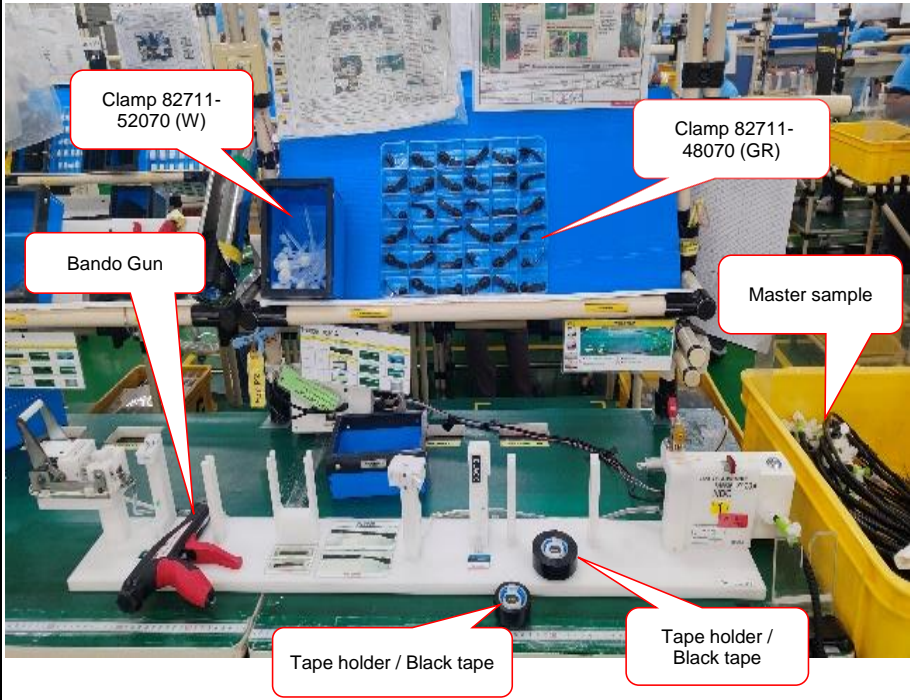
	<b>WORK INSTRUCTION</b>			Effectivity Date:	June 28, 2023		
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	-		
	Process Name/Title:	Model code/Part number: <b>D94L / 7N0028-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>DAIHATSU-CAST</b>	Document No.:	<b>WI-ENG-PDE-055B</b>
	Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input type="checkbox"/> MASSPRO	Revision No.:	4	Page No.: 1 of 9

<b>PARTS:</b>	1. Clamp 82711-52070 (W) 2. Clamp 82711-48070 (GR) 3. Black tape 4. Assy parts			JIG:	1. Clamp Assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>4 WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P2	Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY OUT</div> 	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            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: 10px;"> <b>Housekeeping</b>            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;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. No missing parts/tools 2. No excess parts/tools
Revision History					
06/28/23	4	Inclusion of table lay-out and quality checkpoints; improve by two's inspection, work procedure/illustration and important reminder/s and document references. Update template, inclusion of car model.		J. Loterte	C. Villanueva
02/03/21	3	Change clamp color in accordance with color standardization for plastic parts. Conduct semi-annual review. Remove cycle time.		D. Castillo	R. Peñaloza
06/17/20	2	Extend validity date.		D. Castillo	J. Loterte
02/22/20	1	Change part number due to change vinyl tube to sunprene tube.		D. Castillo	J. Loterte
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date:	
				Prepared by	Reviewed by
				Approved by	Noted by

**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**

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 28, 2023

Model code/Part number:

**D94L / 7N0028-7020A**

Customer:

**TRJ**

Car Model:

**DAIHATSU-CAST**

Document No.:

**WI-ENG-PDE-055B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

4

Page No.:


2 of 9

PARTS:		1. Clamp 82711-52070 (W) 2. Clamp 82711-48070 (GR)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Assembly Setting	<div><div> 82711-52070</div><div> 82711-48070</div><div></div><div>1. Get the clamp <b>82711-52070</b> using right hand and set to clamp location ① using both hands.</div><div>2. Get clamp <b>82711-48070</b> using right hand and set to clamp location ② using both hands.</div><div>3. Initially attach tape to location ② using right hand.</div></div> <div>n/a</div> <td><div><div>One side tape under clamp</div><div></div><div>4 <b>Important reminders and Note/s;</b> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div><div>1. No wrong use of clamp</div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52070 (W)</div></div><div><div>NG</div><div></div><div>82711-12A60 (W)</div></div></div></div></td>		<div><div>One side tape under clamp</div><div></div><div>4 <b>Important reminders and Note/s;</b> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div><div>1. No wrong use of clamp</div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52070 (W)</div></div><div><div>NG</div><div></div><div>82711-12A60 (W)</div></div></div></div>	


