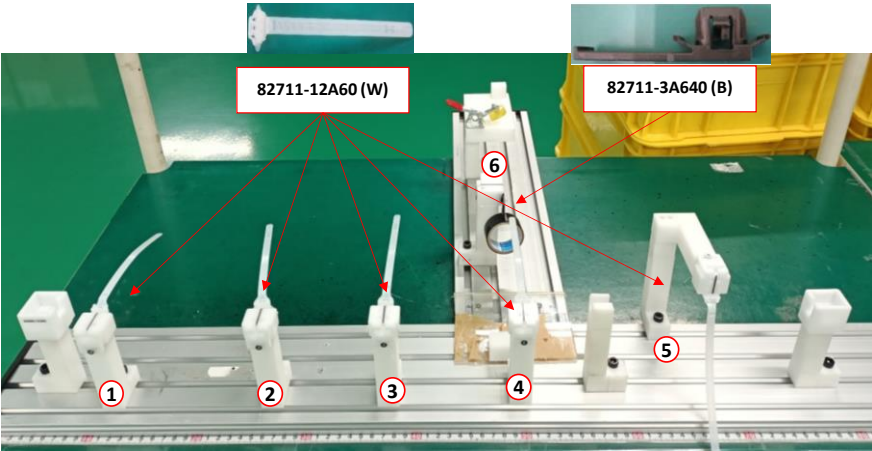


	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effec October 07, 2022		March 10, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: 920B / 7R0118-7021		Customer: TRMX		Document No.:		WI-ENG-PDE-645C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revis 2		0	Page No.: 1 of 6

PARTS:		1. Clamp 82711-12A60 (W) [5pcs] 2. Clamp 82711-3A640 (B) [1pc]		3. Black tape [1pc]		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P3	<div>  </div> <div> <div> 1. Get 3pcs. of clamp 82711-12A60 (W) then set to clamp location 1, 2 and 3 using both hands. </div> <div> 2. Get 2pcs. of clamp 82711-12A60 (W) then set to clamp location 4 and 5 using both hands. </div> <div> 3. Get 1pc. of clamp 82711-3A640 (B) then set to clamp location 6 using both hands. </div> <div> 4. Initially attach Black tape on clamp location 6 using both hands. </div> </div>				<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		<div> STANDARD TAPING FOR CLAMP  </div> <div> 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts </div> <div> Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp. </div> <div> BAND CLAMP ILLUSTRATION  </div>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
03/10/23 0 Initial issue								D.Castillo		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date Rev. No Details of Change								Revised		Reviewed		Approved		Noted	

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

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March 10, 2023

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☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

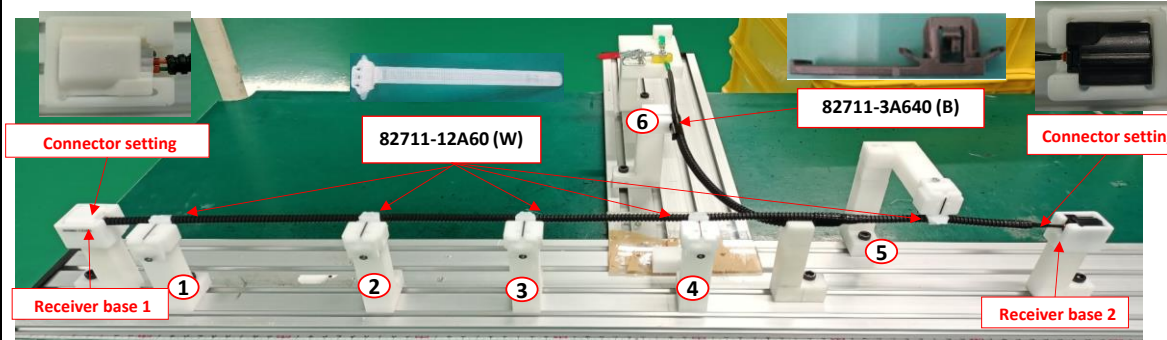
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp assembly



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 **Receiver base 1**. Second, set the harness in Y-taping guide. Third, set the connector **6189-1161 (B)** to **Receiver base 2**. Last, set the end of PCB within the stopper jig then press the toggle clamp.

