



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

September 29, 2022

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

TP1 / 7L0089-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-058B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

1 of 6

PARTS:

1. Assy parts

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Y-Taping	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between COT 6. No exposed wire</div> <div>Important reminders/Note/s 1. Used yellow tape for easy visualization of shifting lines, but actual should be GRAY TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. 3. Do not exert excessive force during pulling & windings of tape.</div> <div>Y-Taping Orientation GOOD FACING NG FACING 43±3mm Good Measurement</div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/29/22	6	Change of tolerance from 35+/-3mm to 35+3/-1mm as countermeasure of encountered NG dimension from end of tape to terminal pointed tip. Improve quality pointers: Reminders/notes and references in process no.1, 2, 3, 5 and 6 due to document improvement. Work procedure/illustration in process no.5-Visual/by two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/22/21	5	Change part number due to changes of Tape color from Black to Gray on Y-taping process. Update illustration of Urethane foam attachment; Continuity test; Visual/By two's inspection, measurement and master sample.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
01/30/21	4	Removal of cycle time; Put assy parts on parts section of Pg. 1~3; Conduct semi-annual review of doc's. Put additional illustration/picture on Y-taping procedure 1	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
							M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

TP1 / 7L0089-7023

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 29, 2022

Validity Date:

n/a

Document No.:

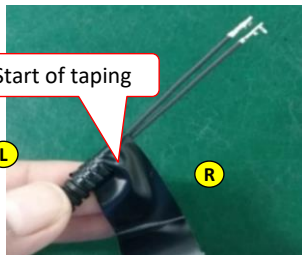
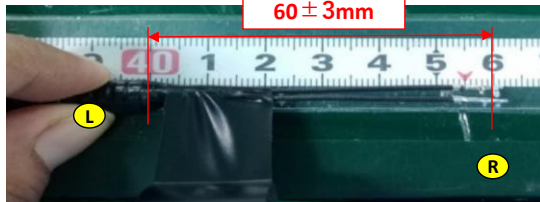

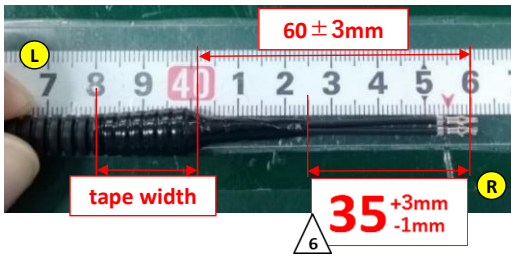

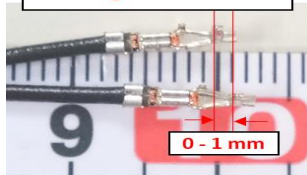
WI-ENG-PDE-058B

Revision No.:

6

Page No.:

2 of 6

PARTS:		1. Black tape 2. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 COT to wire near terminal	<div><p>Start of taping</p></div> <div><p>60 ± 3mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>35 +3mm -1mm</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div> <div><p>60 ± 3mm</p><p>tape width</p><p>35 +3mm -1mm</p></div> <div><p>3. Confirm measurement of 35+3/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>		 <p>MEASURING TAPE</p>	<div><p>1. No loose tape</p><p>2. No peel-off tape</p><p>3. No flip-out tape</p><p>4. No wrong dimension</p></div> <div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</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

Effectivity Date:

September 29, 2022

Validity Date:

n/a

Model Code/Part Number

TP1 / 7L0089-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-058B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

