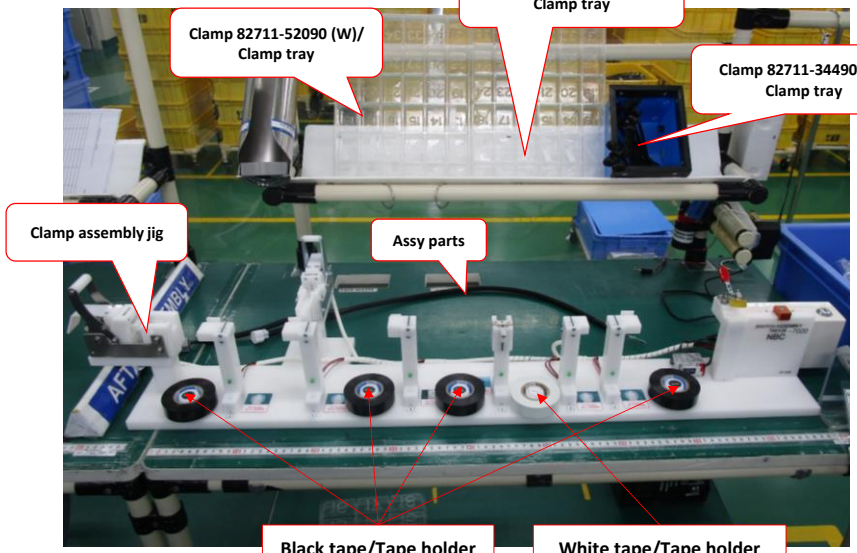
	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0129-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-339C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	1 of 6

PARTS:	1. All parts: Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [4pcs.]; White tape [1pc.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	1 Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required 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.	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
01/06/22	1	Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/20/21	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Est. Date:	September 20, 2021		

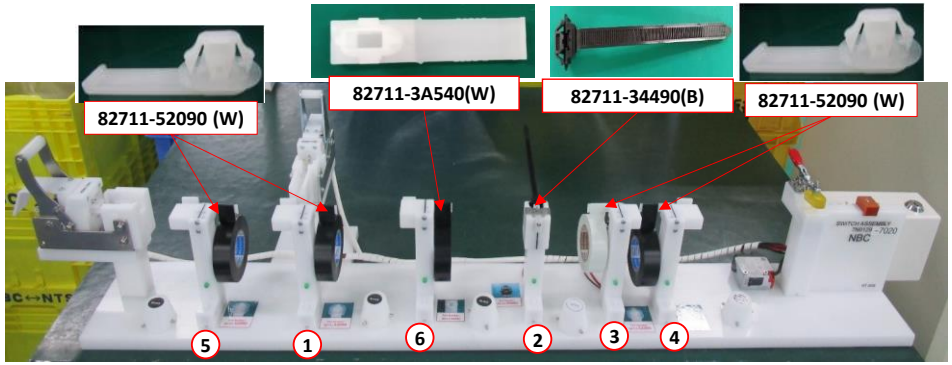
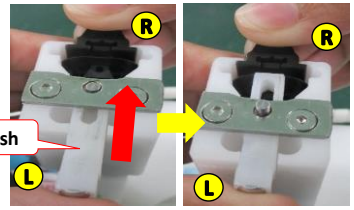
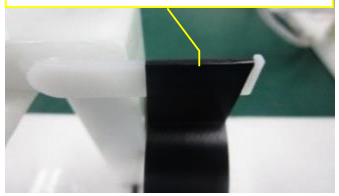
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0129-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-339C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	2 of 6

PARTS:	1. Clamp 82711-52090 (W) [4pcs.] 2. Clamp 82711-3A540 (W) 3. Clamp 82711-34490 (B) 4. Black tape [4pcs.] 5. White tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting	 **Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.** 1. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **5 and 1** using both hands. 2. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **3 and 4** using both hands. 3. Get 1 pc. of clamp **82711-3A540 (W)** using right hand then insert to clamp location **6** using both hands. 4. Get 1 pc. of clamp **82711-34490 (B)** using right hand then insert to clamp location **2** using both hands. ***(See below illustration for clamp setting)***  5. Get the **Black tape** then initially attach to clamp location **5, 1, 6 and 4** using both hands. 6. Get the **White tape** then initially attach to clamp location **3** using both hands.	n/a	**STANDARD TAPING FOR CLAMP** One side tape under clamp  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wvrong clamp position

