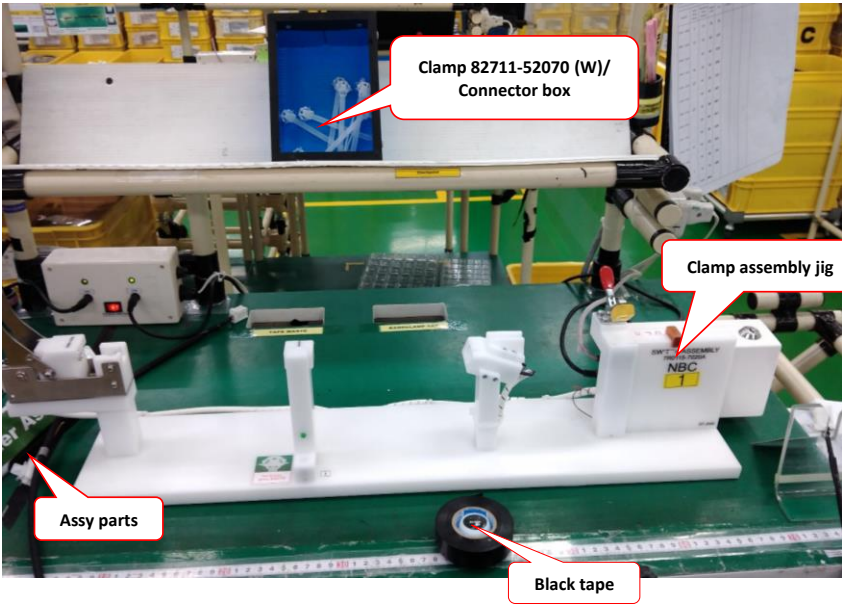

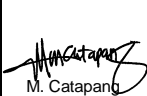

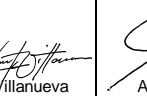



	WORK INSTRUCTION						Effectivity Date:		December 3, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 920B / 7R0115-7020A		Customer: TRMX		Document No.: WI-ENG-PDE-543B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1 Page No.: 1 of 7	

PARTS:	1. Assy parts: Clamp 82711-52070 (W); Black tape					JIG:	1. Clamp assembly jig				
NO.	PROCESS NAME	1 WORK PROCEDURE/ILLUSTRATION					TOOLS/PPE		1 QUALITY POINTERS		
1	P2	<div style="text-align: center;"> Table Lay-out </div> 					<div style="border: 1px dashed red; padding: 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;"> 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="text-align: center;">  </div>		1. No missing parts/tools 2. No excess parts/tools		

Revision History								Prepared by		Reviewed by		Approved by		Noted by					
12/03/22	1	Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process.						M. Catapang	J. Loterte	C. Villanueva	A. Arañes								
07/06/22	0	Initial issue.						K. Doria	J. Loterte	C. Villanueva	A. Arañes	M. Catapang		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date	Rev.No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		July 06, 2022					

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.	<div style="border: 2px solid green; padding: 5px; display: inline-block;"> NBC (Philippines) MASTER COPY </div>	
--	---	--

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number: **920B / 7R0115-7020A**

Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 3, 2022

Validity Date:

n/a

Document No.:

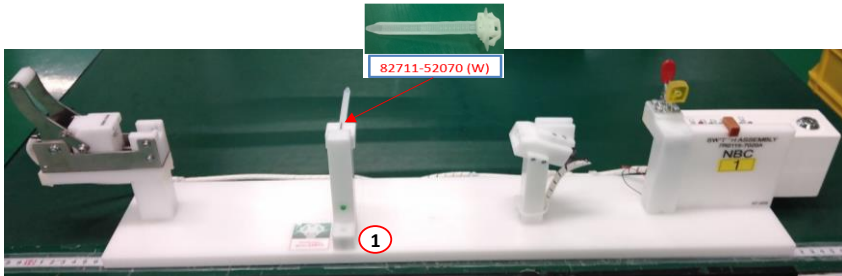
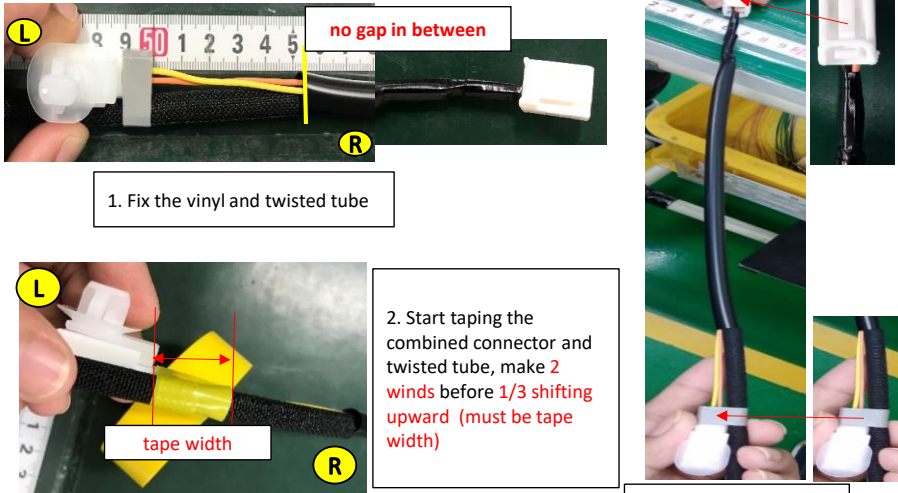

WI-ENG-PDE-543B

Revision No.:

1

Page No.:

2 of 7

PARTS:		1. Assy parts 2. Clamp 82711-52070 (W) 3. Black tape	JIG	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
2	1 Clamp setting	 <p>1. Get 1pc. of clamp 82711-52070 (W) using right hand then set to clamp location 1 using both hands.</p>		1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.
3	P2 1 Y-taping	 <p>1. Fix the vinyl and twisted tube</p> <p>2. Start taping the combined connector and twisted tube, make 2 winds before 1/3 shifting upward (must be tape width)</p> <p>tape width</p> <p>no gap in between</p> <p>Y-Taping orientation</p>	MEASURING TAPE 	Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape

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:

December 3, 2022

Validity Date:

n/a

Model Code/Part Number:

920B

/

7R0115-7020A

Customer:

TRMX

Document No.:

WI-ENG-PDE-543B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

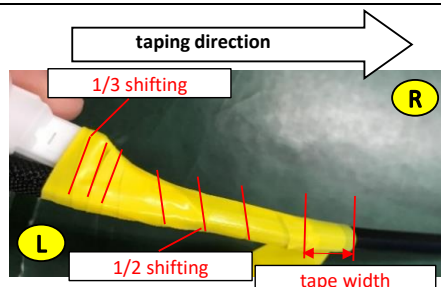
TOOLS/PPE

1 QUALITY POINTERS

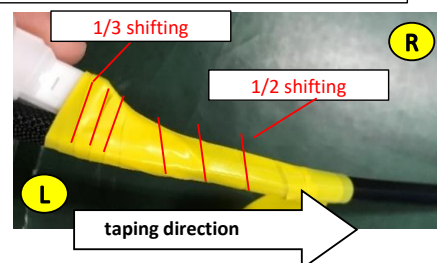
3

P2

Y-taping
(Continuation)



3. Wind the tape upward 1/3 shifting, then conduct 1/2 shifting upward until it reaches the vinyl tube (must be tape width)



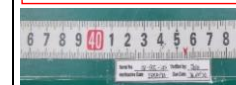
4. Wind the tape backward 1/2 shifting.



5. Wind the tape 1/3 shifting then 1/2 shifting, same shifting to no. 3, then cut the tape after 2 winds on vinyl tube.

6. After taping, check the condition of tape, measurement and the connector facing.

MEASURING TAPE



Important reminders/Note/s:

1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.
2. Please use calibrated/verified measuring tape when getting the measurement.

