

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 25, 2022

Model Code/Part Number: **N/A / 7H0346W7020C**Customer: **NBS**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-466A

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

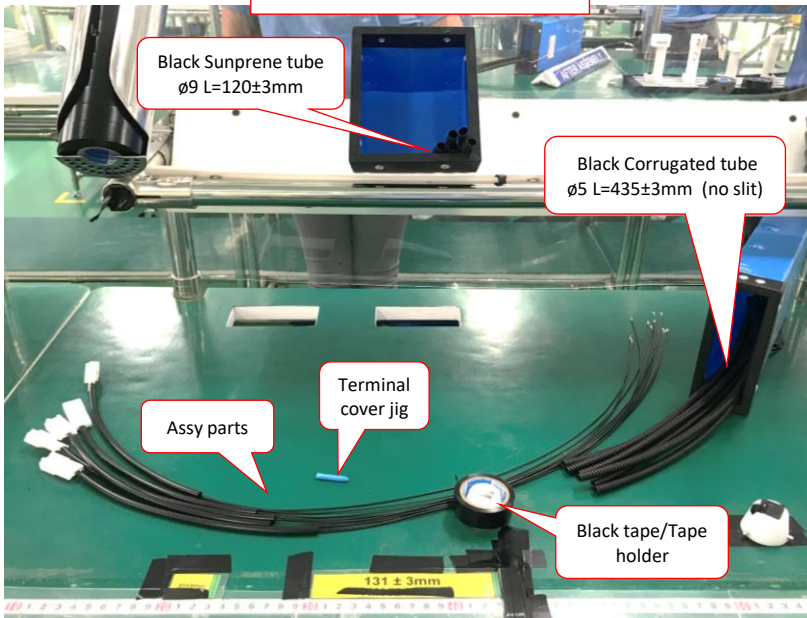
1

Page No.:





1 of 4

PARTS:1. Assy parts; Black Corrugated tube $\phi 5$ L=435 \pm 3mm (no slit); Black Sunprene tube $\phi 9$ L=120 \pm 3mm; Black tape**JIG:**

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out 	Safety Instruction Be sure to wear required 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.	1. No missing parts/ tools. 2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/25/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/07/22	0	Initial Issue.	K. Doria	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






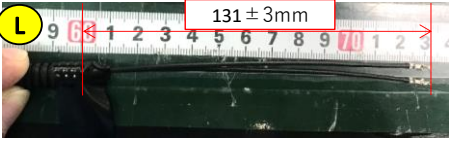
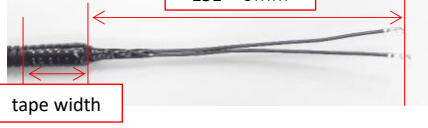

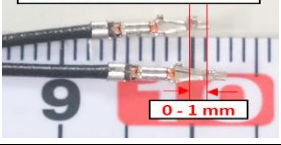


WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:	April 25, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-466A		
Revision No.:	1	Page No.:	2 of 4

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Numbe	N/A / 7H0346W7020C	Customer:	NBS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Black Corrugated tube $\phi 5 L=435\pm 3\text{mm}$ (no slit) 2. Assy parts 3. Black tape			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><p>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</p></div><div><p>2. Get the Black corrugated tube $\phi 5 L=435\pm 3\text{mm}$ (no slit) using right hand and insert the 2 Black wires.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>			<div>Terminal Cover jig </div>	1. No wrong usage of parts. 2. No deformed terminal
3		<div><div><p>1. Hold the COT using left hand, get Black tape using right hand and start pre-taping between COT and wire.</p></div><div><p>2. Hold the corrugated tube using left hand and measure from end of COT to terminal pointed tip $131\pm 3\text{mm}$ and proceed to taping process. <i>Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div>			<div>Measuring Tape </div>	<p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</div> <div><p>Wire alignment tolerance 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**

Effectivity Date:

April 25, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

N/A / 7H0346W7020C

Customer:

NBS

Document No.:

WI-ENG-PDE-466A

Purpose:

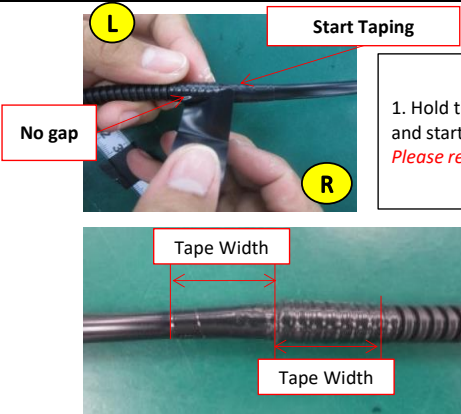
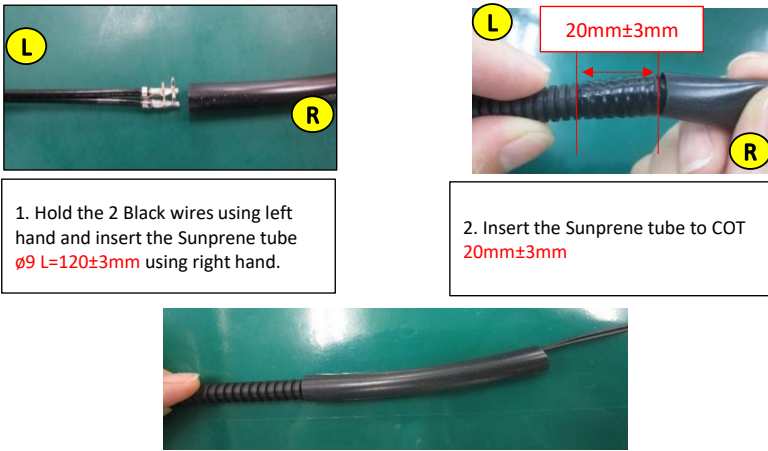

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 4

PARTS:		1. Black tape 2. Black Sunprene tube $\varnothing 9$ L=120 \pm 3mm	3. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Taping 2 Corrugated tube to Vinyl tube	 <p>1. Hold the corrugated tube using left hand, get Black tape and start taping using right hand. <i>Please refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>2. Check the taping condition after taping.</p>		n/a	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension
5	Wire insertion to Black Sunprene tube $\varnothing 9$ L=120 \pm 3mm	 <p>1. Hold the 2 Black wires using left hand and insert the Sunprene tube $\varnothing 9$ L=120\pm3mm using right hand.</p> <p>2. Insert the Sunprene tube to COT 20mm\pm3mm</p>		MEASURING TAPE 	Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i> 1. No wrong use of parts

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:

April 25, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

N/A / 7H0346W7020C

Customer:

NBS

Document No.:

WI-ENG-PDE-466A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

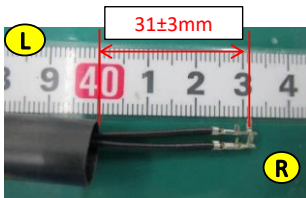

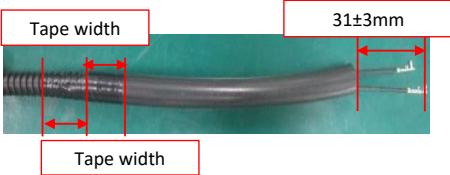

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 4

PARTS:		1. Black tape 2. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P1	<div><p>1. Hold the corrugated tube $\phi 5$ $L=435\pm 3\text{mm}$ (no slit) using left hand and measure the sunprene tube up to terminal tip $31\pm 3\text{mm}$.</p></div> <div><p>2. Hold the COT using left hand and begin taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the dimension, terminal appearance and taping condition.</p></div>			<p>MEASURING TAPE</p> 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p> <p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></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