

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Validity Date:

n/aModel Code/Part Number: **666W / 7H0320W7020C**

Customer:

NBS

Document No.:

WI-ENG-PDE-471B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

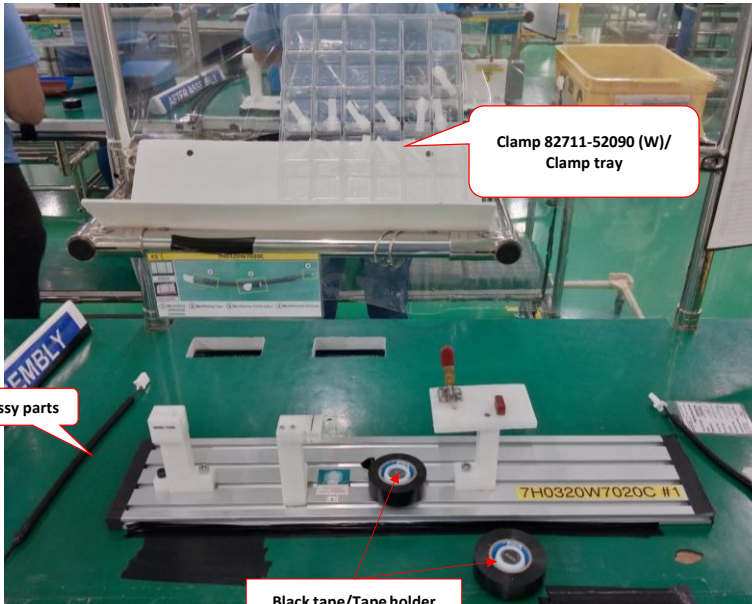
Page No.:

1 of 5**PARTS:**

1. Assy parts: Clamp 82711-52090 (W); Black tape [2pcs.]

JIG:

1. Temporary Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out	<div>Table Lay-out</div>  <div>Clamp 82711-52090 (W)/ Clamp tray</div> <div>Assy parts</div> <div>Black tape/Tape holder</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>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by:
05/17/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
05/04/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Process Name/Title:

Model Code/Part Number: 666W / 7H0320W7020C

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-471B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

PARTS:

1. Clamp 82711-52090 (W)
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

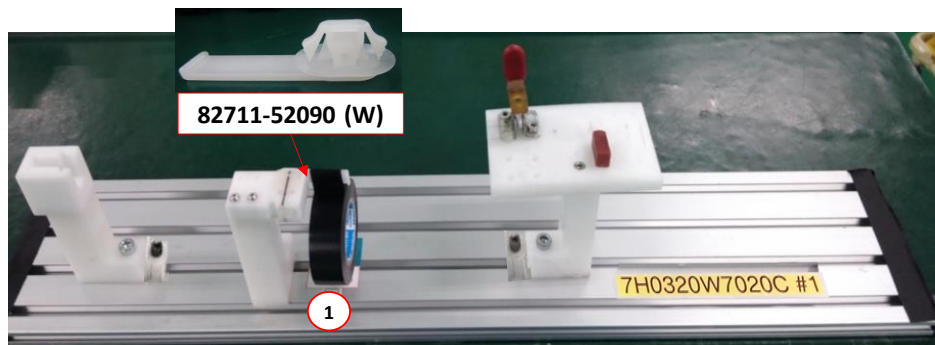
TOOLS/PPE

QUALITY POINTERS

2

P2

Clamp Setting



1. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.

2. Get the Black tape and conduct pre-taping on clamp location 1 using both hands.

Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp

1. No peel-off tape
1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape
4. No missing clamp

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 666W / 7H0320W7020C

Customer:

NBS

Document No.:

WI-ENG-PDE-471B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:

1. Assy part
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

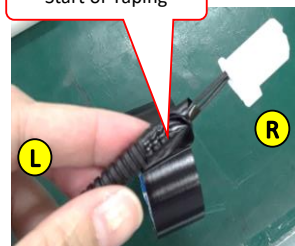
3

P2

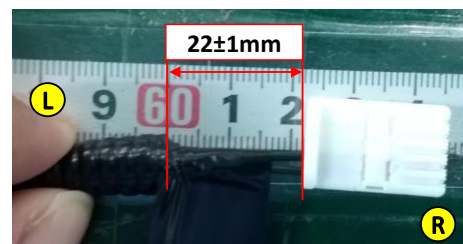
Taping 1
Corrugated tube to wire
near connector



Start of Taping

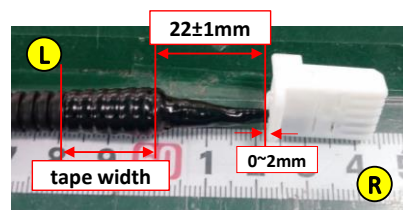


1. Get the **Black tape**, hold corrugated tube using left hand then start pre-taping using both hands



2. Measure from end of corrugated tube up to the edge of connector **22±1mm** then continue the taping process using both hands

Note: Refer to WI-PRO-ASY-001 for taping procedure.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



Note:
Please use calibrated/verified measuring tape when getting the measurement.

