PROCESS NAME PROCEDURE/ILLUSTRATION Document No.: Document No.: Page No.: 1 of 3 1	WORK INSTRUCTION Effectivity Date: May 18, 2021												04			
Product Name(Code: 291B / 7L0036-7020 Customer: TRQSS Purpose: PROTOTYPE PRELAUNCH NASSPRO Revision No.: 2 Page No.: 1 of 3 PARTS: 1 Assy parts 2 Clamp 2711-52090 (W) 2 3. Black tape [1pc.] NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PE StandaRO Taping 1 1. Get 1pc. of clamp 82711-52090 (W) using gift hand and insert to location 1 using both hands. Position 1 Taping 1 Black corrugated tube to Black winy tube 1 Black corrugated tube to Black winy tube 1 Black corrugated tube to Black winy tube 1 Black corrugated tube to Black winy tube 1 Assy parts 2 Hold the corrugated and winy tube, make sure no gap in between. 3 After taping, check the measurement and taping condition. 3 After taping, check the measurement and taping condition.				Process Namo/Titlo:												
PARTS: 1. Assy parts 2. Claimp p2711-52090 (W) 2. Claimp p2711-52090 (W) 3. Block tape [finc.] 3. Block tape [finc.] 4. Claimp perting 4. Claimp perting 5. Safety Instruction 8. Sure to wear 5. Finger cots, etc.) 5. Safety Instruction 8. Sure to wear 5. Finger cots, etc.) 6. Safety Instruction 8. Sure to wear 5. Finger cots, etc.) 6. Safety Instruction 8. Sure to wear 5. Finger cots, etc.) 7. Finger cots, etc.] 7. Finger cots, etc.) 7. Fi																
PARTS: A 2. Clamp 82711-52090 (W) NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE One side tape under clamp prescribed personal protective equipment during operation (gloves, finger cots, etc.) 1. Get 1pc. of clamp 82711-52090 (W) using right hand and insert to location 1 using both hands. 1. Get 1pc. of clamp 82711-52090 (W) using right hand and insert to location 1 using both hands. 1. Fix the corrupated and vinny tube, make sure no again between. 1. Fix the corrupated and vinny tube, make sure no again between. 1. Fix the corrupated and vinny tube, make sure no again between. 2. Hold the corrugated tube to Black vinny tube 1. No wrong use of clamp 2. Hold the corrugated tube to label winny tube, make sure no again than the threa start taping using right hand. 2. Hold the corrugated tube to label winny tube using right hand. 3. After taping procedure. 1. No loose tape 2. No flip-out tape 2. No wrong use of clamp 3. No wrong use of clamp 4. No wrong use of clamp 4. No wrong use of clamp 5. No wrong use of clamp 5. No wrong use of clamp 6. No wrong use of cla																1
PARTS: (2) 2. Clamp Partin-52090 (W) NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE Clamp setting 1. Get 1pc. of clamp 82711-52090 (W) using right hand and insert to location 1 using both hands. P2 P2 Taping 1 Black corrugated tube to Black vinyt tube Black corrugated tube to Black vinyt tube 1. Fix the corrugated and vinyt tube using left hand then start taping using right hand. Refer to Wi-PRO-ASY-021 for taping procedure. Taping 1 Black corrugated tube to Black vinyt tube 1. Alert level Froat protective equipment during town town on the period of tape under clamp before start of assembly to avoid wrong use of parts. P2 Alert level Froat protective state of assembly to avoid wrong use of parts Alert level Froat protective state of assembly to avoid wrong use of tape Alert level Froat protective state of assembly to avoid wrong use of tape 1. No loose tape 2. No lip-out tape 3. No wrong use of gape 5. No wrong use of gape 6. No wr				Purpose:	PROTOTYP	'E	☐ PRE-LAUNCH	MAS	SPRO		Rev	vision No.:		2	Page No.:	1 of 3
Clamp setting 1 Clamp setting 2 Clamp setting prescribed personal procedure start of assembly to avoid wrong use of parts 2 Clamp setting prescribed personal prescribed personal procedure start of assembly to avoid wrong use of parts 2 Clamp setting prescribed personal prescribed personal procedure start of assembly to avoid wrong use of parts 2 Clamp setting prescribed personal prescribed perso		/2∖	2. Clam 3. Black	np 82711-52090 (W) k tape [1pc.]		WORK P	ROCEDURE/ ILLI	JSTRATION						<u>'</u>		NTERS
P2 P2 Taping 1 Black corrugated tube to Black vinyl tube Black corrugated tube to Black vinyl tube Black vinyl tube Black corrugated tube to Black vinyl tube Black vinyl tube Black corrugated tube to Black vinyl tube Black corrugated tube to Black vinyl tube Black vinyl tube Black corrugated tube to Black vinyl tube Black vinyl tube Black corrugated tube to Black vinyl tube Black vinyl tube Black corrugated tube to Black vinyl tube Black vinyl				Clamp setting	1				SHITTER ARRESTS Y	-63	i d	Safety Instruction Be sure to wear prescribed personal protective equipment uring operation (glow finger cots, etc.)	n l			
Taping 1 Black corrugated tube and vinyl tube Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black corrugated tube to Black vinyl tube Taping 1 Black vinyl t					right hand and insert		tape on start	start of assembly to avoid wrong use			1. Maintain and always practice 5's.		2. No wrong use of clamp			
		2	P2	Black corrugated tube to	L tape wid	vinyl tube, n gap in between	rrugated and nake sure no een.	3. After taping, ch	tube and left hand using righ Refer to V for taping	vinyl tube us then start ta it hand . WI-PRO-ASY- g procedure.	v v v v v v v v v v v v v v v v v v v	Alert level For any trouble, info the Assembly Assista Supervisor or Line Leader for immedia: corrective action. MEASURING TAPE	ed. 1. No 2. No 3. No 4. No 5. No 4.	oflip-ou peel-o wrong wrong wrong Note: Please measur	t tape If tape If tape Use of tape If tape Use calibrated/vering tape when g	
	05/40/04	0	I_			Revision History			1			Prepared by	Reviewed	by	Approved by	Noted by
11/17/20 1 Transfer process owner from Production (WI-PRO-ASY-048) to Engineering (WI-ENG-PDE-198B). Apply some improvements/pictures. Removal of marker on taping jig. M. Catapang R. Peñaloza A. Shirmanura A. Arañes	11/17/20	1	Transfer improve	process owner from Production ments/pictures. Removal of m	on (WI-PRO-ASY-048) to arker on taping jig.		DE-198B). Apply some	M. Catapan	R. Peñaloza	A. Shimamura	A. Arañes		201		Shit	
07/10/17 0 Previously established as Production work instruction (WI-PRO-ASY-048). Initial issue J. Montealtov L. Briton L. Briton F. Sugiyama J. M. Catapan C. Villanueva A. Shimamura A. Arañes Eff. Date Rev. No Details of Change Revised Checked Approved Noted Est. Date: July 10, 2017			Previous	sly established as Production v	,	,								eva	Ā. Shimamura	A. Arañes
Emission Change Nevised Approved Noted Est. Date. Puly 10, 2017	Lii. Dale	IVGA INO	1		Details of	Griange		Revised	CHECKED	Approved	INOIEG	Loi. Dale.	puly 10, 2017			

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

			Effectivity Date:		May 18, 2021									
		Process Name/Title:								Validity Date:		n/a		
		Product Name/Code:							Document No.:	Document No.:		WI-ENG-PDE-198B		
		Purpose:	□ P	ROTOTYF	PE	PRE-LAUNCH		MASSPRO	Revision No.:		2	Page No.:	2 of 3	
	_								I					
PARTS:	1. Assy 2. Black									JIG	1. Clamp	p Assembly ji	g	
NO.	PROCESS NAME				WORK PROC	EDURE/ ILL	USTRATION		TOOLS/	PPE	QI	JALITY P	OINTERS	
3	P2	Clamp assembly	1. Get the a correct sett Receiver ba jig. Last, set	ting). First ase 1 and the B/W by toggle thion 1 was	and set into jig. (See above t, set the connector 6188-0: then lock. Continue to set t-GR wires together within clamp. Continue the proce	d the vinyl tube. (sefore cutting of taund will be heard.	wire1, wire2 and encountered abnor immediately CALL t leader. WAIT for fur continue the process	the attention of the orther instruction and	n/a		1. No flip 2. No pe 3. No loc 4. No wr	p-out tape bel-off tape bese tape rong insertion sure no gap	res no clearance and stopper jig.	

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

		WORK INSTRUCTION Effectivity Date:									May 18, 2021		
		Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date:									n/a		
	_	Product Name/Code:	291B /	7L0036-702	Customer:	TRO	QSS	Document No.:			WI-ENG-P	DE-198B	
		Purpose:	☐ PROTO	TYPE	PRE-LAUNCH		MASSPRO	Revision No.:		2	Page No.:	3 of 3	
PARTS:	n/a								JIG	n/a			
NO.	PR	OCESS NAME		WORK PR	OCEDURE/ ILLUSTI	RATION		TOOLS/	PPE	Q	JALITY F	POINTERS	
4	2	Visual/By Two's Inspection	1. Check the c	connector lock.	2. Check the taping conditi	4.	3. Check the terminal a no deformed terminal. Compare to Master Sarbee: Please refer to GL-Pspection of Sub-Assy	mple	—		MASTER		
				6	MEASURING TAPE 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		librated/verified measu tting the measurement			NO	TE: FOR HAT OWARII	SUMONO AND MONO	
5		Measurement	0~5mm					V=	-	1. No w	rong dimens	sion	

338±3mm

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

238±3mm

50±3mm