



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 05, 2022

Product Name/Code:

014B / 17J924-7051Y

Customer:

NBS

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

WI-ENG-PDE-493B

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

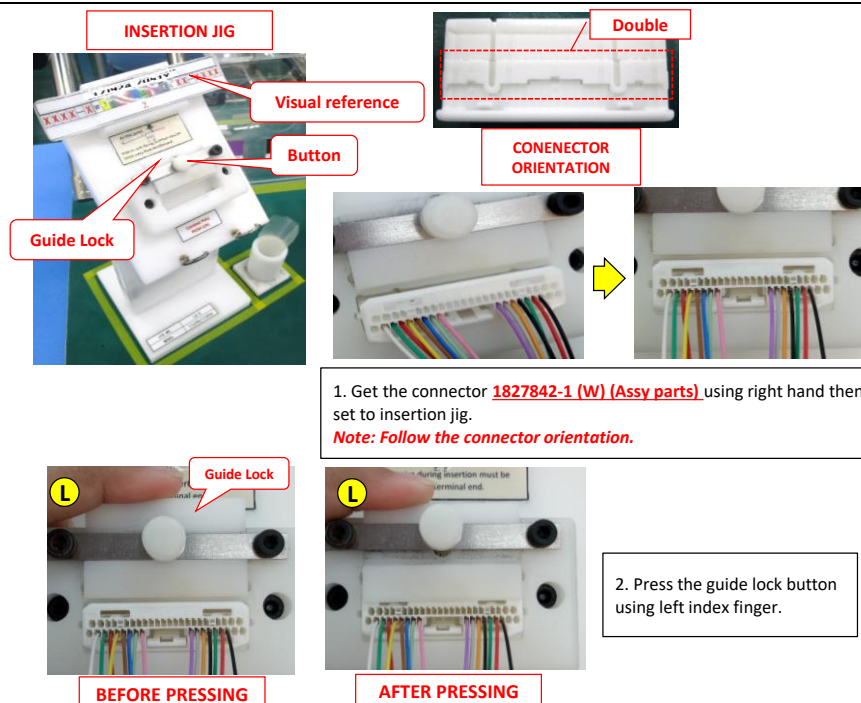
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P2

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

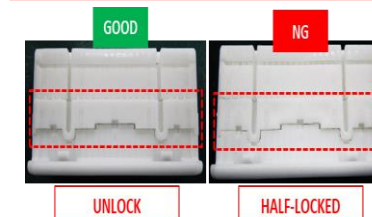
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

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.

Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	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	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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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)		<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>Finger COTS</p> 	<p>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</p> <p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>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.</p> <p>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</p>

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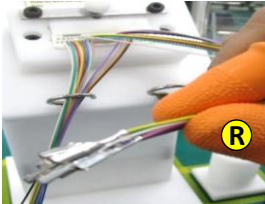
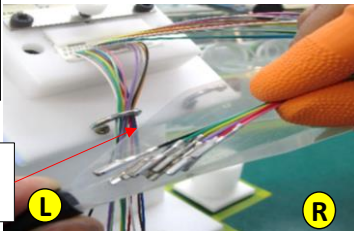
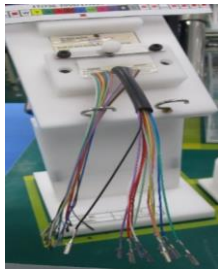
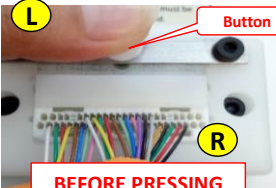

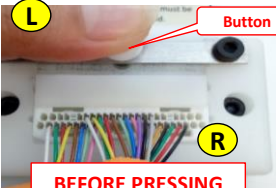
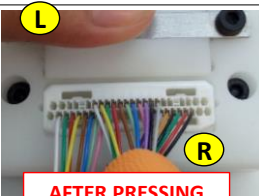
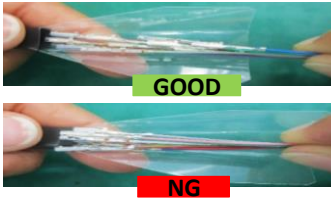


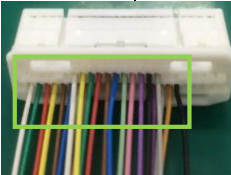
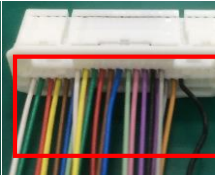
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PARTS:		JIG		
1. Assy parts 2. Black Sunprene tube $\phi 7$ L=55±5mm		1. Adaptor jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black Sunprene tube $\phi 7$ L=55±5mm	<div><p>1. Get the Black sunprene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

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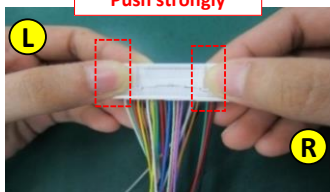
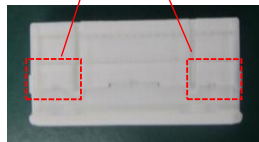


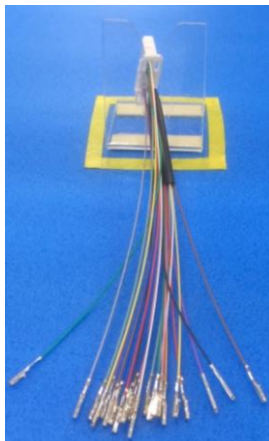
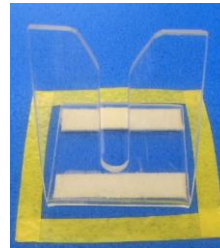
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PARTS:	1. Assy parts				JIG	1. WIP Holder
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P2	Connector lock	<div><div><div>Push strongly</div></div><div><div>push point</div></div><div><div>Before lock</div></div><div><div>After lock</div></div></div> <div><div>1. Push the double lock using left & right thumb. (Same timing)</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	1. No damaged double lock. 2. No half lock connector	
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><div>WIP HOLDER</div></div>	1. No WIP overflow	

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