



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Validity Date:

n/a

Model Code/ Part Number:

240B / 7M0516-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-688

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 9

PARTS:	1. Assy part: Clamp 82711-52090 (W); Clamp 82711-48210 (B); Clamp 82711-3A540 (W); White tape; Black tape [7pcs.]			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<div><div>BATCHING</div><div>TABLE LAY-OUT</div><div>Clamp 82711-52090 (W)/ Clamp tray</div><div>Clamp 82711-3A540 (W)/ Clamp tray</div><div>Clamp 82711-48210 (B)/ Clamp tray</div><div>Assy parts</div><div>Clamp assembly jig</div><div>White tape/Tape holder</div><div>Black tape/Tape holder</div></div>		<div><div>Safety Instruction Be sure to wear prescribed 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>	1. No missing parts/tools 2. No excess parts/tools
Revision History				Prepared by	Reviewed by
06/28/23	0	Initial Issue. Excluded Process from WI-ENG-PDE-387C; Change process Name/Title from "TAPING ASSEMBLY PROCESS" to CLAMP ASSEMBLY PROCESS"; Change Document Control number from WI-ENG-PDE-387C to WI-ENG-PDE-688 due to separation of process.		M. Ariola	J. Loterte
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date:	June 28, 2023

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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Process Name/Title:

Model Code/ Part Number: **240B / 7M0516-7021**Customer: **TRJ**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-688

Purpose:

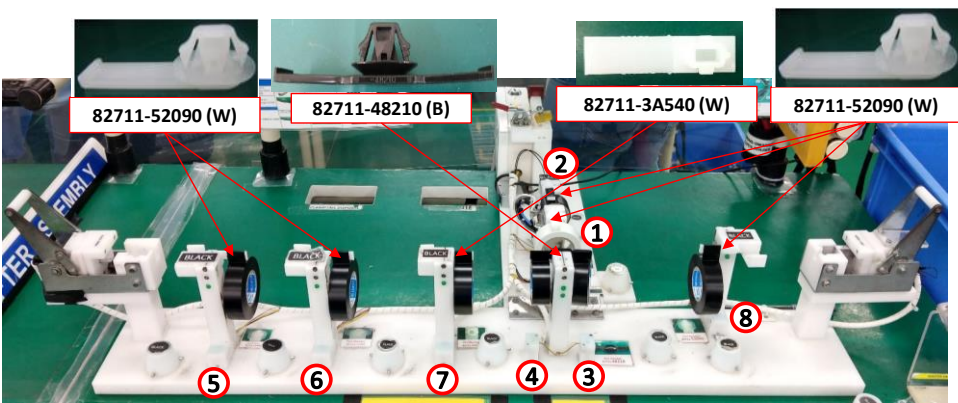
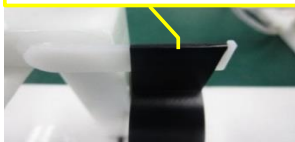


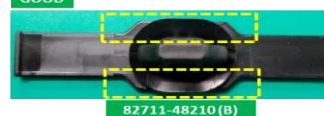

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 9

PARTS:		1. Clamp 82711-52090 (W) (5pcs.) 2. Clamp 82711-48210 (B) 3. Clamp 82711-3A540 (W)		4. White tape 5. Black tape [7pcs.]		JIG	1. Clamp assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
2	n/a	Clamp setting	<div></div> <div>1. Get 2pcs. of clamp 82711-52090 (W) using both hands then set to location 5 & 6 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-52090 (W) using both hands then set to location 1 & 2 using both hands.</div> <div>3. Get 1pc. of clamp 82711-52090 (W) using both hands then set to location 8 using both hands.</div> <div>4. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to location 7 using both hands.</div> <div>5. Get 1pc. of clamp 82711-48210 (B) using right hand then set to location 3 and 4 using both hands.</div> <div>6. Get the White tape then initially attach to clamp location 1 using both hands.</div> <div>7. Get the Black tape then initially attach to clamp location 2, 3, 4, 5, 6, 7 and 8 using both hands.</div>			n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div> <div><div>NG</div><div></div><div>82711-12A80 (W)</div></div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div></div><div>82711-48210 (B)</div></div> <div><div>NG</div><div></div><div>82711-3F290 (B)</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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Process Name/Title:

Model Code/ Part Number: 240B / 7M0516-7021

Customer: TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

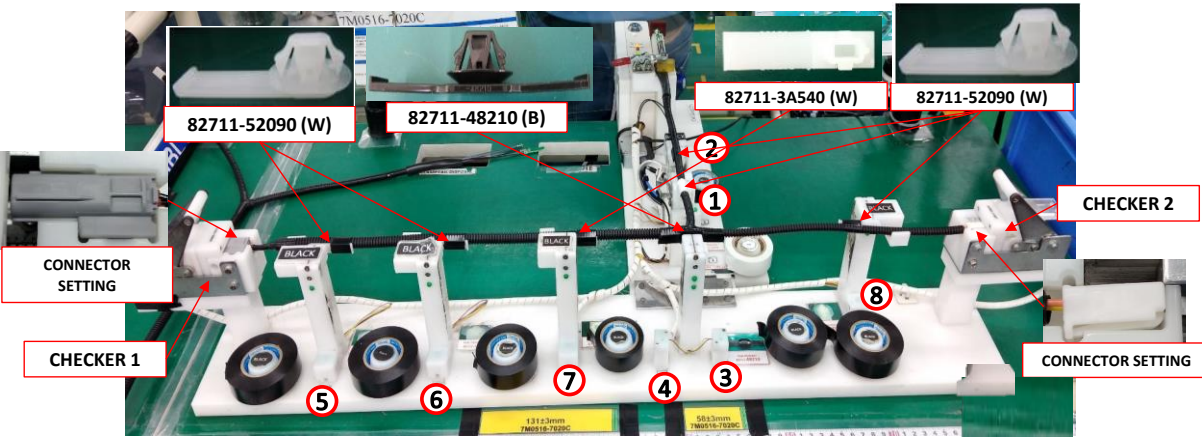
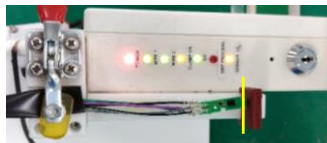
WI-ENG-PDE-688

Revision No.:

0

Page No.:

3 of 9

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	n/a Clamp Assembly	<div></div> <div>1. Hold the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0779 (GR) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the connector 6098-2220 (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.</div> <div>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.</div> <div>3. Hold the tape on clamp location 1, 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 2 was ON.</div> <div>4. Hold the tape on clamp location 2, 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 3 was ON.</div>		<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB</div> <div>1. No flip-out tape 2. No peel-off tape 3. No wrong use of tape 4. No damaged clamp 5. No missing tape 6. No wrong clamp position</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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Process Name/Title:

Model Code/ Part Number: **240B / 7M0516-7021**Customer: **TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

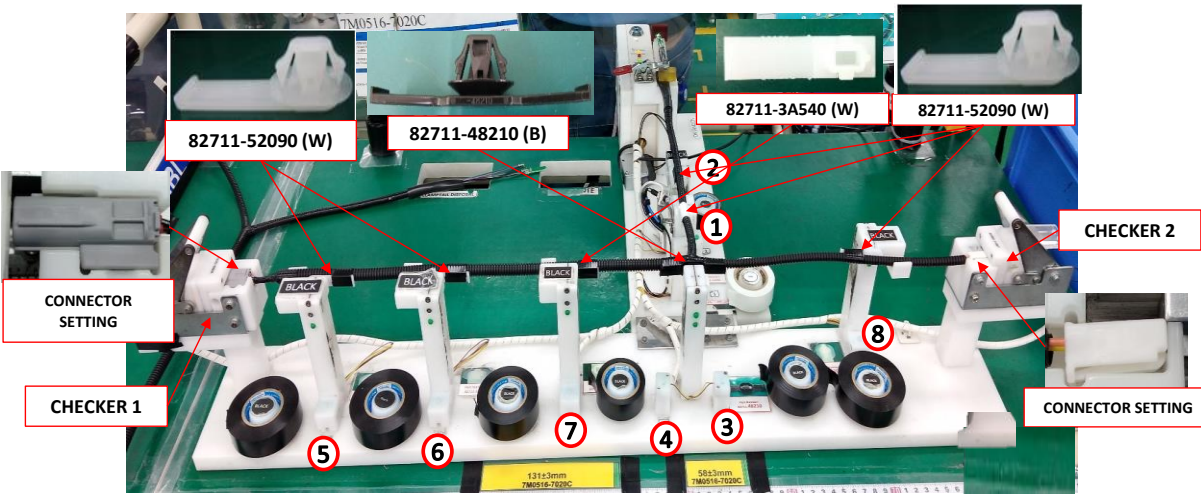

WI-ENG-PDE-688

Revision No.:

0

Page No.:

4 of 9

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a Clamp Assembly (Continuation)	<div></div> <div>5. Hold the tape on clamp location 3, 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 4 was ON.</div> <div>6. 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.</div> <div>7. 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.</div> <div>8. 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. Continue the process if sequence light on clamp location 7 was ON.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB</div> <div>1. No flip-out tape 2. No peel-off tape 3. No wrong use of tape 4. No damaged clamp 5. No missing tape 6. No wrong clamp position</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: **CLAMP ASSEMBLY PROCESS**

Model Code/ Part Number: **240B / 7M0516-7021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 28, 2023

Validity Date:

n/a

Document No.:

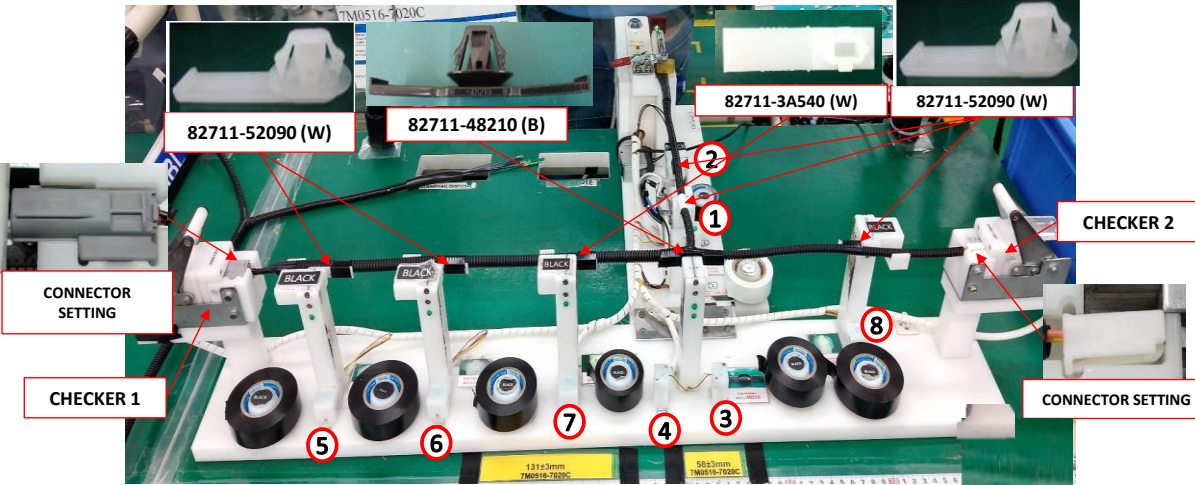

WI-ENG-PDE-688

Revision No.:

0

Page No.:

5 of 9

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div>Clamp Assembly (Continuation)</div><div><p>9. Hold the tape on clamp location 7, 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 8 was ON.</p><p>10. Hold the tape on clamp location 8, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</p><p>11. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div></div>			<div><p>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB</p><p>1. No flip-out tape 2. No peel-off tape 3. No wrong use of tape 4. No damaged clamp 5. No missing tape 6. No wrong clamp position</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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Process Name/Title:

Model Code/ Part Number: **240B / 7M0516-7021**Customer: **TRJ**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-688

Purpose:






☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

6 of 9

PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Visual/By Two's Inspection	<div><p>Master sample</p><p>Assembled parts</p><p>1. Conduct alignment of harness (Master sample vs. assembled parts) using both hands.</p><p>2. Check the terminal and lock condition.</p><p>3. Check the insertion and taping condition.</p><p>4. Check the presence of clamp and taping condition.</p></div>		<div><p>MASTER SAMPLE</p><p>1. No skip process</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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Process Name/Title:

Model Code/ Part Number: **240B / 7M0516-7021**Customer: **TRJ**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-688

Purpose:






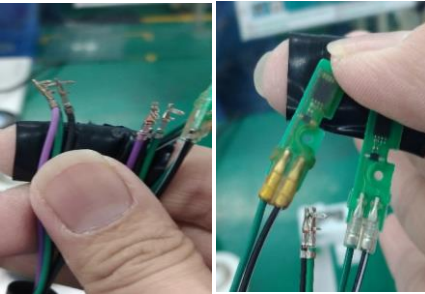

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

7 of 9

PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a Visual/By Two's Inspection (Continuation)	<div data-bbox="645 440 1008 651"></div> <div data-bbox="611 778 900 1174"></div> <div data-bbox="1061 440 1317 715"></div> <div data-bbox="929 839 1236 1106"></div> <div data-bbox="1386 440 1657 687"></div> <div data-bbox="1317 839 1740 1133"></div>			<div data-bbox="1821 528 2101 580">MASTER SAMPLE</div> <div data-bbox="1794 592 2130 831"></div> <div data-bbox="1785 868 1951 895">1. No skip process</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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 28, 2023

Process Name/Title:

Model Code/ Part Number: 240B / 7M0516-7021

Customer: TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-688

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

8 of 9

PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Measurement	<div><div>MEASURING TAPE</div><div></div></div>		<p>Important reminders/Note/s:</p> <p>1. FOR HATSUMONO AND OWARIMONO</p> <p>1. No wrong dimension</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

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

Model Code/ Part Number: **240B / 7M0516-7021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 28, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-688

Revision No.:

0

Page No.:

9 of 9

PARTS:

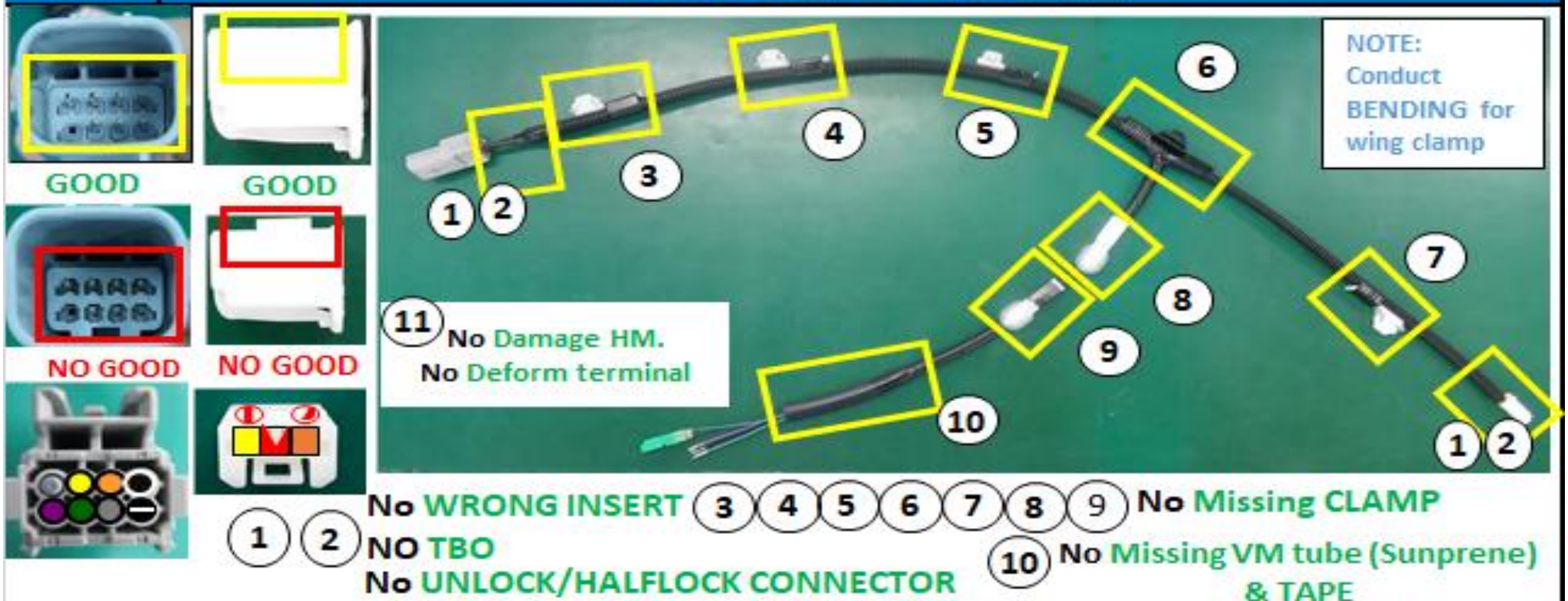
n/a

JIG

n/a

QUALITY CHECKPOINTS

7M0516-7021



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