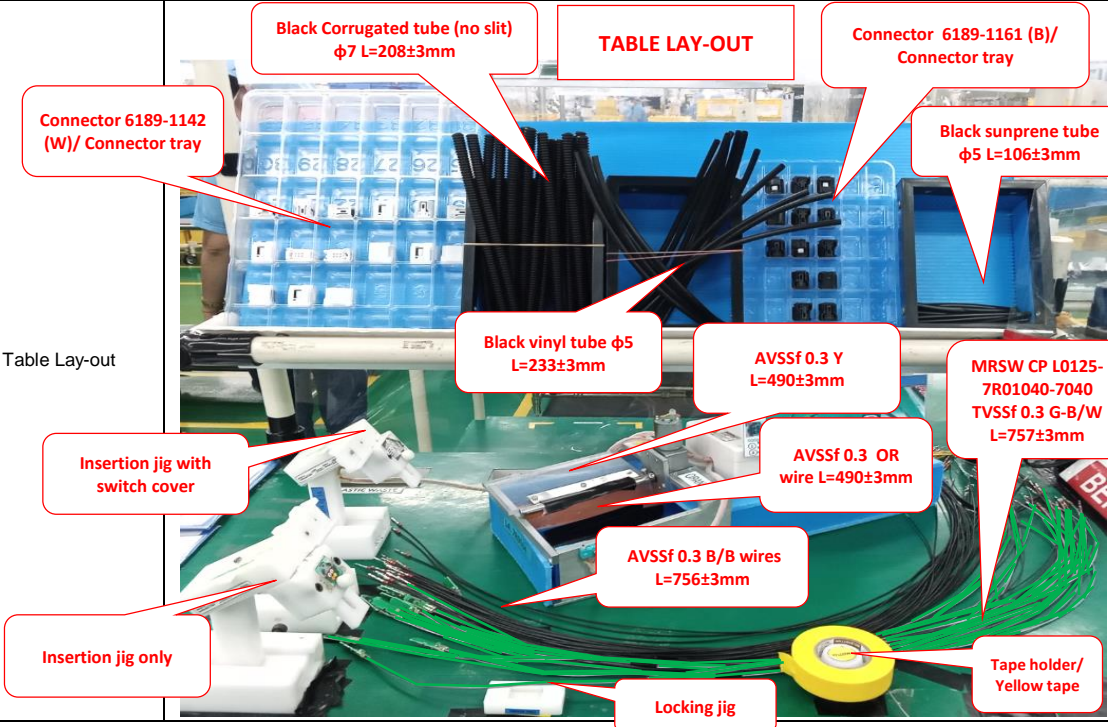
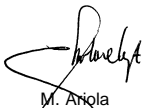


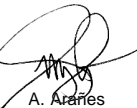
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: February 14, 2022	
	Process Name/Title:				Validity Date:	
	Model Code/ Product Number 780B / 7R0104-7022		Customer: TRMX		Document No.: WI-ENG-PDE-391A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 1 of 8

PARTS: All parts; Connector 6189-1142 (W); Connector 6189-1161 (B); AVSSf 0.3 Y L=490±3mm; OR wire L=490±3mm; Black corrugated tube (no slit) $\phi 7$ L=208±3mm; Black vinyl tube $\phi 5$ L=233±3mm; Yellow tape [1pc]; Black sunprene tube $\phi 5$ L=106±3mm; MRSW CP L0125-7R01040-7040 TVSSf 0.3 B/W L=757±3mm; G wires L=757±3mm; AVSSf 0.3 B/B wires L=756±3mm [2pcs.]		JIG: 1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out		<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		<div> Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Lenght tolerance </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div>	

				Prepared by		Reviewed by		Approved by		Noted by	
											
02/14/22	0	Initial Issue.		M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Est./Date:		February 14, 2022	
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted				

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:

February 14, 2022

Process Name/Title:

Model Code/ Product Number **780B / 7R0104-7022**

Customer: **TRMX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-391A

Revision No.:

0

Page No.:

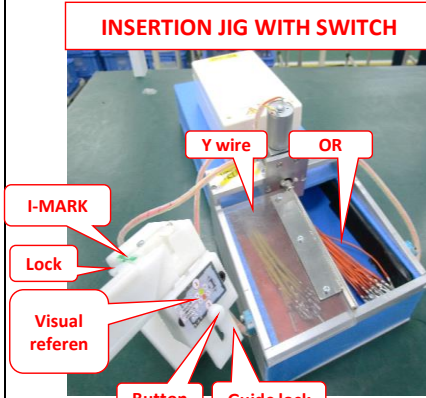
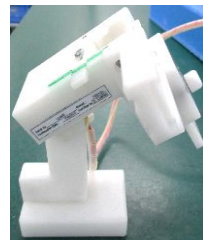
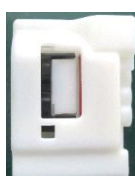
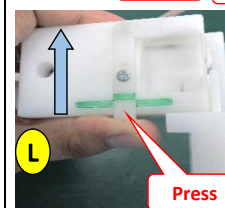
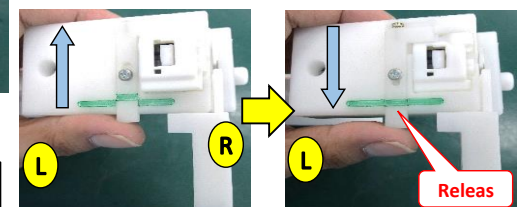
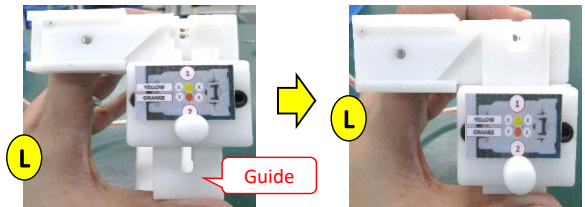
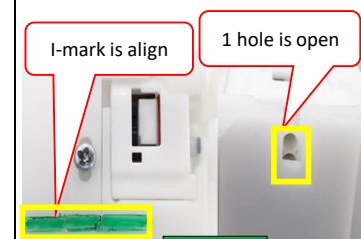
2 of 8

PARTS:

1. Connector 6189-1142 (W)
2. AVSSf 0.3 Y L=490±3mm; OR wire L=490±3mm

JIG

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6189-1142 (W)	<div><div>INSERTION JIG WITH SWITCH</div><div>INSERTION JIG</div><div>CONNECTOR ORIENTATIO</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6189-1142 (W) into jig using right hand and release the lock.</div><div>3. Press the guide using left thumb. The slot for Y wire will be opened.</div></div>	n/a	<div><p>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance</p></div> <div><ol style="list-style-type: none">1. Use the provided jig per model2. No wrong usage of parts3. No wrong orientation of connector4. No damaged connector</div> <div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>GOOD</div></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

Model Code/ Product Number 780B / 7R0104-7022

Customer: TRMX

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 14, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-391A

Revision No.:

0

Page No.:

3 of 8

PARTS:

n/a

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

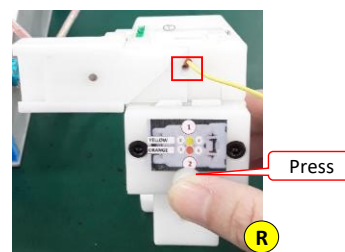
QUALITY POINTERS

3

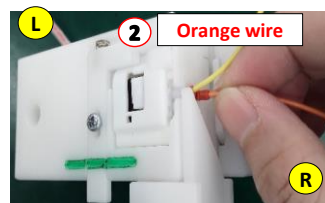
P1

Wire insertion to
connector
6189-1142 (W)

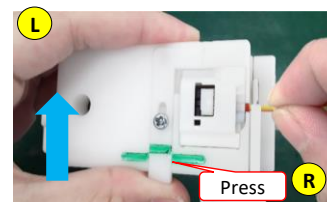
1. Hold the insertion jig using left hand. Get the **Y wire** and insert to connector using right hand.



2. Press the button using right thumb. The slot for **OR wire** will be opened.



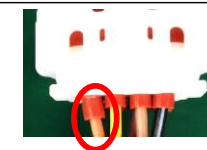
3. Get the **OR wire** and insert to connector using right hand.



4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

Note: During insertion, hold the wire not rubber seal to prevent sagging.



1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Note: Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.

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:

February 14, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Product Number

780B / 7R0104-7022

Customer:

TRMX

Document No.:

WI-ENG-PDE-391A

Purpose:



PROTOTYPE



PRE-LAUNCH





MASSPRO

Revision No.:

0

Page No.:

4 of 8

PARTS:	1. Black corrugated tube (no slit) $\phi 7$ L=208 \pm 3mm 2. Black vinyl tube $\phi 5$ L=233 \pm 3mm 3. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L= 208 \pm 3mm	 <div data-bbox="768 627 1294 767">1. Get the corrugated tube (no slit) $\phi 7$ L= 208\pm3mm using right hand then insert the Y-OR wires using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
5			 <div data-bbox="768 1114 1294 1235">1. Get the vinyl tube $\phi 5$ L= 233\pm3mm using right hand then insert the Y-OR wires using left hand.</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**Model Code/ Product Number **780B / 7R0104-7022**Customer: **TRMX**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 14, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-391A

Revision No.:

0

Page No.:

5 of 8

PARTS:

1. Connector 6189-1161 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

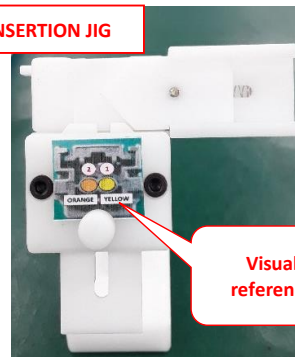
QUALITY POINTERS

6

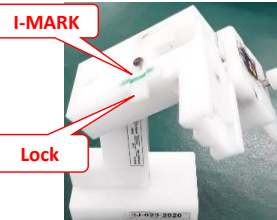
P1

Connector setting to
insertion jig
6189-1161 (B)

INSERTION JIG

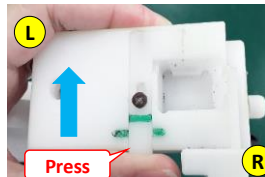
Visual
reference

I-MARK

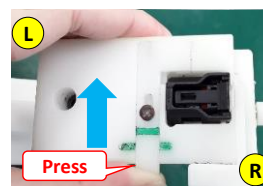


Lock

INSERTION JIG ORIENTATION

CONNECTOR
ORIENTATION

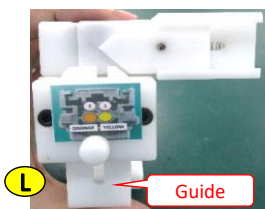
Press

1. Press the insertion jig
lock using left thumb.

Press

2. Get the connector **6189-1161 (B)** using right hand and insert to
insertion jig. Release the lock after insertion.

Release

3. Press the guide using left
thumb. The slot for **Y wire** will
be opened.

Guide

n/a

CONNECTOR ORIENTATION
ILLUSTRATION

I-mark is align

1 hole is open



GOOD

I-mark is not
align

1 hole is open



NG

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation 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

Process Name/Title:

Model Code/ Product Number **780B / 7R0104-7022**

Customer:

TRMX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

February 14, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-391A

Revision No.:

0

Page No.:


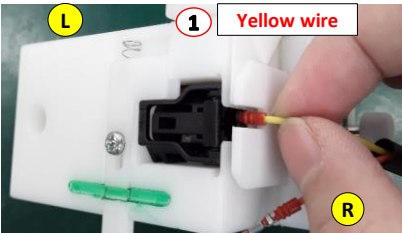
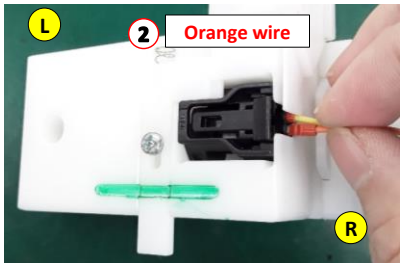
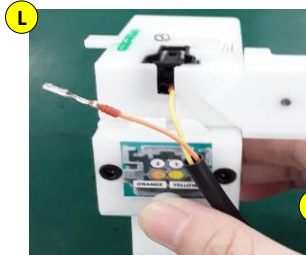
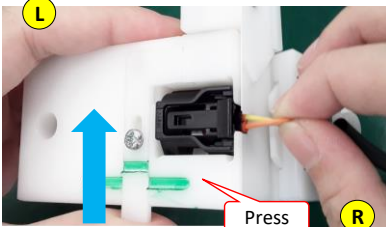
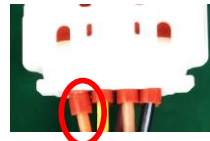
6 of 8

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to connector 6189-1161 (B)	<div><p>WIRE FACING</p></div> <div><p>1 Yellow wire</p><p>1. Hold the insertion jig using left hand. Get the Y wire and insert to connector using right hand.</p></div> <div><p>2 Orange wire</p><p>3. Get the OR wire and insert to connector using right hand.</p></div> <div><p>3</p><p>2. Press the button using right thumb. slot for OR wire will be open.</p></div> <div><p>4</p><p>4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<div><p>Note: During insertion, hold the wire not rubber seal to prevent sagging.</p></div> <div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></div> <div><p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</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:

February 14, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/ Product Number **780B / 7R0104-7022**

Customer:

TRMX

Document No.:

WI-ENG-PDE-391A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

7 of 8

PARTS:

1. Assy parts
2. Yellow tape

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

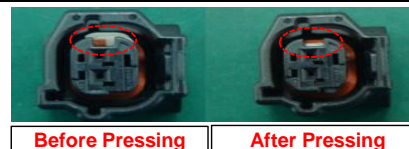
QUALITY POINTERS

8

Connector lock



1. Put the connector into locking using right hand and then press **2x** using both hands.



Before Pressing

After Pressing



Unlock Condition

Half lock Condition

Full lock Condition

LOCKING JIG

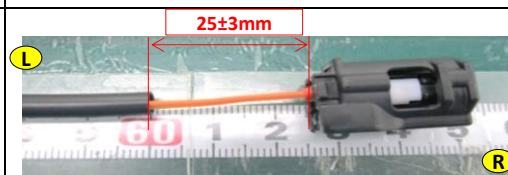


NOTE: MANUAL LOCKING MAY CAUSED DAMAGED CONNECTOR LOCK

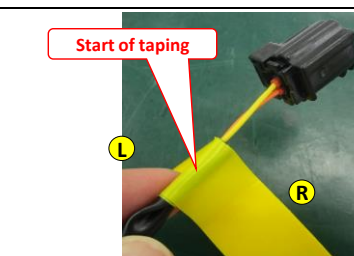
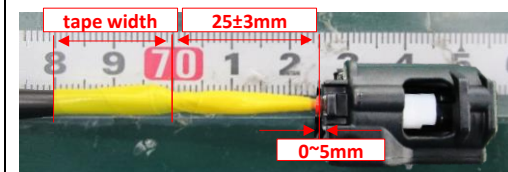
1. Use the provided jig tool per model
2. No unlock/half-locked connector
3. No damaged lock

9

P1

Taping 1
Black vinyl tube to wire
near connector

1. Hold the vinyl tube using left hand. Measure from end of vinyl tube up to connector **25±3mm** using both hands.



Start of taping

2. Hold the vinyl tube using left hand. Get the Black tape using right hand and start taping process using both hands.

Note: Refer to WI-PRO-ASY-001 for taping procedure.

3. After taping, check the measurement and taping condition.

MEASURING TAPE



Note:
Set aside the assy part after assembly.

NOTE:
Use **YELLOW TAPE** only.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

Note:
Please use calibrated/verified measuring tape when getting the measurement.

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:

February 14, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Product Number

780B / 7R0104-7022

Customer:

TRMX

Document No.:

WI-ENG-PDE-391A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

8 of 8

PARTS:

1. Assy parts

2. MRSW CP L0125-7R01040-7040 TVSSf 0.3 B/W L=757±3mm; G wires L=757±3mm

4. Black sunprene tube $\phi 5$ L=106±3mm

3. AVSSf 0.3 B wires L=756±3mm [2pcs.]

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

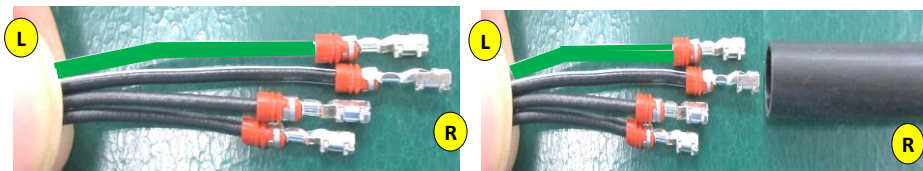
TOOLS/PPE

QUALITY POINTERS

10

P1

Wire insertion to
Black sunprene tube
 $\phi 5$ L=106±3mm



1. Get the **G-B/W hotmelted wires (MR SW CP)** and **B/B wires L=756±3mm** using both hands then hold using left hand.

2. Get the sunprene tube **$\phi 5$ L= 106±3mm** using right hand then insert the **G-B/W hotmelted wires** and **B/B wires** using left hand.

n/a

Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance

1. No wrong use of parts
2. No deformed terminal

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