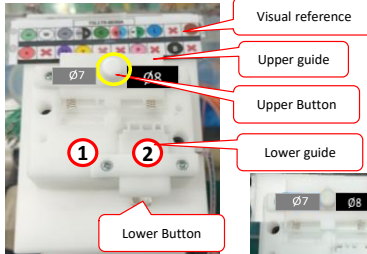

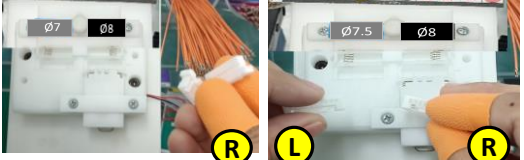
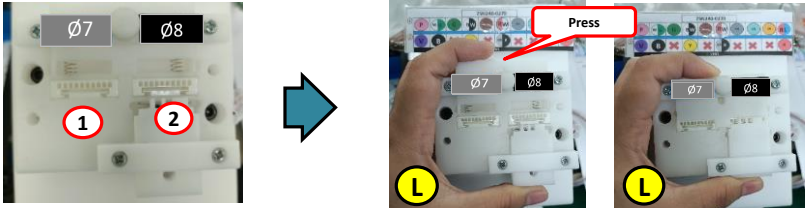




	WORK INSTRUCTION			Effectivity Date:	January 18, 2023		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:				Document No.:	WI-ENG-PDE-183	
	Model Code/Part Number:	011B / 75L179-0030A	Customer:	TRJ	Revision No.:	5	Page No.:
Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			

PARTS:	1. Connector PBVP-10V-S (W) [2pcs]	JIG:	1. Insertion jig
---------------	------------------------------------	------	------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig PBVP-10V-S (W)	    <p>Insertion Jig</p> <p>5 1. Get the 2 pcs of PBVP-10V-S connector using right hand transfer the 1 connector to left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p> <p>5 2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

Revision History						Prepared by:	Checked by:	Approved by:	Noted by:	
01/18/23	5	Improved the insertion jig and procedure. Changed term of Black sunprene tube to Black VM tube (Sunprene). Improved visual/by two's inspection. Include quality pointers.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
04/19/22	4	Improve process illustration and procedure.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
03/21/22	3	Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Established Date: July 10, 2017			

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

January 18, 2023

Validity Date:

n/a

Model Code/Part Number: **011B / 75L179-0030A**

Customer:

TRJ

Document No.:

WI-ENG-PDE-183

Purpose:


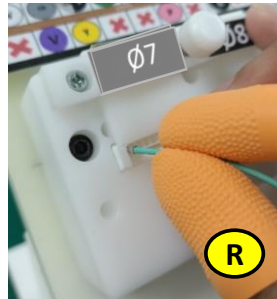


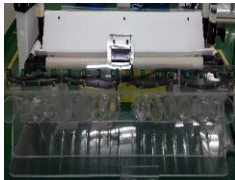

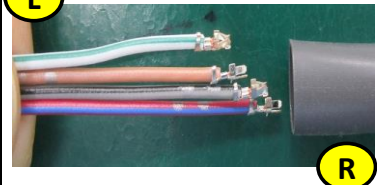

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

2 of 14

PARTS:		1. 1. AVSS 0.3 LG L=217±2mm; W L=215±2mm; GR L=213±2mm; GR/B L=380±2mm; G L=209±2mm; R/L L=382±2mm; W/G L=386; L L=203±2mm; BR L=384±2mm 2. Dark Gray VM tube (Sunprene) Ø7 L=163±3mm		JIG	1. Insertion jig																															
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS																														
2	P1 Wire insertion to Connector PBVP-10V-S (W)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div></div> <div><div>Wire facing</div></div> <table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>LG</td><td>W</td><td>GR</td><td>GR/B</td><td>G</td><td>R/L</td><td>W/G</td><td>L</td><td>X</td><td>BR</td></tr><tr><td>217</td><td>215</td><td>213</td><td>380</td><td>209</td><td>382</td><td>386</td><td>203</td><td></td><td>384</td></tr></table> <div></div> <div>51. Get the LG wire using left hand and transfer to right hand then insert to connector. Repeat the process for W-GR-GR/B-G-R/L-W/G-L-BR wires. Check the wire after insertion. <i>Note: Follow the insertion sequence based on the illustration.</i></div>			1	2	3	4	5	6	7	8	9	10	LG	W	GR	GR/B	G	R/L	W/G	L	X	BR	217	215	213	380	209	382	386	203		384	<div>STEERING NAVIGATION</div> <div></div> <div>CONTROLLER</div> <div></div>	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div>Document References:</div> <div>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div>
1	2	3	4	5	6	7	8	9	10																											
LG	W	GR	GR/B	G	R/L	W/G	L	X	BR																											
217	215	213	380	209	382	386	203		384																											
3	5Wire insertion to Dark Gray VM tube (Sunprene) Ø7 L=163±3mm	<div></div> <div></div> <div>51. Get the Dark Gray VM tuber (Sunprene) Ø7 L=163±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</div>			N/A	<div>1. No wrong usage of parts</div> <div>2. No deformed terminal</div> <div>3. No tangled wires</div>																														

