



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

Document No.:

WI-ENG-PDE-299D

Revision No.:

0

Page No.:

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PARTS:

- Connector 4F1640-000□ (W)
- Assy parts

JIG:

- Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P4

Connector setting to
insertion jig
4F1640-000□ (W)

INSERTION JIG

Visual reference

Guide Lock

Button

Holder

CONNECTOR ORIENTATION

Note: Check the connector before insertion.

BEFORE PRESSING

Guide Lock

AFTER PRESSING

Holder

1. Get the connector **4F1640-000□ (W)** using right hand and set to insertion jig.
Note: Follow the connector orientation.

2. Press the guide lock using left index finger.

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

Safety Instruction

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

Housekeeping

- Maintain and always practice 5's.
- 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.

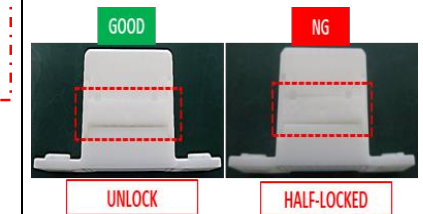
Finger COTS



- Use the provided jig per model
- No wrong usage of parts
- No wrong orientation of connector
- No damaged connector
- 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.



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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PARTS:

1. Assy parts

JIG

1. WIP Holder

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P4

Wire insertion to connector
(Group 1 wires)
4F1640-000□ (W)

WIRE INSERTION ILLUSTRATION



SECOND ROW
TO INSERT

LG Y V B OR G EMPTY EMPTY

176 180 177 181 181 188 EMPTY EMPTY

FIRST ROW TO
INSERT

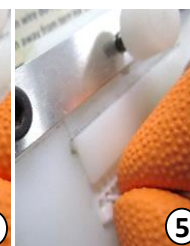
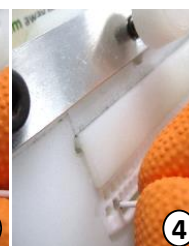
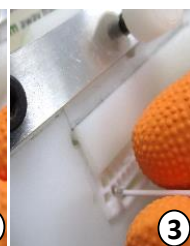
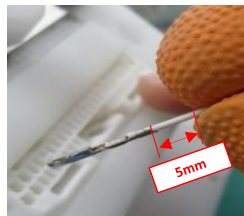
BR W P GR R L EMPTY EMPTY

179 184 178 180 184 184 EMPTY EMPTY

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

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



WIRE FACING



Finger COTS



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

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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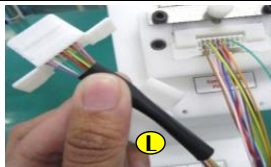
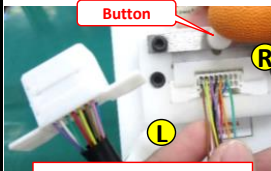
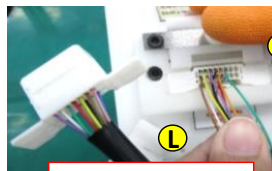



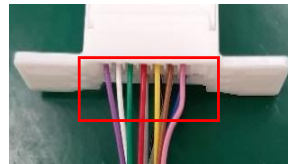
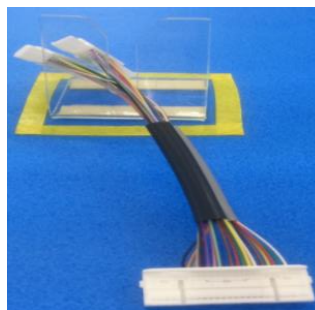

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PARTS:		1. Assy parts			JIG	1. WIP Holder	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P4	Wire insertion to connector (Group 1 wires) 4F1640-000□ (W) (Continuation)	<div><div>6. Release the Group 2 wires (11pcs.) (Assy parts) using left hand.</div></div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>7. Press the button using right thumb.</div><div><div>8. Hold the wires using left hand then gently pull the connector from jig. Check the insertion condition.</div></div></div>			<div><div>Finger COTS</div><div>GOOD</div><div>NG</div></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>
3		Pass WIP to P5	 <div>1. Pass WIP to WIP Holder. Note: One piece flow.</div> <div><div>WIP HOLDER</div></div>	<div>1. No WIP overflow</div>			

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