WORK INSTRUCTION		February 16, 2023		
Process Name/Title: TAPING ASSEMBLY PROCESS	Effectivity Date: Validity Date:	n/a		
Model Code/Part Number: 164B / 7M0610-7021 Customer: TRJ	Document No.:	WI-ENG-PDE-398A		
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO	Revision No.:	1 Page No.: 1 of 9		
PARTS: 1. All parts: Connector 6188-0066 (GR);Black corrugated tube (no slit) Ø7 L= 24±3mm; Black corrugated tube (no slit) Ø5 L= 258±3mm; Black tube (no slit) Ø7 L=456±4mm; AVSSf 0.3 Y/OR L=364±2mm; Connector 6189-1161 (B); MRSW CP G-B/W L=658±3mm; Black tape	Black Corrugated JIG:	Insertion jig w/ Switch cover Terminal cover jig Locking jig		
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
Table Lay-out Connector Black corrugated tube (no slit) ø5 L= 258±3mm Garage Garage Garage Garage Garage AVSSf 0.3 OR L=364mm±2mm Garage Garage	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 positions of parts/tools		

C. Villanueva A.Arañes

C. Villanueva

Approved

A.Arañes

Noted

Est. Date:

D.Castillo

K. Doria

Revised

J. Loterte

J. Loterte

Checked

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.

02/16/23

02/12/22

Eff. Date Rev. No

NBC (Philippines)

MASTER COPY

Work instruction improvement: Update Quality pointers. Inclusion of Quality checkpoint (Page 9).

Initial Issue. PCB from 2 chips (61C619-0002) to 1 chip (7N0994-7060). Wire color from Gray (GR) to Green (G).

Details of Change

February 12, 2022

			WORK	INSTRUC	CTION		Effectivity Date:			February	16, 2023
		Process Name/Title:	TAP	ING AS	SEMBLY PRO	CESS	Validity Date:			n/	a
		Model Code/Part Number	164B / 7M0610-	7021	Customer:	TRJ	Document No.:			WI-ENG-P	PDE-398A
		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		1	Page No.:	2 of 9
		<u> </u>					<u> </u>		1	<u></u>	
PARTS:	1. Conn	ector 6188-0066 (GR)						JIG	1. Inserti	on jig with S	Switch cover
NO.	PI	ROCESS NAME	WORI	K PROCE	EDURE/ ILLUST	RATION	TOOLS	/PPE	Q	UALITY F	POINTERS
2	P1	Connector setting to Insertion jig 6188-0066 (GR)	Insertion jig with switch cover Orange wire Yellow wire Visual reference Press 1. Press the lock using left hand.	I-mar Lock	Insertion jig Orientation Press R De connector 6188-0066 an jig. Release the lock and an jig. Release	Connector orientation Release G (GR) using right hand and insert to	n/a		I-ma ali	ONNECTOR OF ILLUSTRATE IN ILLU	DRIENTATION RATION 1 hole is open

			WORK INSTRU	CTION		Effectivity Date:			February	16, 2023
		Process Name/Title:	TAPING AS	SEMBLY F	PROCESS	Validity Date:			n/a	a
		Model Code/Part Number	164B / 7M0610-7021	Customer:	TRJ	Document No.:			WI-ENG-P	DE-398A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☐ MASSPRO Revision I							0	Page No.:	3 of 9
,										
PARTS:	1. AVSS	Sf 0.3 Y L=364±2mm; OR L	_=364±2mm				JIG	1. Insertic	on jig	
NO.	PI	ROCESS NAME	WORK PROC	EDURE/ ILLI	USTRATION	TOOLS/I	PPE	QI	JALITY P	POINTERS
3	P1	Wire Insertion to connector 6188-0066 (GR)	1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. 2 Orange wire R 3. Get the Orange wire and insert to connector using right hand.	2 O	Press the button using right hand. slot for Drange wire will be open. After insertion, push the lock button sing left thumb and then hold the wires and gently pull out the connector from jig sing right hand.	n/a		2. No wro 3. One by 4. No def 5. No wro Impor 1. Ple termin 2. Institute insert 3. Mo prope Condo after Do no 1. Re Wire 2. Ple	ase hold the nal during in ertion of wind ed. ake sure wire ry inserted uct Pull-Pusi insertion. at exert extra ment reference for to WI-Pland Strip le ease refer to	n ion ninal ring nders/Note/s: e wire near insertion. ire must be res are d. ch-Pull-Push ra force.

			WOI	RK INSTRUCTION			Effectivity Date:			February	16, 2023
		Process Name/Title:	T	APING ASSEMB	LY PROCESS		Validity Date:			n/a	a
		Model Code/Part Number	164B / 7M06	10-7021 Custo	omer:	ΓRJ	Document No.:			WI-ENG-P	DE-398A
		Purpose:	PROTOTYPE	☐ PRE-L	AUNCH	MASSPRO	Revision No.:		0	Page No.:	4 of 9
		<u> </u>					1		<u>l </u>		
PARTS:		corrugated tube (no slit) a corrugated tube (no slit)			onnector 6189-1161 (B) sy parts			JIG	1. Insertio	n jig	
NO.	PI	ROCESS NAME	W	ORK PROCEDURE	/ ILLUSTRATION		TOOLS/I	PPE	Ql	JALITY P	POINTERS
4		Wire insertion to COT (no slit) Ø7 L= 24±3mm Ø5 L= 258±3mm	1. Hold the wires using left h Corrugated tube (no slit) Ø7 I using right hand and insert th	= 24±3mm ne wires. Ø7, L= 24±3	2. Hold the wires usin Corrugated tube (no using right hand and	slit) ø5 L= 258±3mm	n/a		1. No wro	ong use of p	arts
5	P1	Connector setting to insertion jig 6189-1161 (B)	Visual reference Press 1. Press the lock using left hand.	Insertion jig Orier Press 2. Get the connector 6183 hand and insert to insertion after insertion.	Releas 9-1161 (B) using right	Connector Orientation 3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.	n/a		I-ma al I-ma not	ark is ign Gark is align No	1 hole is open 1 hole is open

			WORK INST	RUCTION			Effectivity Date:			February	16, 2023
		Process Name/Title:	TAPING	ASSEME	LY PROCESS	3	Validity Date:			n/a	a
		Model Code/Part Number	164B / 7M0610-702	Cust	omer:	TRJ	Document No.:			WI-ENG-P	DE-398A
		Purpose:	PROTOTYPE	PRE-I	AUNCH	MASSPRO	Revision No.:		0	Page No.:	5 of 9
									<u> </u>		
PARTS:	1. Assy	parts						JIG	1. Insertio	on jig	
NO.	PF	ROCESS NAME	WORK PR	OCEDURE	/ ILLUSTRATIO	N	TOOLS/I	PPE	QUALITY POINTERS		
6	P1	Wire Insertion to connector 6189-1161 (GR)	1. Hold the insertion jig using left hand the Yellow wire and insert to connecte using right hand. 2 Orange wire and insert to connector using right hand.	or	4. After insertion, thumb and then h	using right hand. slot for	n/a		2. No wro 3. One by 4. No def 5. No wro Import 1. Pleatering 2. Inserting 3. Ma proper Condurafter in Do not Docur 1. Ref Wire 2. Ple	ase hold the nal during in rition of wir ed. ke sure win rly inserted. ct <u>Pull-Push</u> nsertion. t exert extro ment refere fer to WI-PR and Strip le. ase refer to	ders/Note/s: wire near asertion. e must be es are a-Pull-Push

				INSTRUCTION		Effe	ectivity Date:	February 16, 2023
		Process Name/Title:	TAF	ING ASSEME	BLY PROCESS	Val	lidity Date:	n/a
		Model Code/Part Number	164B / 7M0610)-7021 Cust	tomer: TRJ	Doc	cument No.:	WI-ENG-PDE-398A
		Purpose:	PROTOTYPE	☐ PRE-	-LAUNCH MASS	SPRO Rev	vision No.:	0 Page No.: 6 of 9
						l		
PARTS:	1. Black 2. Assy						JIG	1. Locking jig
NO.	PF	ROCESS NAME	WOR	K PROCEDURI	E/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7		Connector lock	in pubc	Put the connector to locking jig and lish down 2x using bith hands. Check the innector lock if operly locked. After Pressing	NG NG UNLOCK CONDITION HALF LOCKED CONDITION	GOOD FULLY LOCKED CONDITION	LOCKING JIG	Important reminders/Note/s: 1. Manual locking may cause damaged connector lock 1. No unlock/half-locked connector 2. No damaged lock
8	P1	Taping 1 COT to wire near connector	1. Hold the assy parts using left haget Black tape and conduct pre-tausing right hand. 28±3mm Tape width 0~5	2. Hold from Co	28±3mm If the assy parts using left hand and moon to connector 28±3mm. 3. Check the measurement and taping after taping.	easure		Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measuremement. Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure. 1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

				WORK INSTRUCTION	ON		Effectivity Date:	February 16, 2023
		Process Name/Title:		TAPING ASSE	MBLY I	PROCESS	Validity Date:	n/a
		Model Code/Part Number	164B /	7M0610-7021	Customer:	TRJ	Document No.:	WI-ENG-PDE-398A
		Purpose:	☐ PROTOTYP	E .	PRE-LAUNCH	H MASSPRO	Revision No.:	0 Page No.: 7 of 9
	1							
PARTS:	1. MRSV 2. Black	V CP G-B/W L=658±3mm tape		;	3. Black Co	orrugated tube Ø7 (no slit) , L=456±4mm	JIG	1. Terminal cover jig
NO.	PF	ROCESS NAME		WORK PROCEDU	JRE/ ILL	USTRATION	TOOLS/PPE	QUALITY POINTERS
9		Wire insertion to COT Ø7 L= 456±4mm		ver jig using right hand then als (G-B/W wires) using right	usii wir	Get the corrugated tube Ø7, L=456±4mm ng right hand then insert the G wire and B/W re using left hand. After insertion, remove the ver jig using right hand.	TERMINAL COVER JIG	1. No wrong use of parts
10	P1	Taping 2 COT to wire near hotmelted wires	Start of Taping L Tape width	1. Hold the corrugated tube using left hand and start taping using right hand. 131±3mm	2. Hol COT u contir	Id the COT using left hand and measure the up to the end of melted wire 131±3mm and nue taping using right hand.	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 10 10 10 10 10 10 10 10 10 10 10 10	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measuremement. Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure. 1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

				WORK INSTRU	JCTION		Effectivity Date:			February 1	6, 2023
		Process Name/Title:		TAPING AS	SSEMBLY PROC	ESS	Validity Date:	Validity Date:			
		Model Code/Part Number	164B /	7M0610-7021	Customer:	TRJ	Document No.:			WI-ENG-PD	E-398A
	Process Name/Title: Model Code/Part Number 164B	8 of 9									
PARTS:	1. Assy	parts						JIG	1. Termi	inal cover jig	
NO.	Р	ROCESS NAME		WORK PROC	EDURE/ ILLUSTR	ATION	TOOLS/PPE QUALITY POINTERS				
11	P1	Wire insertion to assy		t the terminal cover jig using r	right hand then insert to bo		TERMINAL CO	VER JIG	1. No wr	ong use of pa	rts

L R

3. After insertion, remove the terminal cover jig using right hand.

2. Hold the COT Ø7 L= 24±3mm using left hand then insert the G-B/W wires using right hand.

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.

parts

MAA	Process Name/Title:	Effectivity Date: Validity Date:		February 16, 2023 n/a				
	Model Code/Part Number:		APING ASSEMBLY PROD 10-7021 Customer:	TRJ	Document No.:		WI-ENG-PDE-398A	
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	9 of 9
ARTS: 1. As:	sy parts					JIG n/a		
			QUALITY CHECK	POINTS		I		
P1			7M061	0-7021				
5						. (3		
- Common					The state of the s	3)	

NO GOOD



GOOD

- 1 No Wrong insert
- 2 NO Unlock/HALFLOCK

- 3 No Missing tape
- 4 No Missing COT

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.