



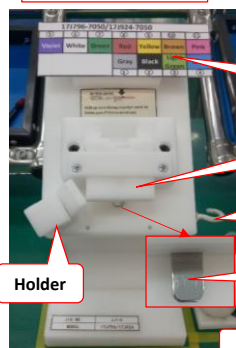


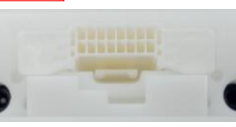

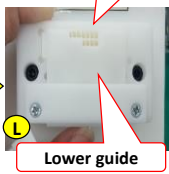
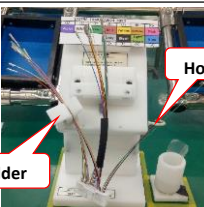
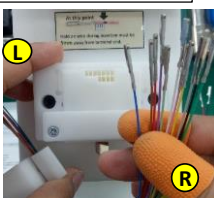
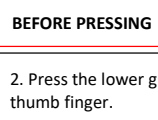
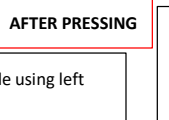

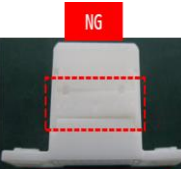

WORK INSTRUCTION TAPING ASSEMBLY PROCESS

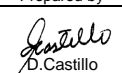

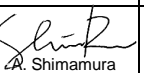
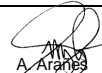
Effectivity Date:	August 12, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-300C		
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

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

Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:		1. Connector 4F1640-000 (W)				JIG:		1. Insertion jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		P3		<div><div>Connector Setting to Insertion jig (Assy parts) 4F1640-000 (W)</div><div><div><div>INSERTION JIG</div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><div>Note: Check the connector before insertion.</div><div>1. Get the connector 4F1640-000 (W) using right hand then set to insertion jig. Note: Follow the connector orientation.</div><div>2. Press the lower guide using left thumb finger.</div><div>3. Separate Group 1 (12pcs) and Group 3 wires (3pcs). Set the Group 1 wires (12pcs) to holder using both hands and set the Group 3 wires (3pcs) to hook using right</div><div>4. Hold the Group 2 wires (11pcs) using right hand for insertion.</div></div></div><div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div><div>Finger COTS </div></div><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>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><div><div></div><div>UNLOCK</div><div>HALF-LOCKED</div></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						Revised		Checked		Approved		Noted	
Details of Change						Est. Date:		August 12, 2021					

Revision History

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08/12/21	0	Initial issue.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes

Prepared by

Reviewed by

Reviewed by

Approved by

Est. Date:

August 12, 2021

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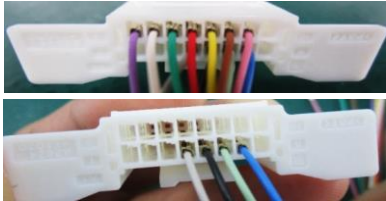

