



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

June 7, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: D01L / 75N351-0021

Customer:

TRJ

Document No.:

WI-ENG-PDE-101

Purpose:

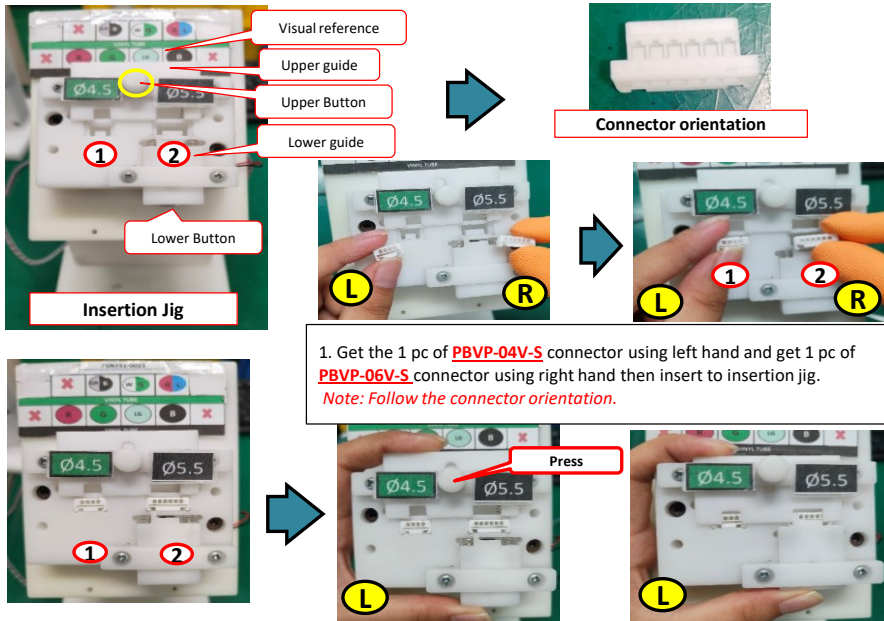
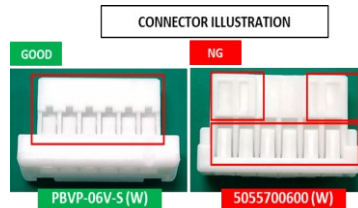
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

1 of 16

PARTS:		1. Connector PBVP-04V-S (W) 2. Connector PBVP-06V-S (W)				JIG:	1. Insertion jig					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
1	P1	Connector setting to insertion jig PBVP-04V-S (W) PBVP-06V-S (W)	<div><p>1. Get the 1 pc of <b>PBVP-04V-S</b> connector using left hand and get 1 pc of <b>PBVP-06V-S</b> connector using right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p><p>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p></div>				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>CONNECTOR ILLUSTRATION</b></div> <div></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>			
Revision History							Prepared by	Reviewed by	Approved by	Noted by		
06/07/23	7	Improve the insertion jig and procedue. Improved work procedure/illustration. Update Quality checkpoints.				D. Castillo	J. Loterte	C. Villanueva	A. Arañes			
05/10/23	6	Inclusion of quality checkpoints; standardize VM tube (Sunprene) term.				J. Loterte	C. Villanueva	A. Arañes	n/a			
10/21/22	5	Improve Quality pointers; Reminders/Notes and references on page no. 2,3,4,5,6,6,8,9,11 and 12. Improve work procedure/illustration on process no.11-Visual/by two's inspection.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:	July 09, 2019	

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:




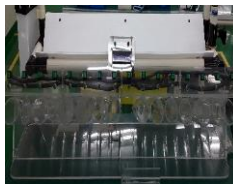


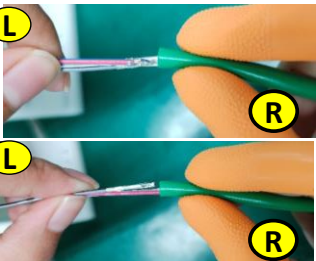
**2 of 16**

### PARTS:

1. AVSS 0.3 GR/B L=158±2mm; W/G L=158±2mm; R/L L=286±2mm
2. Green VM tube (Sunprene) Ø4.5 L=116±3mm

### JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1  Wire insertion to connector PBVP-04V-S (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div>Wire facing</div><div>1. Get the <b>GR/B wire</b> using right hand and insert to connector. Repeat the process for <b>W/G-R/L wires</b>. Check the wire after insertion <b>Note: Follow the insertion sequence based on the illustration.</b></div></div>	<div><div>STEERING NAVIGATION</div><div>CONTROLLER</div></div>	<ol style="list-style-type: none"><li>1. Use provided jig per model</li><li>2. No wrong usage of parts</li><li>3. One by one insertion</li><li>4. No wrong insertion</li><li>5. No deformed terminal</li><li>6. No stuck of terminal tip</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. <b>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></li><li>2. <b>Please hold the wire near terminal during insertion.</b></li><li>3. <b>insertion must be from left to right.</b></li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to <b>WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</b></li><li>2. Refer to <b>WI-ENG-PDE-044 for Steering Navigation Controller procedure.</b></li><li>3. Refer to <b>GL-PRO-ASY-029 for Pull-Push procedure.</b></li></ol>
3	Wire insertion to connector Green VM tube (Sunprene) Ø4.5 L=116±3mm	<div><div><div>1. Get the <b>Green VM tube (Sunprene) Ø4.5 L=116±3mm</b> using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hands.</div></div></div>	n/a	<ol style="list-style-type: none"><li>1. Use provided jig per model</li><li>2. No wrong usage of parts</li><li>3. One by one insertion</li><li>4. No wrong insertion</li><li>5. No deformed terminal</li><li>6. No stuck of terminal tip</li></ol>

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**3 of 16**

### PARTS:

1. AVSS 0.3 R L=158±2mm; G L=158±2mm; LG L=158±2mm; B L=158±2mm

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

4

P1

Wire insertion to connector  
PBVP-06V-S (W)

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



#### WIRE INSERTION ILLUSTRATION

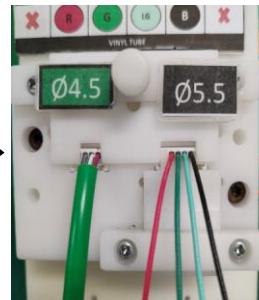
1	2	3	4	5	6
X	R	G	LG	B	X
	158	158	158	158	



#### WIRE FACING

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 **G-LG-B wires**. Check the wire after insertion.

Note: Follow the insertion sequence based on 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. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion must be from left to right.

#### Document reference/s:

1. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance.
2. Refer to **WI-ENG-PDE-044** for Steering Navigation Controller procedure.
3. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**4 of 16**

