

	WORK INSTRUCTION						Effectivity Date:		May 04, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 014B / 17J796-7051Y		Customer: NBS		Document No.: WI-ENG-PDE-492B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.:

PARTS:	1. Assy parts				JIG:	1. Insertion jig 2. Adaptor jig holder							
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS						
1	P2	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>Connector setting to insertion jig (Assy parts) 1827842-1 (W)</p> </div> <div style="width: 45%;"> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>1. Get the connector 1827842-1 (W) (Assy parts) using right hand then set to insertion jig. <i>Note: Follow the connector orientation.</i></p> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>2. Press the guide lock using left index finger.</p> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div> <div style="text-align: center; margin-top: 10px;"> <p>Finger COTS</p> </div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <p><i>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</i></p> </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <p><i>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.</i></p> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>GOOD</p> <p>UNLOCK</p> </div> <div style="text-align: center;"> <p>NG</p> <p>HALF-LOCKED</p> </div> </div>			

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
05/04/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang		 J. Loterte		 C. Villanueva		 A. Arañes		
04/29/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	April 29, 2022							

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PARTS:

1. Assy parts
2. CIVUS 0.13 W L=183±2mm; Y L=178±2mm; G L=181±2mm; R L=178±2mm; BR L=176±2mm; L L=175±2mm; LG L=176±2mm; P L=175±2mm; V L=185±2mm; B L=179±2mm; GR L=179±2mm;

JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																		
2	P2	Wire insertion to connector (Group 2 wires) 1827842-1 (W)	<div>WIRE INSERTION ILLUSTRATION</div> 	<div>17J796-7051Y</div> <table><tr><td>W</td><td>Y</td><td>G</td><td>R</td><td>BR</td><td>L</td><td>LG</td><td>P</td><td>V</td><td>B</td><td>GR</td></tr><tr><td>183</td><td>178</td><td>181</td><td>178</td><td>176</td><td>175</td><td>176</td><td>175</td><td>185</td><td>179</td><td>179</td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td></tr></table>	W	Y	G	R	BR	L	LG	P	V	B	GR	183	178	181	178	176	175	176	175	185	179	179	1	2	3	4	5	6	7	8	9	10	11	<div>Finger COTS</div> 	<div>GOOD SHORT terminal</div> <div>NG LONG terminal</div> <div>Wire facing</div> <div>Note: Hold on wire during insertion must be 5mm away from terminal end.</div> <div>Note: 5mm</div> <div>1. Get the wire and hold it 5mm away from terminal.</div> <div>2. Half insert the wire.</div> <div>3. Release wire to check the color.</div> <div>4. Hold again 5mm away from terminal</div> <div>5. Fully inserted wires (avoid bending during insertion)</div> <div>Note: Follow the insertion sequence based on the visual reference</div>	<div>1. No wrong wire insertion</div> <div>2. No terminal backing out</div> <div>3. No deformed terminal</div> <div>4. Make sure wires are properly inserted.</div> <div>5. Must have slight MOVEMENT after insertion</div> <div>6. No bend terminal/wires</div> <div>Note: Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</div> <div>Note: If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>Do not attempt to repair.</div>
			W	Y	G	R	BR	L	LG	P	V	B	GR																											
183	178	181	178	176	175	176	175	185	179	179																														
1	2	3	4	5	6	7	8	9	10	11																														
<div>1</div> <div>2</div> <div>3</div> <div>4</div> <div>5</div>																																								

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PARTS:

1. Assy parts
2. Black Sunprene tube $\phi 7$ L=55 \pm 5mm

JIG

1. Insertion jig
2. Adaptor jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Wire insertion to Black Sunprene tube $\phi 7$ L=55\pm5mm</p> <p>1. Get the Black sunprene tube $\phi 7$ L=55\pm5mm using left hand then insert the adaptor jig using right hand.</p> <p>2. Hold the Group 2 wires [11pcs.] using right hand.</p> <p>3. Insert the wires to Black sunprene tube using right hand.</p> <p>Use the adaptor jig to easily insert wires.</p>	<p>Adaptor jig</p> <p>Finger COTS</p>	<p>GOOD</p> <p>NG</p> <p>1. No wrong use of parts. 2. No remaining wires outside black sunprene tube 3. No cut tube</p> <p>STANDARD TUBE APPEARANCE</p> <p>GOOD NG</p>

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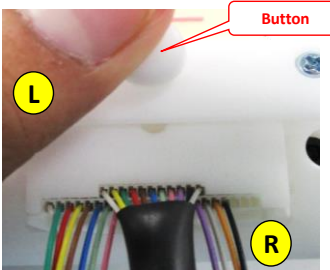
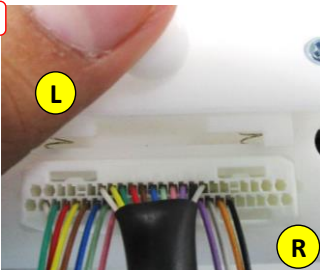




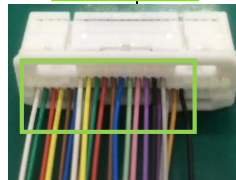

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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Wire insertion to Black Sunprene tube $\phi 7$ L=55\pm5mm (Continuation)</p> <div><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div> <div><p>5. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</p></div>		<p>4. Press the button using left thumb.</p> <p>Finger COTS</p> 	<p>1. No wrong use of parts 2. No remaining wires outside black sunprene tube 3. No cut tube</p> <p>STANDARD TUBE APPEARANCE</p> <div><p>GOOD</p></div> <div><p>NG</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div>

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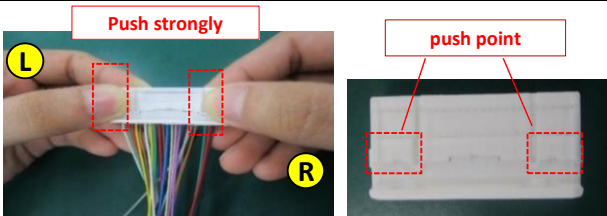
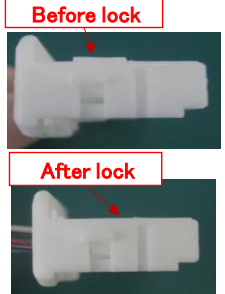
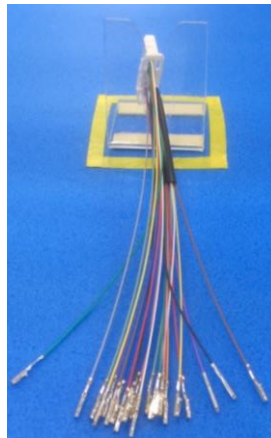

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PARTS:		1. Assy parts			JIG	1. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Connector lock	<div><div><p>1. Push the double lock using left & right thumb. (Same timing) 2. Check the connector lock after locking Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p></div><div></div></div>			n/a	1. No damaged double lock. 2. No half lock connector
5	P2 Pass WIP to P3	<div><p>1. Pass WIP to WIP Holder. Note: One piece flow.</p></div>			<div>WIP HOLDER</div> 	1. No WIP overflow

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