



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

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

Customer:

**NBC**

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

**August 12, 2021**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-300A**

Revision No.:

**0**

Page No.:

**1 of 3****PARTS:**

1. Connector 1827842-1 (W)

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 1827842-1 (W)	<div><div>INSERTION JIG</div><div>Visual reference</div><div>Button</div><div>Guide Lock</div><div>CONECTOR ORIENTATION</div><div>Double lock</div><div>1. Get the connector <b>1827842-1 (W)</b> using right hand then set to insertion jig. <b>Note: Follow the connector orientation.</b></div><div>Guide Lock</div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>2. Press the guide lock button using left index finger.</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. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 5. No half-locked connector</div> <div><b>Note:</b> Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</div> <div><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.</div> <div><div>GOOD</div><div>NG</div><div>UNLOCK</div><div>HALF-LOCKED</div></div>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
08/12/21	0	Initial issue	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	August 12, 2021		

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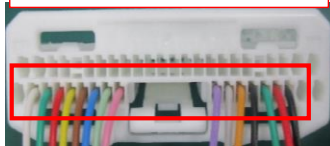

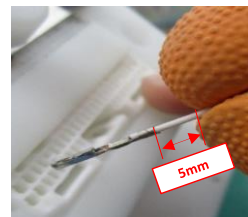

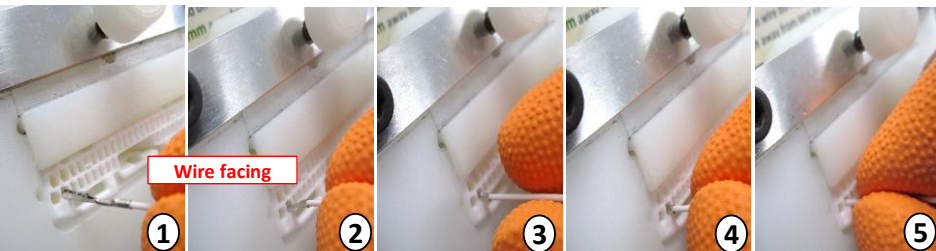
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**PARTS:**

1. CIVUS 0.13 W L=185±2mm; G L=188±2mm; R L=184±2mm; Y L=180±2mm; BR L=179±2mm; L L=184±2mm;  
LG L=176±2mm; P L=178±2mm; V L=177±2mm; GR L=181±2mm; OR L=181±2mm; B L=181±2mm; G L=1±190mm; R L=189±2mm; B L=190±2mm

**JIG**

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																																																									
2	P1	Wire insertion to connector (Group 1 & 3 wires) 1827842-1 (W)	<div>WIRE INSERTION ILLUSTRATION</div> 	<table border="1"><thead><tr><th colspan="18">17J613 (GROUP 1 WIRES)</th></tr><tr><th colspan="18">X</th></tr></thead><tbody><tr><td>Empty</td><td>W</td><td>G</td><td>R</td><td>Y</td><td>BR</td><td>L</td><td>LG</td><td>P</td><td>V</td><td>GR</td><td>OR</td><td>B</td><td>G</td><td>R</td><td>B</td><td>Empty</td><td>Empty</td></tr><tr><td>Empty</td><td>185</td><td>188</td><td>184</td><td>180</td><td>179</td><td>184</td><td>176</td><td>178</td><td>177</td><td>181</td><td>181</td><td>181</td><td>190</td><td>189</td><td>190</td><td>Empty</td><td>Empty</td></tr></tbody></table>	17J613 (GROUP 1 WIRES)																		X																		Empty	W	G	R	Y	BR	L	LG	P	V	GR	OR	B	G	R	B	Empty	Empty	Empty	185	188	184	180	179	184	176	178	177	181	181	181	190	189	190	Empty	Empty	<div><div>GOOD Smaller terminal</div><div>NG Long terminal</div></div> <div>Wire facing</div> <div><div>Note: Hold on wire during insertion must be 5mm away from terminal end.</div></div> <div><div>1. Get the wire and hold it 5mm away from terminal.</div><div>2. Half insert the wire.</div><div>3. Release wire to check the color.</div><div>4. Hold again 5mm 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>Finger COTS</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 Pull-Push-Pull-Push 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, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</div>
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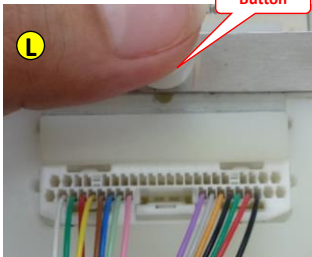





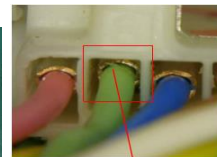
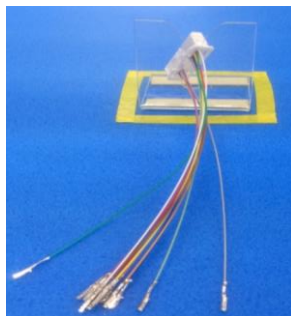
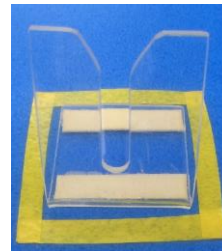
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**PARTS:**

1. Assy parts

**JIG**

1. WIP Holder

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector (Group 1 & 3 wires) 1827842-1 (W) (Continuation)  P1	<div><p>Button</p><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div> <div><p>R</p></div> <div><p>6. Press the button using left thumb.</p><p>7. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</p></div>	<div><p>Finger COTS</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div> <div><p>Damaged/whitens</p></div>	<ol style="list-style-type: none"><li>1. No wrong wire insertion</li><li>2. No terminal backing out</li><li>3. No deformed terminal</li><li>4. Make sure wires are properly inserted.</li><li>5. Must have slight MOVEMENT after insertion</li><li>6. No bend terminal/wires</li></ol>
3	Pass WIP to P2	<div></div> <div><p>1. Pass WIP to WIP Holder. <b>Note: One piece flow.</b></p></div>	<div><p>WIP HOLDER</p></div>	<ol style="list-style-type: none"><li>1. No WIP overflow</li></ol>

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