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## WORK INSTRUCTION

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Effectivity Date:

August 12, 2021

Product Name/Code:

970A / 17J711-7051P

Customer:

NBC

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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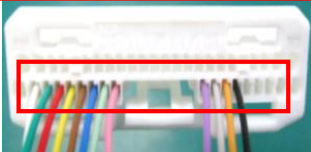




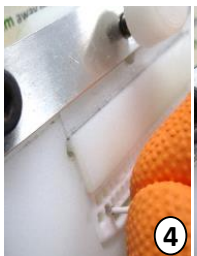
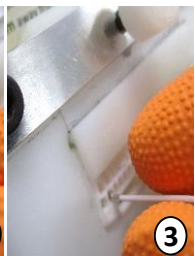


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**PARTS:**

1. CIVUS 0.13 W L=184±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=180±2mm; OR L=181±2mm; B L=181±2mm [GROUP 1 wires]

**JIG**

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																																						
2	P1	Wire insertion to connector (Group 1 wires) 1827842-1 (W)	<div>WIRE INSERTION ILLUSTRATION</div> 	<div>17J711 (GROUP 1 WIRES)</div> <table><tr><td colspan="18">X</td></tr><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>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td></tr><tr><td>Empty</td><td>184</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>180</td><td>181</td><td>181</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td></tr></table> <div><div>GOOD Smaller terminal</div><div>NG Long terminal</div></div> <div>Wire facing</div> <div>Note: Hold on wire during insertion must be 5mm away from terminal end.</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>	X																		Empty	W	G	R	Y	BR	L	LG	P	V	GR	OR	B	Empty	Empty	Empty	Empty	Empty	Empty	184	188	184	180	179	184	176	178	177	180	181	181	Empty	Empty	Empty	Empty	Empty	<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: Refer to GL-PRO-ASY-028 for Pull-Push procedure.</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>
			X																																																									
Empty	W	G	R	Y	BR	L	LG	P	V	GR	OR	B	Empty	Empty	Empty	Empty	Empty																																											
Empty	184	188	184	180	179	184	176	178	177	180	181	181	Empty	Empty	Empty	Empty	Empty																																											
<div></div> <div>Wire facing</div> <div>1</div> <div>2</div> <div>3</div> <div>4</div> <div>5</div>																																																												

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# WORK INSTRUCTION

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

Product Name/Code: **970A / 17J711-7051P**

Customer: **NBC**

Purpose: ☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

**August 12, 2021**

Validity Date:

**n/a**

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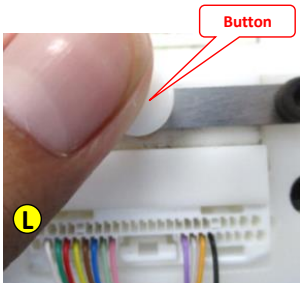
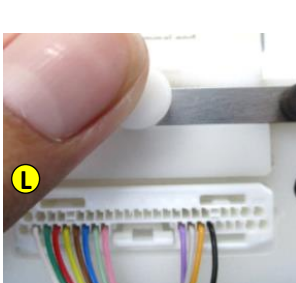

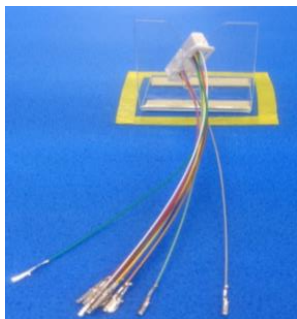
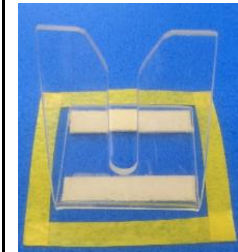
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PARTS:		1. Assy parts		JIG	1. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector (Group 1 wires) 1827842-1 (W) (Continuation)	  <p>6. Press the button using left thumb.</p>	 <p>7. Hold the wires using right hand then gently pull the connector from jig. Check the insertion condition.</p>	<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			 <p>1. Pass WIP to WIP Holder. <b>Note: One piece flow.</b></p>		<ol style="list-style-type: none"> <li>1. No WIP overflow</li> </ol>

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