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number: **011B / 75L179-0030A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 18, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

3 of 14

PARTS:

1. AVSS 0.3 R L=191±2mm; V L=195±2mm; Y L=197±2mm; P L=203±2mm; B L=207±2mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

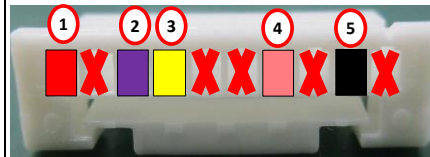
QUALITY POINTERS

4

P1

Wire insertion to
Connector
PBVP-10V-S (W)

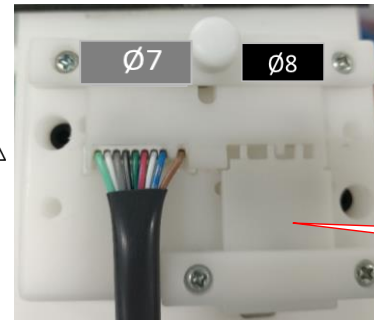
INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

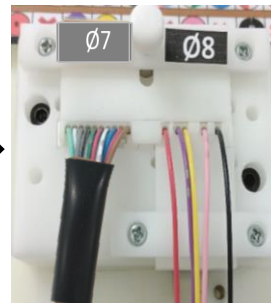
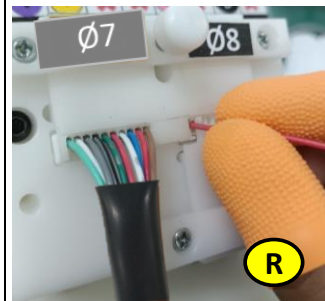
1	2	3	4	5	6	7	8	9	10
R	X	V	Y	X	X	P	X	B	X
191		195	197			203		207	

5



Note: Holes that need to be insert are only open.

Lower guide



1. Get the **R** wire using right hand and insert to connector. Repeat the process for **V-Y-P-B** wires. Check the wire after insertion.

Note: Follow the insertion sequence based on the above illustration.

STEERING NAVIGATION



CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

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TAPING ASSEMBLY PROCESS

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Model Code/Part Number: **011B / 75L179-0030A**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-183

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH


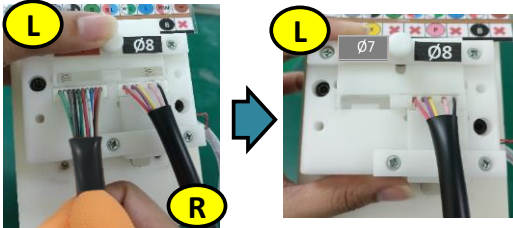


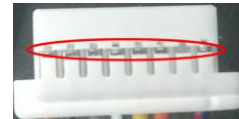

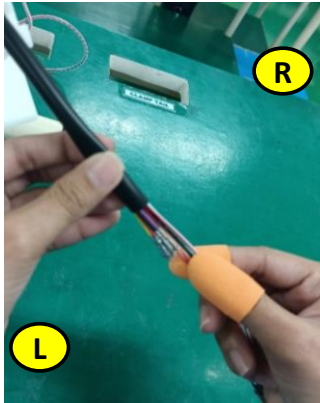
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Revision No.:

5

Page No.:

4 of 14

PARTS: 		1. Black VM tube (Sunprene) Ø8 L=151±3mm		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div></div>		N/A	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div>  <div>Terminal tip must be visible</div> <div>Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</div>
6		<div></div>		N/A	<div>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</div>

