

	WORK INSTRUCTION				Effectivity Date: March 1, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date: -	
	Process Name/Title:		Product Name/Code: D01L / 7M0646-7020A		Customer: TRJ	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-070A		Revision No.: 3	
Page No.: 1 of 3						

PARTS: 3	1. Connector 4G5400-0000 (W)	JIG: 3	1. Insertion jig
--	------------------------------	--	------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 3 Connector setting to insertion jig 4G5400-0000 (W)	<div style="text-align: center;"> </div> <div style="text-align: center;"> </div> <div style="text-align: center;"> <p>1. Press the lock of insertion jig using left thumb.</p> </div> <div style="text-align: center;"> <p>2. Insert the connector 4G5400-0000 (W) into jig using right hand and release the lock.</p> </div> <div style="text-align: center;"> <p>3. Check the holes/terminal slot for B/B wires.</p> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="border: 1px solid lightblue; padding: 5px; margin-bottom: 10px;"> Connector Orientation Illustration </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>I-mark is align 2 holes are opened GOOD</p> </div> <div style="text-align: center;"> <p>I-mark was not align All holes are open NG</p> </div> </div> <p>1. Use the provided jig per model 2. No wrong insertion of connector</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
03/01/21	3	Remove cycle time; Change connector colors in accordance with color standardization for plastic parts (Please refer to GL-COM-003); Change 2x pulling to Pull-Push-Pull-Push in insertion quality pointers Put assy parts on pg. 3 parts section	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
08/01/20	2	Update Cycle time. Change effective and validity date. Change taping dimension of Vinyl to wire near terminal	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
01/31/20	1	Transferred process owner from Production to Engineering. Changed part number from 7M0646-7020 to 7M0646-7020A. Changed document control number from WI-PRO-ASY-137A to WI-ENG-PDE-070A. Add cycle time per process.	M. Catapang	J. Loterte	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	June 23, 2019		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **D01L / 7M0646-7020A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 1, 2021

Validity Date:

-

Document No.:

WI-ENG-PDE-070A

Revision No.:

3

Page No.:

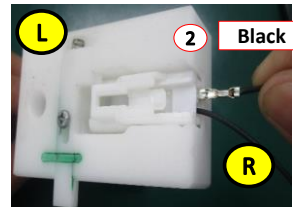

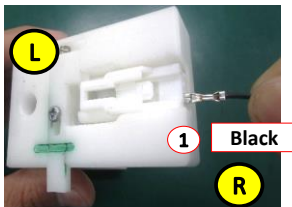
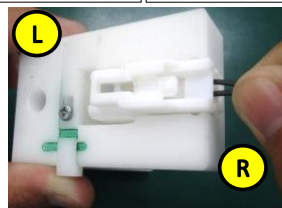
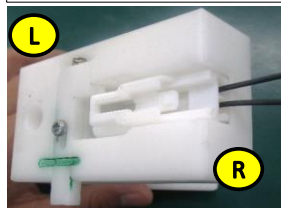




2 of 3

PARTS:

1. AVSSf 0.3 wires Black L=850mm [2pcs]

JIG

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 4G5400-0000 (W) P1	<div><p>1. Hold the insertion jig using left hand. Get the first black wire and then insert to Slot 1 of connector using right hand. Insertion must be from left to right.</p><p>2. Get the 2nd black wire and then insert to Slot 2 of connector using right hand.</p><p>3. After insertion, push the insertion jig lock using left thumb and then hold the wires and gently pull out connector from jig using right hand.</p></div>	N/A	<p>NOTE: <i>Insertion Sequence must be from left to right.</i></p> <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p>
3	Connector Lock	<div><p>1. Put the connector into locking jig using right hand and then press 2x to lock. Touch the connector to confirm if properly locked.</p><p>BEFORE PRESSING AFTER PRESSING</p></div>	LOCKING JIG 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <ol style="list-style-type: none">1. No unlocked/half-locked connector

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 1, 2021

Process Name/Title:

Product Name/Code:

D01L

/

7M0646-7020A

Customer:

TRJ

Validity Date:

-

Document No.:

WI-ENG-PDE-070A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

3 of 3

PARTS:

1. Black Vinyl tube $\varnothing 5$ L=784 \pm 2mm
2. Black tape



3. Assy parts

JIG

1. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4



Wire insertion to Black Vinyl tube
 $\varnothing 5$ L=784 \pm 2mm



1. Get the Vinyl tube $\varnothing 5$ L=784 \pm 2mm using right hand then insert the Black wires.

N/A

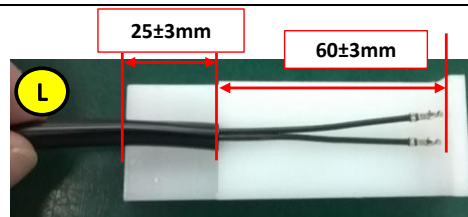
1. No wrong use of parts

5

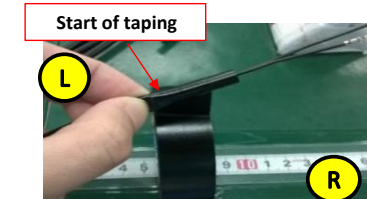
P1



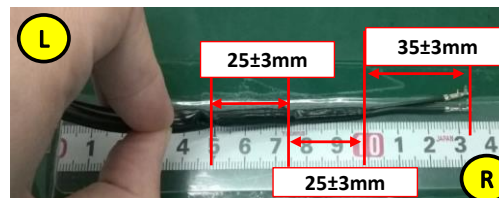
Taping 1
Black Vinyl tube
to wire near terminal



1. Hold the Vinyl tube using left hand and measure the vinyl up to terminal using the provided measuring jig.



2. Hold the assy parts using left hand and start taping using right hand.
Note: Please refer to WI-PRO-ASY-001 for taping procedure.

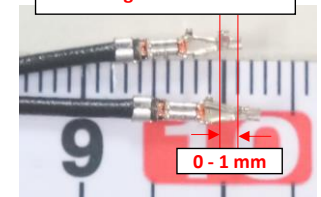


3. After taping, check the dimension, taping condition and terminal appearance.

MEASURING JIG



Wire alignment tolerance



MEASURING TAPE



1. No loose tape
2. No flip-out tape
3. No peef-off tape
4. No wrong dimension
5. No wrong use of tape

Note:
Please use calibrated/verified measuring tape when getting the measurement.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp