCATION 1</p><p>GOOD NG</p><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY NG OK NG</p><p>Fixed setting of band clamp cutter: 3 ~ 4</p></div>	<div><p><b>Important reminders/Note/s:</b> 1. Make sure no gap in stopper and terminals</p><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div>

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME



### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

5

P2

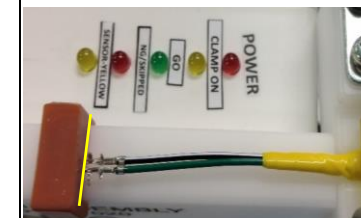


Clamp assembly



5. Hold the tape on clamp location **2**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard

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



### Important reminders/Note/s:

1. Make sure no gap in stopper and terminals

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P2

Visual/By two's inspection

**Master sample**

**Assembled parts**

**Master sample**

**ACTUAL PRODUCT**

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

3. Check the **presence of clamp attachment and band clamp cut.**

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

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

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

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

1. No skip checking during inspection.

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**PARTS:**

1. Assy parts

**JIG**

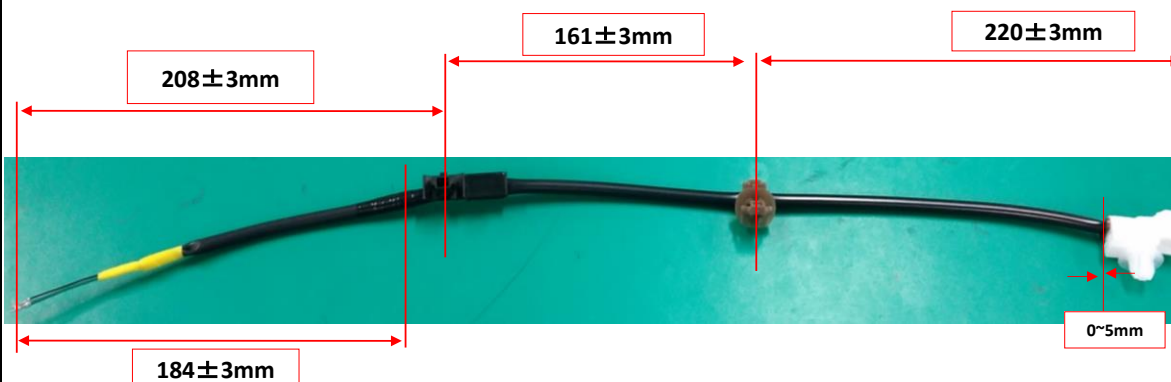
n/a

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

7

P2

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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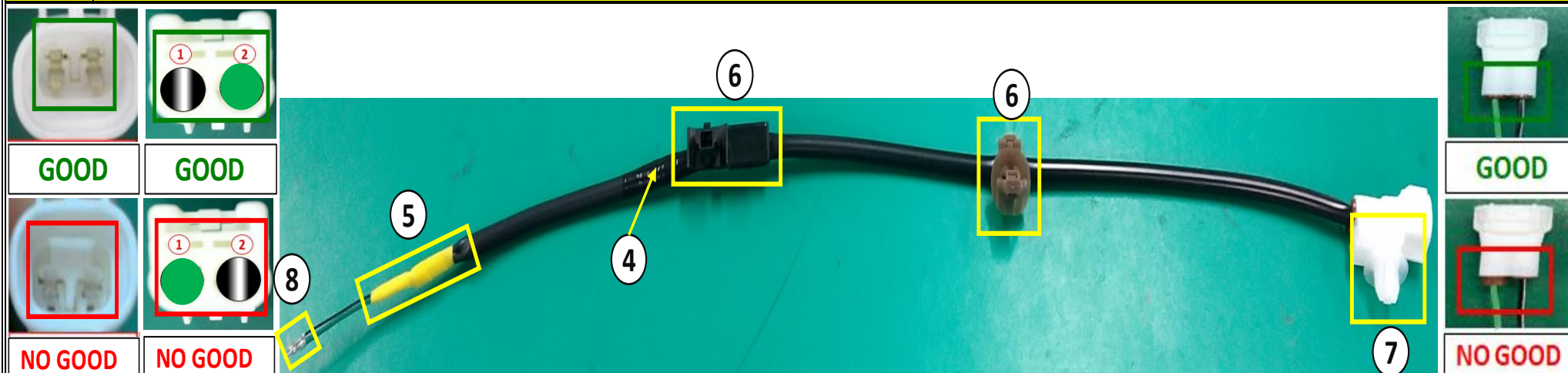
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**9 of 9****PARTS:**

1. Assy parts

**JIG**

n/a

**QUALITY CHECKPOINTS****P2****7R0119-7020**

- ① No Unlock/ Halflocked Connector    ④ No Missing tape    ⑦ No Missing clip clamp (1pc.)  
② No Wrong Insert    ⑤ No Wrong use of tape (Yellow tape)    ⑧ No Deformed Terminal  
③ No Terminal Backing Out    ⑥ No Missing clamp (2pc.)

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