### PARTS:

1. Assy parts
2. Black VM tube (Sunprene) Ø5.5 L=116±3mm

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

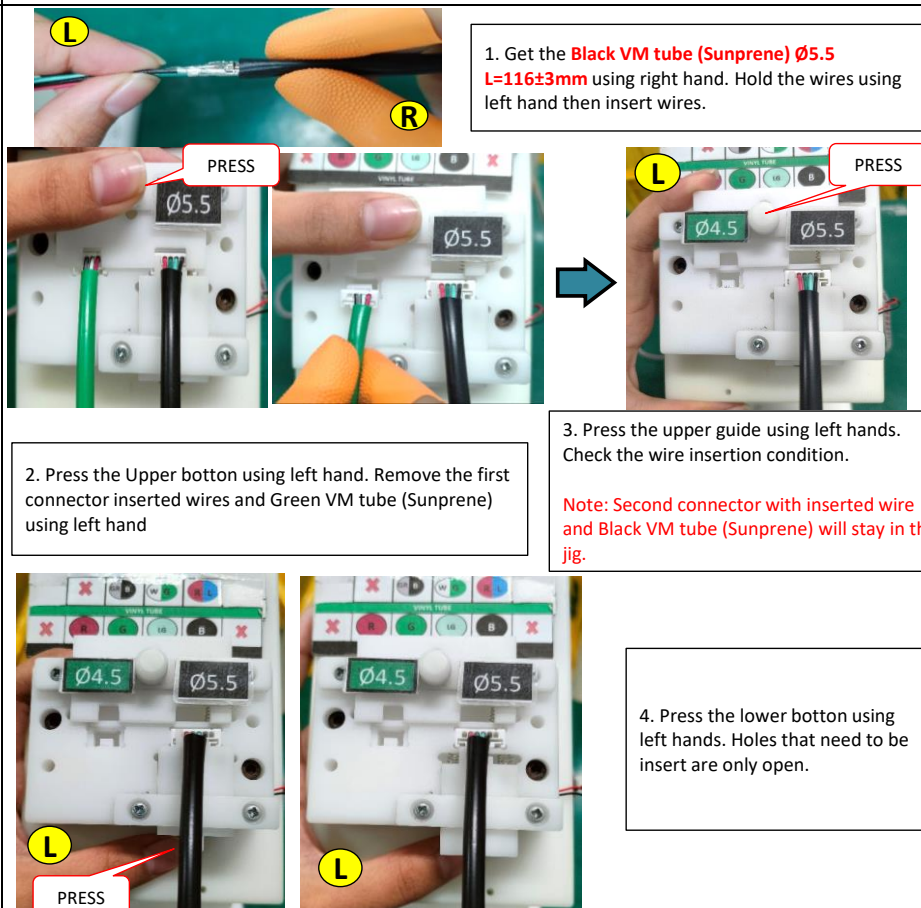
### TOOLS/PPE

### QUALITY POINTERS

5

P1

Wire insertion to  
Black VM tube (Sunprene) Ø5.5  
L=116±3mm



1. Get the **Black VM tube (Sunprene) Ø5.5 L=116±3mm** using right hand. Hold the wires using left hand then insert wires.

2. Press the Upper button using left hand. Remove the first connector inserted wires and Green VM tube (Sunprene) using left hand

3. Press the upper guide using left hands. Check the wire insertion condition.

Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.

4. Press the lower button using left hands. Holes that need to be insert are only open.

n/a

1. No wrong use of parts
2. No deformed terminal
3. No tangled wires

#### Document reference/s:

1. Refer to **GL-PRO-ASY-025** for Inspection Standard for connector insertion.



**Terminal tip must be visible**

**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

Effectivity Date:

June 7, 2023

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

D01L / 75N351-0021

Customer:

TRJ

Document No.:

WI-ENG-PDE-101

Purpose:

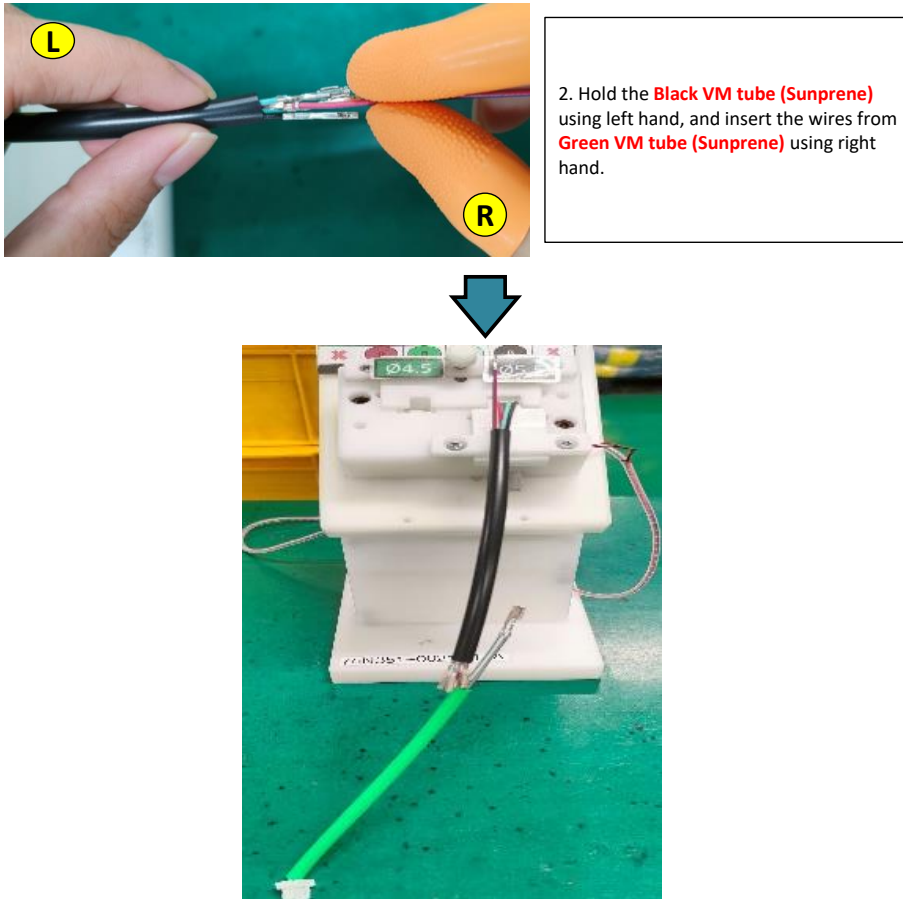
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

5 of 16

PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to assy parts			n/a	1. No wrong use of parts 2. No deformed terminal 3. No tangled wires

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**6 of 16**

### PARTS:

1. Assy parts

### JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

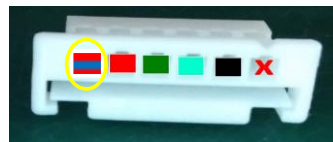
QUALITY POINTERS

7

P1

Wire insertion to  
connector  
PBVP-06V-S (W)

#### INSERTION SEQUENCE FROM LEFT TO RIGHT

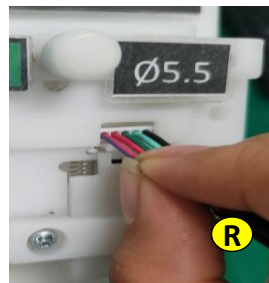


#### WIRE INSERTION ILLUSTRATION

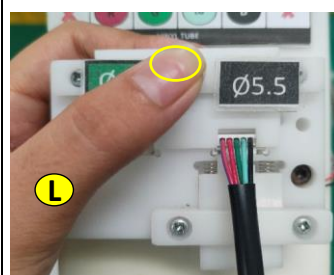
1	2	3	4	5	6
R/L	R	G	LG	B	X
286	158	158	158	158	



#### WIRE FACING



1. Hold the **R/L wire** and insert to terminal slot 1 using right hand.  
**Note: Follow the insertion sequence based on the illustration.**



2. Press the upper button using left hand then remove the assy using right hand. Check the wire insertion condition.

#### STEERING NAVIGATION



#### CONTROLLER



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

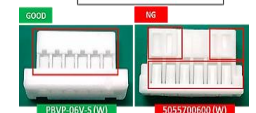
#### Important reminders/Note/s:

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.
3. insertion of wire must be from left to right.

#### Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

#### CONNECTOR ILLUSTRATION



**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**7 of 16**

### PARTS:

1. Assy parts

### JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

P1

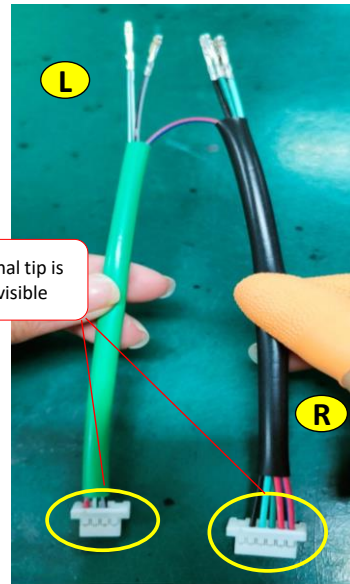
Wire Folding

7



BEFORE FOLDING

AFTER FOLDING



Terminal tip is not visible

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

n/a

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

**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

Process Name/Title:

Model Code/Part Number: **D01L / 75N351-0021**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

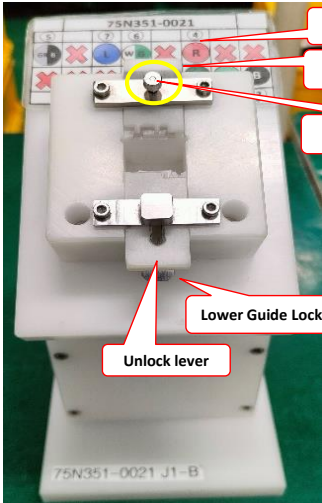

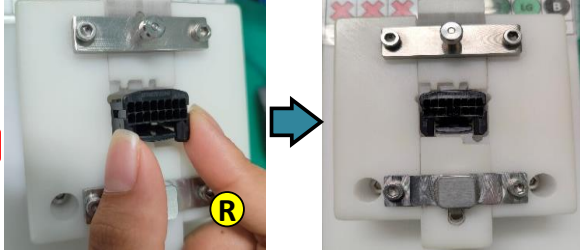
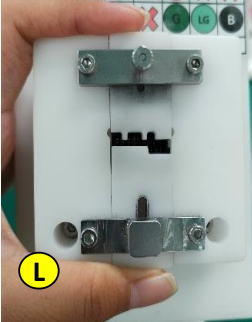
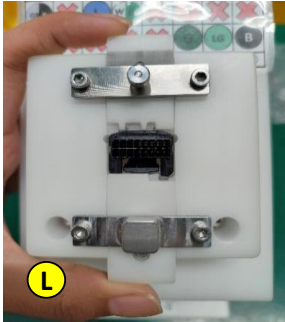
**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**8 of 16**

PARTS:		1. Connector 1318386-2 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Connector setting to insertion jig 1318386-2 (B)	<div><div>INSERTION JIG</div><div>75N351-0021 J1-B</div></div> <div><div>Double lock</div><div>CONNECTOR ORIENTATION</div><div>1. Get the connector <b>1318386-2 (B)</b> using right hand then insert to insertion jig. <b>Note: Follow the connector orientation</b></div></div> <div><div></div><div>2. Press the upper and lower guide lock using left hand. Holes that needs to be inserted are only open.</div></div>		n/a	<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><b>Important reminders/Note/s:</b>  <b>1. Check the connector before insertion.</b> <b>2. Automatically dispose and replace the unit if once encountered bend terminal. difficulty of insertion and half-locked.</b></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:

June 7, 2023

Model Code/Part Number:

D01L / 75N351-0021

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-101

Revision No.:

7

Page No.:

9 of 16

**PARTS:**

1. Assy parts

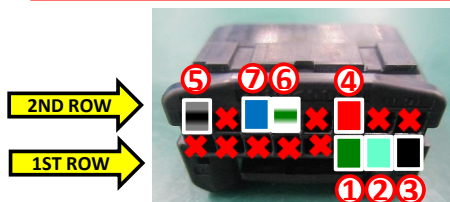
**JIG**

1. Insertion jig

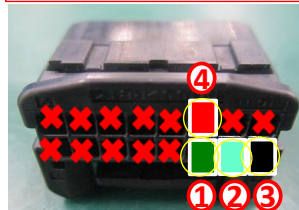
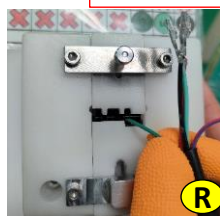
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

10

P1

Wire insertion to  
connector  
1318386-2 (B)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

