



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

August 12, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

970A / 17J711-7051P

Customer:

NBC

Document No.:

WI-ENG-PDE-299C

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

1 of 4

PARTS:

1. Connector 4F1640-000□ (W)

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

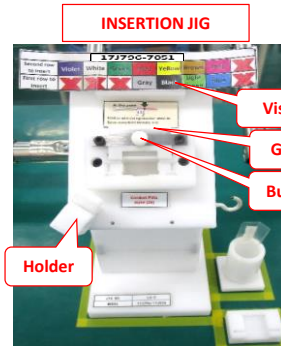
TOOLS/PPE

QUALITY POINTERS

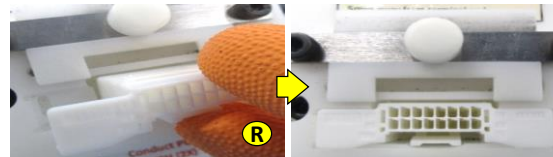
1

P3

Wire insertion to
connector
(Group 2 wires)
4F1640-000□ (W)

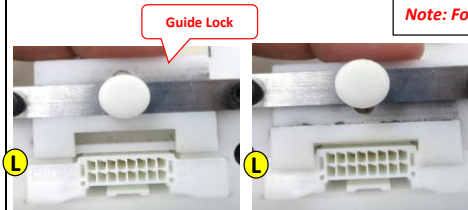


Note: Check the connector
before insertion.



1. Get the connector **4F1640-000□ (W)** using right hand then set to
insertion jig.

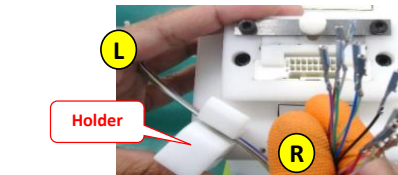
Note: Follow the connector orientation.



BEFORE PRESSING

AFTER PRESSING

2. Press the guide lock using left index finger.



Holder

3. Hold the **Group 2 wires (11pcs.)** using right hand
then put the **Group 1 wires (12pcs.)** in holder using
left hand.

Safety Instruction

Be sure to wear
prescribed 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

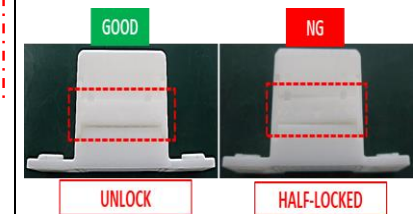
For any trouble, inform
the Assembly Assistant
Supervisor or Line Leader
for immediate corrective
action.

Finger COTS

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

Note: Automatically dispose and replace the
unit if once encountered Bend terminal,
Difficulty of insertion, Half-locked connector.

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.



UNLOCK

HALF-LOCKED

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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Page No.:

2 of 4

PARTS:

1. Assy parts

JIG

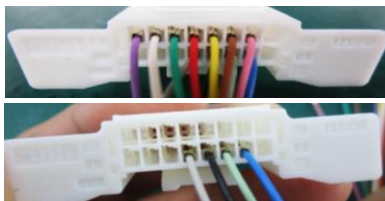
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

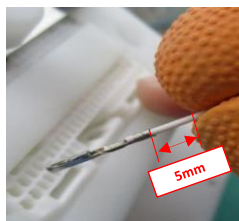
2

P3

Wire insertion to
connector
(Group 2 wires)
4F1640-000□ (W)

