

	WORK INSTRUCTION						Effectivity Date:		November 28, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 920B / 7R0121-7020A		Customer: TRMX		Document No.: WI-ENG-PDE-555	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1 Page No.: 1 of 10	

PARTS:	1. Connector 6098-6663 (B); AVSSf 0.3 B L=316±2mm; Black Twist tube 2420F Ø5 L=247±3mm; Black tape						JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	QUALITY POINTERS
1	<div style="border: 1px solid black; padding: 5px; display: inline-block;"> 1 T1 </div> Table Lay-out (1)	<div style="text-align: center;"> TABLE LAY-OUT </div>						<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and stip length tolerance. </div> <div> 1. No missing parts/tools. 2. No excess parts/tools. </div>

Revision History								Prepared by		Reviewed by		Approved by		Noted by					
11/28/22	1	Change purpose from pre-launch to masspro. Additional table Lay-out Improve Quality pointers; Reminders/Notes and references on pages no.1,2,3,4,6,7,8 and 9; Improve work procedure/illustration on process no.8-Visual/By two's inspection. Improve work procedure/illustration on process no.3 Connector lock. Additional Quality checkpoints on page no.10.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes								
06/29/22	0	Initial issue.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes								
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		June 20, 2022					

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Document No.:

WI-ENG-PDE-555

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 10


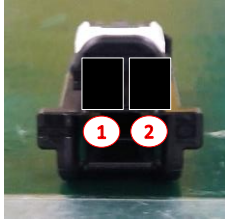

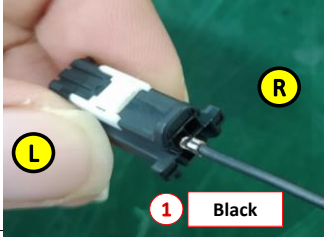
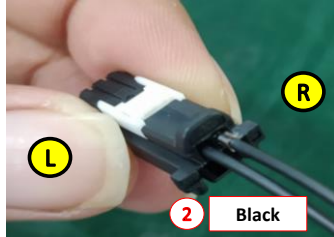
PARTS:

1. Assy parts
2. Connector 6098-6663 (B)

3. AVSSf 0.3 B L=316±2mm [2pcs]

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	T1 Wire insertion to connector 6098-6663 (B)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>Wire facing</p></div> <div><p>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion.</p></div> <div><p>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</p></div>	n/a	<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>Important reminders/Note/s:</p><ol style="list-style-type: none">1. Please hold the wire near terminal during insertion.2. Insertion must be from left to right.3. Make sure wires are properly inserted.<p>Conduct Pull-Pull-Pull-Push after insertion.</p><p>Do not exert extra force.</p></div> <div><p>Document reminder/s:</p><ol style="list-style-type: none">1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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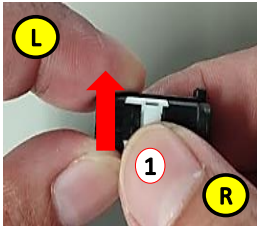
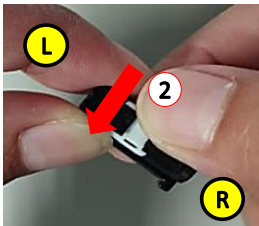
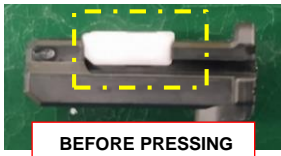
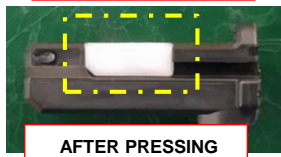




WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:	November 28, 2022
Validity Date:	n/a
Document No.:	WI-ENG-PDE-555
Revision No.:	1
Page No.:	3 of 10

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	920B / 7R0121-7020A	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Black Twist tube 2420F Ø5 L=247±3mm	JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	1 Connector lock	 <p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector lock if properly locked.</p>   <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>  	LOCKING JIG 	1. No wrong use of parts 2. No deformed terminal <i>Important reminders/Note/s:</i> 1. Manual locking may cause damage connector lock.
4	Wire insertion to Black Twist tube 2420F Ø5 L=247±3mm	 <p>1. Get the Black twist tube 2420F Ø5 L=247±3mm using right hand and insert B-B wires using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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Validity Date:

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Model Code/Part Number: 920B / 7R0121-7020A

Customer:

TRMX

Document No.:

WI-ENG-PDE-555

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 10

PARTS:

1. Assy parts.
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

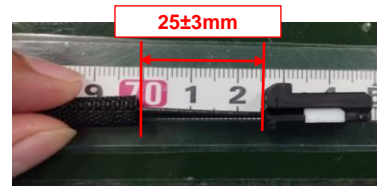
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T1

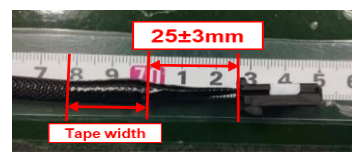
Taping 1
Black twist tube 2420F to
Wire near connector



1. Hold the assy parts using left hand. Get **Black tape** using right hand and start pre-taping using both hands.



2. Measure from end of Black twist tube 2420F up to end of connector **25±3mm** using both hands.



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



MEASURING TAPE



1 Important reminders/Note/s:

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

Wire alignment tolerance



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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	November 28, 2022	
Validity Date:	n/a	
Document No.:	WI-ENG-PDE-555	
Revision No.:	1	Page No.: 5 of 10

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

Model Code/Part Number: **920B / 7R0121-7020A** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Clamp 82711-52070 (W) 2. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	T2 1 Table Lay-out (2)	<div>TABLE LAY-OUT</div> <div><p>Clamp 82711-52070 (W)/ Clamp tray</p><p>Assy parts</p><p>Clamp Assembly jig</p><p>Bando Gun (Flat nosepiece)</p></div>		<div>BANDO GUN</div> <div></div> <div>FLAT NOSEPIECE</div>	<div>1. No missing parts/tools 2. No excess parts/tools</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div><p>82711-52070 (B)</p><p>82711-12A60 (W)</p></div></div><div><div>BANDO GUN ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div><p>FLAT NOSEPIECE</p><p>EXTENDED NOSEPIECE</p></div></div></div></div>

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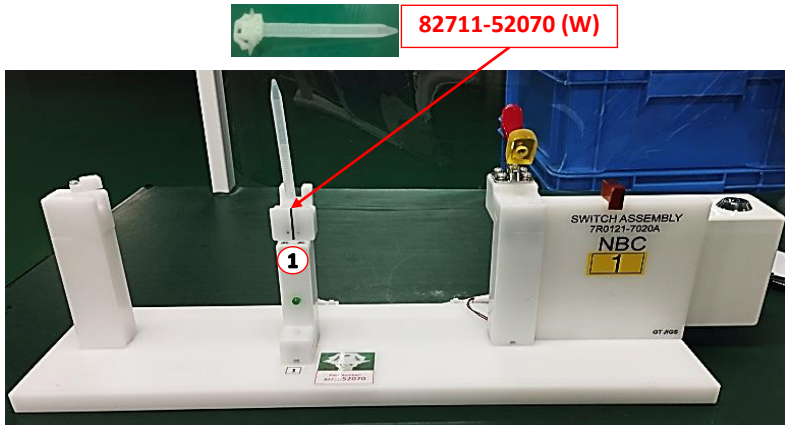


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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date: **November 28, 2022**
Validity Date: **n/a**
Document No.: **WI-ENG-PDE-555**
Revision No.: **1** Page No.: **6 of 10**

Process Name/Title:
Model Code/Part Number: **920B / 7R0121-7020A** Customer: **TRMX**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Clamp 82711-52070 (W)		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
7	T2	Clamp setting  <div>1. Get 1pc of Band clamp 82711-52070(W) using right hand and set to clamp location 1 using both hands.</div>	n/a	<div>1. No wrong use of clamp 2. No damaged clamp</div> <div>1 Important reminders/Note/s: 1. Please check the clamp first before start assembly to avoid wrong use of clamp.</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52070 (B)</div></div><div><div>NG</div><div>82711-12A60 (W)</div></div></div>	

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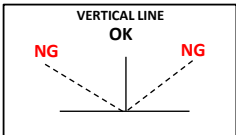


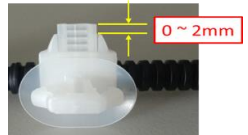
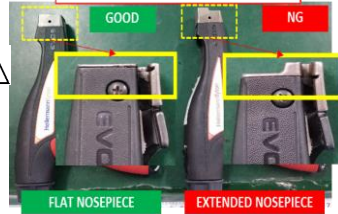
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WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	November 28, 2022	
Validity Date:	n/a	
Document No.:	WI-ENG-PDE-555	
Revision No.:	1	Page No.: 7 of 10

Process Name/Title:	TAPING ASSEMBLY PROCESS	
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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	

PARTS:		1. Assy parts 2. Clamp 82711-52070(W)	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	T2 Clamp assembly	<div><p>1. Get the assy parts and set into jig using both hands. (See above picture for correct setting). First, set the connector 6098-6663 (B) in Receiver base then lock. Continue to set the harness into jig. Last, set the B-B wires together within the stopper then press by toggle clamp. Continue if the sequence light of location 1 was ON.</p><p>2. Check if all LED light for POWER On, Clamp On, Wire 1 and 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Initially tighten the clamp on location 1 using both hands.</p><p>4. Get the Bando Gun using right hand and cut the band clamp on location 1 using both hands. Press the SW button after insertion. GO sound will be heard.</p><p>5. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div> <div> BANDO GUN</div> <div> FLAT NOSEPIECE</div> <div> GOOD NG</div> <div> VERTICAL LINE OK NG NG</div>	<div> BANDO GUN</div> <div> FLAT NOSEPIECE</div>	<p>1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment</p> <p>1 Important reminders/Note/s:</p> <p>1. Setting the band clamp cutter depends on the size of the COT/Vinyl Tube. For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$</p> <div> 0 ~ 2mm</div> <p>BANDO GUN ILLUSTRATION</p> <div> GOOD NG FLAT NOSEPIECE EXTENDED NOSEPIECE</div>

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TAPING ASSEMBLY PROCESS

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Customer:

TRMX

Document No.:

WI-ENG-PDE-555

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

8 of 10

PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

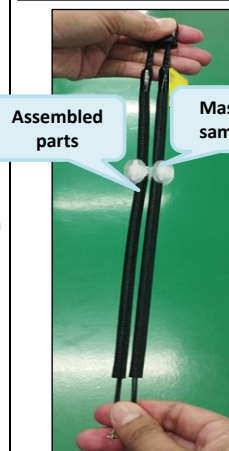
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T2

Visual/ By two's Inspection



ACTUAL PRODUCT

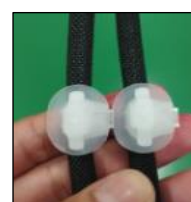


Assembled parts

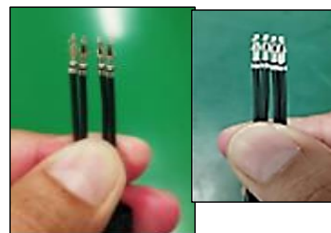
Master sample



2. Check the **connector lock condition** and **insertion** and **taping condition**.



3. Check the **presence of clamp attachment** and **band clamp cut**.



4. Check the **terminal appearance**. Must be **no deformed terminals**.

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

n/a

MASTER SAMPLE



1. No skip checking during inspection.

1 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).



0 ~ 2mm



BAND CLAMP ILLUSTRATION

GOOD

NG

R2711-52070 (B)

R2711-12A60 (W)

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Document No.:

WI-ENG-PDE-555

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

9 of 10**PARTS:**

n/a

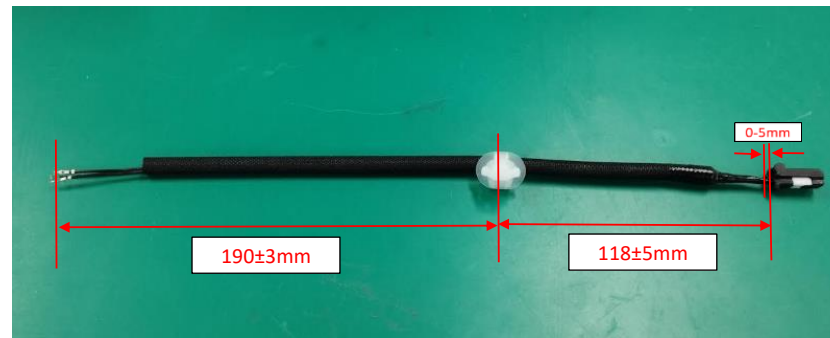
JIG

n/a

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

9

Measurement

**MEASURING TAPE****1****Important reminders/Note/s:**

1. No wrong dimension.

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

T2

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Document No.:

WI-ENG-PDE-555

Revision No.:

1

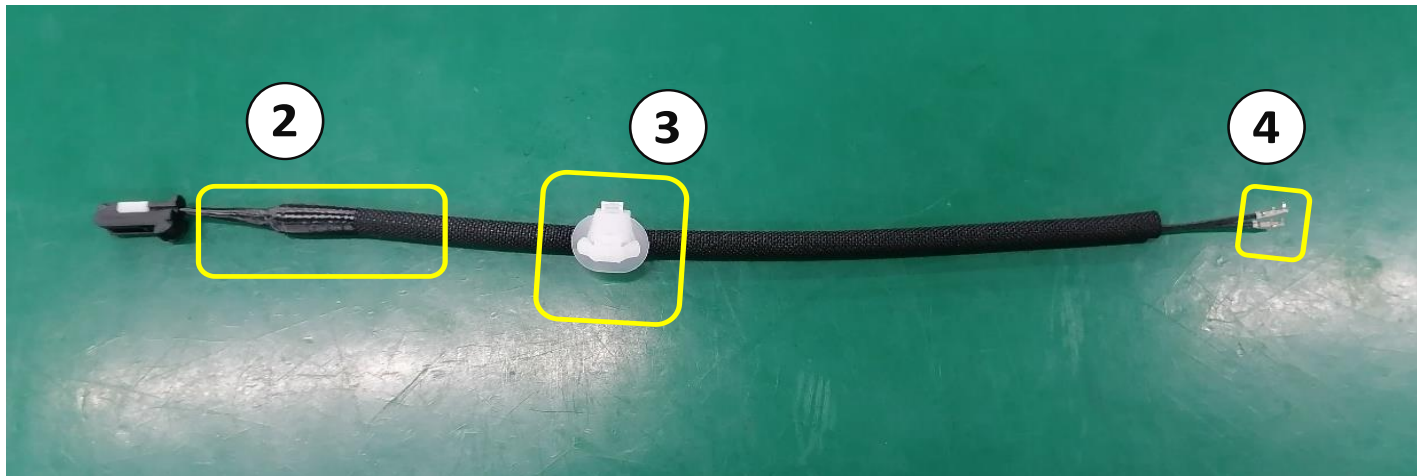
Page No.:

10 of 10

PARTS: n/a

JIG

n/a

QUALITY CHECKPOINTS**P1****7R0121-7020A****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/**
Halflock Connector**2** No **Missing Tape****3** No **Missing band**
clamp**4** No **Deformed**
Terminal**5** No **Terminal Backing**
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