

	<b>WORK INSTRUCTION</b>						Effectivity Date:		May 04, 2022	
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: <b>014B / 17J796-7051Y</b>		Customer: <b>NBS</b>		Document No.: <b>WI-ENG-PDE-492D</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1      Page No.:      1 of 3	

<b>PARTS:</b>	1. Connector 4F1640-000□ (W) 2. Assy parts				JIG:	1. Insertion jig				
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
1	P4	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> <div style="border: 1px solid red; padding: 5px; font-size: 0.8em;"> <p><b>Note:</b> Check the connector before insertion.</p> </div> </div> <p>1. Get the connector <b>4F1640-000□ (W)</b> using right hand then set to insertion jig. <i>Note: Follow the connector orientation.</i></p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> </div> <p>2. Press the guide lock using right thumb.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> </div> <p>3. Hold the <b>Group 1 wires (12pcs.)</b> using right hand then put the <b>Group 2 wires (11pcs.) (assy parts)</b> in holder using left hand.</p>				<div style="border: 1px dashed red; padding: 5px; font-size: 0.8em;"> <p><b>Safety Instruction</b></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; font-size: 0.8em;"> <p><b>Housekeeping</b></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; font-size: 0.8em;"> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div> <div style="border: 1px solid red; padding: 5px; font-size: 0.8em; margin-top: 10px;"> <p><b>Finger COTS</b></p> </div>		<div style="border: 1px solid red; padding: 5px; font-size: 0.8em; margin-bottom: 10px;"> <p><b>Note:</b> If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process. Do not attempt to repair.</p> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p style="background-color: green; color: white; padding: 2px;">GOOD</p> </div> <div style="text-align: center;"> <p style="background-color: red; color: white; padding: 2px;">NG</p> </div> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="border: 1px solid red; padding: 2px; width: 40px; text-align: center;">UNLOCK</div> <div style="border: 1px solid red; padding: 2px; width: 40px; text-align: center;">HALF-LOCKED</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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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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**PARTS:**

1. Assy parts

**JIG**

1. Insertion jig

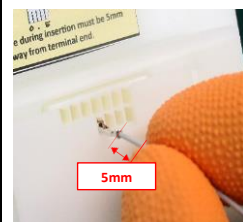
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P4

Wire insertion to connector  
(Group 1 wires)  
4F1640-000 (W)**WIRE INSERTION ILLUSTRATION****SECOND  
ROW TO  
INSERT**

7	8	9	10	11	12
LG	Y	V	B	OR	G
176	180	177	181	181	186
BR	W	P	GR	R	L
178	183	177	179	184	184
1	2	3	4	5	6

**FIRST  
ROW TO  
INSERT****WIRE FACING****Note: Hold on wire during  
insertion must be 5mm  
away from terminal end.**

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****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: Refer to GL-PRO-ASY-029  
for Pull-Push procedure.****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.**

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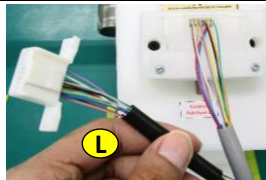
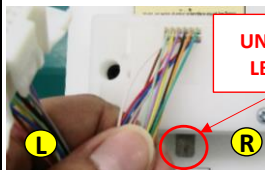
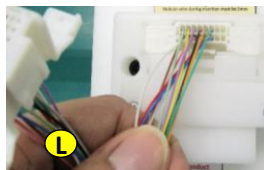


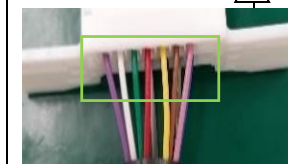
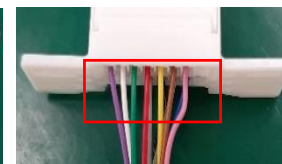
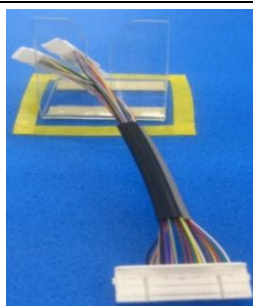
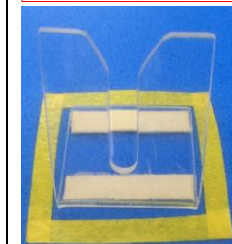
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:		1. Assy parts			JIG	1. Locking jig 2. WIP Holder	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
2	P4	Wire insertion to connector (Group 1 wires) 4F1640-000□ (W) (Continuation)	<div><p>6. Release the <b>Group 2 wires [12pcs.] (Assy parts)</b> using left hand.</p></div> <div><p><b>UNLOCK LEVER</b></p><p><b>BEFORE PRESSING</b></p></div> <div><p><b>AFTER PRESSING</b></p></div> <div><p>7. Press the unlock lever using right thumb.</p></div> <div><p>8. Hold the wires using left hand then gently pull the connector from jig. Check the insertion condition.</p></div>		<div><p><b>Finger COTS</b></p></div> <div><p><b>GOOD</b></p></div> <div><p><b>NG</b></p></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	
		3	Pass WIP to P5	<div><p>1. Pass WIP to WIP Holder. <b>Note: One piece flow.</b></p></div>		<div><p><b>WIP HOLDER</b></p></div>	1. No WIP overflow

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