

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 5, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐

PRE-LAUNCH

☒

MASSPRO

Revision No.:

3

Page No.:

1 of 16

PARTS:

1.Connector 6098-3802 (W); Black Corrugated Tube (No slit) $\phi 5$ L=483 \pm 4mm; Black VM tube (Sunprene) $\phi 9$ L=112 \pm 3mm; AVSSf 0.3 G-B-V wires L=646mm; Clamp 82711-34490 (B); Clamp 82711-48070 (GR); Clamp 82711-52090(W); Black tape [2pcs]; White tape

JIG:

1. Insertion jig with and w/o switch cover
2. Locking jig
3. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 (Table 1)	Table Lay-out	<div>BATCHING QUANTITY: 10pcs</div> <div>TABLE LAY-OUT</div> <div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>CONNECTOR ILLUSTRATION</div> <div>CLAMP ILLUSTRATION</div> <div>BAND CLAMP ILLUSTRATION</div> <ol style="list-style-type: none">1. No missing parts/tools.2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
04/05/23	3	Work instruction improvement: Inclusion of batching and update table lay-out (Page 1). Change term from sunprene tube to VM tube (Sunprene). Inclusion of Quality Checkpoints (Page 16).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
10/14/22	2	Merge P1 and P2. Improve Quality pointers; Reminders/notes and references on page no.1,3,5,6,7,8,9,10,11,12,13 and 15; Improve work procedure on process no.6- Connector lock and process no. 14-Visual/By two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
03/20/21	1	Change from pre-launch to masspro. Add tape quantity in parts.	D.Castillo	C.Villanueva	A.Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 9, 2020		

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 5, 2023

Process Name/Title:

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

2 of 16

PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 (Table 1)	Connector setting to insertion jig 6098-3802 (W)	<div><div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div><div>I-mark</div><div>G-wire</div><div>Switch cover</div><div>B-wire</div><div>Lock</div><div>Insertion jig</div><div>Button</div></div></div><div><div><div>↑</div><div>Press</div></div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div></div><div><div><div>Connector Orientation</div><div><div><div>↑</div><div>Release</div></div></div><div><div>2. Insert the connector 6098-3802 into jig using right hand and release the lock.</div></div></div><div><div><div>Guide</div><div><div>↑</div><div>Hole</div></div></div><div><div>3. Push the guide using left thumb. The slot for Green wire will be opened.</div></div></div></div></div>	N/A	<div><div><div>Connector Orientation</div><div><div><div>I-mark is</div><div>1 Hole is</div></div></div><div><div>GOOD</div></div><div><div><div>I-mark is</div><div>1 hole is</div></div></div><div><div>NG</div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></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

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 5, 2023

Process Name/Title:

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


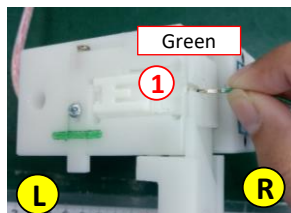
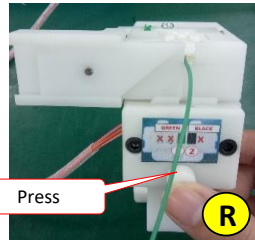
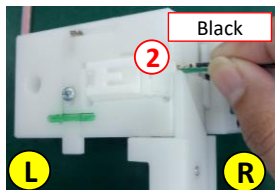
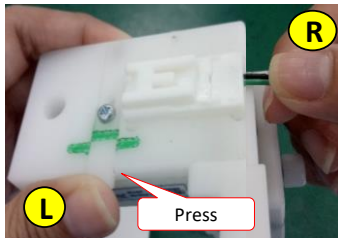
☒ MASSPRO

Revision No.:

3

Page No.:

3 of 16

PARTS:		1. AVSSf 0.3 G wires L=646±3mm			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 (Table 1)	Wire insertion to connector 6098-3802 (W)	<div><div><p>Wire facing</p></div><div><p>Green ①</p><p>L R</p><p>1. Get the Green wire then insert to terminal slot ① using right hand.</p></div><div><p>Press</p><p>R</p><p>2. After insertion of Green wire press the button using right hand. The slot for Black wire will be opened.</p></div><div><p>Black ②</p><p>L R</p><p>3. Get the Black wire then insert to terminal slot ② using right hand.</p></div><div><p>L R</p><p>Press</p><p>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div> <div>N/A</div> <td><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</div><div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></td>		<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</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:

April 5, 2023

Process Name/Title:

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

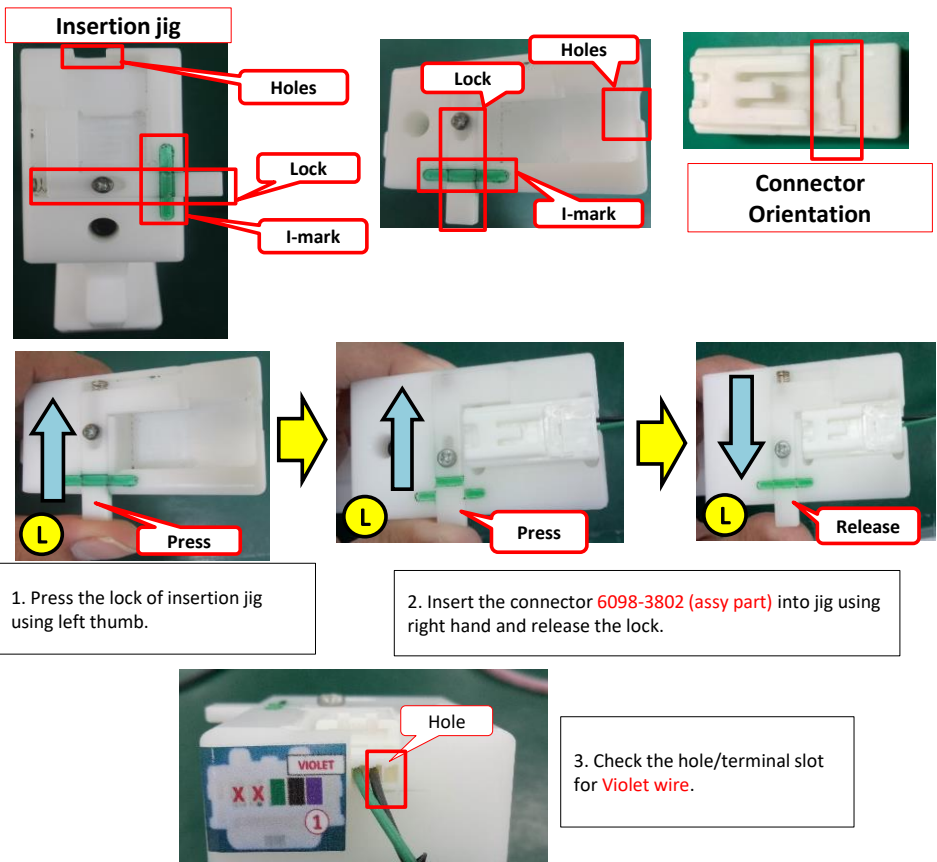
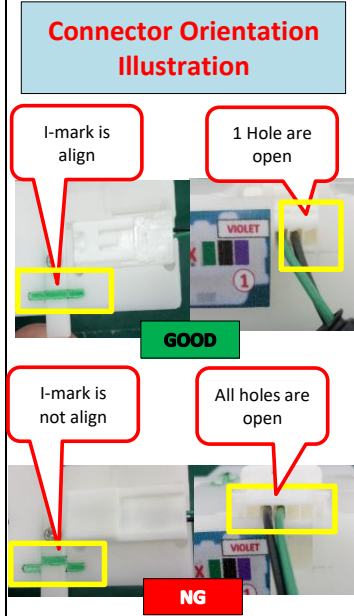
☒ MASSPRO

Revision No.:

3

Page No.:

4 of 16

PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 (Table 1)	<p>Connector setting to insertion jig 6098-3802 (W)</p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6098-3802 (assy part) into jig using right hand and release the lock.</p> <p>3. Check the hole/terminal slot for Violet wire.</p>		N/A	<p>Connector Orientation Illustration</p>  <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p> <p>3. No wrong use of connector</p> <p>4. No damaged connector</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

**WORK INSTRUCTION**

Effectivity Date:

April 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/aModel Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

5 of 16**PARTS:**

1. AVSSf 0.3 V wire L=646mm

JIG

1. Insertion jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

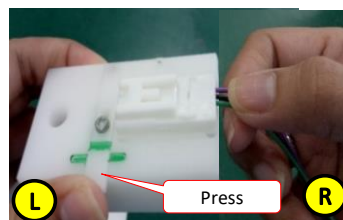
5

P1
(Table
1)

Wire insertion to assy parts



1. Get **Violet wire** then insert to terminal slot
① using right hand.



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

n/a

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

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
 2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document reference/s:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Stip length tolerance.

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:

April 5, 2023

Validity Date:

n/a

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

6 of 16

PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P1
(Table
1)

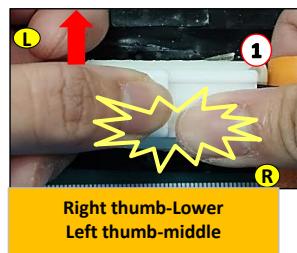
Connector lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



3. Press the lower parts of connector using right hand while left hand holding the middle.



4. Press the upper part of connector using right hand while left hand holding the middle.

Locking jig



1. Use the provided locking jig per model
2. No unlock/half-lock connector

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.



GOOD

NG



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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/aModel Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3






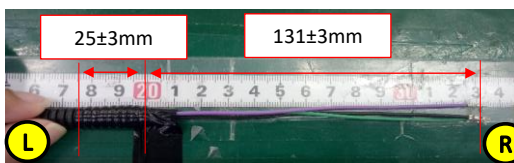


Page No.:

7 of 16**PARTS:**

1. Black corrugated tube (no slit) $\varnothing 5$ L=483 \pm 4mm
2. Black tape

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Black corrugated tube (no slit) $\varnothing 5$ L=483 \pm 4mm	 <p>1. Get the terminal cover jig using right hand and insert wires using left hand.</p>  <p>2. Get the Black corrugated tube (no slit) $\varnothing 5$ L=483\pm4mm using right hand and insert the wires using left hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>	Terminal Cover Jig 	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
8	Taping 1 Corrugated tube to wire near terminal	 <p>1. Get Black tape, hold corrugated tube using left hand then start pre-taping.</p>  <p>2. Measure the end of the corrugated tube up to the terminal tip 131\pm3mm. Then continue taping using right hand.</p>  <p>3. After taping, check the dimension, taping condition and wire alignment.</p>	Measuring tape 	<ol style="list-style-type: none">1. No loose tape2. No peel-off tape3. No flip-out tape4. No wrong dimension <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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

**WORK INSTRUCTION**

Effectivity Date:

April 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/aModel Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

8 of 16**PARTS:****3**

1. Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm
2. Black tape

JIG

N/A

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

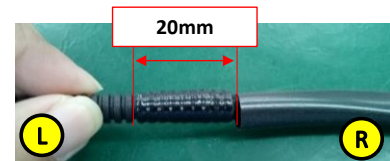
9

3

Wire insertion to
Black VM tube (Sunprene)
 $\varnothing 9$ L=112 \pm 3mm



1. Hold the wires using left hand and insert the VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm using right hand.



2. Insert the VM tube (Sunprene) to COT 20mm.

N/A

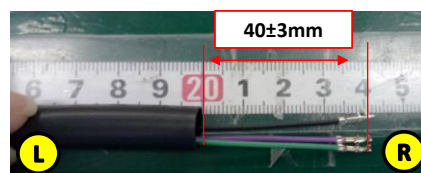
1. No wrong use of parts

P1
(Table
1)

10

3

Taping 2
Corrugated tube to
VM tube (Sunprene)



1. Hold the COT using left hand and measure the end of VM tube (Sunprene) up to the terminal tip 40 \pm 3mm.



2. Hold the VM tube (Sunprene) using left hand then start taping using right hand.



3. After taping, check the taping condition and terminal appearance.

40 \pm 3mm**Measuring tape**

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

Important reminders/Note/s:

1. 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:

April 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Part Number: **800B / 7N0069-7020**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-188

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

9 of 16

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

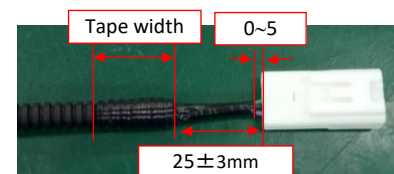
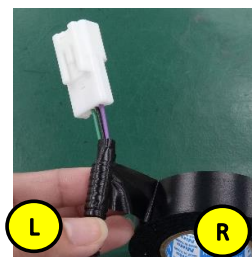
TOOLS/PPE

QUALITY POINTERS

11

P1
(Table
1)

Taping 3
Black Corrugated tube to
wire near connector



Measuring tape



1. No wrong use of tape
- 2 No wrong clamp position

Important reminders/Note/s:

1. 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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 5, 2023

Validity Date:

n/a

Model Code/ Part Number:

800B

/

7N0069-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

10 of 16

PARTS:

1. Clamp 82711-34490 (B)
2. Clamp 82711-48070 (GR)
3. Clamp 82711-52090 (W)

4. Black tape
5. White tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

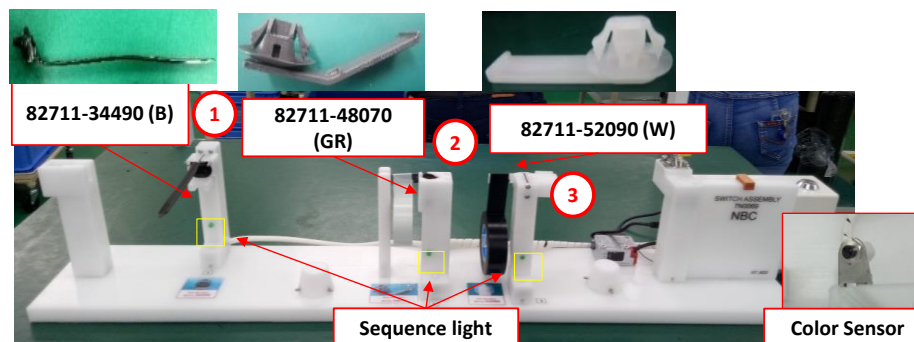
TOOLS/PPE

QUALITY POINTERS

12

P1
(Table
2)

Clamp setting



1. Get the clamp **82711-34490** using right hand and set to clamp location ① using both hands.

2. Get the clamp **82711-48070** using right hand set to clamp location ② using both hands.

3. Get the clamp **82711-52090** using right hand and set to clamp location ③ using both hands.

4. Get the **White tape** and initially attach tape to location ② using both hands.

5. Get the **Black tape** and initially attach tape to location ③ using both hands.

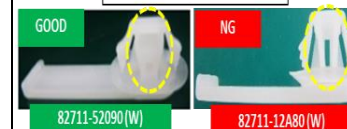
n/a

One side tape
under clamp

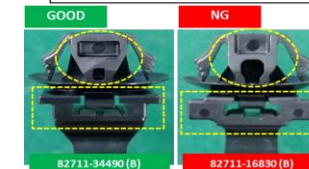
Important reminders/Note/s:

1. Please check the clamp first before start of assembly to avoid wrong use of clamp.

CLAMP ILLUSTRATION



BAND CLAMP ILLUSTRATION



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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/aModel Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

11 of 16**PARTS:**

1. Assy parts

JIG

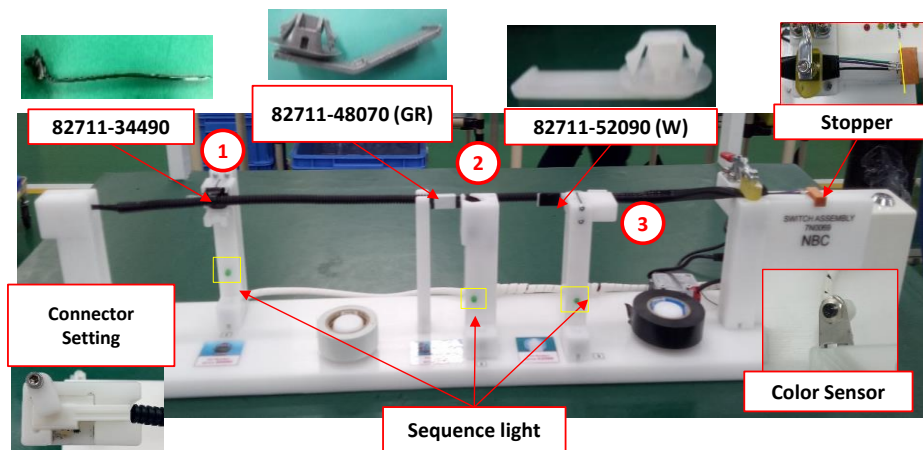
1. Clamp Assembly Jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

13

P1
(Table
2)

Clamp Assembly



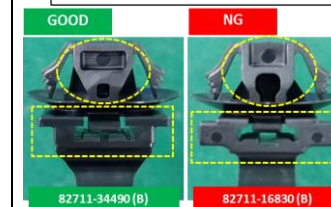
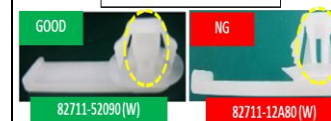
1. Get the assy parts and then put it on jig using both hands (See picture above). Set the **Green, Black and Violet wires** with terminal end together within the stopper then press by **Toggle clamp**.

2. Check if all LED light for **POWER ON** and **CLAMP** was **ON**. Check also if clamp location ① sequence light is **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

3. Initially tighten the band clamp on location ① using right hand.

N/A

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No tight/loose clamp attachment
7. No wrong use of clamp

BAND CLAMP ILLUSTRATION**CLAMP ILLUSTRATION**

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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Part Number: 800B / 7N0069-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

12 of 16

PARTS:

1. Assy parts

JIG

1. Clamp Assembly Jig

NO.

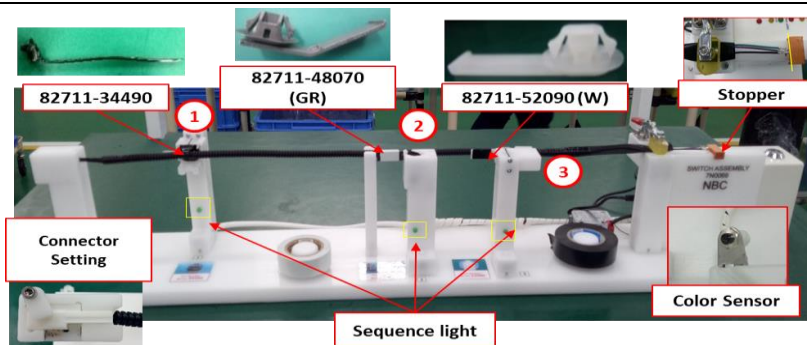
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

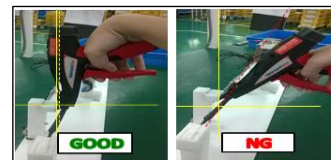
P1
(Table
2)Clamp Assembly
(Continuation)

4. Get the bando gun and cut the band clamp (82711-34490) using right hand. Press the SW after cutting. Continue to location ② if light was on.

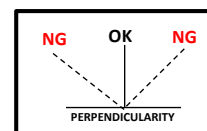
6. Hold the tape on clamp location ③ and start taping (3 windings) using both hands. Press the sequence light button after taping. GO buzzer will be heard.

7. **CONDUCT POINT CHECKING** before removing from jig.

5. Hold the tape on clamp location ② and start taping (3 windings) using both hands. Beep sound will be heard if the color sensor detects the **White tape**. Press the sequence light button after taping. Continue to location ③ if light was on.



BANDO GUN ALIGNMENT



Bando Gun

FLAT NOSEPIECE



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No tight/loose clamp attachment

Important reminders/Note/s:

1. **Must be no gap between the terminal and stopper jig.**
2. **Setting of band clamp cutter depends on the size of the COT/Vinyl tube.**
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$.

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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Part Number: 800B / 7N0069-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

13 of 16

PARTS:

1. Assembled parts
2. Master sample

JIG

N/A

NO.

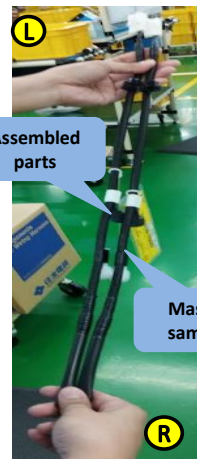
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

P1
(Table
2)Visual/By Two's
Inspection

1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **connector lock, insertion, and terminal**



3. Check the **taping condition.**



4. Check the **presence of clamp attachment, taping condition and color of tape.**



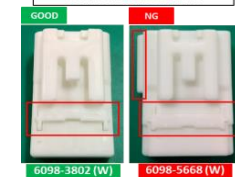
1. No skip checking during inspection.

Important reminders/Note/s:

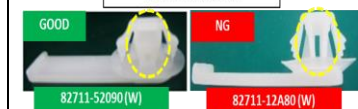
1. Using steel rule, check if the **band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).**



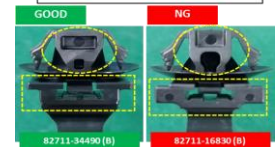
CONNECTOR ILLUSTRATION



CLAMP ILLUSTRATION



BAND CLAMP ILLUSTRATION



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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

14 of 16

PARTS:

1. Assembled parts
2. Master sample

JIG

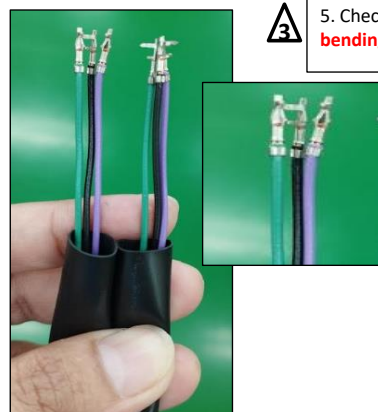
N/A

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

14

P1
(Table
2)Visual/By Two's
Inspection
(Continuation)

5. Check the **taping of COT to VM tube (Sunprene)**. Conduct **slightly bending**.



6. Check the **terminal appearance**. **Must be no deformed terminal**

MASTER SAMPLE

1. No skip checking during inspection.

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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Part Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

15 of 16

PARTS:

N/A

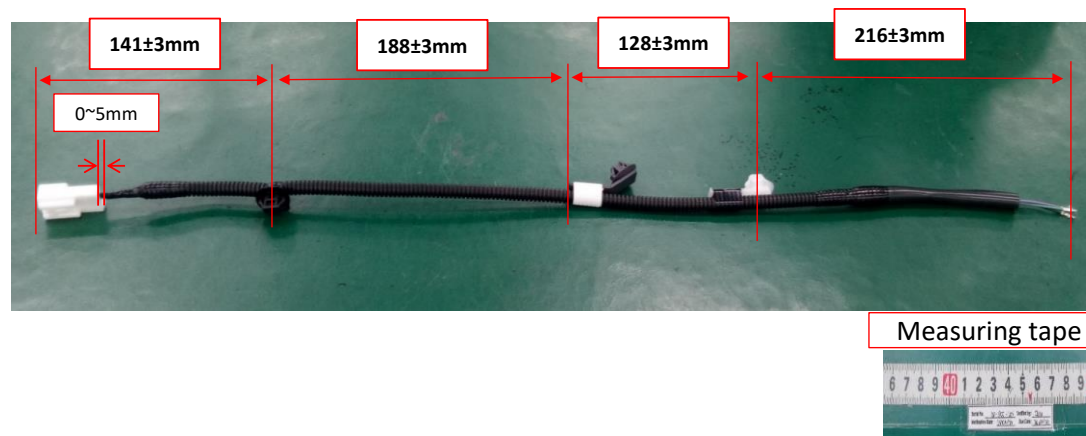
JIG

N/A

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

15

Measurement



1. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/ verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

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 5, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Product Number: **800B / 7N0069-7020**

Customer:

TRJ

Document No.:

WI-ENG-PDE-188

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

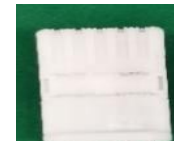
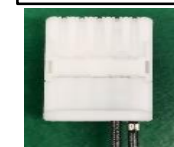
16 fo 16

PARTS:

n/a

JIG

n/a

**QUALITY CHECKPOINTS****P1****7N0069-7020****1****GOOD****NO GOOD****3****4****7****6****8****2****GOOD****NO GOOD****9****5****10****1** No **Unlock/Halflocked Connector****2** No **Terminal Backing Out****3** No **Wrong Insert****4** **5** No **Missing Tape****6** No **Wrong Used of Tape**
(**white tape**)**7** **8** **9** No **Missing Clamp (3pcs.)****10** No **Deform**
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