



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 3, 2023

Process Name/Title:

Model Code/Part Number: 120D / 75S184-0281

Customer: TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-625

Revision No.:

1

Page No.:

1 of 14

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)				<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's.</div><div>2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</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	
Revision History																	
						Prepared by:		Checked by:		Approved by:		Noted by:					
02/03/23		1		Change purpose from Pre-launch to Masspro.				M. Ariola		J. Loterte		C. Villanueva		A. Arañes			
01/31/23		0		Initial issue. Change all wires length. Change length of Black VM tube (Sunprene) from L=129±3mm to 121±3mm ; Blue VM tube (Sunprene) from L= 133±3mm to 121±3mm				K. Doria		J. Loterte		C. Villanueva		A. Arañes			
Eff. Date		Rev. No		Details of Change				Prepared		Reviewed		Approved		Noted			
														Established Date: January 31, 2023			

**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:

February 3, 2023

Validity Date:

n/a

Model code/Part number: **120D / 75S184-0281**

Customer:

**TRJ**

Document No.:

**WI-ENG-PDE-625**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 14

**PARTS:**

1. AVSS 0.3 wire B/W L=327±2mm; OR wire L=309±2mm; GR wire L=173±3mm; LG wire L=315±2mm; P wire L=169±3mm; R/W wire L=299±3mm; BR wire L=165±2mm; R/L wire 301±2mm; G wire L=161±2mm; W/G wire L=159±2mm; Blue Sunprene tube ø8 L=121±3mm

**JIG**

1. Insertion jig

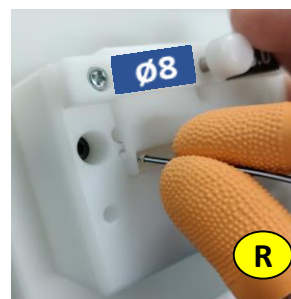
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P1

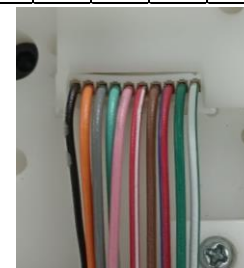
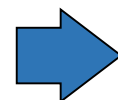
Wire insertion to  
Connector  
PBVP-10V-S (W)

INSERTION SEQUENCE FROM  
LEFT TO RIGHT



WIRE INSERTION  
ILLUSTRATION

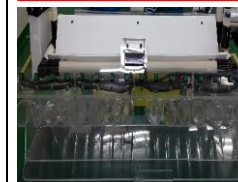
1	2	3	4	5	6	7	8	9	10
B/W	OR	GR	LG	P	R/W	BR	R/L	G	W/G
327	309	173	315	169	299	165	301	161	159



1. Get the **B/W wire** using left hand and transfer to right hand then insert to connector. Repeat the process for **OR-GR-LG-P-R/W-BR-R/L-G-W/G wires**. Check the wire after insertion.

*Note: Follow the insertion sequence based on the 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. Insertion of Wire must be from left to right.
3. 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-029 for Pull-Push procedure.

3

Wire insertion to Blue  
Sunprene tube ø8  
L=121±3mm

Blue VM tube(Sunprene)



1. Get the **Blue Sunprene tube ø8 L=121±3mm** using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.

N/A

1. No wrong usage 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: **120D / 75S184-0281**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**February 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-625**

Revision No.:

**1**

Page No.:

**3 of 14**

#### PARTS:

1. AVSS 0.3 R wire L=159±2mm; Y wire L=163±2mm; GR/B L=165±2mm; V wire L=169±2mm; B wire L=171±2mm

#### JIG

1. Insertion jig

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

#### TOOLS/PPE

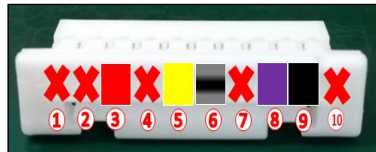
#### QUALITY POINTERS

4

P1

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

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



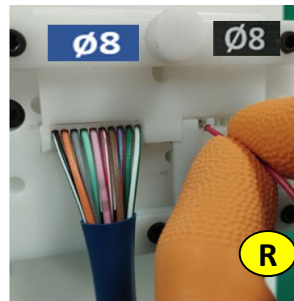
#### Wire facing

1	2	3	4	5	6	7	8	9	10
x	x	R	x	Y	GR/B	x	V	B	x
		159		163	165		169	171	



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

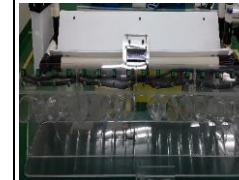
Lower guide



1. Get the **R wire** using right hand and insert to connector. Repeat the process for **Y-GR/B-V-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. Insertion of Wire must be from left to right.
3. 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-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

Effectivity Date:

February 3, 2023

Validity Date:

n/a

Model code/Part number: **120D / 75S184-0281**

Customer:

**TRJ**

Document No.:

**WI-ENG-PDE-625**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

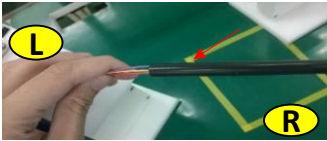
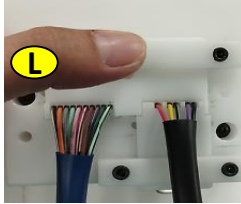
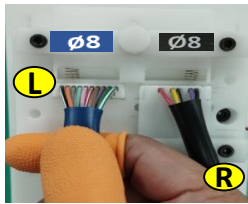

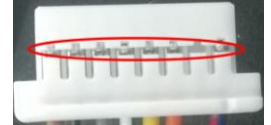
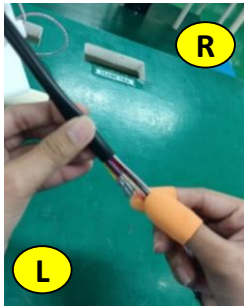

4 of 14

**PARTS:**

1. Assy parts
2. Black VM tube (Sunprene)  $\varnothing 8$  L=121 $\pm$ 3mm

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black VM Tube (Sunprene) $\varnothing 8$ L=121 $\pm$ 3mm	   	n/a	<ol style="list-style-type: none"><li>1. No wrong usage of parts</li><li>2. No deformed terminal</li><li>3. No tangled wires</li></ol>  <b>Terminal tip must be visible</b> <b>Document References:</b> <i>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</i>
6	Wire insertion to Black VM Tube (Sunprene) (Assy parts)	 	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li><li>3. No tangled wires</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

Effectivity Date:

February 3, 2023

Model Code/Part Number:

120D / 75S184-0281

Customer:

TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-625

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 14

## PARTS:

1. Assy parts

## JIG

1. Insertion jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

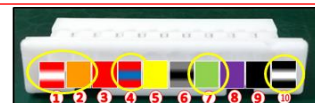
## QUALITY POINTERS

7

P1

Wire insertion to PBVP-10V-S (W) (Assy parts)

## INSERTION SEQUENCE FROM LEFT TO



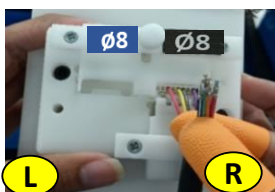
## VISUAL REFERENCE

## WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/W	OR	R	R/L	Y	GR/B	LG	V	B	B/W
299	309	159	301	163	165	315	169	171	327



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



2. Hold the R/W Wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **OR-R/L-LG and B/W wires**. Check the wire after insertion.

(Note: Follow the insertion sequence based on the illustration).

## STEERING NAVIGATION



## CONTROLLER



1. No wrong use of parts
2. No deformed terminal

## 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-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****TAPING ASSEMBLY PROCESS**

Effectivity Date:

February 3, 2023

Process Name/Title:

Validity date

n/a

Model Code/Part Number: **120D / 75S184-0281**Customer: **TRJ**

Document No.:

**WI-ENG-PDE-625**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

6 of 14

**PARTS:**

1. Assy parts

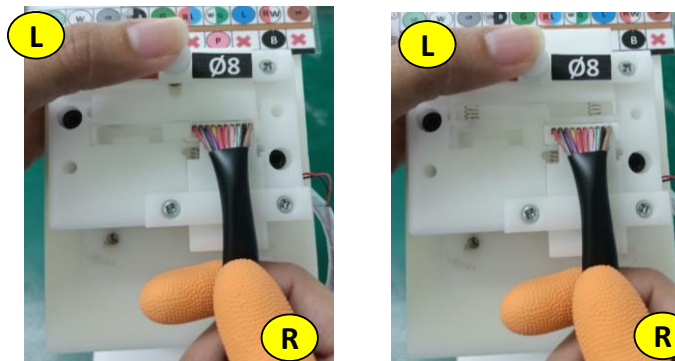
**JIG**

1. Insertion jig

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

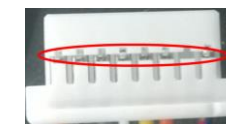
7

P1

Wire insertion to PBVP-10V-S (W) Assy parts  
(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

**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:

**February 3, 2023**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity date

**n/a**Model Code/Part Number: **120D / 75S184-0281**

Customer:

**TRJ**

Document No.:

**WI-ENG-PDE-625**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**7 of 14****PARTS:**

1. Assy parts

**JIG**

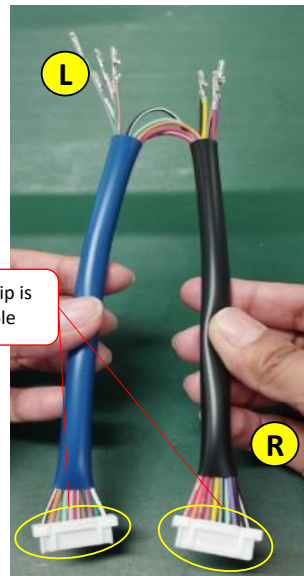
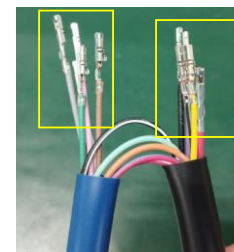
n/a

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

8

P1

Wire arrangement

**BEFORE FOLDING**Terminal tip is  
not visible1. Hold the assy parts using both hands  
then conduct wire arrangement.**AFTER FOLDING**

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

Effectivity Date:

February 3, 2023

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number:

120D / 75S184-0281

Customer:

TRJ

Document No.:

WI-ENG-PDE-625

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

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

Connector setting to  
insertion jig  
1746872-1 (B)

#### INSERTION JIG



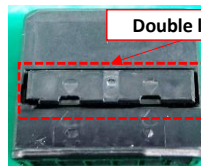
Visual reference

Upper guide

Lower guide

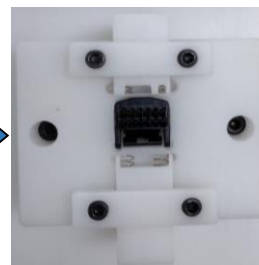
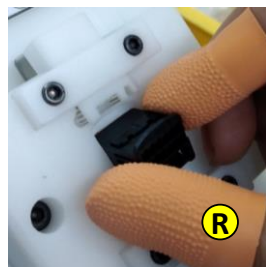
75S184-0281

#### Double lock



Note: Check the  
connector before  
insertion.

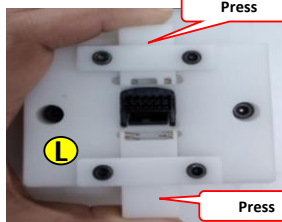
#### CONNECTOR ORIENTATION



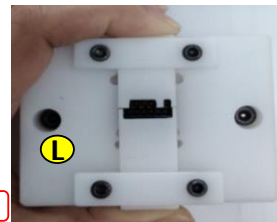
1. Get the connector **1746872-1 (B)** and insert to insertion jig  
using right hand.

Note: Follow the connector orientation

Press



Press

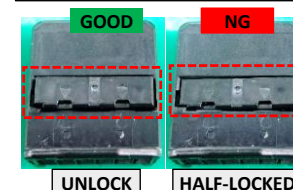


2. Press the upper and lower  
guide (same timing) using left  
hand. Holes that need to be  
insert are only open.

N/A

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

#### CONNECTOR LOCK APPEARANCE CHECK



UNLOCK

HALF-LOCKED

#### CONNECTOR ILLUSTRATION



#### Important reminders/Note/s:

1. Automatically dispose and  
replace the unit if once  
encountered bend terminal,  
difficulty of insertion and half-  
locked connector.

**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:

February 3, 2023

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number:

120D / 75S184-0281

Customer:

TRJ

Document No.:

WI-ENG-PDE-625

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

9 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

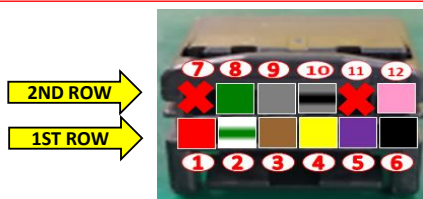
QUALITY POINTERS

10

P1

Wire insertion to  
Connector  
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



BLACK VM TUBE (SUNPRENE)



WIRE INSERTION ILLUSTRATION

7	8	9	10	11	12
X	G	GR	GR/B	X	P
161	173	165		169	
1	2	3	4	5	6
R	W/G	BR	Y	V	B
159	159	165	163	169	171



Wire facing

N/A

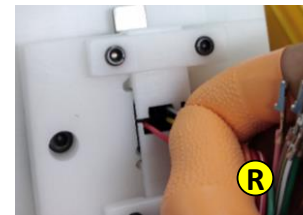
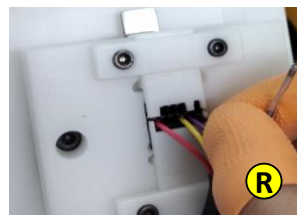
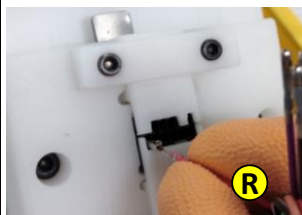
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

### 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.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

### Document References:

1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.



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

2. Hold the **GR/B wire** and insert to terminal slot 5.  
*Note: Follow the insertion sequence based on the illustration stated above.*

**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:

February 3, 2023

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number:

120D / 75S184-0281

Customer:

TRJ

Document No.:

WI-ENG-PDE-625

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:



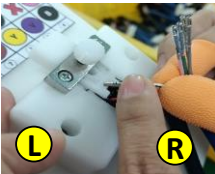
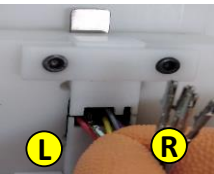
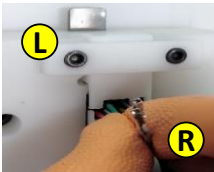
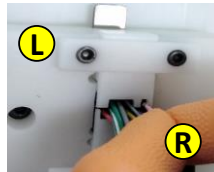
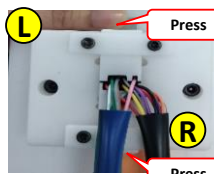
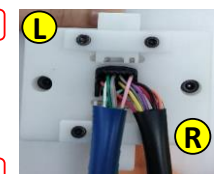

10 of 14

## PARTS:

1. Assy parts
2. Connector 1746872-1(W)

## JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<p><b>BLUE VM TUBE (SUNPRENE)</b></p>     <p>3. Insert the wires from <b>Blue VM tube (Sunprene)</b>, hold the <b>W/G wire</b> using right hand and support the wire by left index finger then insert to terminal <b>slot 6</b> using right hand. Repeat the process for <b>BR wire</b>. <i>Note: Follow the insertion sequence based on the above illustration.</i></p>   <p>4. Hold the <b>G wire</b> and insert to terminal <b>slot 8</b> using right hand. Repeat the process for <b>GR-P wire</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p>   <p>5. Press the upper and lower lever guide (same timing) using both hands.</p>  <p>6. Remove the assy parts using right hand.</p>	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> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal during insertion.</li><li>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</li><li>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</li></ol> <p><b>Document References:</b></p> <ol style="list-style-type: none"><li>1. Refer to <b>GL-PRO-ASY-029</b> for <b>Pull-Push</b> procedure.</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

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 3, 2023

Process Name/Title:

Model Code/Part Number: 120D / 75S184-0281

Customer: TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-625

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

11 of 14

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

11

P1

Wire folding

BLACK VM TUBE (SUNPRENE)



BLUE VM TUBE (SUNPRENE)



1. Hold the connector PBVP-10V-S(W) using left hand and slightly fold the wires from Black VM tube (Sunprene) ( as shown in illustration above) using right . Repeat the process for Blue VM tube (Sunprene)



