



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Product Number: 740B / 7H0425W7020

Customer:

NBS

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

May 17, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-526B

Revision No.:

1

Page No.:

1 of 6

PARTS:

1. Assy parts: Black tape [1pc.]

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

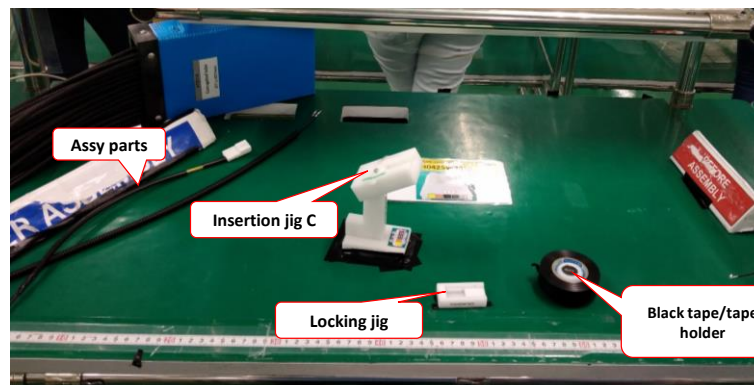
QUALITY POINTERS

1

P2

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	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/17/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
05/13/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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**

Model Code/Product Number: **740B / 7H0425W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 17, 2022

Validity Date:

n/a

Document No.:


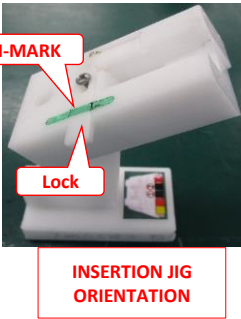
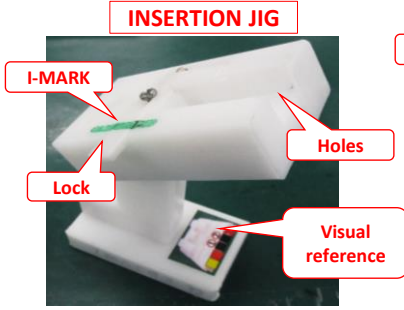
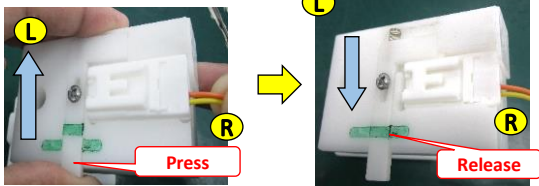
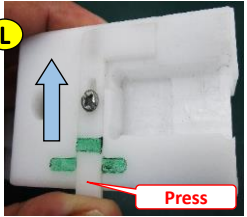

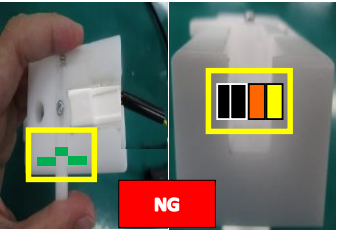
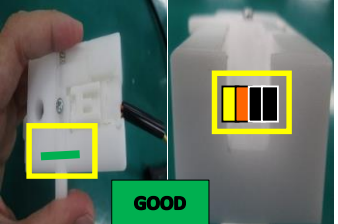
WI-ENG-PDE-526B

Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P2 Connector setting to insertion jig 6098-3802 (W) (Assy parts)	<div></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3802 (W) with inserted Y-OR wires into jig using right hand and release the lock. Holes/terminal slot for B-B wires are opened. <i>Note: Follow the connector orientation.</i></p><p>3. Check the holes for B-B wires, it must be opened.</p></div>			n/a	<div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 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

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

Effectivity Date:

May 17, 2022

Model Code/Product Number: **740B / 7H0425W7020**

Customer: **NBS**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-526B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

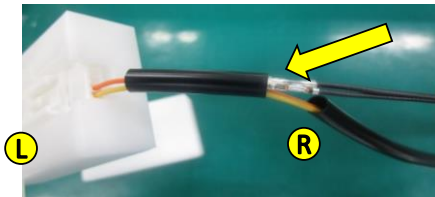


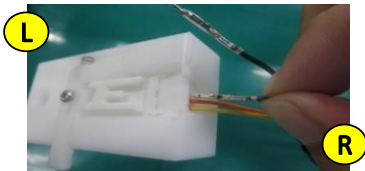
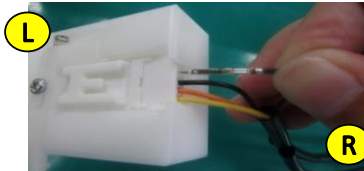

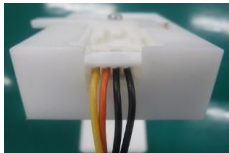
☒ MASSPRO

Revision No.:

1

Page No.:

3 of 6

PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	Wire insertion to assy parts	 <div>1. Hold the vinyl tube $\phi 5$ L=30\pm3mm using left hand then insert the assy parts using right hand.</div>			n/a	1. No wrong insertion 2. No deformed terminal	
4	P2 Wire insertion to connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div>TERMINAL SLOTS</div></div> <div><div>1. Hold the 1st B wire and insert to terminal slot 3 beside OR wire using right hand. <i>Note: Insertion of wire must be from left to right.</i></div></div> <div><div>2. Hold the 2nd B wire and insert to terminal slot 4 using right hand.</div></div> <div><div>3. After insertion, press the lock of insertion jig using left hand, hold the wires and gently pull out the connector from jig using right hand.</div></div>			n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. <i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i>	

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**

Model Code/Product Number: **740B / 7H0425W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 17, 2022

Validity Date:

n/a

Document No.:

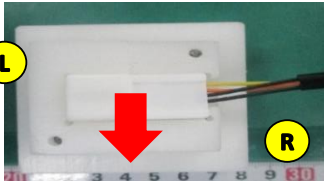
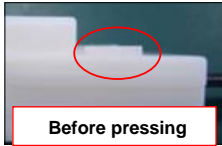


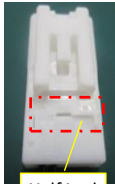


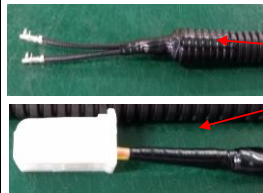
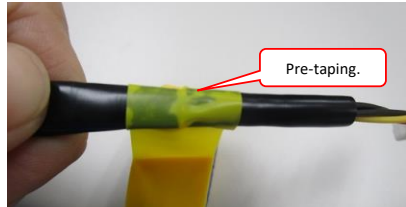

WI-ENG-PDE-526B

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Assy parts 2. Black tape		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Connector Lock	<div><div><div></div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div></div><div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly locked.</p><p><i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p></div></div>		<div><p>LOCKING JIG</p></div>	<div><p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p><p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p></div>
6	Y- Taping	<div><div><p>No gap between the vinyl</p><p>1. Fix the vinyl tube using both hands.</p></div><div><p>Pre-taping.</p><p>2. Hold the vinyl tube using left hand and start pre-taping using right hand.</p></div></div>		<div><p>n/a</p><div><p>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK TAPE.</p></div></div>	<div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p><p>Y-Taping orientation</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

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

Model Code/Product Number: **740B / 7H0425W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 17, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-526B

Revision No.:

1

Page No.:

5 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

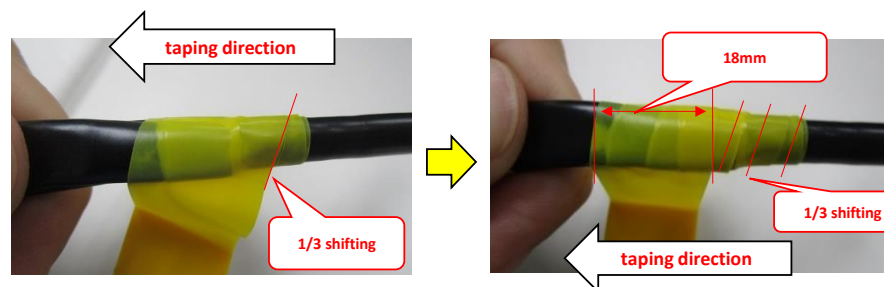
TOOLS/PPE

QUALITY POINTERS

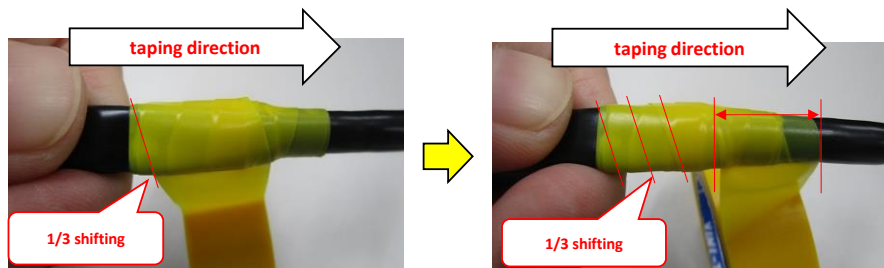
6

P2

**Y- Taping
(Continuation)**



3. After pre-taping, make **1/3 shifting** to the left until tape width. Wind the tape **2x** before shifting to the right side.



4. Make **1/3 shifting** going to the right side.

MEASURING TAPE



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

Note:
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**

Model Code/Product Number: **740B / 7H0425W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 17, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-526B

Revision No.:

1

Page No.:

6 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

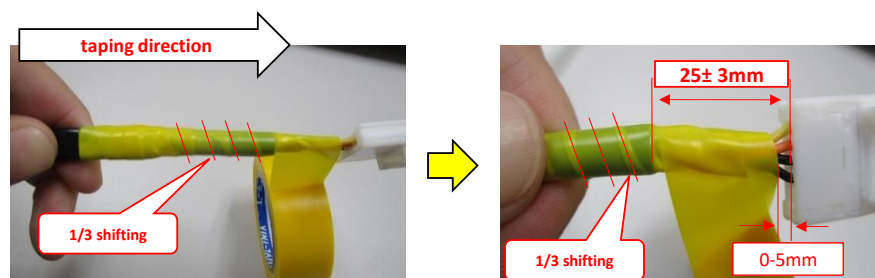
TOOLS/PPE

QUALITY POINTERS

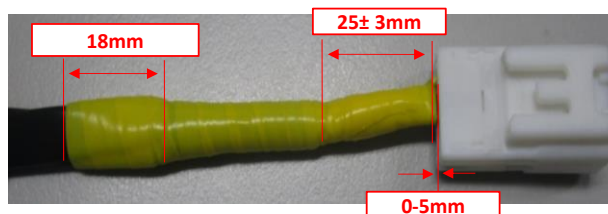
6

P2

**Y- Taping
(Continuation)**



5. Make **1/3 shifting**, cover the vinyl tube and wire. Measure vinyl tube up to connector **25±3mm** then make **3 winds** in wire before cutting of tape.
Note: No folding of vinyl tube.



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

MEASURING TAPE



NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF Tape SHIFTING, BUT ACTUAL SHOULD BE BLACK TAPE.

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

Note:
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