WIRE INSERTION ILLUSTRATION**WIRE FACING**

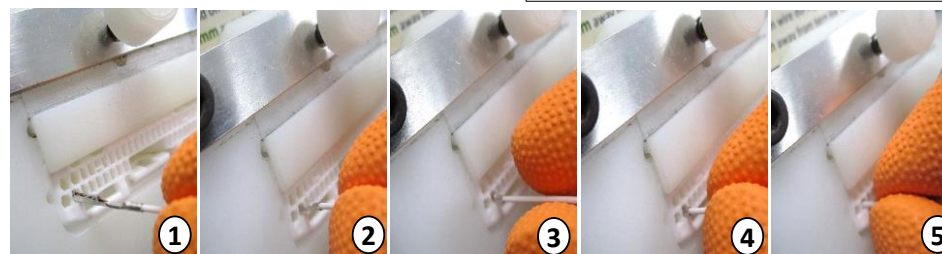
SECOND ROW TO INSERT	V	W	G	R	Y	BR	P	EMPTY
185	183	181	178	178	176	175	EMPTY	EMPTY
FIRST ROW TO INSERT	EMPTY	EMPTY	EMPTY	GR	B	LG	L	EMPTY
EMPTY	EMPTY	EMPTY	180	179	176	175	EMPTY	EMPTY



Note: Hold on wire during insertion must be 5mm away from terminal end.

1. Get the wire and hold it **5mm** away from terminal.
2. Half insert the wire.
3. Release wire to check the color.
4. Hold again **5mm** away from terminal
5. Fully inserted wires (avoid bending during insertion)

Note: Follow the insertion sequence based on the visual reference

**Adaptor jig****Finger COTS**

Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.

Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.

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.

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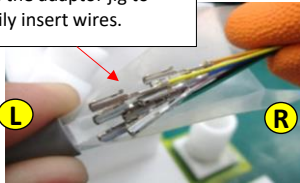
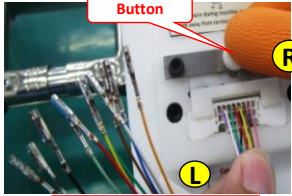



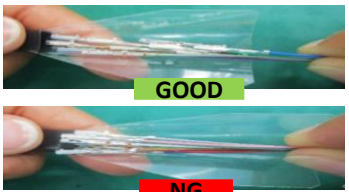
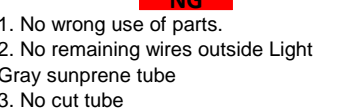
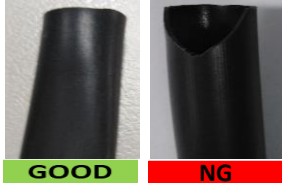
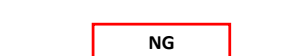
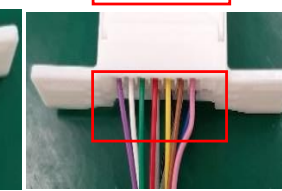
3 of 4

PARTS:

1. Assy parts
2. Light Gray 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 Light Gray Sunprene tube $\phi 7$ L=55 \pm 5mm	<div><p>1. Get the Light Gray 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 Light Gray sunprene tube using right hand.</p></div> <div><p>4. Press the button 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>Adaptor jig</p></div> <div><p>Finger COTS</p></div>	<div><p>GOOD</p></div> <div><p>NG</p></div> <div><p>STANDARD TUBE APPEARANCE</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div>

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Page No.:

4 of 4

PARTS:

1. Assy parts

JIG

1. Locking jig
2. WIP Holder

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

Connector Lock



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.

Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.

Before lock



After lock



Locking jig



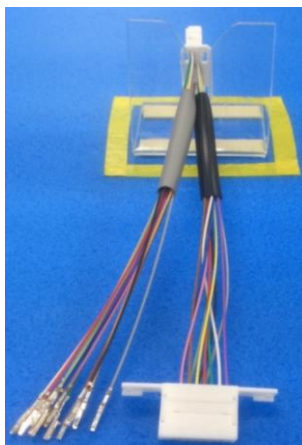
NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK.

1. No damaged double lock.
2. No halfed lock connector

5

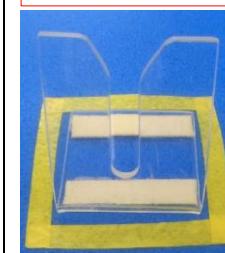
P3

Pass WIP to P4



1. Pass WIP to WIP Holder.
- Note: One piece flow.*

WIP HOLDER



1. No WIP overflow

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