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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **011B / 75L179-0030A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 18, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

5 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P1

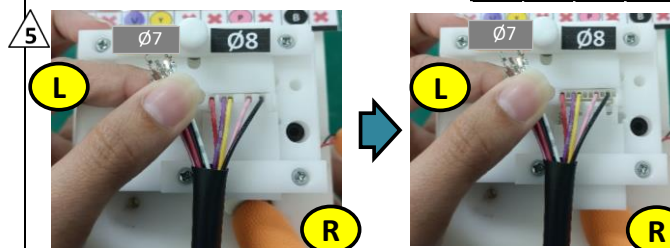
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

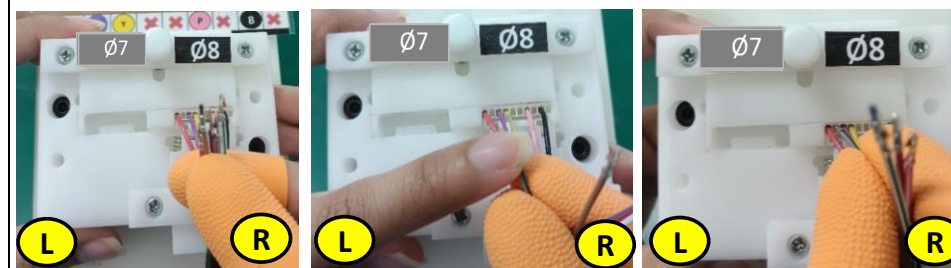


Wire facing

1	2	3	4	5	6	7	8	9	10
R	GR/B	V	Y	R/L	X	P	W/G	B	BR
191	380	195	197	382	X	203	386	207	384



1. Press the Lower button
using right hand. Holes that
need to be insert are only
open.



2. Hold the **GR/B wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **R/L-W/G-BR wires**. Check the wire after insertion
Note: Follow the insertion sequence based on the above illustration.

**STEERING
NAVIGATION**



CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

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WORK INSTRUCTION

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Model Code/Part Number: **011B / 75L179-0030A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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January 18, 2023

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Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

6 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

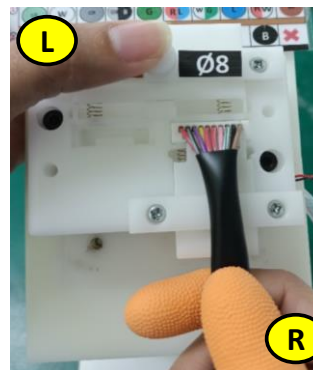
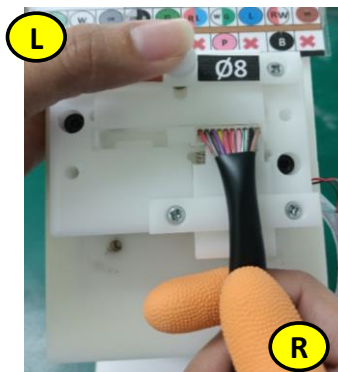
TOOLS/PPE

QUALITY POINTERS

7

P1

Wire insertion to
Connector
PBVP-10V-S (W)
(Continuation)



3. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.

N/A



Terminal tip must be visible

Document References:

1. Refer to GL-PRO-ASY-025 for
Inspection Standard for Coupler
Insertion.

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **011B / 75L179-0030A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

7 of 14

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

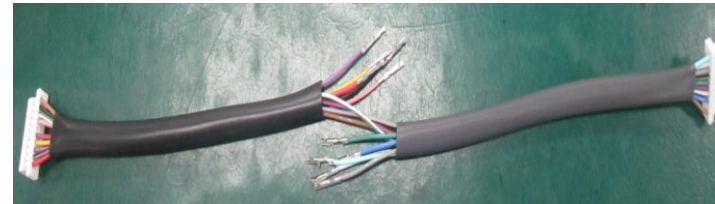
TOOLS/PPE

QUALITY POINTERS

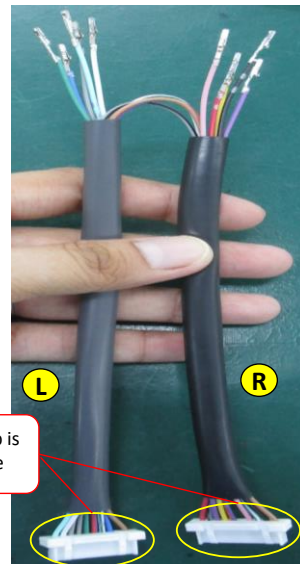
8

P1

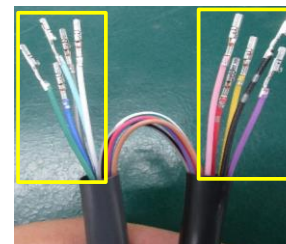
Wire arrangement



BEFORE FOLDING



AFTER FOLDING



1. Hold the assy parts using both hands then conduct wire arrangement.

n/a

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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WORK INSTRUCTION

