

	<b>WORK INSTRUCTION</b>						Effectivity Date:		September 30, 2022	
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: <b>220D / 7R0127-7021</b>		Customer: <b>TRMX</b>		Document No.: <b>WI-ENG-PDE-550</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		2	Page No.:

<b>PARTS:</b>	1. Assy parts: Clamp 82711-16830 (B); Red tape [1pc.]						JIG:	1. Clamp assembly jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	<div style="border: 1px solid black; padding: 5px; display: inline-block; margin-bottom: 10px;">Table Lay-out</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <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: 10px;"> <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>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> <b>Document references:</b> <span style="border: 1px solid black; padding: 2px;">2</span>            1. Refer to WI-ENG-PDE-562 7R0127-7021 - Offline Assembly Process         </div> <div>           1. No missing parts/tools            2. No excess parts/tools         </div>

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/30/22	2	Improve quality pointers: References in process no.1,2,3,4,5 and 6 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.5 - visual/by two's inspection.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
07/19/22	1	Change document purpose from pre-launch to masspro. Additional table-layout, quality pointers and improve illustration.	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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**220D / 7R0127-7021**

Customer:

**TRMX**

Document No.:

**WI-ENG-PDE-550**

Purpose:



PROTOTYPE



PRE-LAUNCH



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**2 of 6****PARTS:**

1. Assy parts
2. Clamp 82711-16830 (B) [1pc.]

**JIG**

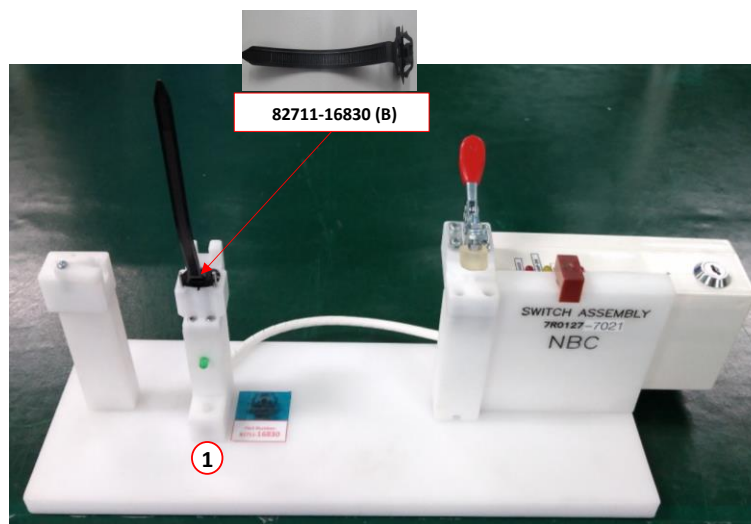
1. Clamp assembly jig

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

2

P1

Clamp setting



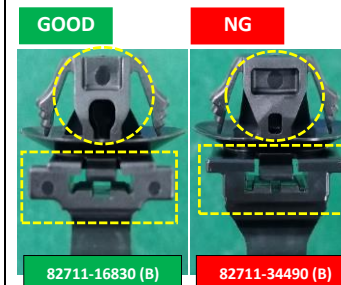
1. Get 1pc. of band clamp **82711-16830 (B)** then set to clamp location **1** using both hands.

n/a

**2 Important reminders/Note/s:**

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

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

**BAND CLAMP ILLUSTRATION**

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Purpose:

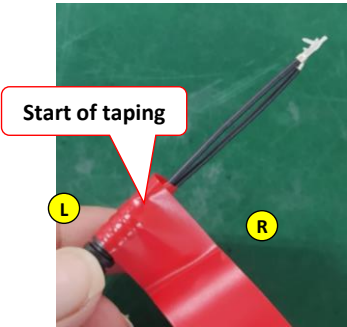
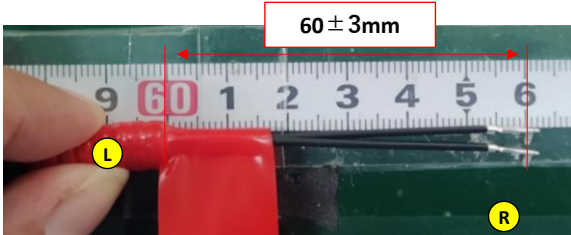
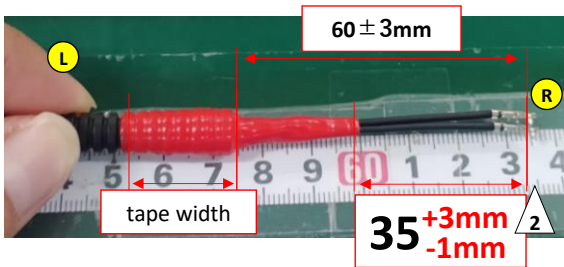

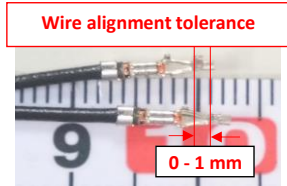
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Red tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 COT to wire near terminal	<div><p>1. Hold the COT using left hand, get the <b>Red tape</b> using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip <b>60±3mm</b> then continue the taping process using both hands.</p></div> <div><p>3. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>0 - 1 mm</p></div> <div>2</div> <div>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</div> <div><b>Important reminders/Note/s:</b> <b>1. USE RED TAPE ONLY</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></div> <div><b>Document references:</b> <b>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</b></div>

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## PARTS:

1. Assy parts

## JIG

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

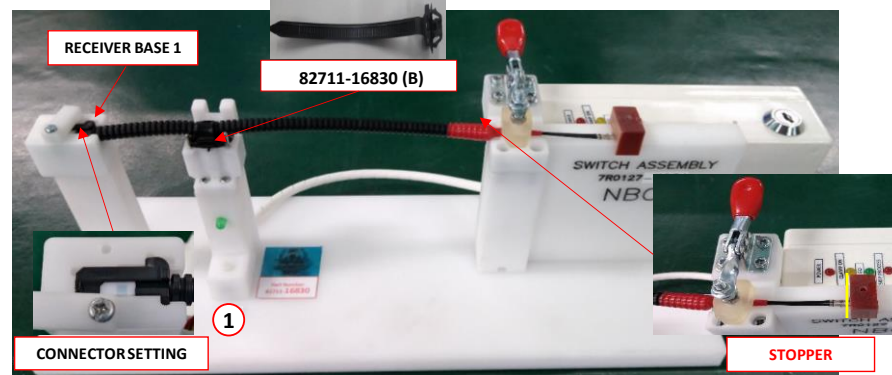
## TOOLS/PPE

## QUALITY POINTERS

4

P1

Clamp assembly



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

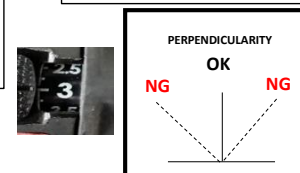
3. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Go sound will be heard.

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



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.

## BANDO GUN ALIGNMENT

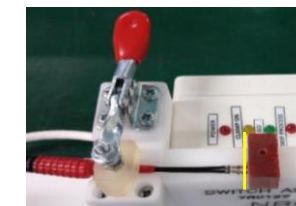


4. Conduct POINT CHECKING before removing the harness from jig.

## BANDO GUN



2

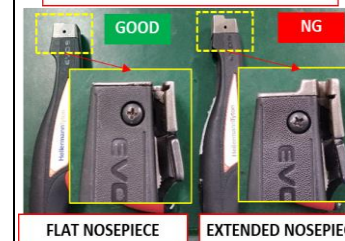


## Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

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

## BANDO GUN ILLUSTRATION



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☐ PRE-LAUNCH



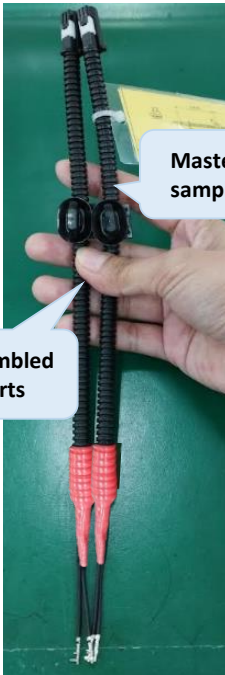



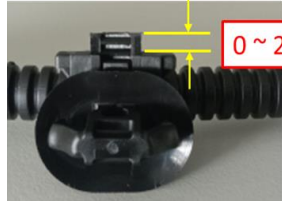
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PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div><div><p>ACTUAL PRODUCT</p></div></div>			<div><div><p>MASTER SAMPLE</p></div></div>
		<div><div><div><div><p>Master sample</p></div><div><p>Assembled parts</p></div></div><div><div><p>1. Conduct alignment of harness (<b>Master sample vs. assembled parts</b>) using both hands.</p></div></div></div></div> <div><div><div><p>2. Check the <b>connector lock</b> condition and <b>insertion</b>.</p></div><div><p>3. Check the <b>presence of clamp attachment</b>.</p></div><div><p>4. Check the <b>taping condition</b> and <b>terminal appearance</b>. Must be <b>no deformed terminal</b>.</p></div></div></div>	<div><div><div><p>0 ~ 2mm</p></div><div><p><b>Important reminders/Note/s:</b></p><p>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></div></div></div>		

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PARTS:	n/a				JIG	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P1	Measurement	<div><div>MEASURING TAPE</div><div></div></div> <div><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div></div>				<div><div>2</div><div>Important reminders/Note/s: 1. FOR HATSUMONO AND OWARIMONO</div></div> <div>1. No wrong dimension</div>

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