



WORK INSTRUCTION

Effectivity Date:

May 20, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

550B / 4 7L0083-7022

Customer:

TRQSS

Document No.:

WI-ENG-PDE-020B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

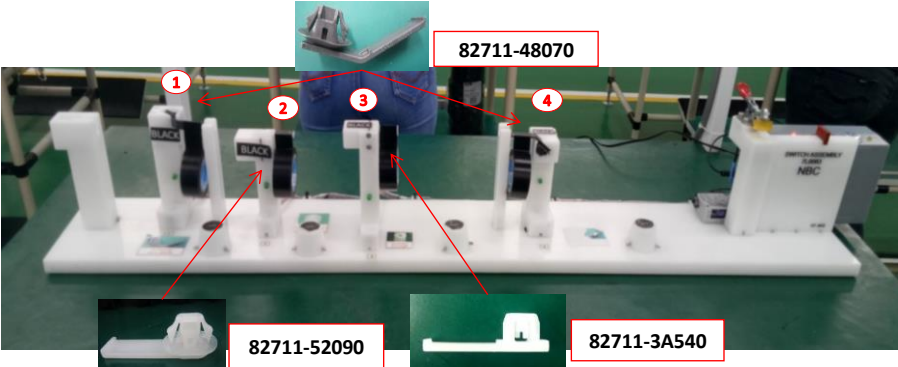
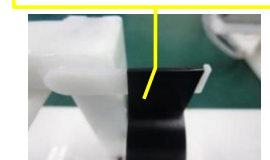
Revision No.:

4

Page No.:

1 of 3

PARTS:	1. Clamp 82711-52090 (W) 2. Clamp 82711-48070 (GR) [2pcs]	3. Clamp 82711-3A540 (W) 4. Black tape [4pcs]	JIG:	1. Clamp assembly jig
---------------	--	--	-------------	-----------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp Assembly setting	 <div> <p>1. Get 2pcs of clamp 82711-48070 (GR) using right hand and set to clamp location 1 and 4 using both hands.</p> <p>2. Get 1pc of clamp 82711-52090 (W) using right hand and set to clamp location 2 using both hands.</p> <p>3. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</p> <p>4. Get Black tape and put pre-tape on clamp location 1, 2, 3 and 4.</p> </div> <div> <p>STANDARD TAPING FOR CLAMP</p>  <p>One side tape under clamp</p> </div>	<p>Safety Instruction Be sure to wear required 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>	<p>Note: Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of clamp 2. No damaged clamp 2. No wrong use of tape</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by:	Checked by:	Approved by:	Noted by:
05/20/21	4	Part number change from 7L0083-7021 to 7L0083-7022 due to remove taping process of Vinyl tube to wire near connector. Change connector setting sequence. Update pictures on Clamp assembly, Visual/By two's inspection and measurement.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes				
05/03/21	3	Change clamp colors in accordance with color standardization for plastic parts refer to GL-COM-003. Add tape quantity.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes				
07/09/19	n/a	Previously established Engineering Instruction(EI-ENG-PDE-099).Initial issue.	J. Loterte	R. Alcantara	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
							Est. date:	July 08, 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

Effectivity Date:

May 20, 2021

Product Name/Code:

550B /  7L0083-7022

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

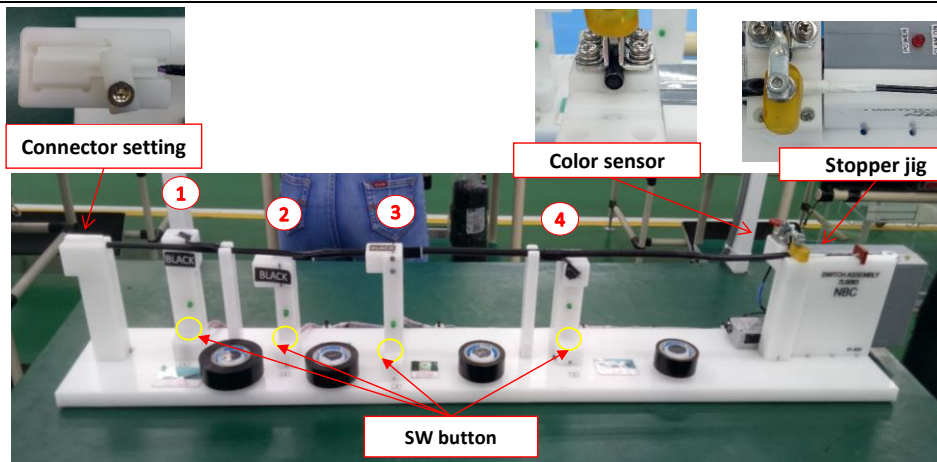

WI-ENG-PDE-020B

Revision No.:

4

Page No.:

2 of 3

PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Clamp Assembly	 <p>1. Get the assy parts and set to jig using both hands. (<i>see above picture for correct setting</i>) First, put the white connector to receiver base then lock. Second, put the terminal to stopper jig and pull the toggle clamp.</p> <p>2. Check if all LED light for POWER, CLAMP ON and COLOR SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light in location 1 is ON. <i>Note: Sequence light of Location 1 will ON if the sensor detect the White tape.</i></p> <p>3. Hold the tape on clamp location 1 and start taping (3 windings) using both hands. Press the switch button after taping. Continue to location 2 if light was ON.</p> <p>4. Repeat the step 3 to clamp location 2 and 3. Continue to location 4 if light was ON.</p> <p>5. Hold the tape on clamp location 4, and start taping (3 windings) using both hands. Press the switch button after taping. Go sound will be heard.</p> <p>6. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p>		n/a	 <p><i>Make sure no gap between terminal and stopper jig.</i></p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No tight/loose clamp attachment</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

Effectivity Date:

May 20, 2021

Product Name/Code:

550B / Δ 7L0083-7022

Customer:

TRQSS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-020B

Purpose:

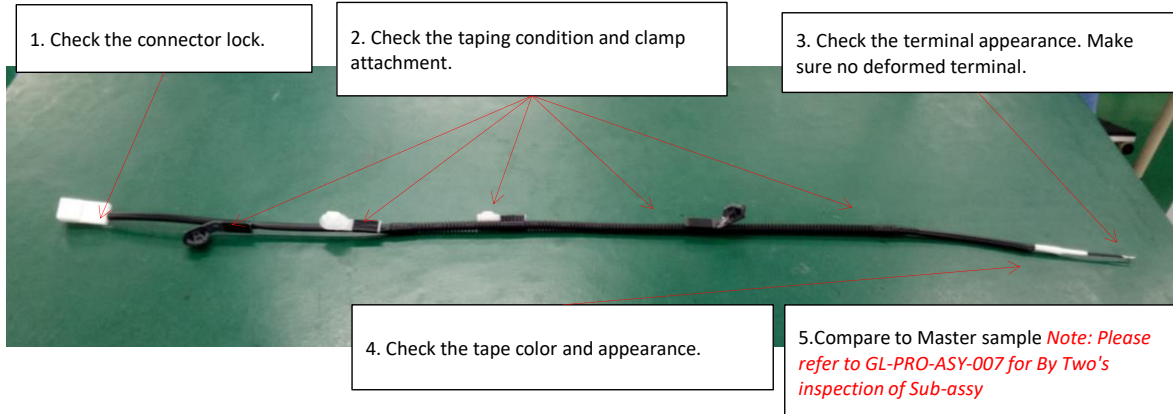

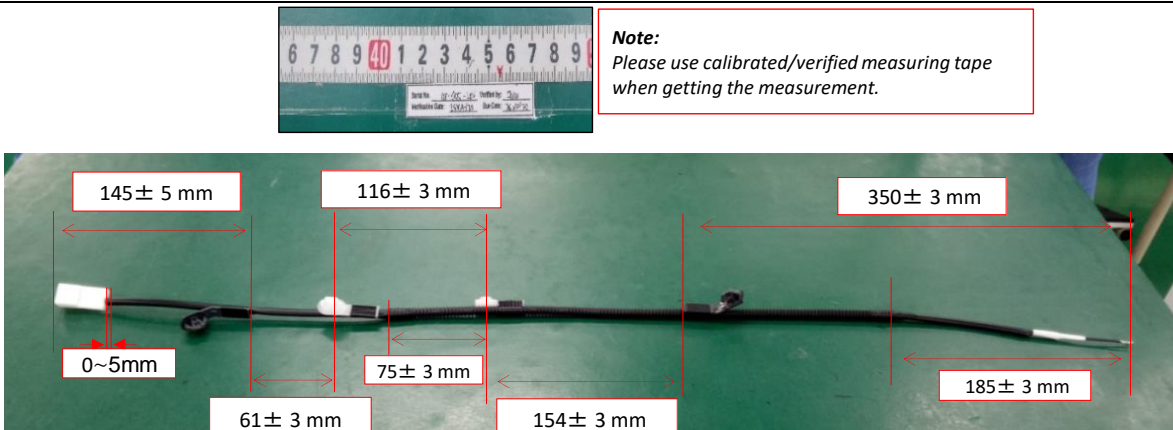
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

3 of 3

PARTS:	N/A			JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Δ Visual Inspection				MASTER SAMPLE 
4	Δ Measurement				For Hatsumono and Owarimono only

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