



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

May 04, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: 014B / 17J796-7051Y

Customer:

NBS

Document No.:

WI-ENG-PDE-492A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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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>HOOK</div><div>Connector orientation</div><div>Double lock</div><div>1. Get the connector 1827842-1 (W) using right hand then set to insertion jig. <i>Note: Follow the connector orientation.</i></div><div>2. Press the guide lock using left index finger.</div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div>	<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div><div>Finger COTS</div></div>	<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><i>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</i></div><div><i>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.</i></div><div><div>GOOD</div><div>NG</div><div>UNLOCK</div><div>HALF-LOCKED</div></div></div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/04/22	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
04/29/22	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. CIVUS 0.13 W L=183±2mm; G L=186±2mm; R L=184±2mm; Y L=180±2mm; BR L=178±2mm; L L=184±2mm;
LG L=176±2mm; P L=177±2mm; V L=177±2mm; GR L=179±2mm; OR L=181±2mm; B L=181±2mm

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></div>	<div>17J796-7051Y</div> <div>X</div> <table><tr><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></tr><tr><td>183</td><td>186</td><td>184</td><td>180</td><td>178</td><td>184</td><td>176</td><td>177</td><td>177</td><td>179</td><td>181</td><td>181</td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td></tr></table>	W	G	R	Y	BR	L	LG	P	V	GR	OR	B	183	186	184	180	178	184	176	177	177	179	181	181	1	2	3	4	5	6	7	8	9	10	11	12	<div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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>
			W	G	R	Y	BR	L	LG	P	V	GR	OR	B																												
183	186	184	180	178	184	176	177	177	179	181	181																															
1	2	3	4	5	6	7	8	9	10	11	12																															
<div><div>GOOD SHORT terminal</div><div></div><div><div>NG LONG terminal</div><div></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><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><div>Note: Follow the insertion sequence based on the visual reference</div><div></div></div></div></div>	<div>Finger COTS</div> <div></div>	<div>Note: Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 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.</div> <div>Do not attempt to repair.</div>																																								

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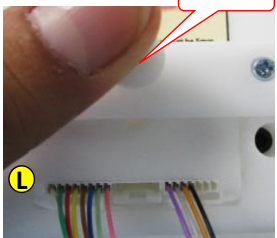



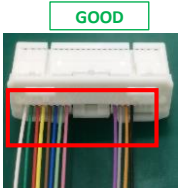
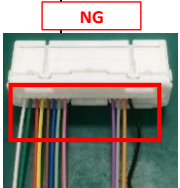
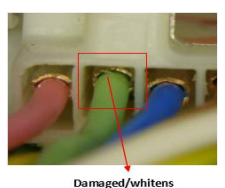
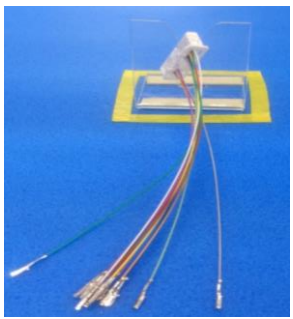
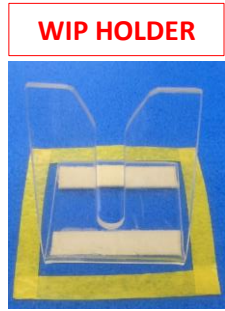
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PARTS:		1. Assy parts			JIG	1. Insertion jig 2. WIP Holder	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P1	Wire insertion to connector (Group 1 wires) 1827842-1 (W) (Continuation)	 BEFORE  AFTER PRESSING  7. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.			 Finger COTS  GOOD  NG  Damaged/whitens	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 6. No bend terminal/wires
3		Pass WIP to P2	 1. Pass WIP to WIP Holder. Note: One piece flow.			 WIP HOLDER	1. No WIP overflow

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