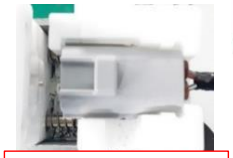
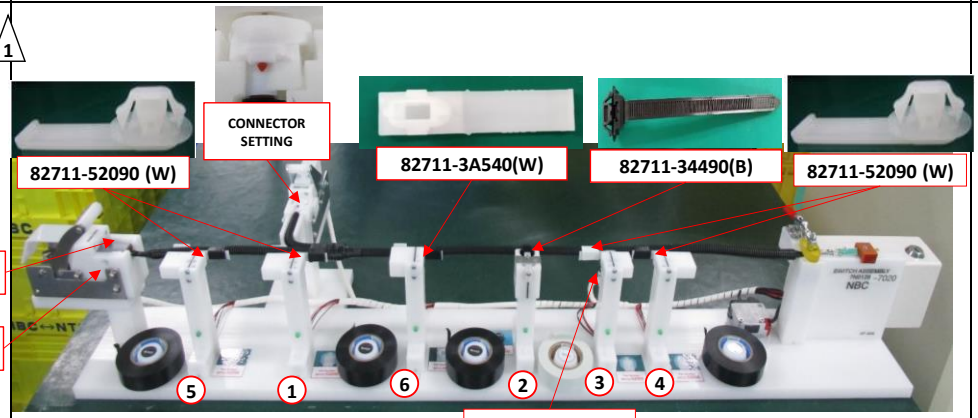
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0129-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-339C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	3 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	 CONNECTOR SETTING CHECKER 1  COLOR SENSOR **WHITE TAPE** ONLY 1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON.** 2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON.** If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. 3. Hold the tape on clamp location **1,** make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **2** was **ON.**	n/a	 *Note: Make sure no gap between stopper jig and PCB* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

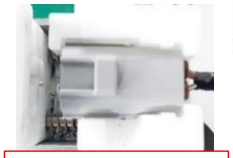
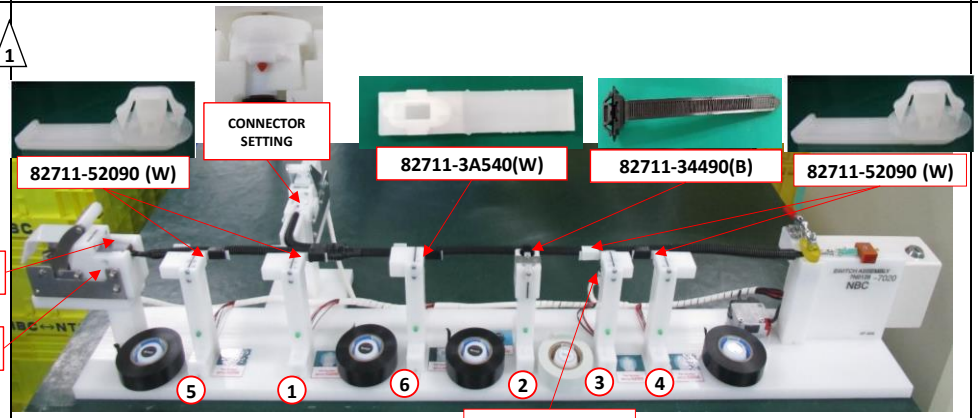
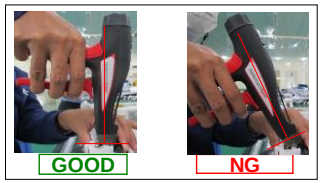
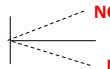
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0129-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-339C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	4 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	 CONNECTOR SETTING CHECKER 1  COLOR SENSOR **WHITE TAPE** ONLY 4. Initially tighten the band clamp on clamp location **2** using both hands. 5. Get the bando gun using right hand then cut the band clamp on location **2** using both hands. Press the **SW button** after cut. Continue the process if sequence light on clamp location **3** was **ON.**  BANDO GUN PERPENDICULARITY  **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.** **For: ø5 - 1~2, ø7 - 3~4** Fixed setting of band clamp cutter: 1~ 2	n/a	 *Note: Make sure no gap between stopper jig and PCB* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

