



WORK INSTRUCTION

Process Name/Title:

KITTING ASSEMBLY PROCESS

Effectivity Date:

June 18, 2021

Product Name/Code:

J34A / 7L0106-7020E

Customer:

TRQSS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-285

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 3

PARTS:

1. Connector 7182-8049 (W); AVSSf 0.3 L L=257±2mm; B/W L=257±2mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

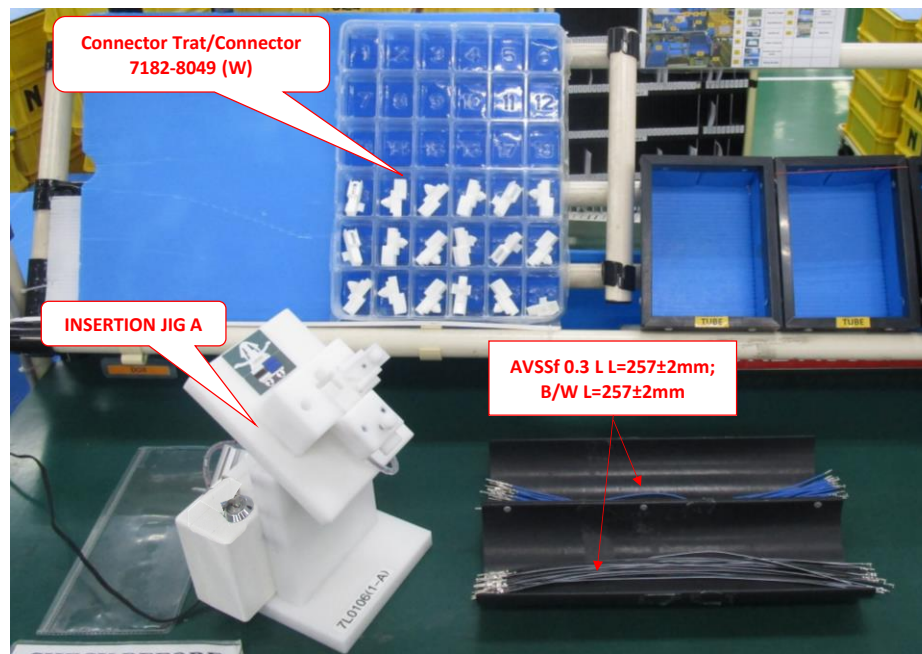
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

Table Lay-out

**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.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/18/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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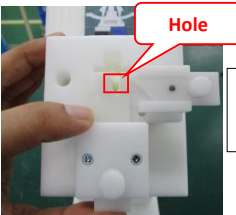
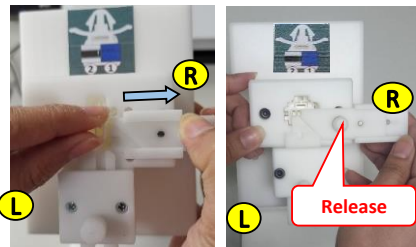
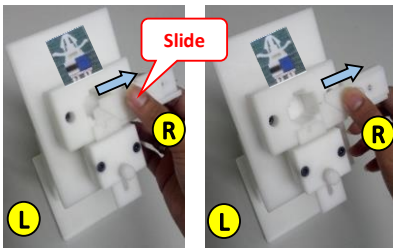

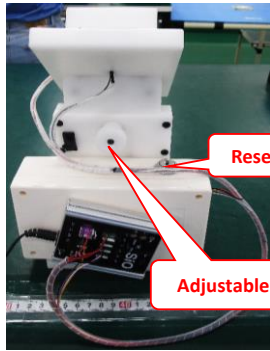
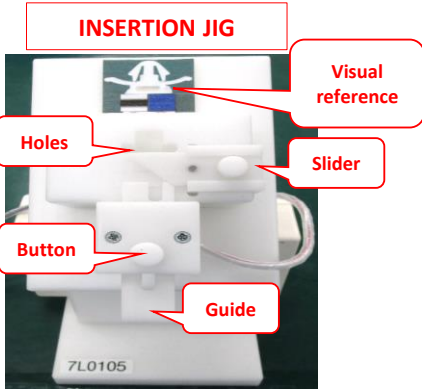
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 3

PARTS:	1. Connector 7182-8049 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector setting to insertion jig 7182-8049 (W)	<div><p>1. Slide the slide lock using right thumb..</p><p>2. Insert the connector 7182-8049 (W) into jig using left hand and release the side lock using right hand. Note: Follow the connector orientation; Cannot insert the inverted connector.</p><p>3. Push the guide using left thumb. The slot for Blue wire will be opened.</p></div>		n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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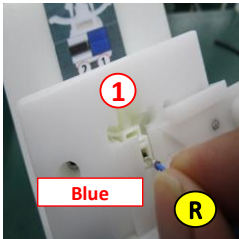
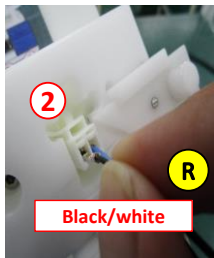
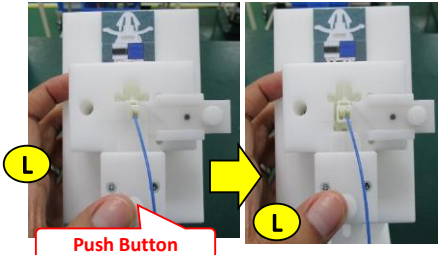
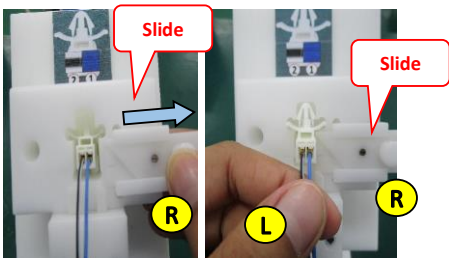
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Revision No.:

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Page No.:

3 of 3

PARTS:	1. AVSSf 0.3 wires L L=257±2mm; B/W L=257±2mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 7182-8049 (W)	<div data-bbox="804 416 1090 488"></div> <div data-bbox="680 491 918 730"></div> <div data-bbox="642 746 969 847"><p>1. Get the Blue wire then insert to terminal slot ① using right hand. Conduct Pull-Push-Pull-Push after insertion.</p></div> <div data-bbox="689 868 902 1126"></div> <div data-bbox="631 1145 963 1326"><p>3. Get the Black/white wire then insert to terminal slot ② using right hand. Conduct Pull-Push-Pull-Push after insertion. Note: Insertion jig will alarm if Black/White wire will not insert before 5 seconds.</p></div> <div data-bbox="999 491 1435 746"></div> <div data-bbox="999 778 1453 831"><p>2. Press the button using left thumb. The slot for Black/White wire will be opened.</p></div> <div data-bbox="1037 868 1485 1126"></div> <div data-bbox="999 1158 1462 1259"><p>4. After insertion, GO sound will be heard. Slide the slider lock using right thumb then hold the wires and gently pull out the connector from jig using left hand.</p></div>		n/a	<div data-bbox="1783 469 2125 584">NOTE: Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</div> <div data-bbox="1783 624 2125 699">ATTENTION: This connector has NO DOUBLE LOCK, proper insertion method must be followed.</div> <div data-bbox="1783 788 1995 914"><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></div> <div data-bbox="1783 991 2125 1118">Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>

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