2. Initially tighten the band clamp on clamp location **1, 2, 3, 4 and 5** using both hands.

3. Get the **Bando gun** using right hand then cut the clamp on location **1, 2, 3, 4 and 5** using both hands.

4. Hold the tape on clamp location **6**. Make **3 windings** of tape then cut the tape using both hands.

5. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

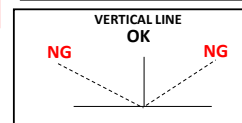
BAND CLAMP CUT POSITION FOR LOCATION 1,2,3 & 4



BAND CLAMP CUT POSITION FOR LOCATION 5



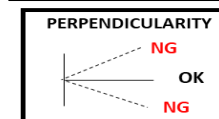
BANDO GUN ALIGNMENT



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

Fixed setting of band clamp cutter: 1~ 2

BANDO GUN ALIGNMENT



Important reminders/Note/s:

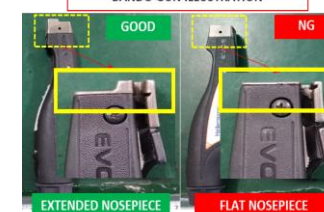
1. Make sure no gap between stopper and PCB

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

BAND CLAMP ILLUSTRATION



BANDO GUN ILLUSTRATION



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PARTS:

1. Assy parts
2. Engineering sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

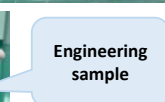
3

P3

Visual/By two's inspection

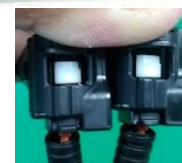
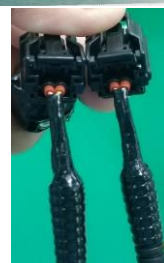


Assembled parts

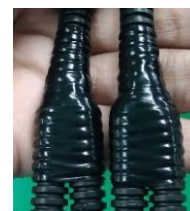


Engineering sample

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



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



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

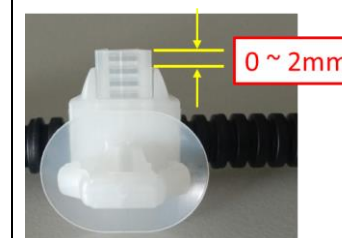


3. Check the **presence of ALL clamp attachment and cut appearance.**

**ENGINEERING
SAMPLE**



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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4 of 6**PARTS:**

1. Assy parts

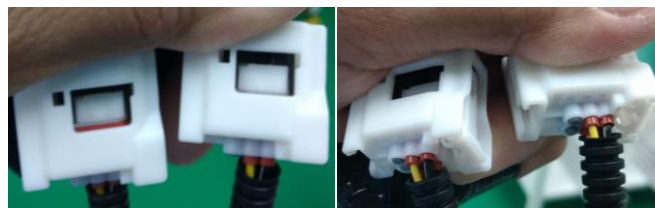
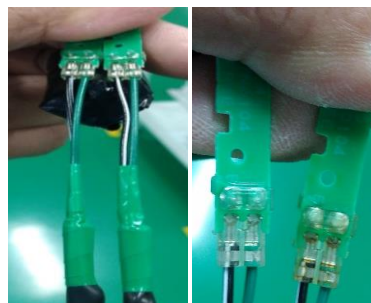
JIG

n/a

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

3

P3

Visual/By two's inspection
(Continuation)5. Check the **terminal, connector lock** condition and **insertion**.6. Check the **presence of clamp, taping condition of clamp and COT to VT taping condition**.7. Check the **tape color, taping condition and PCB appearance**.**ENGINEERING
SAMPLE**

1. No skip process

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

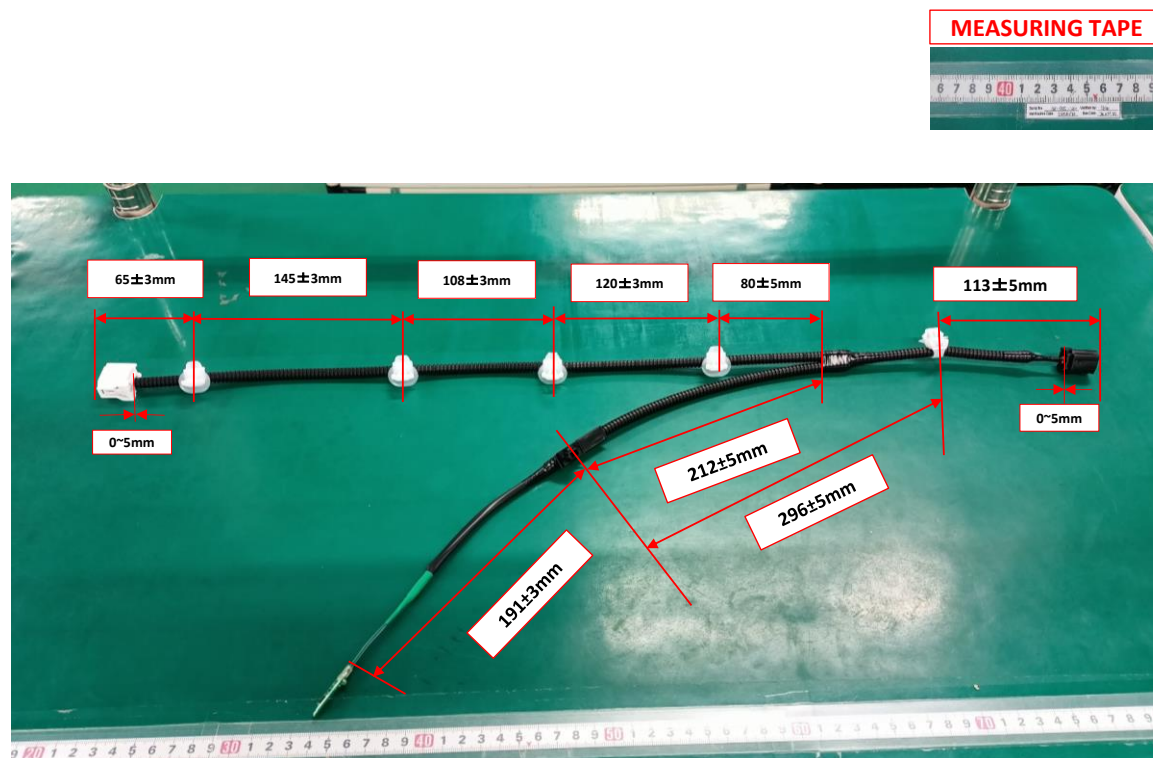
TOOLS/PPE

QUALITY POINTERS

4

P3

Measurement



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

1. No wrong dimension

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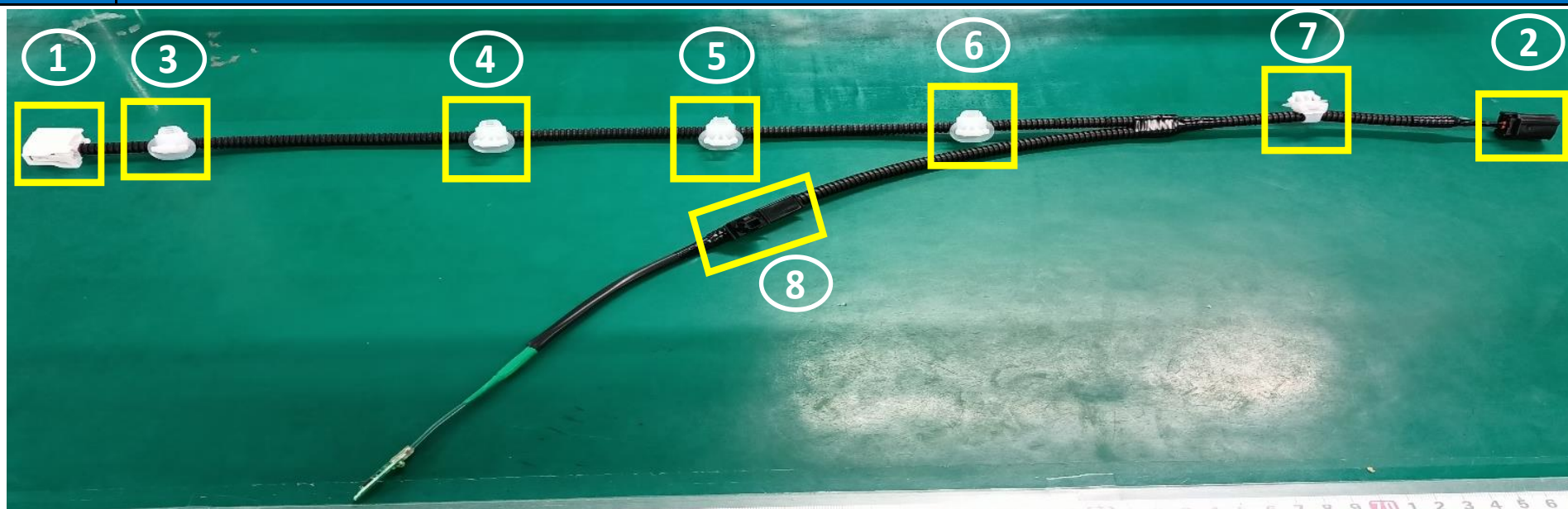
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PARTS:

n/a

JIG

n/a

QUALITY CHECKPOINTS**P3****7R0118-7021****1 2 No UNLOCKED/HALFLOCKED CONNECTOR****9 CORRECT FACING OF CLAMP****3 4 5 6 7 8 No MISSING CLAMP/BAND CLAMP**

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