



WORK INSTRUCTION

Process Name/Title: **KITTING ASSEMBLY PROCESS**

Product Name/Code: **587B / 7M0532-7020** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

July 07, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-208

Revision No.:

1

Page No.:

1 of 3

PARTS:
1. Connector 6188-0066 (GR)
2. TVSSf 0.3 B/W-GR wires L=638±3mm

JIG:

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Connector setting to insertion jig 6188-0066 (GR)	<p>INSERTION JIG WITH SWITCH COVER</p> <p>INSERTION JIG ORIENTATION</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6188-0066 (GR) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p> <p>3. Push the guide upward using right thumb. Check the holes/terminal slot for B/W wires.</p>	<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>Connector Orientation Illustration</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/07/21	1	Removal of validity date. Apply notes in insertion process and in quality pointers.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
01/06/21	0	Excluded from WI-PRO-ASY-171 due to removal of insertion of dummy seal in process. Apply some improvements.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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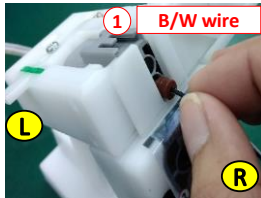
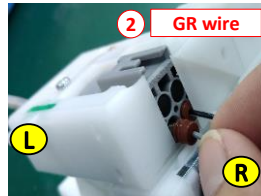

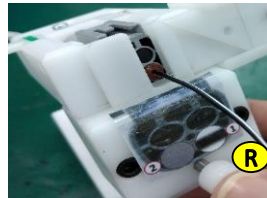










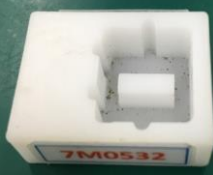



WI-ENG-PDE-208

Revision No.:

1

Page No.:

2 of 3

PARTS:	n/a			JIG	1. Insertion jig with switch cover 2. Locking jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS			
2	Wire insertion to connector 6188-0066 (GR)	<div><div><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Get the GR wire then insert to terminal slot 2 using right hand.</p></div></div> <div><div><p>WIRE FACING</p></div><div><p>3. After insertion of B/W wire, press the button using right thumb. The slot for GR wire will be opened.</p></div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing <div>1. Note: Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div>			
3	Connector Lock	<div><div><p>Put the connector into locking jig using right hand then press 2x. Check if properly locked.</p></div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div></div> <div><div><p>Connector Cross Sectional View</p><table><tr><td> NG Unlock Condition</td><td> NG Half Lock Condition</td><td> GOOD Full Lock Condition</td></tr></table></div></div>		 NG Unlock Condition	 NG Half Lock Condition	 GOOD Full Lock Condition	<div>LOCKING JIG</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div> <div>1. Use the provided jig per model 2. No unlock/half-locked connector</div>
 NG Unlock Condition	 NG Half Lock Condition	 GOOD Full Lock Condition						

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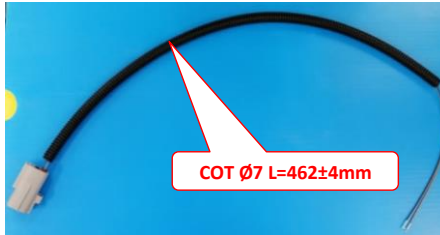

3 of 3

PARTS:

1. Assy parts
2. Black corrugated tube (no slit) $\varnothing 7$ L=462 \pm 4mm

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black corrugated tube (no slit) $\varnothing 7$ L=462 \pm 4mm	<div><p>1. Get the terminal cover jig using right hand and then insert the B/W-GR wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) $\varnothing 7$ L=462\pm4mm using right hand and then insert the B/W-GR wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> <div><p>COT $\varnothing 7$ L=462\pm4mm</p></div>	<div><p>TERMINAL COVER JIG</p></div>	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal

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