



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Process Name/Title:

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1075

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS:

1. All parts: Connector 7182-8049 (W); AVSSf 0.3 L L=307±2mm; B/W L=307±2mm; Black SV tube (Vinyl) Ø5 L=209±3mm; Black tape

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

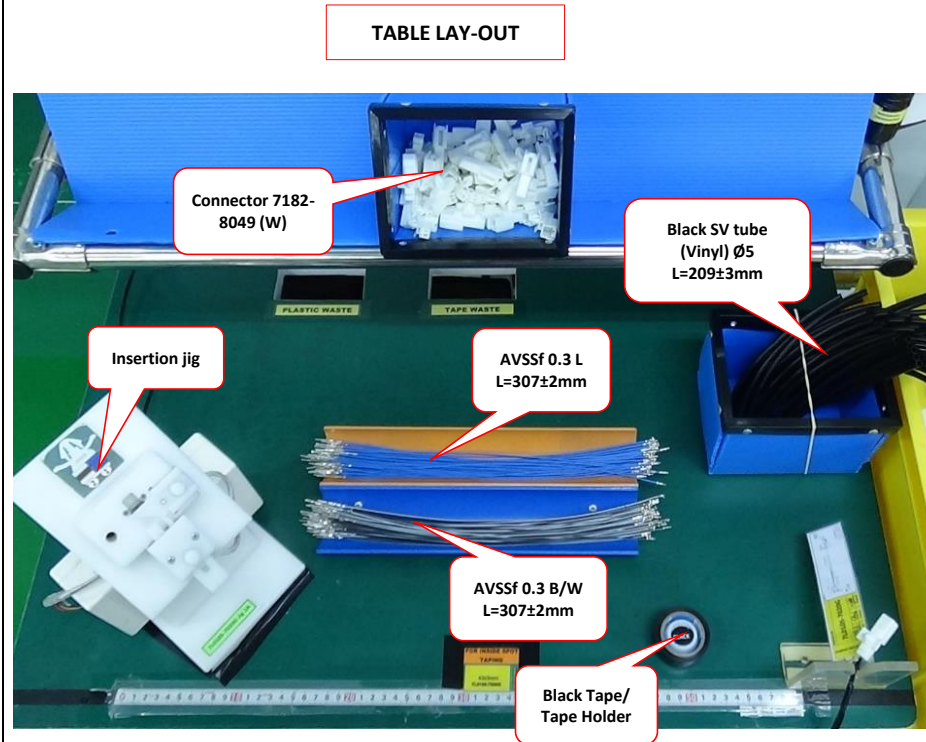
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

						Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change "pre-launch to mass pro".	A.Hernandez	C.Villanueva	A.Arañes	n/a			
09/24/24	0	Initial issue.	A.Hernandez	C.Villanueva	A.Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2024	

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:

October 01, 2024

Process Name/Title:

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1075

Purpose:



PROTOTYPE



PRE-LAUNCH



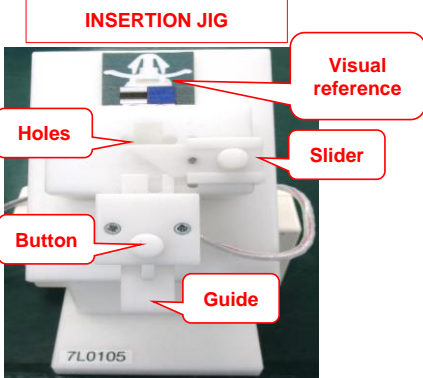

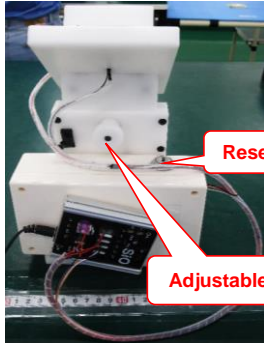
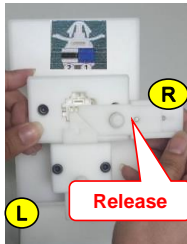
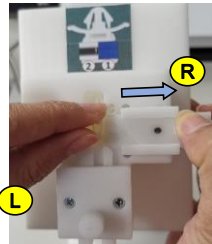
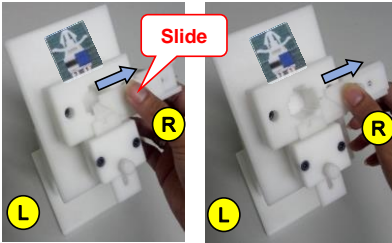
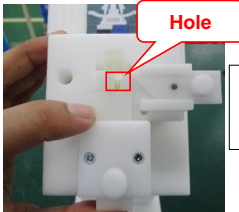
MASSPRO

Revision No.:

1

Page No.:

2 of 7

PARTS:	1. Connector 7182-8049 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 7182-8049 (W)	<div><div></div><div></div><div></div><div><div>1. Slide the slide lock using right thumb.</div><div>2. Insert the connector 7182-8049 (W) into jig using left hand and release the side lock using right hand. <i>Note: Follow the connector orientation; Cannot insert the inverted connector.</i></div><div><div>3. Push the guide using left thumb. The slot for Blue wire will be opened.</div></div></div></div>	n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged 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

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Process Name/Title:

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1075

Purpose:



PROTOTYPE



PRE-LAUNCH




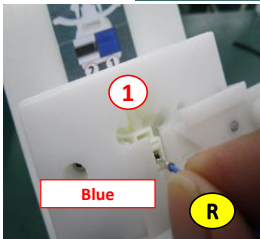
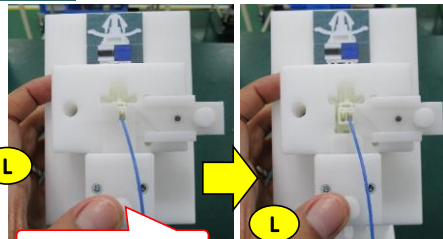
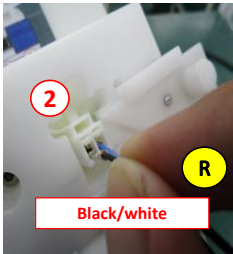
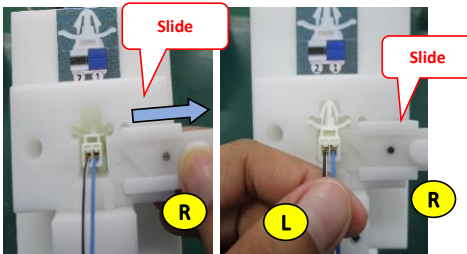
MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:		1. AVSSf 0.3 L L=307±2mm; B/W L=307±2mm 2. Connector 7182-8049 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><p>WIRE TERMINAL FACING</p></div> <div><p>1. Get the Blue wire then insert to terminal slot ① using right hand. Conduct Pull-Push-Pull-Push after insertion.</p></div> <div><p>2. Press the button using left thumb. The slot for Black/White wire will be opened.</p></div> <div><p>3. Get the Black/white wire then insert to terminal slot ② using right hand. Conduct Pull-Push-Pull-Push after insertion. Note: Insertion jig will alarm if Black/White wire will not insert before 5 seconds.</p></div> <div><p>4. After insertion, GO sound will be heard. Slide the slider lock using right thumb then hold the wires and gently pull out the connector from jig using left hand.</p></div>		n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged 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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



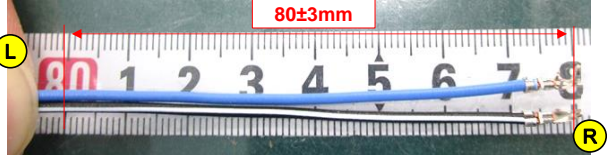
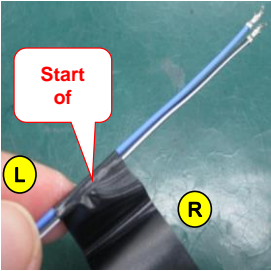
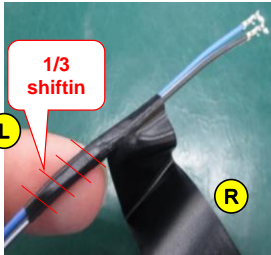



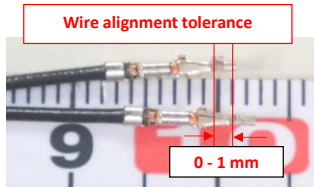
MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Wire taping	<div><p>80±3mm</p><p>1. Hold the wires using left hand then measure 80±3mm up to terminal pointed tip using both hands.</p></div> <div><p>Start of</p><p>2. Initially attach Black tape using right hand then make 2 windings of tape before shifting.</p></div> <div><p>1/3 shiftin</p><p>3. Make 1/3 shifting of tape then continue the taping process using both hands.</p></div> <div><p>43±3mm</p><p>4. Confirm measurement then make 3 windings of tape before cut.</p></div> <div><p>43±3mm</p><p>5. After taping, check the measurement, taping condition and terminal appearance.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <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

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Document No.:

WI-ENG-PDE-1075

Purpose:



PROTOTYPE



PRE-LAUNCH




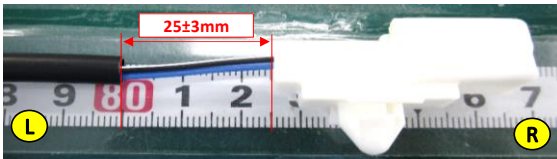
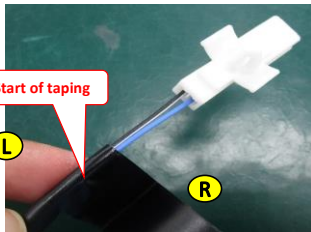
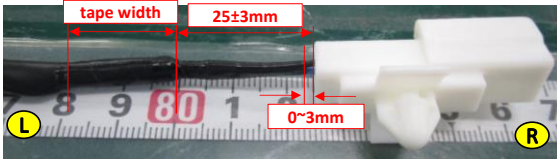

MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:		1. Assy parts 2. Black tape [1 pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black SV tube (Vinyl) Ø5 L=209±3mm	 <p>1 Get the Black SV tube (Vinyl) Ø5 L=209±3mm using right hand then insert the L-B/W wires using left hand.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal
6		Taping 2 Black SV tube (Vinyl) to wire near connector	 <p>1. Hold the SV tube (Vinyl) using left hand then measure from end of SV tube (Vinyl) up to edge of connector 25±3mm using both hands.</p>  <p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the taping condition and measurement.</p>	<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Refer to GL-PRO-ASY-001 for taping procedure. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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:

October 01, 2024

Validity Date:

n/a

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Document No.:

WI-ENG-PDE-1075

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

6 of 7

PARTS:		1. Assy parts 2. Black tape [1 pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Measurement	<div><div><div>④ 299 ± 3</div><div>③ 65 ± 3</div><div>② 43 ± 3</div><div>① 0 +1 0</div><div>⑥ 0 +3 0</div></div><div><div>Black SV Tube Ø5</div><div>A</div><div>C</div></div><div><div>NOTE:</div><div>① - Taping (B)</div><div>② - Taping (L)</div><div>③ - Clamp (W)</div><div>Unit of measurement is in millimeter (mm)</div></div></div>		<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</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:

October 01, 2024

Validity Date:

n/a

Model code/Part number:

J34A / 7L0105-7020H

Customer:

TRQSS

Car Model:

MAZDA MX

Document No.:

WI-ENG-PDE-1075

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

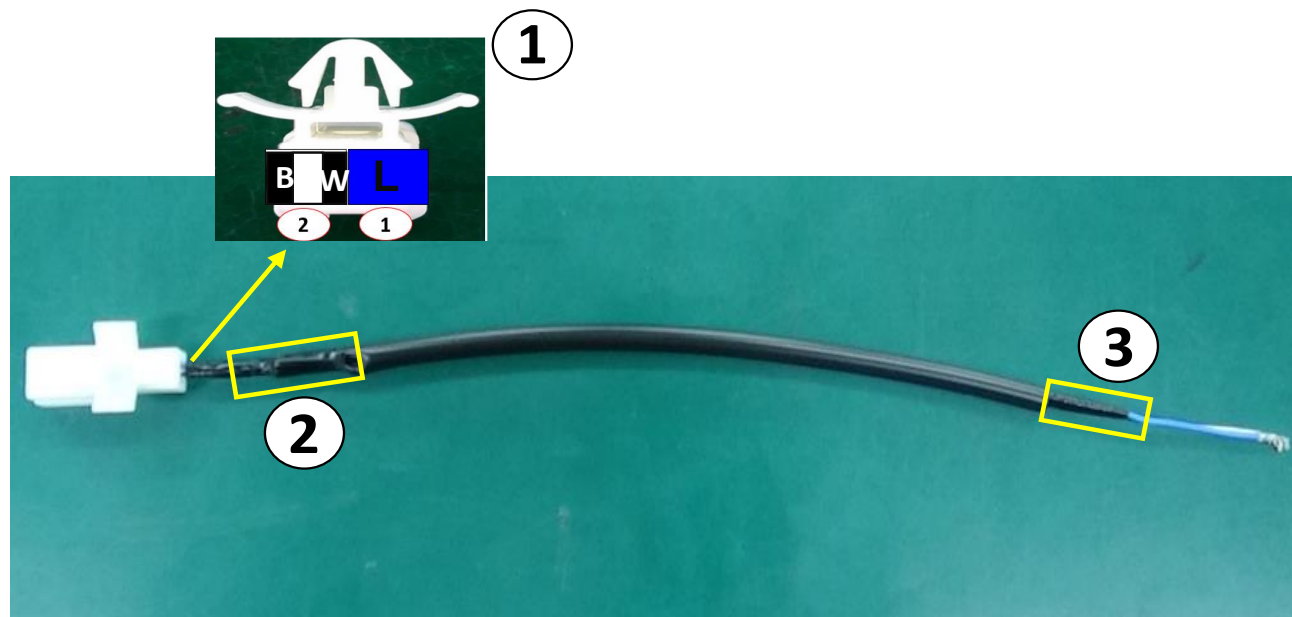
7 of 7

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0105-7020H****① No Wrong Insert****② No Missing Tape****③ (Black Tape)****④ No Deformed Terminal****⑤ No 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