



WORK INSTRUCTION SUB-ASSEMBLY/ CONTINUITY TESTING

Process Name/Title:

Product Name/Code: **5 Levercon / 17J796/17J924/17L544**

Customer: **TRP**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

August 06, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-010

Revision No.:

5

Page No.:

1 of 6

PARTS:

1. Assy parts

JIG:

1. Tester jig

NO.

PROCESS NAME

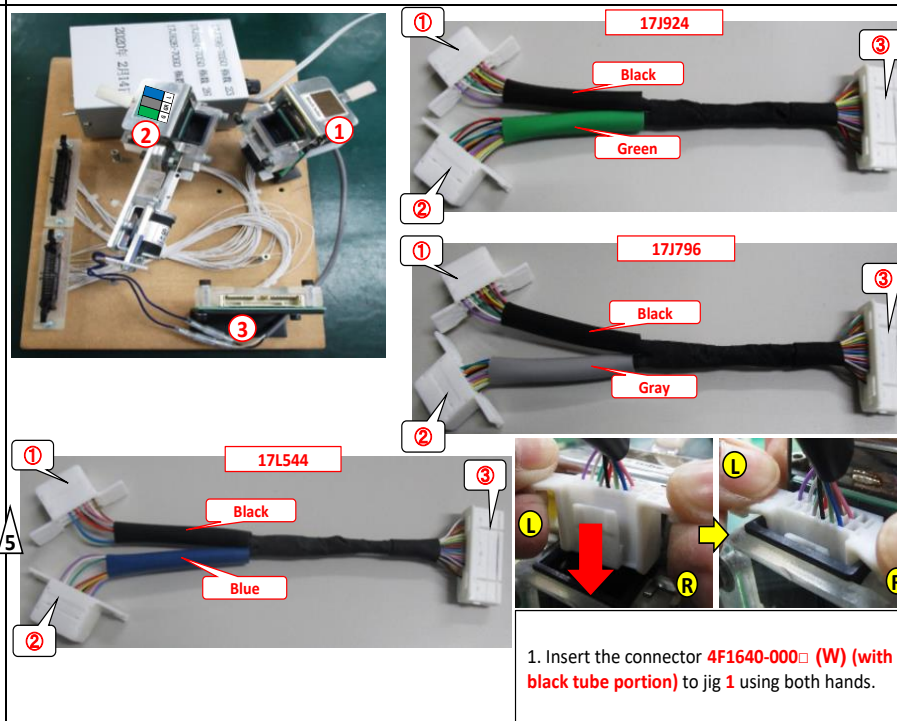
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

Wire harness testing



Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

NOTE:
Conduct equipment inspection before start of operation
Refer to F-PRO-ASY-024A-B

1. No wrong setting of connector
2. No damage or broken connector pin
3. Hold only on connector during insertion

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
08/06/21	5	Revise due to use of 'Levercon' as product name and inclusion of 17L544 in product code. Apply some improvements in testing process. Inclusion of NG WIRING #1: A1/B2	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
04/13/21	4	Removal of validity date.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
06/07/17	0	Initial issue	D. Castillo	R. Alcantara	A. Arañes	n/a
			Revised	Checked	Approved	Noted
			Est. Date:	June 07, 2017		

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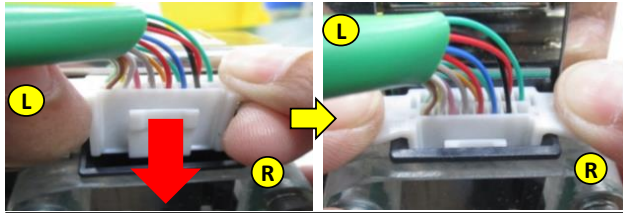
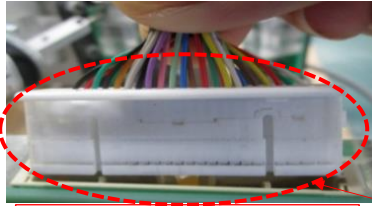
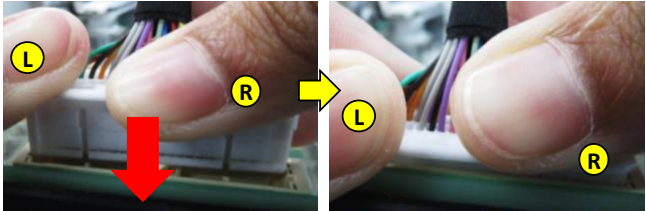
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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG	1. Tester jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Wire harness testing (Continuation)	<div></div> <div><p>5 2. Insert the connector 4F1640-000 (W) (with Green tube portion for 17J794) and (with Gray tube portion for 17J796) and (Blue tube portion for 17L544) to jig 2 using both hands.</p><p>CONNECTOR ORIENTATION</p><p>Correct facing of the connector</p></div> <div><p>3. Insert the last connector 1827842-1 (W) to jig 3 using both hands then wait for the test result.</p></div>		n/a	1. No wrong setting of connector 2. No damage or broken connector pin 3. Hold only on connector during insertion

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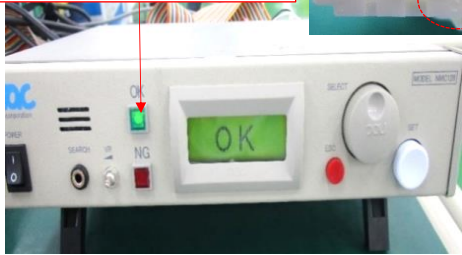
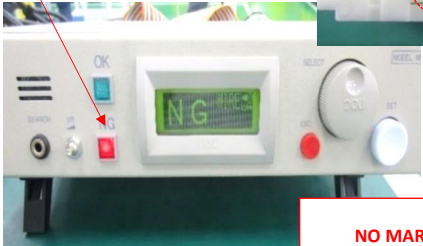
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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	n/a				JIG	1. Tester jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	Wire harness testing (Continuation)	<div><p>If GREEN LIGHT is ON means GOOD</p><p>With MARKING Note: Refer to GL-ENG-PDE-008 for number of marking dots per line.</p></div> <div><p>And if the RED LIGHT is ON means its NG</p><p>NO MARKING</p></div>		n/a	<p>Note: If the result was NG, STOP and immediately CALL the attention of the leader and WAIT for further instruction then continue the process.</p>	

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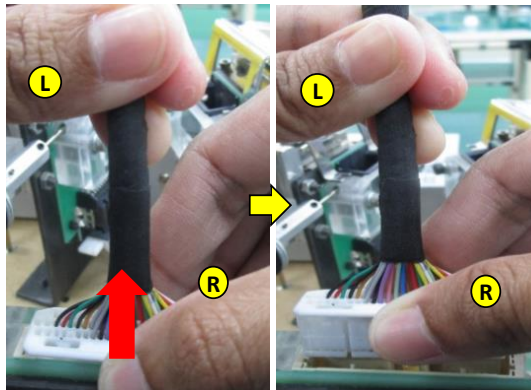
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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts			JIG	1. Tester jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>5</div> Removal of connector from tester jig	<div><p>1. Press the ejector jig using both hands (<i>same timing</i>) then remove the connector 4F6140-000 (W) [2pcs.] using both hands.</p><p>2. Remove the connector 1827842-1 (W) using both hands.</p></div>		n/a	1. Check if with broken parts 2. Do not exert extra force when removing harness from jig. 3. Marking should be visible.

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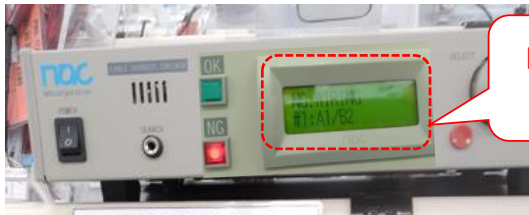


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PARTS:	1. Assy parts			JIG	1. Tester jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire harness with NG Wiring #1: A1/B2 Error	<p>IF ENCOUNTERED, NG WIRING #1: A1/B2</p>  <p>NG WIRING #1 : A1/B2</p> <p>If machine detected NG WIRING, STOP and immediately CALL the attention of the leader and WAIT for further instruction then continue the process. Note: Refer to GL-ENG-COM-004 (Levercon Wire Color Identification for NG)</p> <p>1. The unit should be pulled-out by the Leader to re-test/verify in other lines.</p> <p>2. Conduct function test on the affected unit to other three (3) lines consecutively.</p> <p>*PUNCHMARK MUST BE IN "OFF" CONDITION</p>  <p>*Return to "ON" condition after re-test</p> 		n/a	1. No 2x verification of unit per line/machine 2. No 'turn on' punchmark during testing

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PARTS:	n/a				JIG	1. Tester jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
3	<div>5</div> <						

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