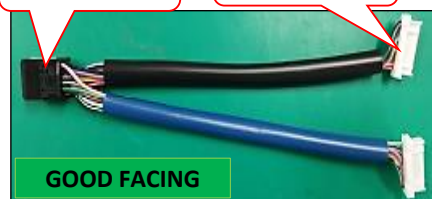
BEFORE FOLDING



AFTER FOLDING

Double lock in upward position

Terminal tip is not visible



GOOD FACING

Double lock is upward position

Terminal tip is visible



WRONG FACING

Terminal tip is not visible

n/a

1. No wrong orientation of connector.  
2. No tangled wires.  
3. Terminal backing out.

**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:

**February 3, 2023**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity date

**n/a**Model Code/Part Number: **120D / 75S184-0281**

Customer:

**TRJ**

Document No.:

**WI-ENG-PDE-625**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**12 of 14****PARTS:**

1. Assy parts
2. Master sample

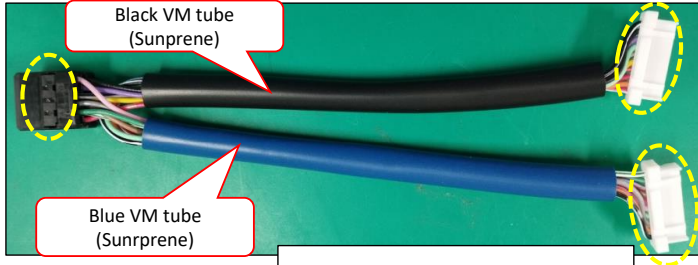
**JIG****n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****12****P1**

Visual/By two's inspection

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

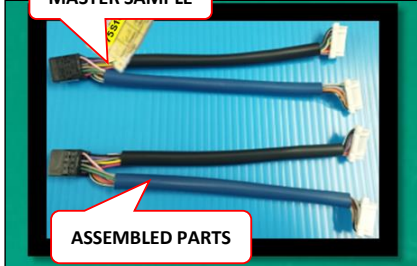
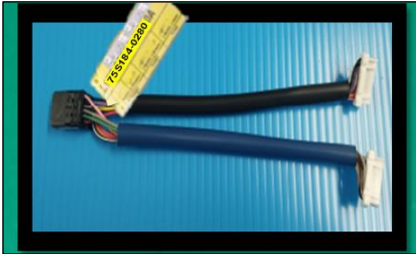
2. Check the wire alignment. Make sure no tangled wires.

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



4. Check the orientation of harness.

5. Compare to Master sample by tapping.



**n/a**

1. No skip checking during inspection.

**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:

**February 3, 2023**

Model Code/Part Number:

**120D / 75S184-0281**

Customer:

**TRJ**

Validity date

**n/a**

Document No.:

**WI-ENG-PDE-625**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**13 of 14****PARTS:**

1. Assy parts

**JIG**

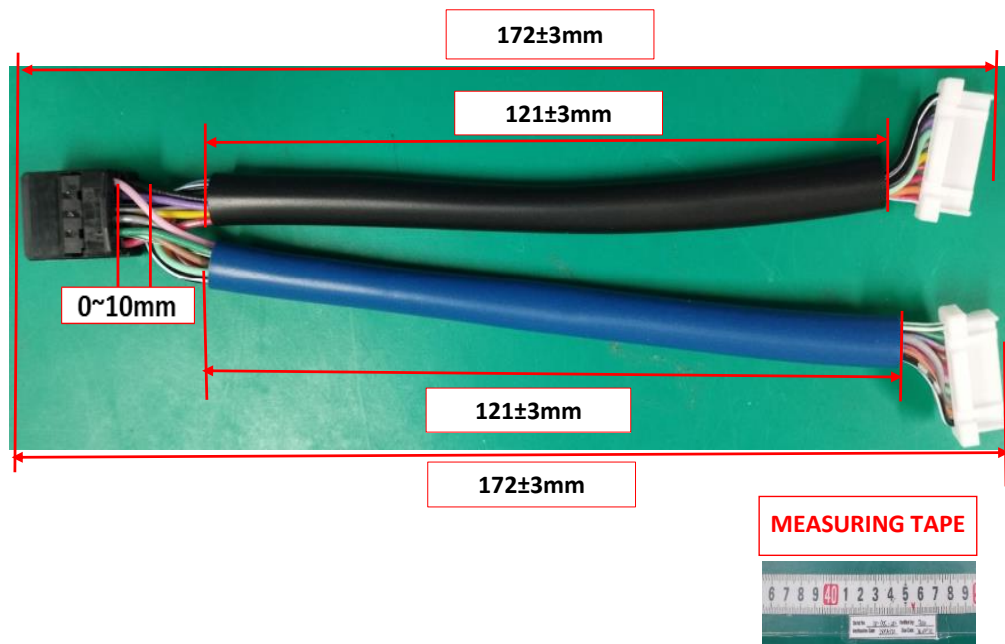
n/a

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

13

P1

Measurement



1. No wrong dimension.

**Important reminders/Note/s:**

1. Please use calibrated /verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

**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:

February 3, 2023

Validity date

n/a

Model Code/Part Number:

120D / 75S184-0281

Customer:

TRJ

Document No.:

WI-ENG-PDE-625

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

14 of 14

### PARTS:

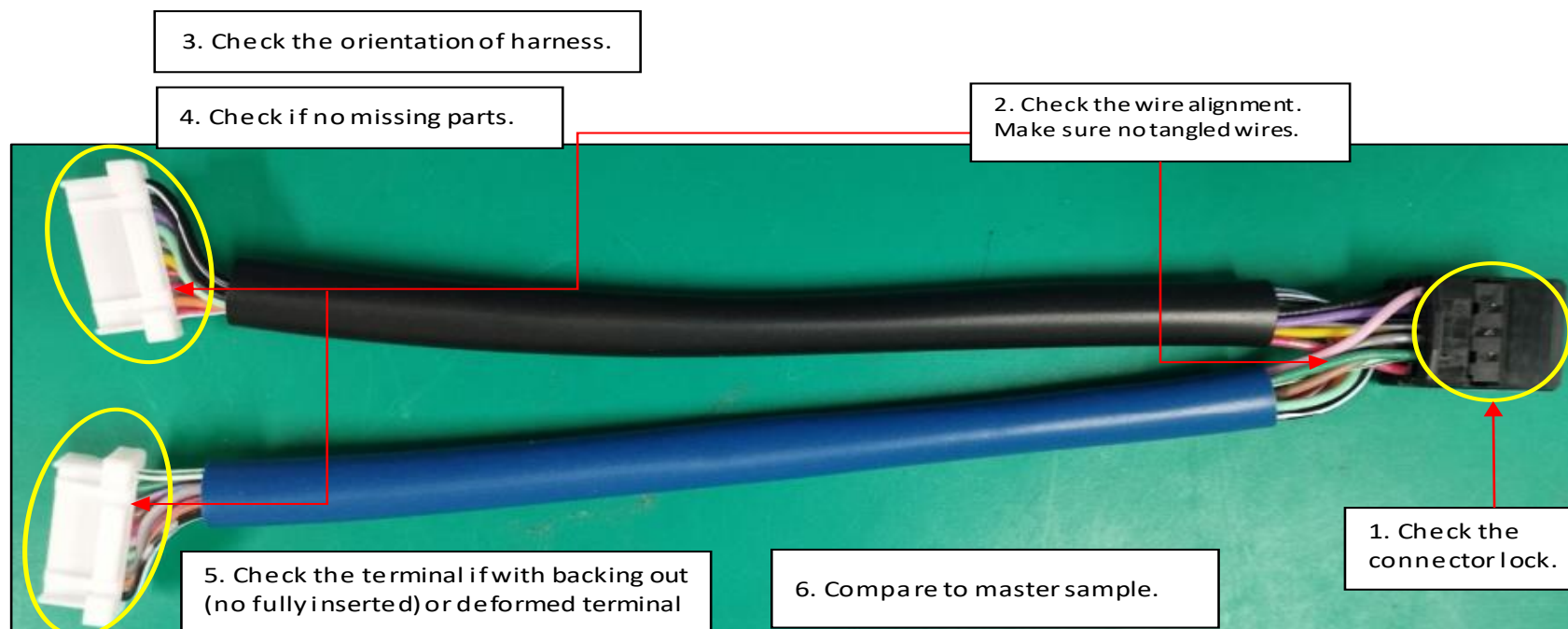
1. Assy parts

JIG

n/a

### QUALITY CHECKPOINTS

## 75S184-0281



**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