



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Product Name/Code:

970A

/ 17J711-7051P

Customer:

NBC

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

August 12, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-299B

Revision No.:

0

Page No.:

1 of 4

PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P2

Connector setting to
insertion jig
(Assy parts)
1827842-1 (W)

INSERTION JIG

Visual reference

Button

Guide Lock

Double lock

CONECTOR ORIENTATION

Note: Check the connector before insertion.

1. Get the connector **1827842-1 (W) (Assy parts)** using right hand then set to insertion jig.
Note: Follow the connector orientation.

Guide Lock

BEFORE PRESSING

AFTER PRESSING

2. Press the guide lock 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.

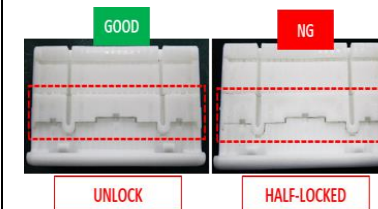
Finger COTS



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	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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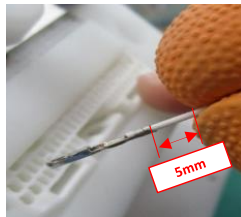
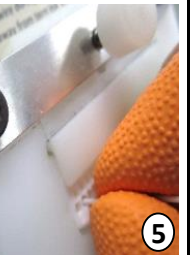



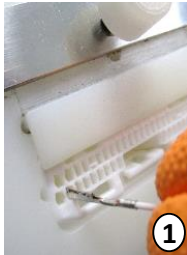

2 of 4**PARTS:**

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=180±2mm [GROUP 2 wires]

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><table><tr><th colspan="20">17711 (GROUP 2 WIRES)</th></tr><tr><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>-</td><td>Empty</td><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><td>Empty</td><td>Empty</td><td>-</td><td>Empty</td><td>Empty</td><td>Empty</td></tr><tr><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>-</td><td>Empty</td><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>180</td><td>Empty</td><td>Empty</td><td>-</td><td>Empty</td><td>Empty</td><td>Empty</td></tr><tr><td colspan="24">X</td></tr></table></div>	17711 (GROUP 2 WIRES)																				Empty	Empty	Empty	Empty	-	Empty	W	Y	G	R	BR	L	LG	P	V	B	GR	Empty	Empty	-	Empty	Empty	Empty	Empty	Empty	Empty	Empty	-	Empty	183	178	181	178	176	175	176	175	185	179	180	Empty	Empty	-	Empty	Empty	Empty	X																									<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></div>
			17711 (GROUP 2 WIRES)																																																																																												
Empty	Empty	Empty	Empty	-	Empty	W	Y	G	R	BR	L	LG	P	V	B	GR	Empty	Empty	-	Empty	Empty	Empty																																																																									
Empty	Empty	Empty	Empty	-	Empty	183	178	181	178	176	175	176	175	185	179	180	Empty	Empty	-	Empty	Empty	Empty																																																																									
X																																																																																															
<div><div><div>GOOD Smaller terminal</div><div></div><div>NG Long terminal</div><div></div></div><div><div>Wire facing</div><div></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>Finger COTS</div> <div></div>	<div>Note: Refer to GL-PRO-ASY-028 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. Do not attempt to repair.</div>																																																																																													

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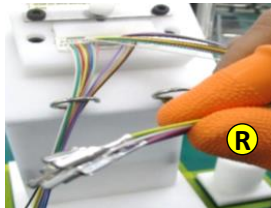
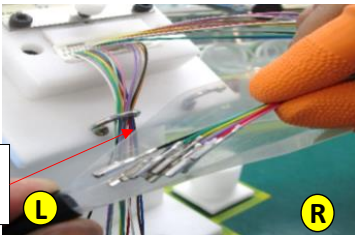

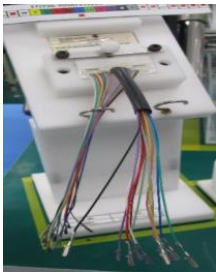





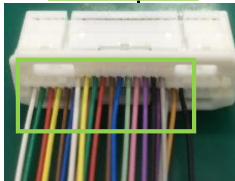
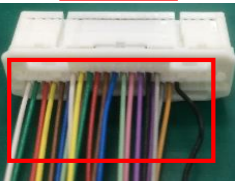


☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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PARTS:		1. Assy parts 2. Black Sunprene tube $\phi 7$ L=55 \pm 5mm		JIG	1. Adaptor jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black Sunprene tube $\phi 7$ L=55 \pm 5mm	<div><div><div></div><div></div></div><div><div><div></div><div></div></div><div><div><div></div><div></div></div><div><div><div></div><div></div></div><div><div></div><div></div></div></div><div><div><div><div>1. Get the Black sunprene tube $\phi 7$ L=55\pm5mm using left hand then insert the adaptor jig using right hand.</div><div>2. Hold the Group 2 wires (11pcs) using right hand.</div><div>3. Insert the wires to Black sunprene tube using right hand.</div><div>4. Press the button using left thumb.</div><div>5. Hold the wires using right hand then gently pull the connector from jig. Check the insertion condition.</div></div><div><div>Use the adaptor jig to easily insert wires.</div><div>2. Insert the wires to Black sunprene tube using right hand.</div></div></div></div><div><div><div>Adaptor jig</div><div>Finger COTS</div></div></div><div><div><div><div>GOOD</div><div>NG</div></div><div><div></div><div></div></div></div></div><div><div>1. No wrong use of parts. 2. No remaining wires outside Black sunprene tube 3. No cut tube</div><div>STANDARD TUBE APPEARANCE</div><div><div></div><div></div></div></div></div></div></div>			

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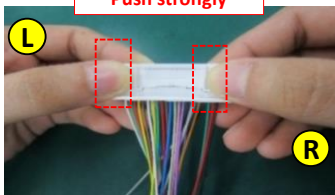
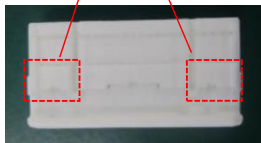
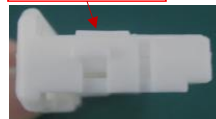

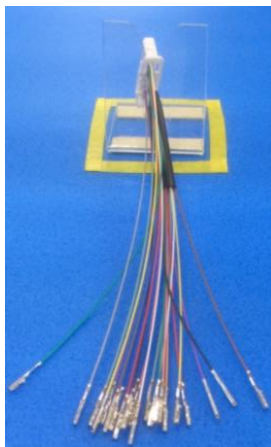
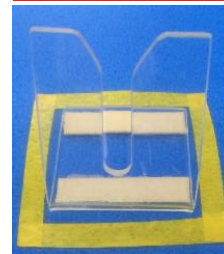
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PARTS:

1. Assy parts

JIG

1. WIP Holder

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

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