X	X	X	X	X	4		
					R	X	X
					158		
					1	2	3
X	X	X	X	X	G	LG	B
					158	158	158

**BLACK VM TUBE (SUNPRENE)****Wire facing****FIRST ROW (LEFT TO RIGHT)****SECOND ROW (LEFT TO RIGHT)**

1. Insert the wires from **Black VM tube (Sunprene)**. Hold the **G wire** and insert to terminal **slot 6** using right hand. Repeat the process for **LG-B wires**.  
**Note: Follow the insertion sequence based on the illustration stated above.**

2. Hold the **R wire** and insert to terminal **slot 14**.  
**Note: Follow the insertion sequence based on the illustration stated above.**

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
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.
3. Insertion of wire must be from left to right.

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

**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:

June 7, 2023

Model Code/Part Number:

D01L / 75N351-0021

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-101

Revision No.:

7

Page No.:

10 of 16

**PARTS:**

1. Assy parts

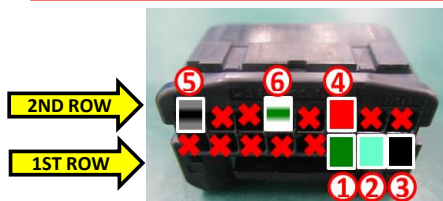
**JIG**

1. Insertion jig

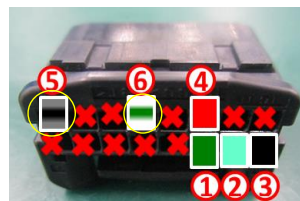
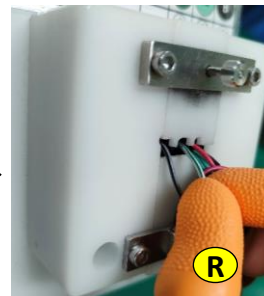
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

10

P1

Wire insertion to  
connector  
1318386-2 (B)  
(Continuation)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

5			6		4		
GR/B	X	X	W/G	X	R	X	X
158			158		158		
X	X	X	X	X	1	2	3
					G	LG	B
					158	158	158

**GREEN VM TUBE (SUNPRENE)****Wire facing****SECOND ROW (LEFT TO RIGHT)**

3. Insert the wires from **Green VM tube (Sunprene)**. Hold the **GR/B** wire and insert to terminal slot 5 and **W/G** to terminal slot 6.

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

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
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.
3. Insertion of wire must be from left to right.

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**11 of 16**

### PARTS:

1. AVSS 0.5 L L=129mm±1mm
2. Black VM tube (Sunprene) Ø3 L=113±3mm

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

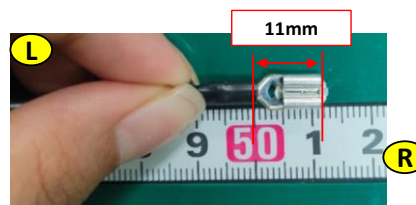
11

P1

Wire insertion to  
Black VM tube  
(Sunprene) Ø3  
L=113±3mm



1. Get the **Blue wire** using right hand then insert to **Black VM tube (Sunprene) Ø3 L=113±3mm**.



2. Measure the end of sunprene tube up to the tip of the terminal, it should be **11mm**.



### MEASURING TAPE



1. No wrong use of parts

### Important reminders/Note/s:

1. Please use calibrated/ verified measuring tape when getting the measurement.
2. Peel-off wires should be covered by sunprene tube (Black)



**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**12 of 16**

### PARTS:

1. Assy parts

### JIG

1. Insertion jig

### NO.

### PROCESS NAME



### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

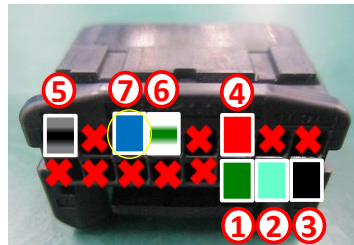
### QUALITY POINTERS

12

P1

Wire insertion to  
connector  
1318386-2 (B)  
(Continuation)

