



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

August 12, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code: 240B / 17J613-7091P

Customer: NBC

Document No.:

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Purpose:

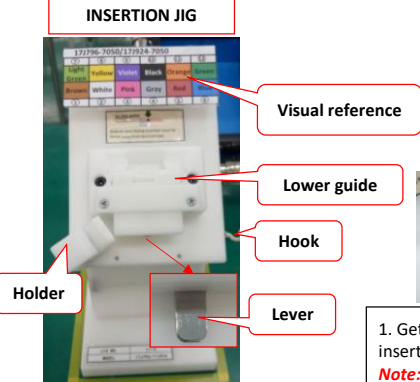
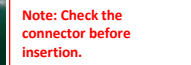
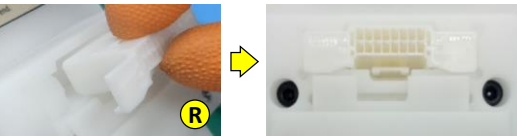
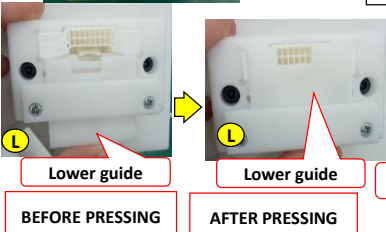
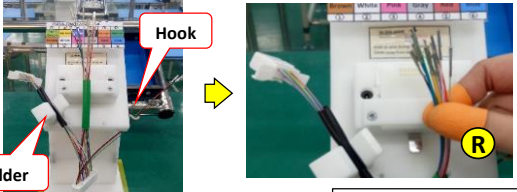

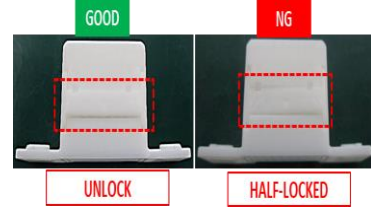
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

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PARTS:	1. 4F1640-000 (W) 2. Assy parts				JIG:	1. Insertion jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	P4	<div><div>INSERTION JIG</div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div></div><div>1. Get the connector 4F1640-000 (W) using right hand and set to insertion jig. <b>Note: Follow the connector orientation.</b></div><div></div><div>2. Press the lower guide using left thumb finger.</div><div></div><div>3. Set the Group 2 wires (11pcs) to holder using both hands and set the Group 3 wires (3pcs) to hook using right hand.</div><div>4. Hold the Group 1 wires (12pcs) using right hand for insertion.</div></div>				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div><b>Finger COTS</b> </div>	<div>1. No wrong wire inserted 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><b>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</b></div> <div><b>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.</b></div> <div></div>			
Revision History						Prepared by	Reviewed by	Reviewed by	Approved by	
08/12/21	0	Initial issue.				D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	

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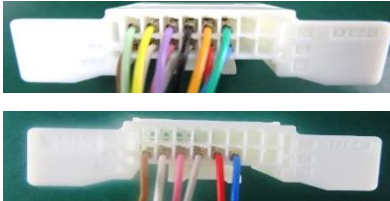


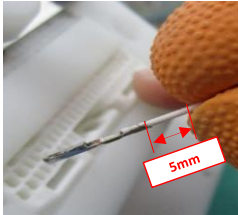
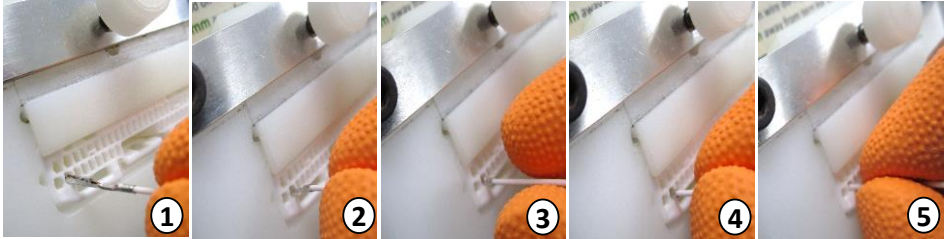
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**PARTS:**

