



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model Code/Part Number:

920B

/ 7R0116-7021

Customer:

TRMX

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

February 22, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-638B

Revision No.:

0

Page No.:

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## PARTS:

1. Clamp 82711-3A640 (B)
2. Black tape

JIG:

1. Temporary clamp assembly jig

## NO.

## PROCESS NAME

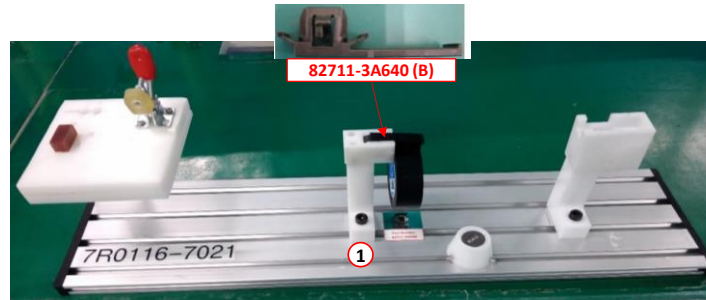
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

1

Clamp setting



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

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

**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.

**STANDARD TAPING FOR CLAMP**

One side tape under clamp



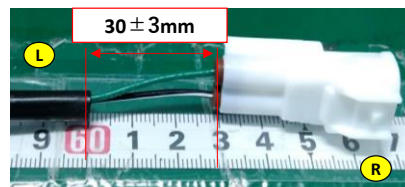
1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

**Important reminders/Note/s:**

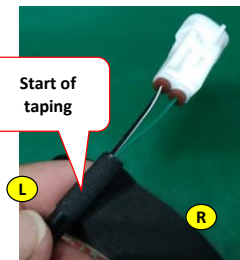
**1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.**

2

Taping 1  
Black tesa tape 51036 to wire  
near connector



1. Measure from end of Black SV tube (Vinyl) up to edge of connector **30±3mm** using both hands.



2. Hold the tube using left hand, get the **Black tesa tape 51036** using right hand then start taping process using both hands.

Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/22/23	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Prepared	Reviewed	Approved	Noted

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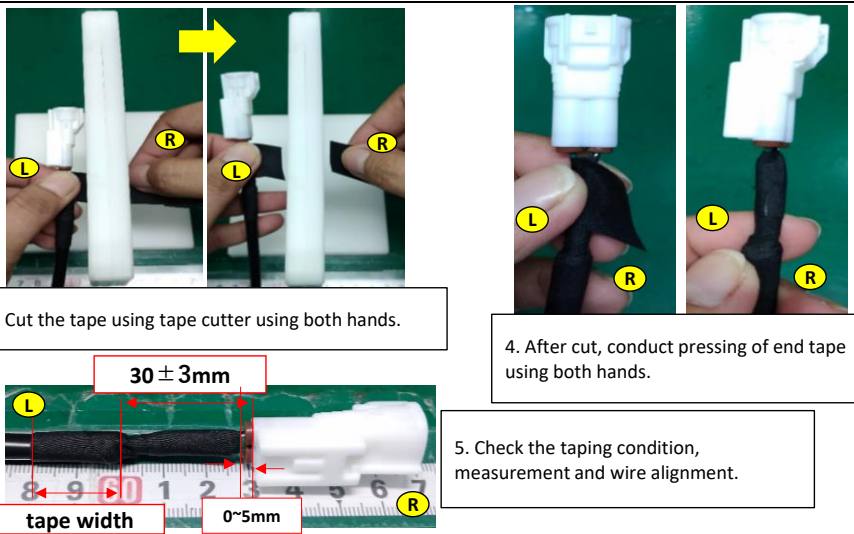

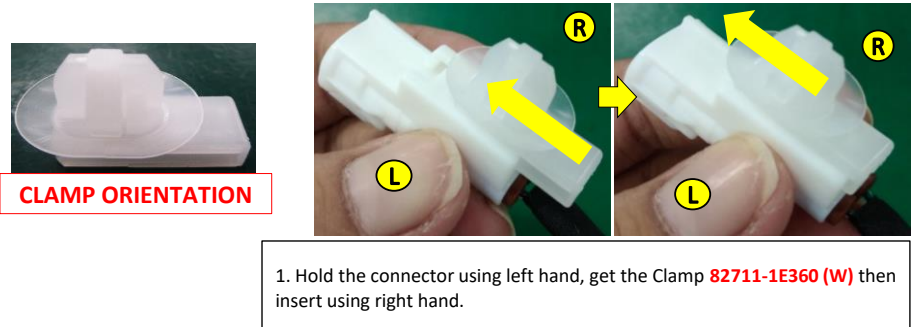
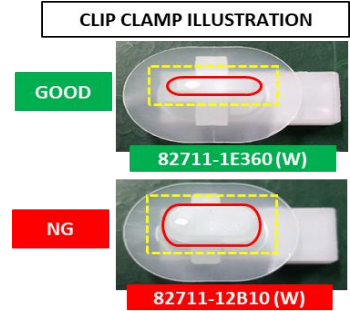
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### PARTS:

1. Assy parts
2. Black tesa tape 51036

### JIG


1. Tape cutter

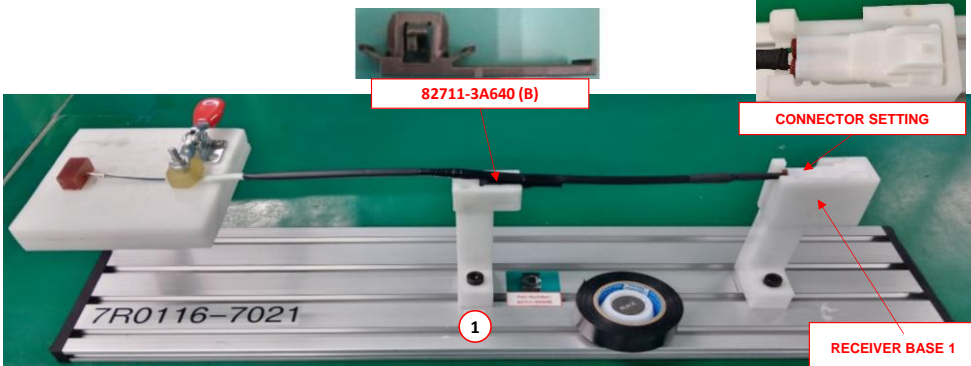
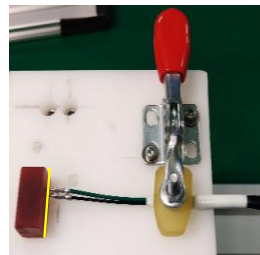
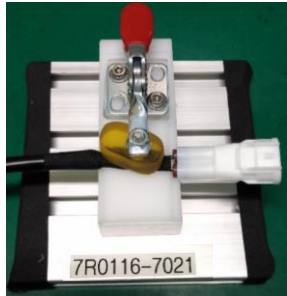

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Taping 1 Black tesa tape 51036 to wire near connector (Continuation)	 <p>3. Cut the tape using tape cutter using both hands.</p> <p>4. After cut, conduct pressing of end tape using both hands.</p> <p>5. Check the taping condition, measurement and wire alignment.</p> <p>30 ± 3mm</p> <p>tape width</p> <p>0~5mm</p>	 <p>MEASURING TAPE</p> <p>TAPE CUTTER</p>	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <p><b>Important reminders/Note/s:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>
3	Clip attachment 82711-1E360 (W)	 <p>CLAMP ORIENTATION</p> <p>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</p>	 <p>CLIP CLAMP ILLUSTRATION</p> <p>GOOD</p> <p>82711-1E360 (W)</p> <p>NG</p> <p>82711-12B10 (W)</p>	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No loose attachment</li></ol>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 6	

PARTS:		1. Assy parts 2. Clamp 82711-1E360 (W)  3. Black tape			JIG	1. Temporary clamp assembly jig 2. Pressing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Clamp assembly	<div></div> <div>1. Get the assy parts then set into jig. (<i>See above illustration</i>). First, set the connector <b>6098-0407 (W)</b> to <b>Receiver base 1</b>. Continue to set the harness in jig. Last, set the <b>G-B/W wires</b> to stopper then press by <b>toggle clamp</b>.</div> <div>2. Hold the tape on clamp location <b>1</b>. Make <b>3 windings</b> of tape then cut the tape using both hands.</div> <div>3. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div>				<div></div> <div><b>Important reminders/Note/s:</b> <b>1. Make sure no gap in stopper and terminals</b></div>
					<div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</div>	
5	Pressing jig	<div></div> <div>1. Conduct pressing of end tape by putting the assy parts into pressing jig, make sure that <b>end tape</b> must be <b>pressed</b>.</div>			<div></div> <div><b>PRESSING JIG</b></div>	<div><b>Important reminders/Note/s:</b> <b>1. Removal of assy parts from pressing jig will be done after producing the next assy parts.</b></div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong set-up</div>

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### PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

n/a

Visual/By two's inspection

**Engineering sample**

**Assembled parts**

**ACTUAL PRODUCT**

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

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

3. Check the **taping condition of tesa tape.**

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

n/a

Measurement

**MEASURING TAPE****Note:***Please use calibrated/verified measuring tape when getting the measurement.***392±5mm****208±5mm****184±3mm****0~5mm****Important reminders/Note/s:****1. FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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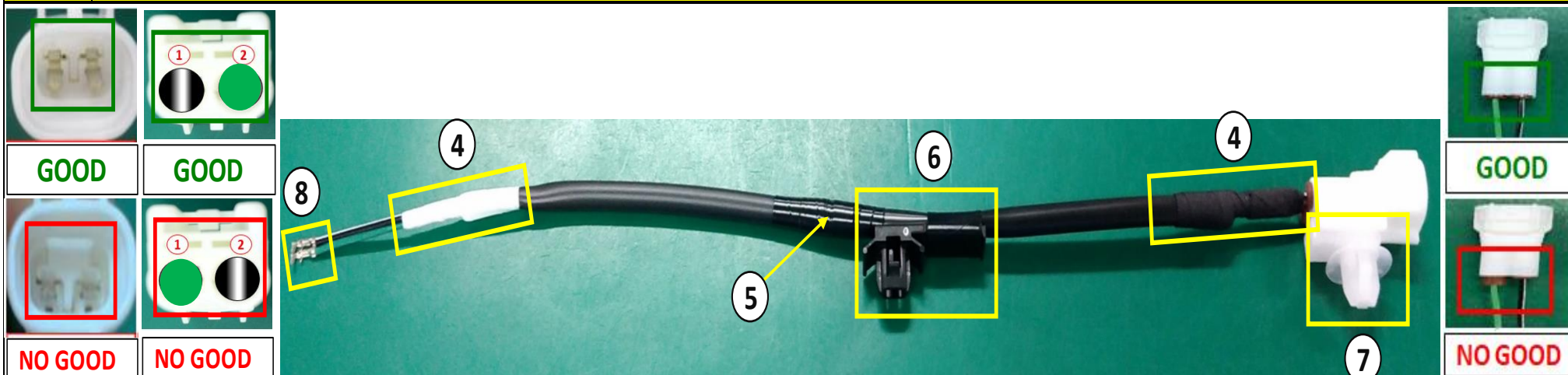
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**PARTS:**

1. Assy parts

**JIG**

n/a

**QUALITY CHECKPOINTS****P2****7R0116-7021**

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

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