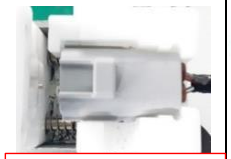
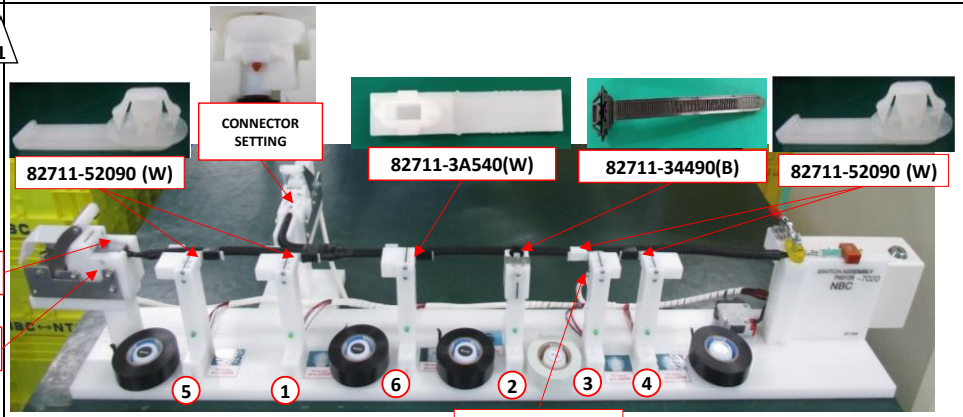
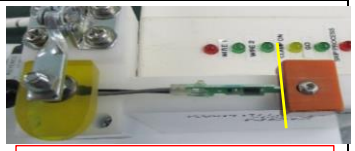
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROPCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0129-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-339C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	5 of 6

PARTS:	1. Assy parts 2. Black tape	3. White tape	JIG	1. Clamp assembly jig

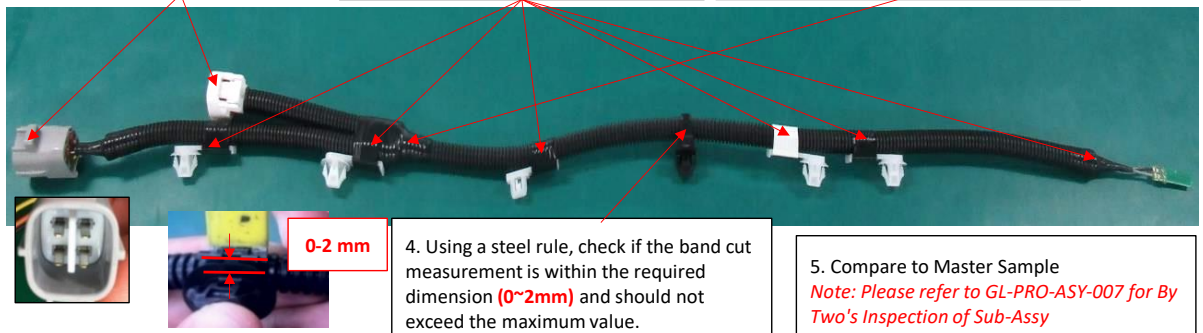
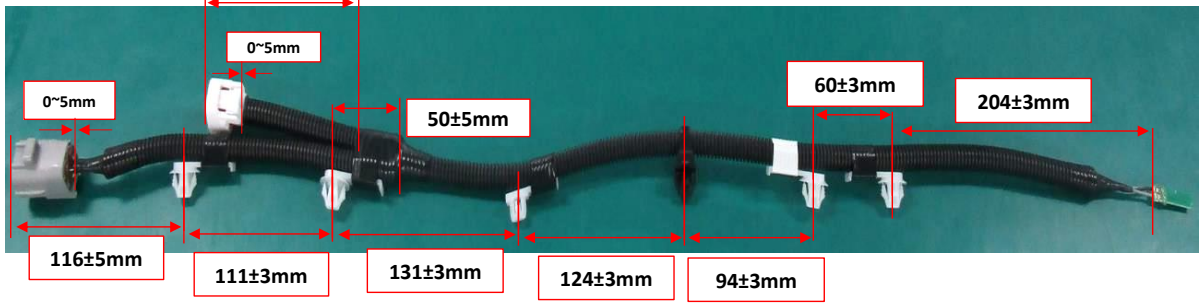
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly (Continuation)	 CONNECTOR SETTING CHECKER 1  COLOR SENSOR WHITE TAPE ONLY 6. Hold the tape on clamp location **3**, make **3 windings** of tape then cut the tape using both hands. **Color sensor** light will beep/buzz if sensor detects **White tape.** Press the **SW button** after taping. Continue the process if sequence light on clamp location **4** was **ON.** 7. Hold the tape on clamp location **4**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **5** was **ON.** 8. Hold the tape on clamp location **5**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **6** was **ON.** 9. Hold the tape on clamp location **6**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard. 10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.	n/a	 *Note: Make sure no gap between stopper jig and PCB* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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

PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	Visual/ By two's inspection	1 		**MASTER SAMPLE**
5		Measurement	1 **MEASURING TAPE** *Note: Please use calibrated/verified measuring tape when getting the measurement.* 		***FOR HATSUMONO AND OWARIMONO*** 1. No wrong dimension

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