

	WORK INSTRUCTION					Effectivity Date:		May 05, 2022	
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Process Name/Title:			Product Name/Code: 014B / 17J924-7051Y		Customer: NBS		Document No.: WI-ENG-PDE-493D	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		1 Page No.: 1 of 4	

PARTS:	1. 4F1640-000 (W) 2. Assy parts					JIG:	1. Insertion jig						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	QUALITY POINTERS					
1	P4	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p style="text-align: center;">INSERTION JIG</p> <p style="text-align: center;">CONNECTOR ORIENTATION</p> <p style="text-align: center;">BEFORE PRESSING</p> <p style="text-align: center;">AFTER PRESSING</p> </div> <div style="width: 45%;"> <p style="text-align: center;">Holder</p> </div> </div> <div style="margin-top: 10px;"> <p>1. Get the connector 4F1640-000 (W) using right hand and set to insertion jig. <i>Note: Follow the connector orientation.</i></p> <p>2. Press the lower guide using left thumb finger.</p> <p>3. Set the Group 2 wires (11pcs) to holder using both hands and set the Group 3 wires (3pcs) to hook using right hand.</p> <p>4. Hold the Group 1 wires (12pcs) using right hand for insertion.</p> </div>					<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p style="text-align: center;">Finger COTS</p>		<p>1. No wrong wire inserted 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</p> <p><i>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</i></p> <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 style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> GOOD </div> <div style="text-align: center;"> NG </div> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> UNLOCK </div> <div style="text-align: center;"> HALF-LOCKED </div> </div>				

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
05/05/22	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		
04/28/22	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 28, 2022			

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DCC Stamp



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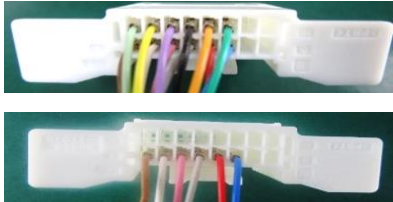

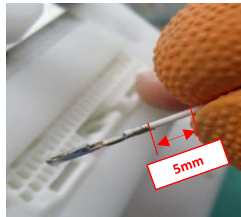
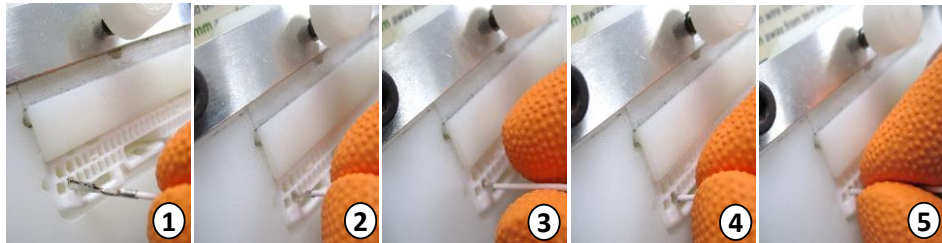
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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																				
2	P4	Wire insertion to connector (Group 1 wires) 4F1640-000 (W)	<div>WIRE INSERTION ILLUSTRATION</div> <div></div>	<div>WIRE FACING</div> <table><tr><td>SECOND ROW TO INSERT</td><td>LG</td><td>Y</td><td>V</td><td>B</td><td>OR</td><td>G</td><td>X</td><td>X</td></tr><tr><td></td><td>176</td><td>180</td><td>177</td><td>181</td><td>181</td><td>186</td><td>-</td><td>-</td></tr><tr><td>FIRST ROW TO INSERT</td><td>BR</td><td>W</td><td>P</td><td>GR</td><td>R</td><td>L</td><td>X</td><td>X</td></tr><tr><td></td><td>178</td><td>183</td><td>177</td><td>179</td><td>184</td><td>184</td><td>-</td><td>-</td></tr></table>	SECOND ROW TO INSERT	LG	Y	V	B	OR	G	X	X		176	180	177	181	181	186	-	-	FIRST ROW TO INSERT	BR	W	P	GR	R	L	X	X		178	183	177	179	184	184	-	-	<div>Finger COTS</div> <div></div>	<div>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</div>
			SECOND ROW TO INSERT	LG	Y	V	B	OR	G	X	X																															
	176	180	177	181	181	186	-	-																																		
FIRST ROW TO INSERT	BR	W	P	GR	R	L	X	X																																		
	178	183	177	179	184	184	-	-																																		
<div><div><div>Note: Hold on wire during insertion must be 5mm away from terminal end.</div></div><div><div>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</div><div></div></div></div>	<div>Note: Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</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. Do not attempt to repair.</div>																																									

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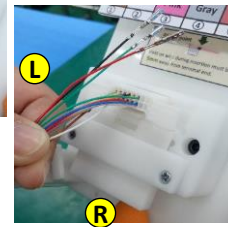

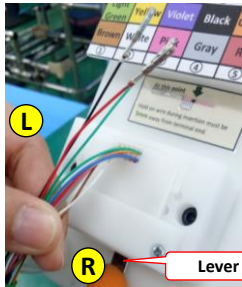
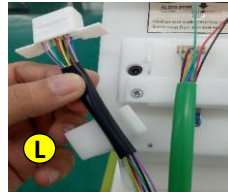
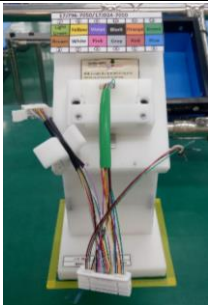


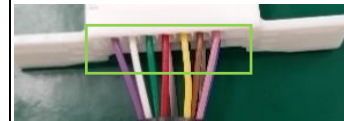
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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P4 Wire insertion to Green Sunprene tube (Group 3 wires)	<div></div> <div>1. Hold the Green sunprene tube using left hand. Get the Group 3 wires (3pcs) in the hook and insert to Green sunprene tube using right hand.</div> <div>2. Release the Group 2 wires (11pcs) (Assy parts) using left hand.</div> <div>3. Press the lever using right thumb.</div> <div>4. Hold the wires using left hand then gently pull the connector from jig. Check the insertion condition.</div> <div>Finger COTS</div>		<div>1. No wrong use of parts. 2. No remaining wires outside Green sunprene tube 3. No deformed terminal</div> <div></div>

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PARTS:

1. Assy parts

JIG

1. WIP Holder

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

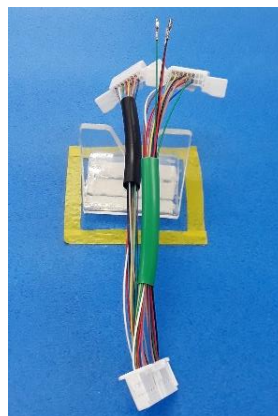
TOOLS/PPE

QUALITY POINTERS

4

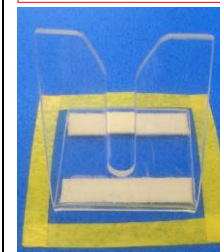
Pass WIP to P5

P4



1. Pass WIP to WIP Holder.
Note: One piece flow.

WIP HOLDER



1. No WIP overflow

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