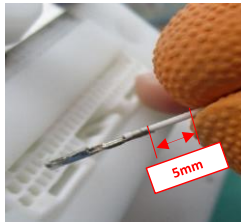





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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS																																				
2	P3	Wire insertion to connector (Group 2 wires) 4F1640-000 (W)	<div>WIRE INSERTION ILLUSTRATION</div> <div></div>		<div>WIRE FACING</div> <table><tr><td>SECOND ROW TO INSERT</td><td>V</td><td>W</td><td>G</td><td>R</td><td>Y</td><td>BR</td><td>P</td><td>X</td></tr><tr><td></td><td>185</td><td>183</td><td>181</td><td>178</td><td>178</td><td>176</td><td>175</td><td>-</td></tr><tr><td>FIRST ROW TO INSERT</td><td>X</td><td>X</td><td>X</td><td>GR</td><td>B</td><td>LG</td><td>L</td><td>X</td></tr><tr><td></td><td>-</td><td>-</td><td>-</td><td>179</td><td>179</td><td>176</td><td>175</td><td>-</td></tr></table>		SECOND ROW TO INSERT	V	W	G	R	Y	BR	P	X		185	183	181	178	178	176	175	-	FIRST ROW TO INSERT	X	X	X	GR	B	LG	L	X		-	-	-	179	179	176	175	-	<div>Finger COTS</div> <div></div>	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
			SECOND ROW TO INSERT	V	W	G	R	Y	BR	P	X																																	
	185	183	181	178	178	176	175	-																																				
FIRST ROW TO INSERT	X	X	X	GR	B	LG	L	X																																				
	-	-	-	179	179	176	175	-																																				
<div><div><div>Note: Hold on wire during insertion must be 5mm away from terminal end.</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><div></div><div></div><div></div></div></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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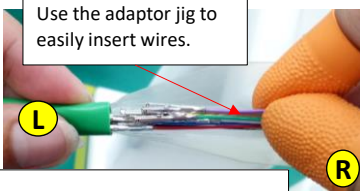
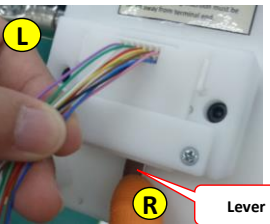

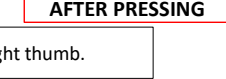





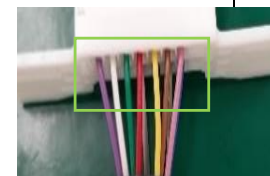
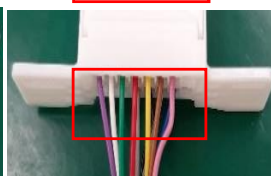
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PARTS:

1. Assy parts
2. Green Sunprene tube $\phi 7$ L=55 \pm 5mm

JIG

1. Adaptor jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Wire insertion to Green Sunprene tube $\phi 7$ L=55 \pm 5mm	<div><p>1. Get the Green sunprene tube $\phi 7$ L=55\pm5mm using left hand then insert the adaptor jig using right hand.</p></div> <div><p>2. Release the Group 1 wires (12pcs) using right hand.</p></div> <div><p>3. Insert the wires to Green sunprene tube using right hand.</p></div> <div><p>4. Press the lever using right thumb.</p></div> <div><p>5. Hold the wires using left hand then gently pull the connector from jig. Check the insertion condition.</p></div> <div><p>Use the adaptor jig to easily insert wires.</p></div>	<div><p>Adaptor jig</p></div> <div><p>Finger COTS</p></div>	<div><p>GOOD</p></div> <div><p>NG</p></div> <div><p>GOOD NG</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div> <div><p>1. No wrong use of parts. 2. No mixed wires between Group 1 and Group 3 3. No cut tube</p><p>STANDARD TUBE APPEARANCE</p></div>

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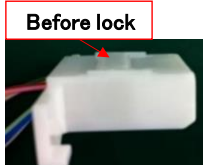
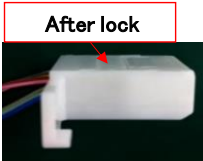

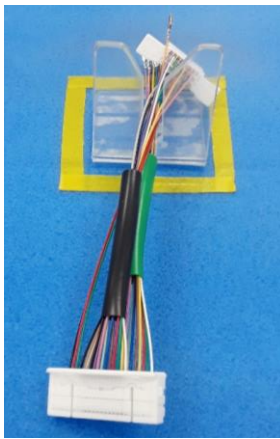

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PARTS:

1. Assy parts

JIG

1. Locking jig
2. WIP Holder

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Connector Lock	 <ol style="list-style-type: none">1. Put the connector to locking jig using left hand and press down the connector to locking jig 2x using right thumb.2. Touch the connector lock after locking. <p><i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p>	  	<p><i>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK.</i></p> <ol style="list-style-type: none">1. No damaged double lock.2. No halfed lock connector
5	Pass WIP to P4	 <ol style="list-style-type: none">1. Pass WIP to WIP Holder. <p><i>Note: One piece flow.</i></p>		<ol style="list-style-type: none">1. No WIP overflow

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