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)	<div>WIRE INSERTION ILLUSTRATION</div> <div></div>		<div>WIRE FACING</div> <div></div>			<table><tr><td>SECOND ROW TO INSERT</td><td>LG</td><td>Y</td><td>V</td><td>B</td><td>OR</td><td>G</td><td>X</td><td>X</td></tr><tr><td></td><td>176</td><td>180</td><td>177</td><td>181</td><td>181</td><td>186</td><td>-</td><td>-</td></tr><tr><td>FIRST ROW TO INSERT</td><td>BR</td><td>W</td><td>P</td><td>GR</td><td>R</td><td>L</td><td>X</td><td>X</td></tr><tr><td></td><td>178</td><td>183</td><td>177</td><td>179</td><td>184</td><td>184</td><td>-</td><td>-</td></tr></table>		SECOND ROW TO INSERT	LG	Y	V	B	OR	G	X	X		176	180	177	181	181	186	-	-	FIRST ROW TO INSERT	BR	W	P	GR	R	L	X	X		178	183	177	179	184	184	-	-	<div>Finger COTS</div> <div></div>	<div>1. No wrong wire insertion</div> <div>2. No terminal backing out</div> <div>3. No deformed terminal</div> <div>4. Make sure wires are properly inserted.</div> <div>5. Must have slight MOVEMENT after insertion</div> <div>6. No bend terminal/wires</div> <div>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</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, <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.</div>
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FIRST ROW TO INSERT	BR	W	P	GR	R	L	X	X																																							
	178	183	177	179	184	184	-	-																																							
<div><div><div>Note: Hold on wire during insertion must be <b>5mm</b> away from terminal end.</div></div><div><div>1. Get the wire and hold it <b>5mm</b> away from terminal.</div><div>2. Half insert the wire.</div><div>3. Release wire to check the color.</div><div>4. Hold again <b>5mm</b> away from terminal</div><div>5. Fully inserted wires (avoid bending during insertion)</div><div>Note: Follow the insertion sequence based on the visual reference</div></div><div><div></div></div></div>																																															

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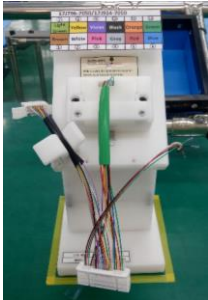
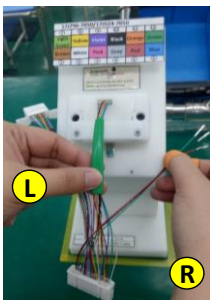
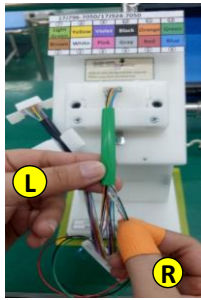
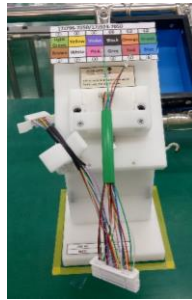



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**PARTS:**

1. Assy parts

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P4 Wire insertion to Green Sunprene tube (Group 3 wires)	    <p>1. Hold the <b>Green sunprene tube</b> using left hand. Get the <b>Group 3 wires (3pcs)</b> in the hook and insert to <b>Green sunprene tube</b> using right hand.</p> <p>2. Release the <b>Group 2 wires (11pcs) (Assy parts)</b> using left hand.</p> <p>3. Press the lever using right thumb.</p> <p>4. Hold the wires using left hand then gently pull the connector from jig. Check the insertion condition.</p> <p><b>BEFORE PRESSING</b> <b>AFTER PRESSING</b></p>	 <p><b>Finger COTS</b></p>	<p>1. No wrong use of parts. 2. No remaining wires outside Green sunprene tube 3. No deformed terminal</p>  <p><b>GOOD</b></p>  <p><b>NG</b></p>

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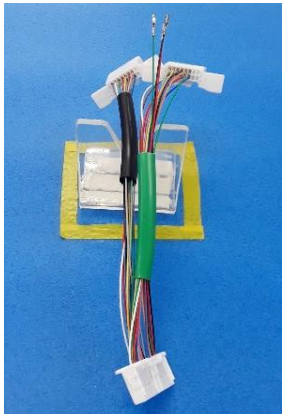
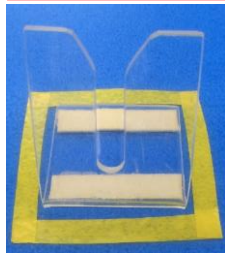
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## PARTS:

1. Assy parts

## JIG

1. WIP Holder

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P4 Pass WIP to P5	 <p>1. Pass WIP to WIP Holder. <b>Note: One piece flow.</b></p>	 <p><b>WIP HOLDER</b></p>	1. No WIP overflow

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