1. No peel-off tape
2. No flip-out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension
6. No missing tape

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 666W / 7H0320W7020C

Customer:

NBS

Document No.:

WI-ENG-PDE-471B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


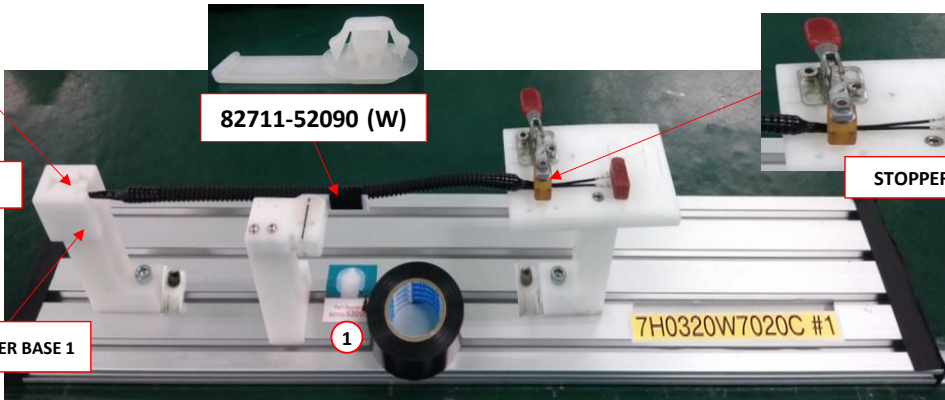

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Black tape		JIG	1. Temporary Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div><p>CONNECTOR SETTING</p></div><div></div></div> <div>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness)</i>. First, set the connector 6098-3810 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the B-B terminal within the stopper then press by Toggle clamp.</div> <div>2. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 5.</div> <div>3. Conduct POINT CHECKING before removing the harness from jig.</div>		n/a	<div><p><i>Note: Make sure no gap between stopper jig and terminal tip</i></p></div> <div>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Model Code/Part Number:

666W / 7H0320W7020C

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-471B

Purpose:



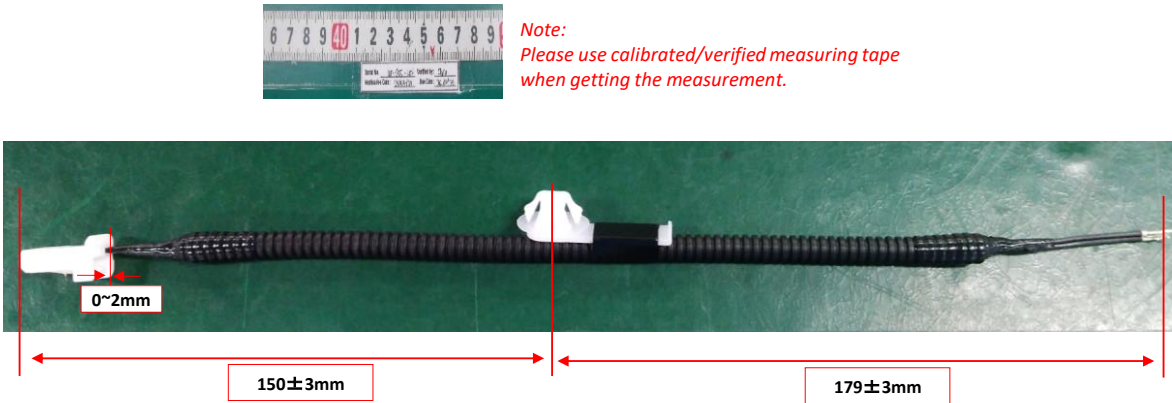
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5

PARTS:	n/a			JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By two's inspection	<div>1. Check the double lock.</div> <div>2. Check the taping condition and clamp attachment.</div> <div>3. Check the terminal appearance, make sure no deformed terminal.</div>  <div>4. Compare to Master sample. <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div>		MASTER SAMPLE 
6		Measurement	 <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div>		FOR HATSUMONO AND OWARIMONO ONLY 1. No wrong measurement

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp