

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

January 29, 2022

Model Code/ Part Number:

**010B / 7L0030-7024**

Customer:

**TRQSS**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-390B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 6

**PARTS:**

1. Assy parts; Label 7V1070-0020 (73230-06750); Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clip type clamp 82711-1E360(W); Black tape [2pcs

**JIG:**

Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out	<p>TABLE LAY-OUT</p> <p>Label (7V2080-0020)/ Label dispenser</p> <p>Clamp 82711-52090(W)/Clamp tray</p> <p>Clamp 82711-34490 (B)/ Clamp tray</p> <p>Assy parts</p> <p>Clip type Clamp 82711-1E360 (W)</p> <p>Clamp Assembly jig</p> <p>(Tape holder/ Black tape)</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/29/22	0	Initial issue. Change PCB from 2 chip (61C619-0002) to 1 chip (7N0994-7060). Change wire color from Gray(GR) to Green (G)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Established Date:							July 10, 2017			

**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: **010B / 7L0030-7024**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 29, 2022

Validity Date:

n/a

Document No.:

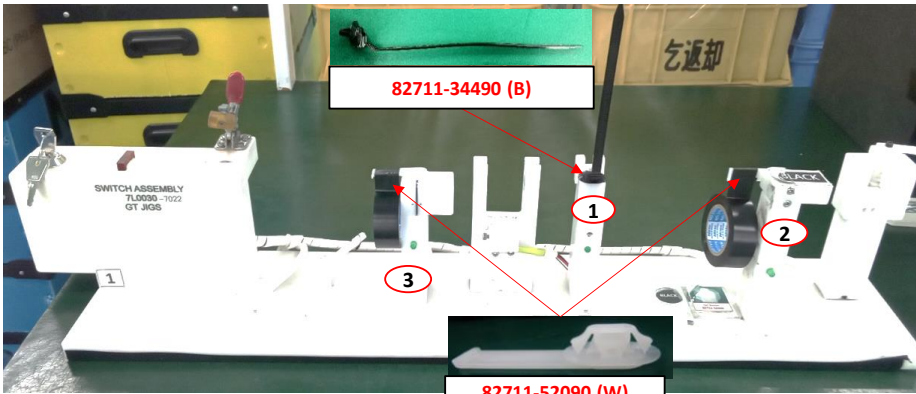

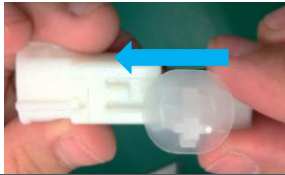
WI-ENG-PDE-390B

Revision No.:

0

Page No.:

2 of 6

PARTS:		1. Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W) [2pcs]	JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp assembly setting	 <p>82711-34490 (B)</p> <p>82711-52090 (W)</p> <p>1. Get 1 pc of band clamp 82711-34490 (B) using right hand and set to clamp location ① using both hands.</p> <p>2. Get 2 pcs of clamp 82711-52090 (W) using both hands and set to clamp location 3 and 2 using both hands.</p> <p>3. Get the Black tape using right hand and conduct pre-taping on clamp location 3 and 2 using both hands.</p>	n/a	 <p>One side tape under clamp</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp</p>
3	Clamp attachment (clip type clamp)	 <p>1. Hold the connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></p>	n/a	1. Must be fully inserted

**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: **010B / 7L0030-7024**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 29, 2022

Validity Date:

n/a

Document No.:

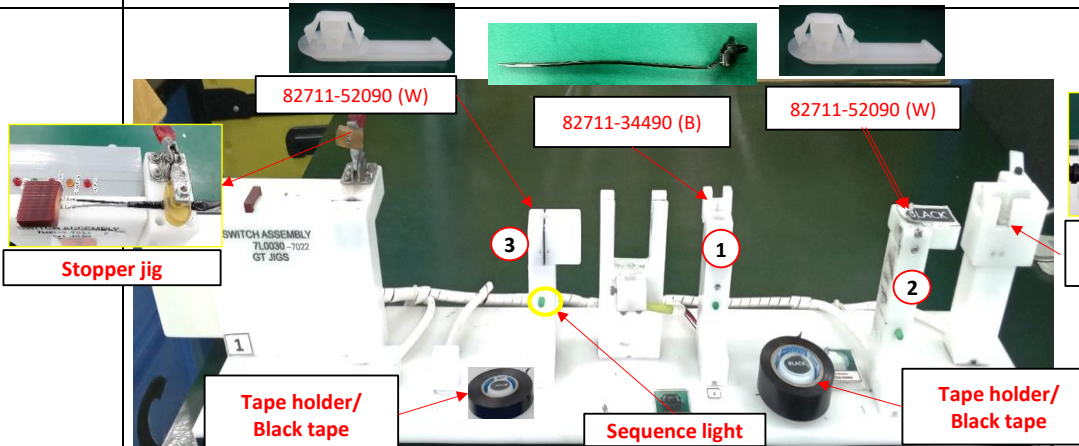
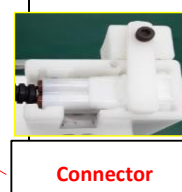


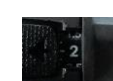
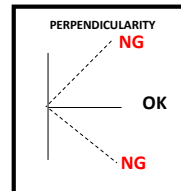
WI-ENG-PDE-390B

Revision No.:

0

Page No.:

3 of 6

PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly	<div><p>1. Put the assy parts into jig using both hands. First put the connector to receiver base using left hand and lock using right hand. Second, put the terminal into stopper jig using left hand and pull down the toggle clamp using right hand. <i>Refer to above illustration for the correct setting.</i></p><p>2. Check if the LED light for <b>POWER, CLAMP</b> and <b>SEQUENCE LIGHT</b> is <b>ON</b>. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the attention of the Leader and <b>WAIT</b> for instruction.</p><p>3. Initially tighten the band clamp <b>82711-34490</b> on clamp location <b>1</b> using right hand.</p><p>4. Get the bando gun using right hand then cut the band clamp on Location <b>1</b>. Press the <b>SW button</b> every cut using both hand.</p></div>	<div><p>Connector</p><p>BANDO GUN</p></div>	<p>Note: Make sure no clearance between terminal and stopper jig</p>  <ol style="list-style-type: none"><li>1. No wrong setting of clamp</li><li>2. No wrong use of clamp</li><li>3. No Loose attachment of clamp</li><li>4. No wrong setting of Bando gun</li><li>5. No wrong use of tape</li><li>6. No peel off tape</li><li>7. No missing tape</li></ol> <div><p>Fixed setting of band clamp cutter: 1 ~ 2</p><p><b>BANDO GUN ALIGNMENT</b></p></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**

Model Code/ Part Number: **010B / 7L0030-7024**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 29, 2022

Validity Date:

n/a

Document No.:

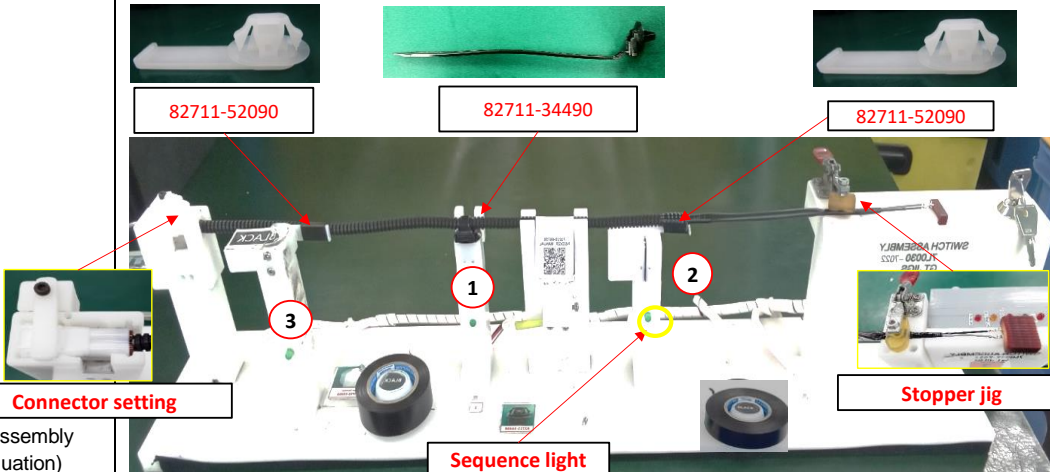


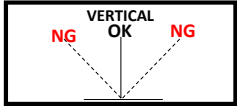
WI-ENG-PDE-390B

Revision No.:

0

Page No.:

4 of 6

PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly (Continuation)	<div><p>82711-52090</p><p>82711-34490</p><p>82711-52090</p><p>Connector setting</p><p>Sequence light</p><p>Stopper jig</p><p>1</p><p>2</p><p>3</p></div> <div><p>5. Hold the tape on clamp location ② using both hands. Make 3 windings then cut the tape using both hand. Press the SW button every taping. Continue if sequence light on clamp location 3 was ON.</p><p>6. Hold the tape clamp on location ③ using both hands. Make 3 windings then cut the tape. Press the SW button every taping. Proceed to attachment of Label.</p></div> <div><p>One side tape under clamp</p><p>GOOD</p><p>NG</p></div>	<div><p><b>BANDO GUN</b></p></div>	<p>Note: Make sure no clearance between terminal and stopper jig</p>  <ol style="list-style-type: none"><li>1. No wrong setting of clamp</li><li>2. No wrong use of clamp</li><li>3. No Loose attachment of clamp</li><li>4. No wrong setting of Bando gun</li><li>5. No wrong use of tape</li><li>6. No peel off tape</li><li>7. No missing tape</li></ol> <div><p><b>BANDO GUN ALIGNMENT</b></p><p>VERTICAL OK NG</p></div> <p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</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: **010B / 7L0030-7024**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 29, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-390B

Revision No.:

0

Page No.:

5 of 6

### PARTS:

1. Assy parts; Label (7V1070-0020)

### JIG

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

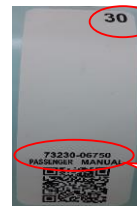
### TOOLS/PPE

### QUALITY POINTERS

5

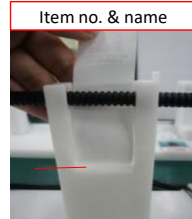
P2

Clamp assembly  
Label Attachment



Model Code

Item no. & name

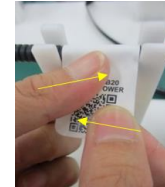


Item no. & name

1. Get the label.

Check the model code, item no. & name

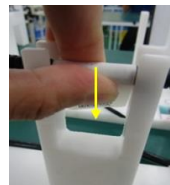
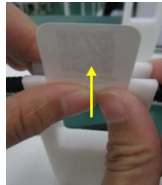
2. Align the end part of label in the jig.



3. Fold the center part of the label

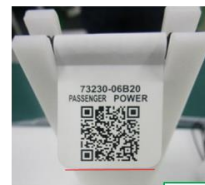
4. Align both end part of label .

5. After alignment , Press the label with both fingers.  
Make sure it was attach properly.



6. Press the label upside down using finger.

7. Press the SW button after label attachment. Conduct **POINT CHECKING** and remove the harness from jig.



Acceptable overlap  
0~1mm

GOOD



Label Dispenser

1. No bubbles
- 2.No damage
- 3.No peel off
- 4.No wrong use of label
5. No missing parts
6. No loose attachment



NG

**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:

January 29, 2022

Model Code/ Part Number: **010B / 7L0030-7024**

Customer: **TRQSS**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-390B

Revision No.:

0

Page No.:

6 of 6

PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Visual/By two's inspection	<div>1. Check the connector lock</div> <div>2. Check the clamp attachment, alignment and tape condition.</div> <div>3. Check the presence of label and terminal appearance.</div> <div>3. Using a steel rule check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div> <div>5. Compare to Master sample. <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></div> <div></div>		<div>MASTER SAMPLE</div> <div></div>
7	Measurement	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div></div>		<div>FOR HATSUMONO AND OWARIMONO ONLY</div> <div>1. No wrong measurement</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