



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

August 12, 2021

Process Name/Title:

Validity Date:

n/a

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

Customer: NBC

Document No.:

WI-ENG-PDE-300B

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

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PARTS:	1. Assy parts			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	P2	<div>Connector setting to insertion jig (Assy parts) 1827842-1 (W)</div> <div><p>1. Get the connector <u>1827842-1 (W) (Assy parts)</u> using right hand then set to insertion jig. Note: Follow the connector orientation.</p><p>2. Press the guide lock button using left index finger.</p></div> <div><p>BEFORE PRESSING AFTER PRESSING</p></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>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged 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>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</div> <div><p>GOOD NG</p><p>UNLOCK HALF-LOCKED</p></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	Details of Change			Revised	Checked	Approved	Noted

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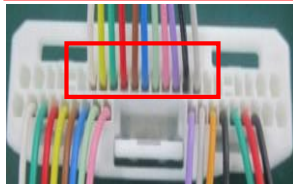


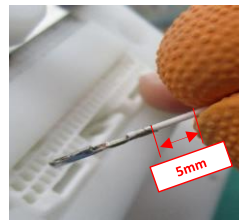
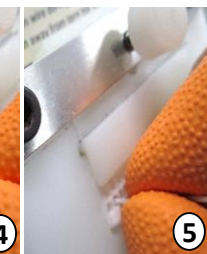
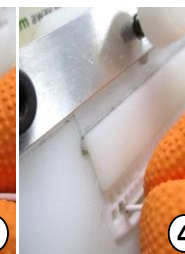

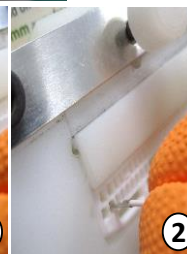
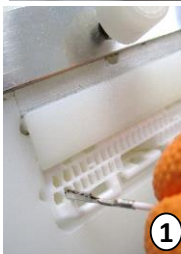

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PARTS:

1. Assy parts
2. CIVUS 0.13 W L=184±2mm; Y L=178±2mm; G L=181±2mm; R L=178±2mm; BR L=176±2mm; L L=175±2mm; LG L=176±2mm; P L=175±2mm; V L=185±2mm; B L=179±2mm; GR L=180±2mm;

JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS																																																											
2	P2	Wire insertion to connector (Group 2 wires) 1827842-1 (W)	<div><div>WIRE INSERTION ILLUSTRATION</div><div><table><tr><th colspan="16">17J613 (GROUP 2 WIRES)</th></tr><tr><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>W</td><td>Y</td><td>G</td><td>R</td><td>BR</td><td>L</td><td>LG</td><td>P</td><td>V</td><td>B</td><td>GR</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td></tr><tr><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>184</td><td>178</td><td>181</td><td>178</td><td>176</td><td>175</td><td>176</td><td>175</td><td>185</td><td>179</td><td>180</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td><td>Empty</td></tr></table><div>X</div></div><div><div><div>GOOD Smaller terminal</div><div></div><div>NG Long terminal</div><div></div></div><div>Wire facing</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>Note: Follow the insertion sequence based on the visual reference</div></div></div><div><div></div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div></div></div> <div><div>Finger COTS</div><div></div></div>	17J613 (GROUP 2 WIRES)																Empty	Empty	Empty	Empty	Empty	W	Y	G	R	BR	L	LG	P	V	B	GR	Empty	Empty	Empty	Empty	Empty	Empty	Empty	Empty	Empty	Empty	Empty	184	178	181	178	176	175	176	175	185	179	180	Empty	Empty	Empty	Empty	Empty	Empty	<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>Note: Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull after insertion.</div> <div>Do not exert extra force.</div> <div>Note: If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>Do not attempt to repair.</div> <div>Note: Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</div>
17J613 (GROUP 2 WIRES)																																																																
Empty	Empty	Empty	Empty	Empty	W	Y	G	R	BR	L	LG	P	V	B	GR	Empty	Empty	Empty	Empty	Empty	Empty																																											
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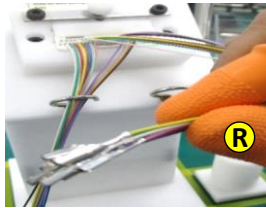
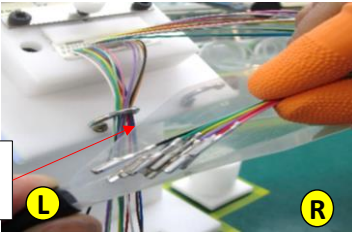
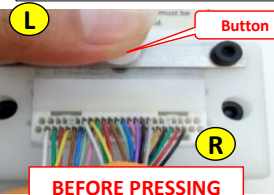
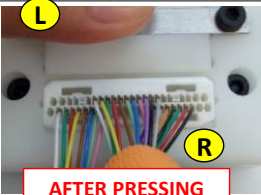








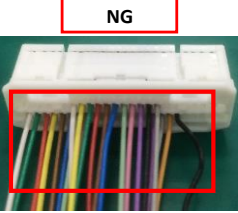
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PARTS:

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

JIG

1. Adaptor jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black Sunprene tube $\phi 7$ L=55 \pm 5mm	<div><p>1. Get the Black sunprene tube $\phi 7$ L=55\pm5mm using left hand then insert the adaptor jig using right hand.</p></div> <div><p>2. Hold the Group 2 wires (11pcs) using right hand.</p></div> <div><p>Use the adaptor jig to easily insert wires.</p></div> <div><p>3. Insert the wires to Black sunprene tube using right hand.</p><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div> <div><p>4. Press the button using left thumb.</p><p>5. Hold the wires using right 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>1. No wrong use of parts. 2. No remaining wires outside black sunprene tube 3. No cut tube</p><p>STANDARD TUBE APPEARANCE</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div>

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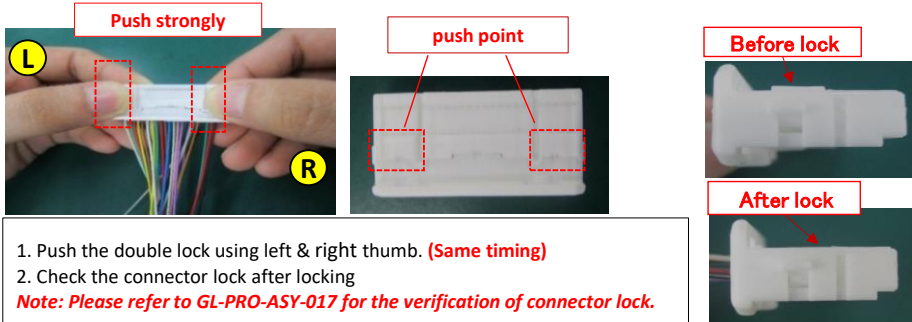
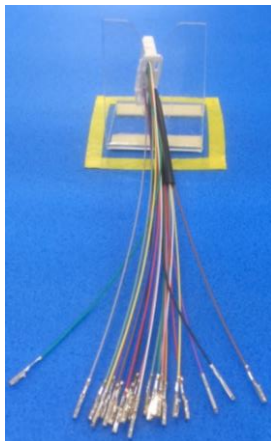

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PARTS:		1. Assy parts			JIG	1. WIP Holder
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Connector lock	<div><div><p>1. Push the double lock using left & right thumb. (Same timing) 2. Check the connector lock after locking <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p></div></div>		n/a	1. No damaged double lock. 2. No half lock connector
5		Pass WIP to P3	<div><p>1. Pass WIP to WIP Holder. Note: One piece flow.</p></div>		<div><div>WIP HOLDER</div></div>	1. No WIP overflow

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