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Model Code/Part Number **011B / 75L179-0030A**

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Purpose: ☐ PROTOTYPE

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Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

8 of 14

PARTS:		1. Connector 1746872-1 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<p>Connector setting to insertion jig 1746872-1 (B)</p>		N/A	<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p> <p>CONNECTOR LOCK APPEARANCE CHECK</p> <p>5</p> <p>CONNECTOR ILLUSTRATION</p> <p>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</p>

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WORK INSTRUCTION

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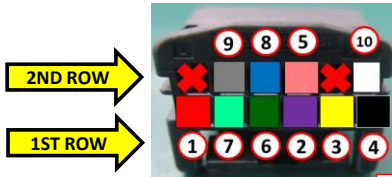
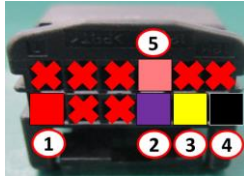
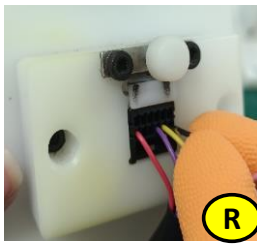
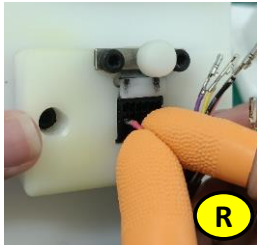
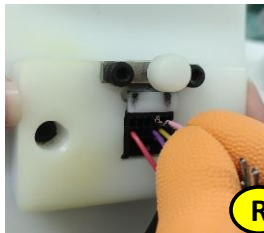
WI-ENG-PDE-183

Revision No.:

5

Page No.:

9 of 14

PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
10	P1	Wire insertion to Connector 1746872-1 (B)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div><div><div>2ND ROW</div><div>1ST ROW</div></div><div></div><div>BLACK VM TUBE (SUNPRENE)</div><div></div><div>FIRST ROW (LEFT TO RIGHT)</div><div>SECOND ROW (LEFT TO RIGHT)</div><div><div></div><div></div></div><div><div>1. Insert first the wires from Black VM tube (Sunprene). Hold the R wire and insert to terminal slot 1 using right hand. Repeat the process for V-Y-B wires. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></div><div>2. Hold the P wire and insert to terminal slot 5. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></div></div></div></div>			N/A	<div>1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div>Document References: 1. Refer to GL-PRO-ASY-028 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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WORK INSTRUCTION

Effectivity Date:

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TAPING ASSEMBLY PROCESS

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Customer:

TRJ

Document No.:

WI-ENG-PDE-183

Purpose:


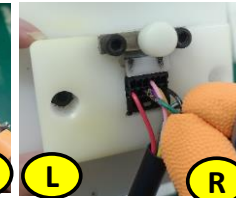
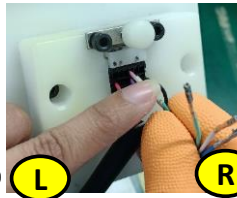
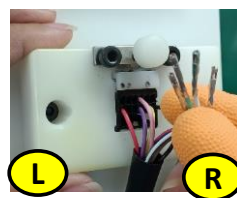
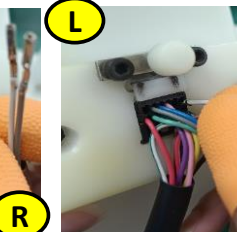
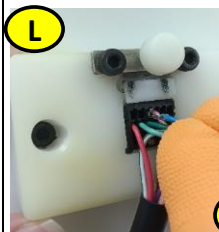
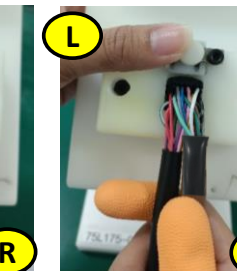
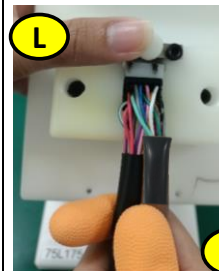
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