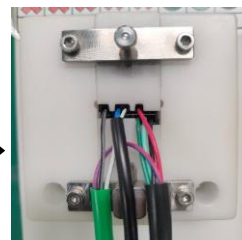
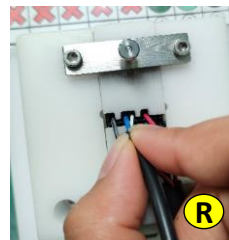
#### INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

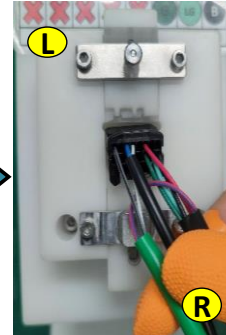
#### Wire Insertion Illustration

5	7	6	4
GR/B	L	W/G	R
158	129	158	158
X	X	X	X
X	X	X	X
158	158	158	158



4. Get the **L** wire with inserted tube and insert to terminal slot **7** using right hand.

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



5. Press the upper and lower guide (same timing) using both hands then remove the assy part using right hand.

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

#### Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
3. Insertion of wire must be from left to right.

#### Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

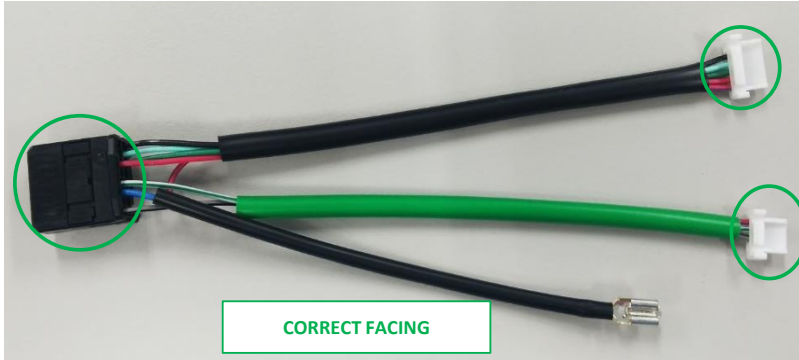
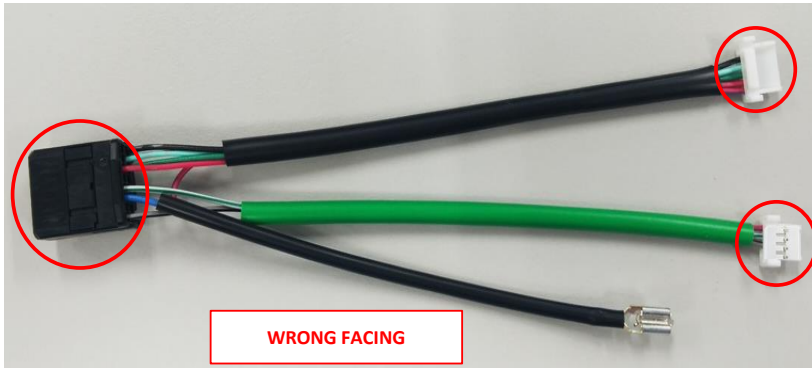
**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**13 of 16**

PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Wire arrangement	<div>1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires. <i>Refer to below illustration for Good wire arrangement and facing.</i></div> <div></div> <div></div>		n/a	1. No wrong orientation of connector 2. No tangled wires 3. No wrong harness facing

**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

Model Code/Part Number:

**D01L / 75N351-0021**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**14 of 16**

#### PARTS:

1. Assembled parts
2. Master sample

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

P1

Visual/By Two's Inspection

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

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

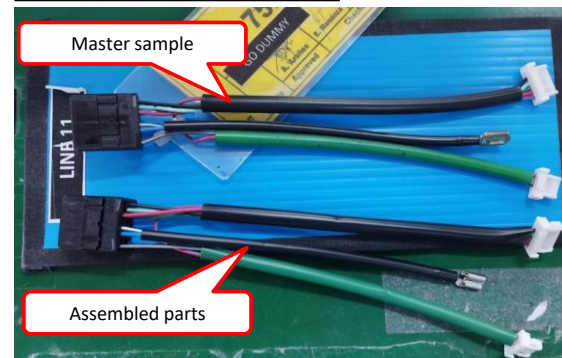
3. Check the terminal if with backing out( not fully  
inserted) or deformed terminal.



