

	<b>WORK INSTRUCTION</b>						Effectivity Date:		July 19, 2022		
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a		
	Process Name/Title:			Model Code/Part Number: <b>200D/220D / 7R0125-7021</b>			Customer: <b>TRMX</b>			Document No.: <b>WI-ENG-PDE-549</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1      Page No.:      1 of 5		

<b>PARTS:</b>	1. Assy parts: Clamp 82711-35730 (B); Black tape [2pcs.]				JIG:	1. Clamp assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; display: inline-block;">Table Lay-out</div>  </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <b>Safety Instruction</b>            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;"> <b>Housekeeping</b>            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;"> <b>Alert level</b>            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 document purpose from pre-launch to masspro. Additional table-layout and improve illustration.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes					
06/16/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 16, 2022							

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**July 19, 2022**Model Code/Part Number: **200D/220D / 7R0125-7021**Customer: **TRMX**

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**2 of 5****PARTS:**

1. Assy parts
2. Clamp 82711-35730 (B) [1pc.]

**JIG**

1. Clamp assembly jig

**NO.****PROCESS NAME****1****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P1

Clamp setting



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

1. Get 1 pc. of band clamp **82711-35730 (B)** then set to clamp location **1** using both hands.

2. Initially attach **Black tape** on clamp location **1** using both hands.

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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PROTOTYPE



PRE-LAUNCH



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**PARTS:**

1. Assy parts
2. Black tape

**JIG**

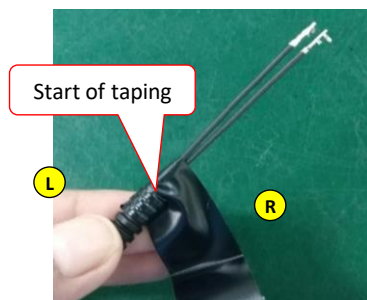
n/a

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

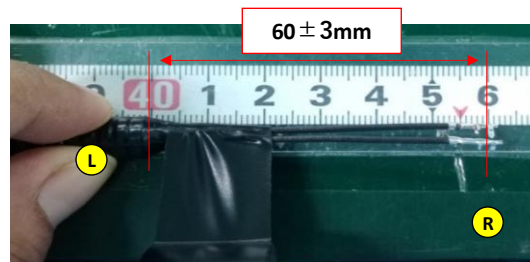
3

P1

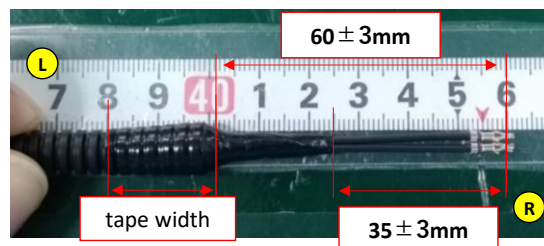
Taping 1  
COT to wire near terminal



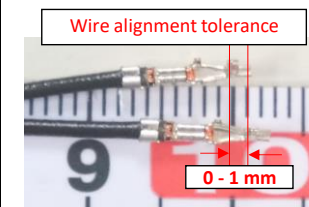
1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to terminal pointed tip **60±3mm** then continue the taping process using both hands.



3. After taping, check the measurement, taping condition and terminal appearance.

**MEASURING TAPE**

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

**Note:**

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

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**PARTS:**

1. Assy parts
2. Black tape

**JIG**

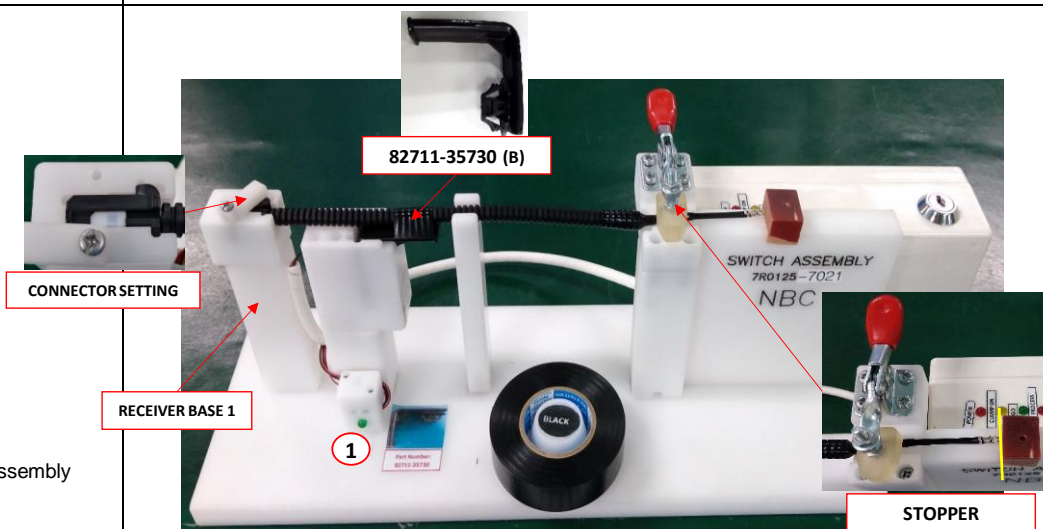
1. Clamp assembly jig

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

4

P1

Clamp assembly



n/a

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

1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector **6098-6663 (B)** in **Receiver base 1** then lock. Continue to set the harness in jig. 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**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

3. Hold the tape on clamp location **1** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. **Go** sound will be heard.

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

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/

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PROTOTYPE



PRE-LAUNCH



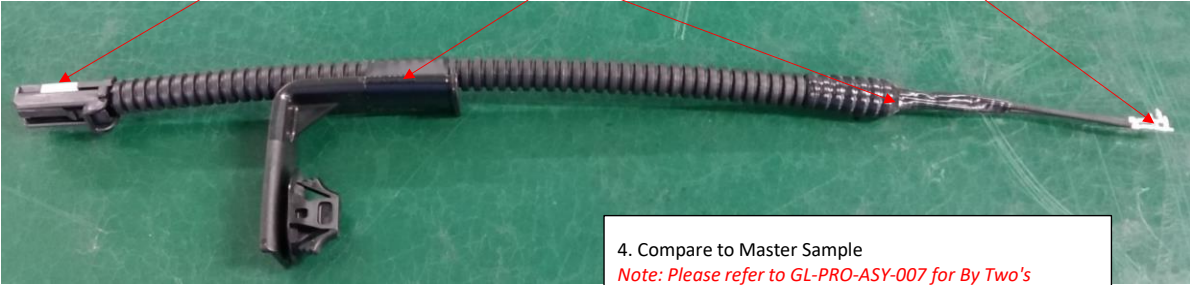


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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P1	<p>1. Check the double lock.</p> <p>2. Check the taping condition and clamp attachment.</p> <p>3. Check the terminal appearance, make sure no deformed terminal.</p> <p>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></p> 		<p>MASTER SAMPLE</p> 	
6		<p>1</p> <p>155±5mm</p> <p>100±5mm</p> <p>0~5mm</p> <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p> 		<p><b>NOTE: FOR HATSUMONO AND OWARIMONO</b></p> <p>1. No wrong dimension</p>	

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