10 of 14

PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div><div>DARK GRAY VM TUBE</div><div></div></div><div></div><div>3. Hold the G wire using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for LG wire. <i>Note: Follow the insertion sequence based on the above illustration.</i></div><div></div><div>4. Hold the L wire and insert to terminal slot 8 using right hand. Repeat the process for GR-W wires. <i>Note: Follow the insertion sequence based on the illustration.</i></div><div></div><div>5. Press the Upper button using left hand then remove the assy part using right hand.</div></div>		n/a	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div>

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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **011B / 75L179-0030A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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Effectivity Date:

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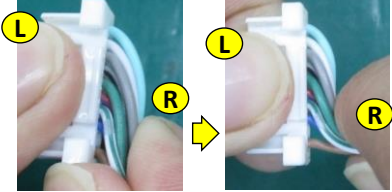
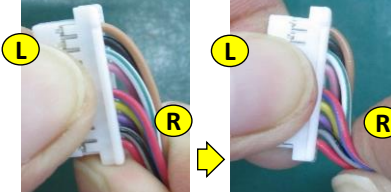




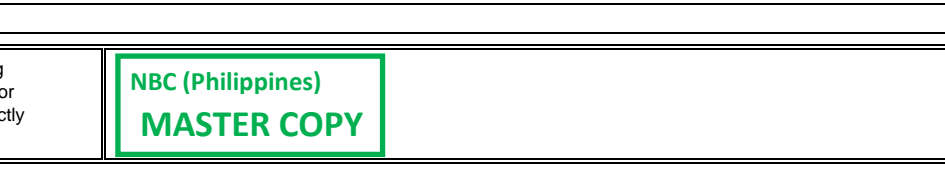
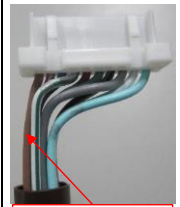
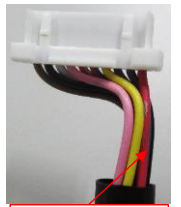
WI-ENG-PDE-183

Revision No.:

5

Page No.:

11 of 14

PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<p>DARK GRAY VM TUBE (SUNPRENE)</p>  <p>BLACK VM TUBE (SUNPRENE)</p>  <p>1. Hold the connector PBVP-10V-S (W) using left hand and slightly fold the wires from Dark Gray sunprene tube <i>(as shown in illustration above)</i> using right hand. Repeat the process for Black sunprene tube wires.</p> <p>BEFORE FOLDING</p>  <p>AFTER FOLDING</p>  <p>DOUBLE LOCK/ FOLDED WIRES IN UPWARD</p>  <p>DOUBLE LOCK IN UPWARD POSITION</p>  <p>FOLDED WIRES UNDER POSITION</p>  <p>WRONG FACING</p>		n/a	<p>WIRE FOLDING APPEARANCE CHECK</p>  <p>BR wire must be straight</p>  <p>R wire must be straight</p> <ol style="list-style-type: none">1. No wrong orientation of connector2. No tangled wires3. No terminal backing out4. No wrong facing5. No tangled wires

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 18, 2023

Model Code/Part Number

011B / 75L179-0030A

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

12 of 14

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

12

P1

Visual/By two's inspection

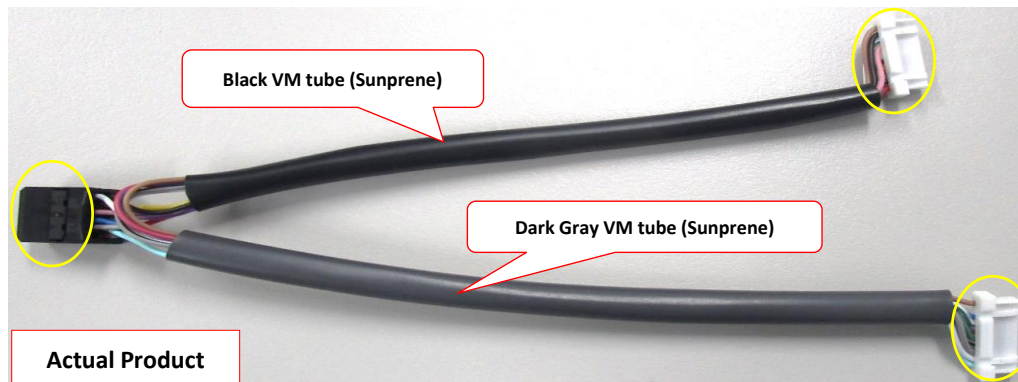
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1. Check the connector lock, locking of connector is included in Steering electrical test.

2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

4. Check the orientation of harness.



Actual Product

5

5. Compare to Master Sample by tapping.

Master Sample



Assembly product

Document References:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

MASTER SAMPLE



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Customer: **TRJ**

Purpose: ☐ PROTOTYPE

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Document No.:


WI-ENG-PDE-183

Revision No.:

5

Page No.:

13 of 14

PARTS:	n/a			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Measurement			<p>1. No wrong dimension</p> <p>Important Reminder/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono</p>

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Document No.:

WI-ENG-PDE-183

Revision No.:

5

Page No.:

14 of 14

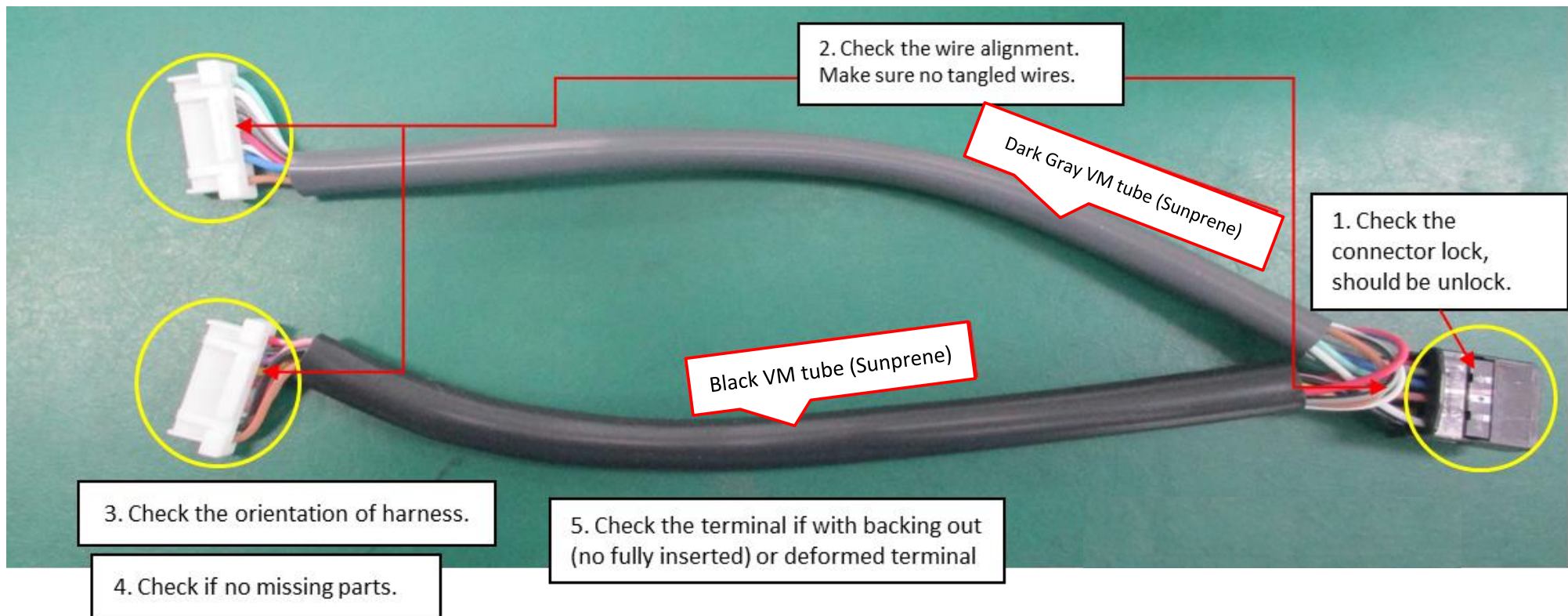
PARTS:

n/a

JIG

n/a

5 QUALITY CHECKPOINTS



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