**ACTUAL PRODUCT**

4. Check the orientation of  
harness.

5. Compare to **Master sample** by  
tapping



1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

**MASTER SAMPLE**



**Document reference/s:**

1. Refer to WI-ENG-PDE-431 for  
Steering electrical test after assembly

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

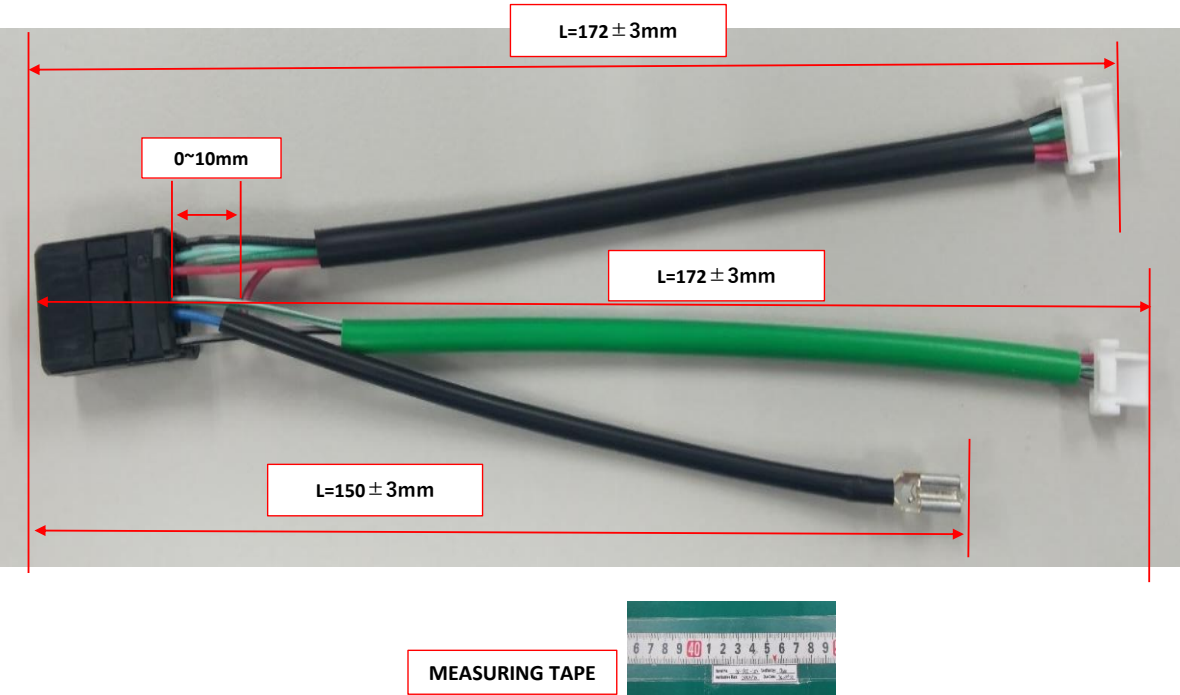
**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**15 of 16**

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

**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**

Model Code/Part Number: **D01L / 75N351-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**June 7, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-101**

Revision No.:

**7**

Page No.:

**16 of 16**

**PARTS:**

n/a

JIG:

n/a

## QUALITY CHECKPOINTS

### 75N351-0021

1. Check the connector lock, should be unlock.

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

3. Check the orientation of harness.

**BLACK VM TUBE (SUNPRENE)**

**GREEN VM TUBE (SUNPRENE)**

**BLACK VM TUBE (SUNPRENE)**

**CORRECT FACING**

4. Check if no missing parts.

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

**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