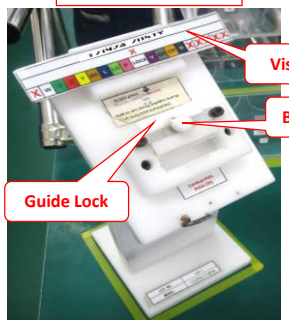
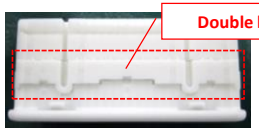
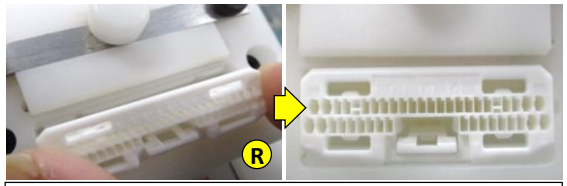
	WORK INSTRUCTION			Effectivity Date:	May 05, 2022
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Product Name/Code:	014B / 17J924-7051Y	Customer: NBS	Document No.:	WI-ENG-PDE-493A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 Page No.: 1 of 3

PARTS:	1. Connector 1827842-1 (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Connector setting to insertion jig 1827842-1 (W)	   1. Get the connector **1827842-1 (W)** using right hand then set to insertion jig. ***Note: Follow the connector orientation.***   2. Press the guide lock button using left index finger.	**Safety Instruction** Be sure to wear prescribed 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. **Finger COTS** 	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 5. No half-locked connector **Note:** Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. **Note:** If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process. Do not attempt to repair. 

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted
05/05/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/28/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Est. Date:	April 28, 2022		

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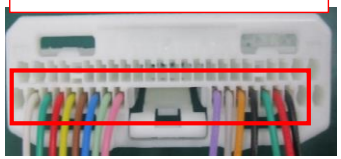
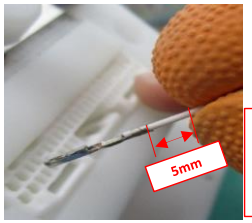
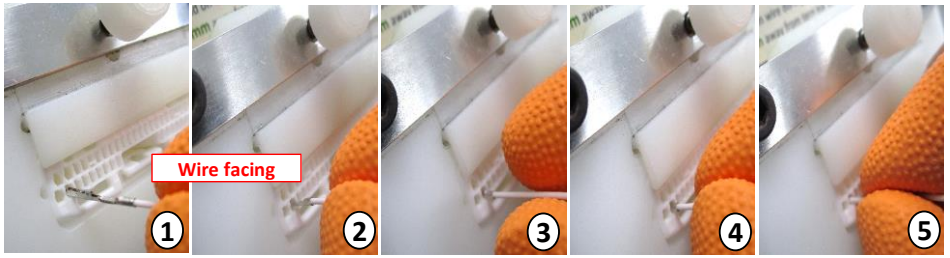
	Product Name/Code: **014B / 17J924-7051Y**	Customer: **NBS**		Document No.:	**WI-ENG-PDE-493A**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 Page No.: 2 of 3

PARTS:	1. CIVUS 0.13 W L=183±2mm; G L=186±2mm; R L=184±2mm; Y L=180±2mm; BR L=178±2mm; L L=184±2mm; LG L=176±2mm; P L=177±2mm; V L=177±2mm; GR L=179±2mm; OR L=181±2mm; B L=181±2mm; G L=1±193mm; R L=192±2mm; B L=193±2mm;	**JIG**	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector (Group 1 & 3 wires) 1827842-1 (W)	**WIRE INSERTION ILLUSTRATION**  **GOOD** Smaller terminal  **NG** Long terminal **Wire facing**  **Note: Hold on wire during insertion must be 5mm away from terminal end.**  **Wire facing** 1. Get the wire and hold it **5mm** away from terminal. 2. Half insert the wire. 3. Release wire to check the color. 4. Hold again **5mm** away from terminal 5. Fully inserted wires (avoid bending during insertion) ***Note: Follow the insertion sequence based on the visual reference***	*Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* **Finger COTS** 	1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted. 5. Must have slight MOVEMENT after insertion 6. No bend terminal/wires **Note: Make sure wires are properly inserted.** **Conduct Pull-Push-Pull-Push after insertion.** **Do not exert extra force.** **Note:** Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. **Note:** If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process. Do not attempt to repair.

17J924-7051Y

X																	
X	W	G	R	Y	BR	L	LG	P	LOCK	V	GR	OR	B	G	R	B	X	X
-	183	186	184	180	178	184	176	177	-	177	179	181	181	193	192	193	-	-

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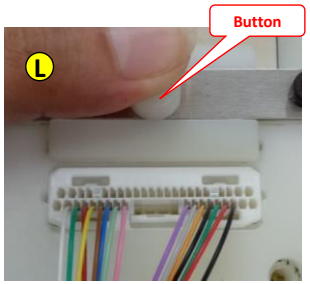
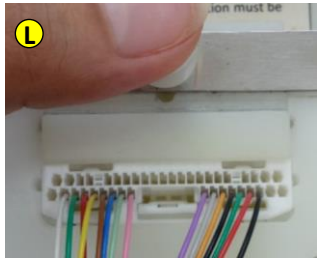
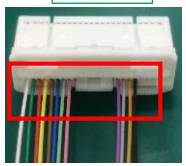
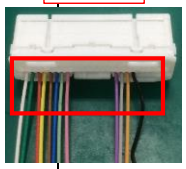
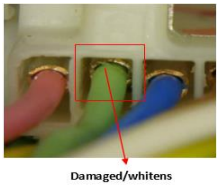
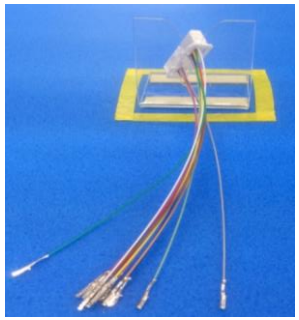
PARTS:	1. Assy parts	**JIG**	1. WIP Holder

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector (Group 1 & 3 wires) 1827842-1 (W) (Continuation)	 BEFORE PRESSING  AFTER PRESSING  6. Press the button using left thumb. 7. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.	Finger COTS  GOOD  NG  	1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted. 5. Must have slight MOVEMENT after insertion 6. No bend terminal/wires
3		Pass WIP to P2	 1. Pass WIP to WIP Holder. **Note: One piece flow.**	WIP HOLDER 	1. No WIP overflow

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