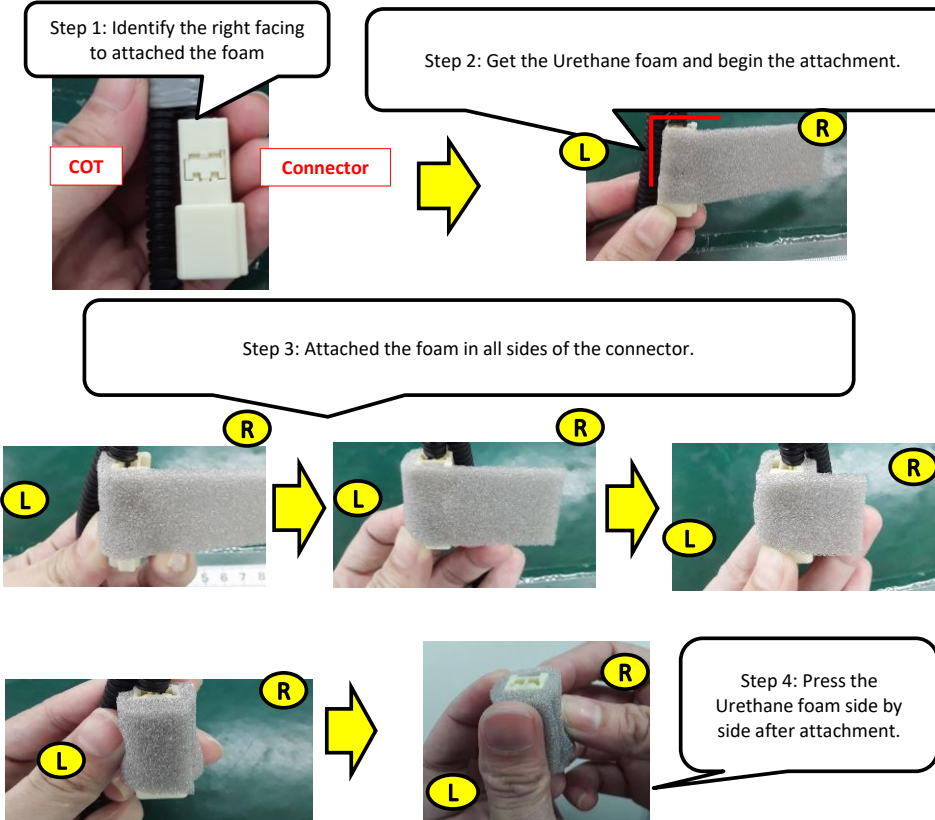
☒ MASSPRO

Revision No.:

6

Page No.:

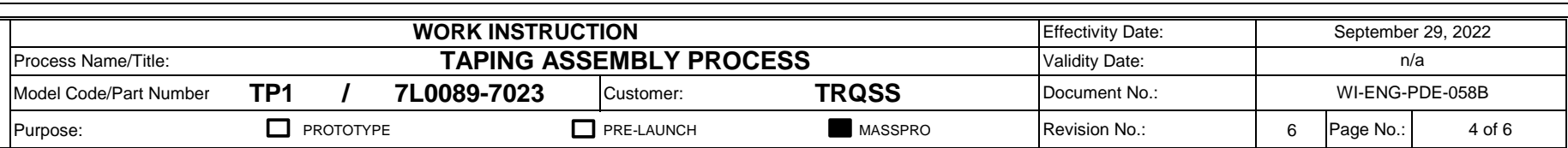
3 of 6

PARTS:		1. Black tape 2. Gray Urethane foam t=4; 75mm X 30mm	3. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Urethane foam attachment</p> <p>Step 1: Identify the right facing to attached the foam</p> <p>Step 2: Get the Urethane foam and begin the attachment.</p> <p>Step 3: Attached the foam in all sides of the connector.</p> <p>Step 4: Press the Urethane foam side by side after attachment.</p> 		n/a	<p>1. No damaged Urethane foam 2. No missing Urethane foam 3. No stretched Urethane foam</p> <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Do not stretch the Urethane foam.2. Foam and connector must be align.3. Follow the attachment sequence based on the illustration.4. Tolerance from Urethane foam and connectoe must be 0~3mm. <p>URETHANE FOAM CONDITION</p> <p>GOOD</p> <p>NG</p> <p>Over-stretched</p> <p>Excess foam</p> <p>0~3mm</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



<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.</p>	<p>NBC (Philippines) MASTER COPY</p>	<p>DCC Stamp</p>
---	--	------------------



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

TP1 / 7L0089-7023

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 29, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-058B

Revision No.:

6

Page No.:

5 of 6

PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

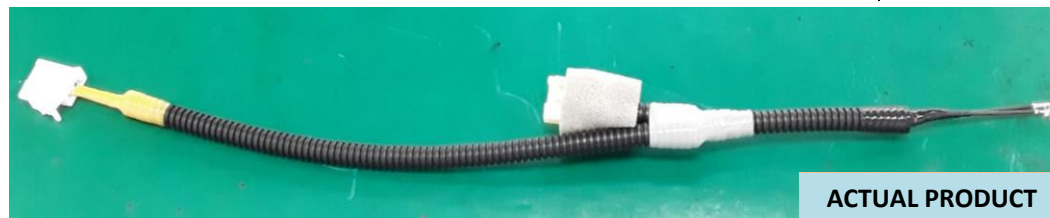
TOOLS/PPE

QUALITY POINTERS

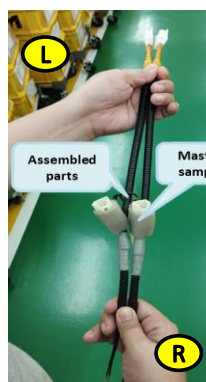
5

P2

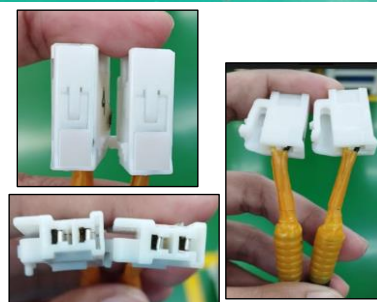
Visual/By Two's Inspection



ACTUAL PRODUCT



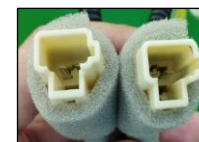
1. Conduct alignment of harness
(Master sample vs. Assembled parts) using both hands.



2. Check the connector lock, terminal an tapping condition.



4. Check the Y-Taping condition.



3. Check the terminal, insertion and presence of urethane foam.



5. Check the terminal, insertion and tapping condition. Must no deformed terminal.

MASTER SAMPLE



6

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**Model Code/Part Number: **TP1 / 7L0089-7023**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 29, 2022

Validity Date:

n/a

Document No.:

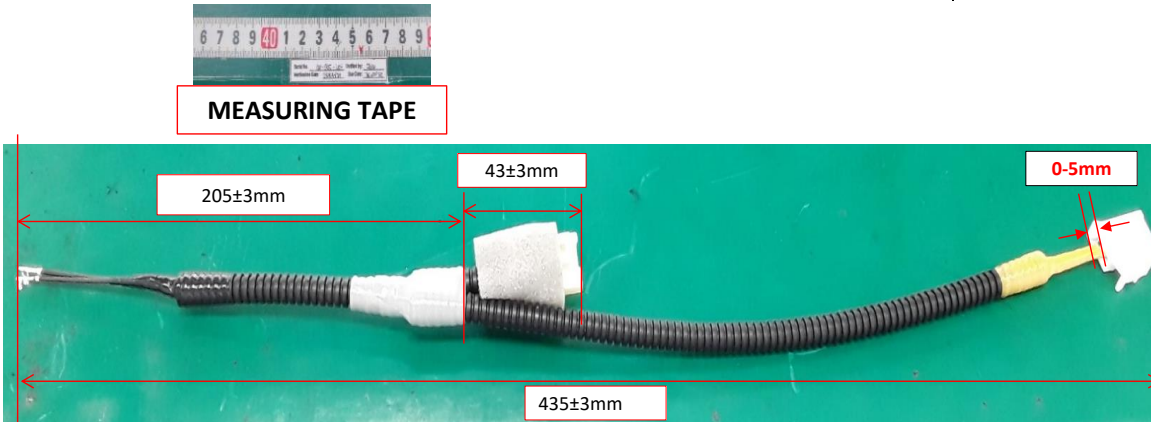
WI-ENG-PDE-058B

Revision No.:

6

Page No.:

6 of 6

PARTS:		n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement				<div>1. No wrong dimension</div> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/ verified measuring tape when grtting the measurement.</div> <div>2. For Hatsumono and Owarimono.</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