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

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:

December 3, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0115-7020A

Customer: TRMX

Document No.:

WI-ENG-PDE-543B

Purpose:

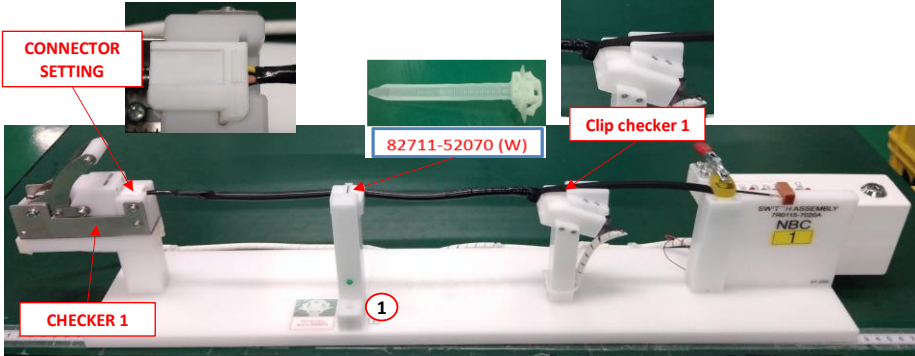
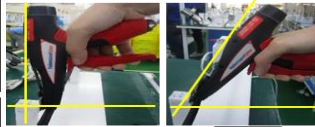



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:		1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
4	P2 Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 7189-0995 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6098-6653 (W) to Clip Checker 1 for continuity checking. Last, set the terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</p><p>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.</p><p>3. Initially tighten the band clamp from location 1 using both hands.</p><p>4. Get the bando gun and cut the band clamp on location 1 using both hands. Press the SW button after cut. GO sound will be heard.</p></div> <div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>OK</p><p>NG NG</p><p>Fixed setting of band clamp cutter: 3 ~ 4</p></div>	<div></div> <p>BANDO GUN</p>	<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun</p> <div></div> <p>BANDO GUN ILLUSTRATION</p> <p>GOOD NG</p> <p>FLAT NOSEPIECE EXTENDED NOSEPIECE</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

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 3, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: **920B / 7R0115-7020A**

Customer: **TRMX**

Document No.:

WI-ENG-PDE-543B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


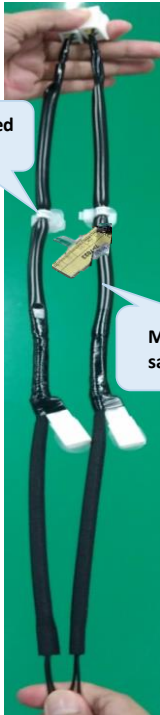
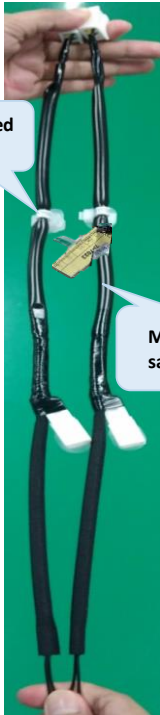



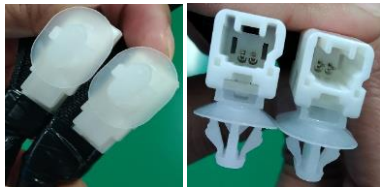

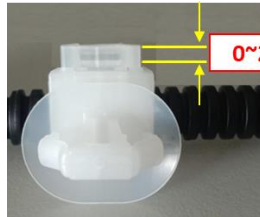
☒ MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	P2	1			
		Visual/By two's inspection			
		<div><p>ACTUAL PRODUCT</p></div> <div><p>Assembled parts</p></div> <div><p>Master sample</p></div> <div><p>2. Check the insertion and taping condition.</p></div> <div><p>3. Check the presence of clamp attachment and band clamp cut condition.</p></div> <div><p>4. Check the Y-taping condition.</p></div> <div><p>5. Check the terminal and presence of clip-clamp attachment.</p></div> <div><p>6. Check the terminal appearance. Must be no deformed terminal.</p></div> <div><p>0~2mm</p></div> <div><p>Important reminders/Note/s:</p><p>1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</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**

Process Name/Title:

Model Code/Part Number: **920B / 7R0115-7020A**Customer: **TRMX**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

December 3, 2022

Validity Date:

n/a

Document No.:


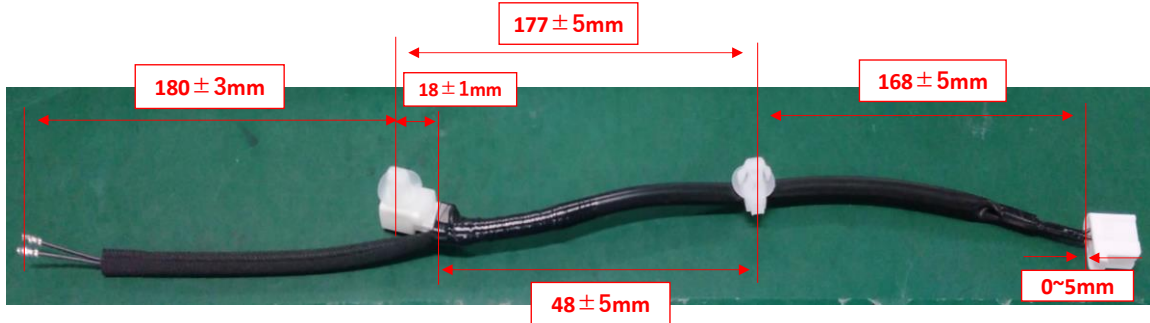
WI-ENG-PDE-543B

Revision No.:

1

Page No.:

6 of 7

PARTS:	1. Assy parts			JIG	n/a	
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS	
6	P2	<div><div>MEASURING TAPE</div><div></div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div></div>				<div>Important reminders/Note/s: 1. FOR HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</div>
		1	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:

December 3, 2022Model Code/Part Number: **920B / 7R0115-7020A**

Customer:

TRMX

Document No.:

WI-ENG-PDE-543B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

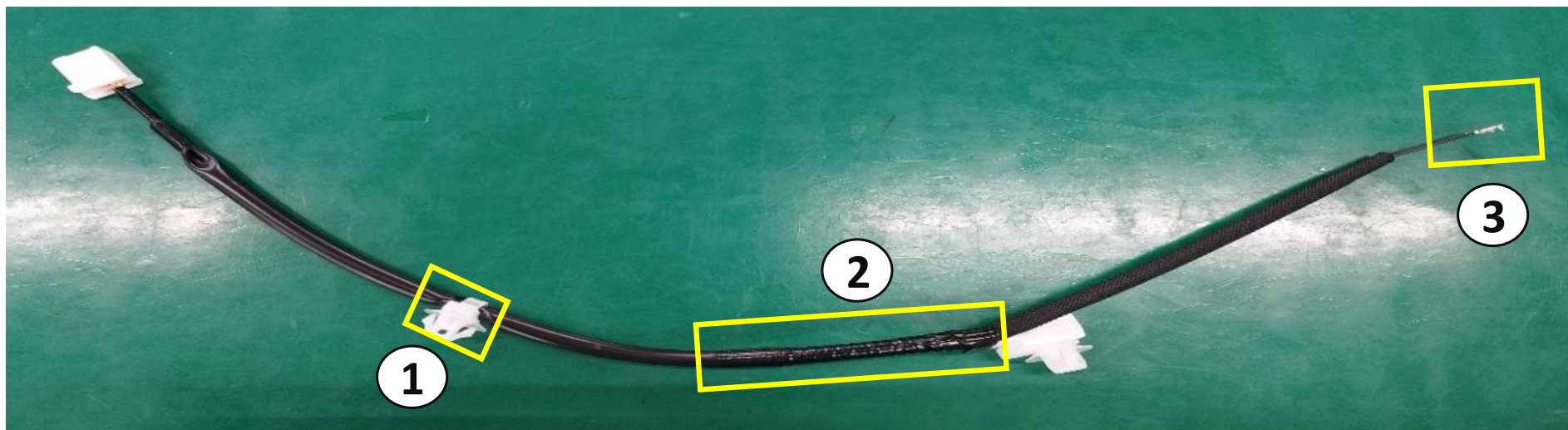
7 of 7

PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS**P2****7R0115-7020A****1 No Missing Clamp****2 No Missing Tape****3 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