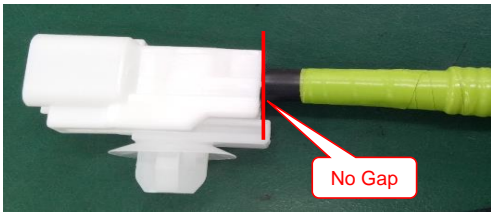

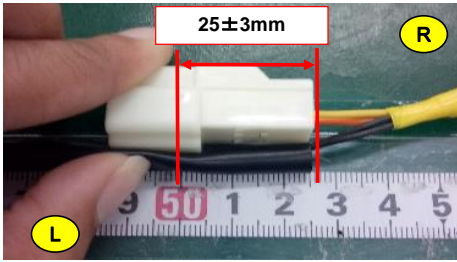


**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	June 28, 2023					
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	-					
	Process Name/Title:		Model code/Part number: <b>D94L / 7N0028-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>DAIHATSU-CAST</b>	Document No.:	WI-ENG-PDE-055B			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

<b>PARTS:</b>		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<sup>4</sup> WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Pre-taping Vinyl to wire	 		<b>MEASURING TAPE</b> 	<sup>4</sup> <b>Important reminders and Note/s;</b> <b>1. Make sure that no gap between vinyl and connector.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  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
4	P2 Y-Taping	 		<b>MEASURING TAPE</b> 	<sup>4</sup> <b>Important reminders and Note/s;</b> <b>1. Used yellow tape for easy visualization of tape shifting. But actual should be BLACK.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. 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



# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

D94L / 7N0028-7020A

Customer:

TRJ

Car Model:

DAIHATSU-CAST

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

June 28, 2023

Validity Date:

-

Document No.:

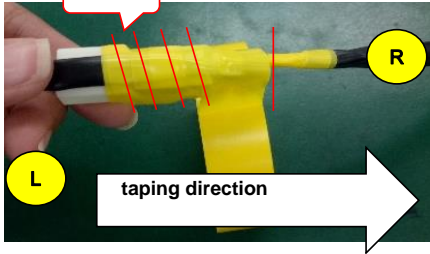
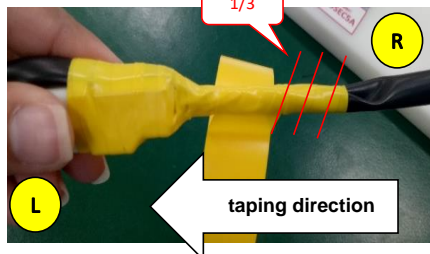
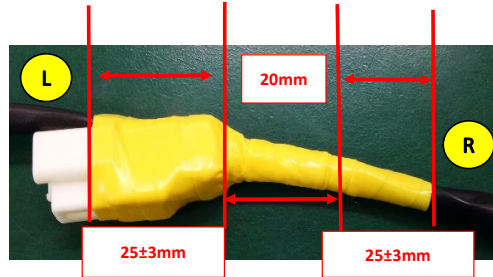

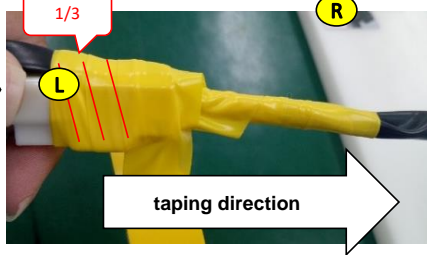





WI-ENG-PDE-055B

Revision No.:

4

Page No.:

4 of 9

PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2  Y-Taping (Continuation)	<div><div><div><div>1/3</div><div></div><div>taping direction</div></div><div><div>1/3</div><div></div><div>taping direction</div></div><div><div>4. Make 1 wind and then 1/3 shifting to the left.</div></div><div><div><div><div>20mm</div><div></div><div>25±3mm</div><div>25±3mm</div></div></div><div><div>5. Make 1 wind and then 1/3 shifting to the right and make 3 winds then cut Note: End of taping must be in center.</div></div><div><div>6. After taping, check the measurement and the taping condition.</div></div></div><div><div><div>70±3mm</div><div></div></div><div><div>3. Make 1/3 shifting to the right side and continue taping to vinyl tube 70mm.</div></div><div><div>1/3</div><div></div><div>taping direction</div></div><div><div>5. Make 1 wind and then 1/3 shifting to the right and make 3 winds then cut Note: End of taping must be in center.</div></div></div></div></div>		<div>MEASURING TAPE</div> <div></div>	<div><div>Important reminders and Note/s; 1. Used yellow tape for easy visualization of tape shifting. But actual should be <b>BLACK</b>. 2. Please use calibrated/verified measuring tape when getting the measurement.</div><div><div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension</div><div><div><div>GOOD FACING</div><div></div></div><div><div>NG FACING</div><div></div></div><div><div>GOOD FACING</div><div></div></div><div><div>NG FACING</div><div></div></div></div><div><div>Important reminders and Note/s; 1. After taping, make sure that sunprene tube must be on the center of connector</div></div></div></div>

MEASURING TAPE

Important reminders and Note/s;  
1. Used yellow tape for easy visualization of tape shifting. But actual should be **BLACK**.  
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

GOOD FACING

NG FACING

GOOD FACING

NG FACING

Important reminders and Note/s;  
1. After taping, make sure that sunprene tube must be on the center of connector

**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:

June 28, 2023

Model code/Part number:

D94L / 7N0028-7020A

Customer:

TRJ

Car Model:

DAIHATSU-CAST

Document No.:

WI-ENG-PDE-055B

Purpose:

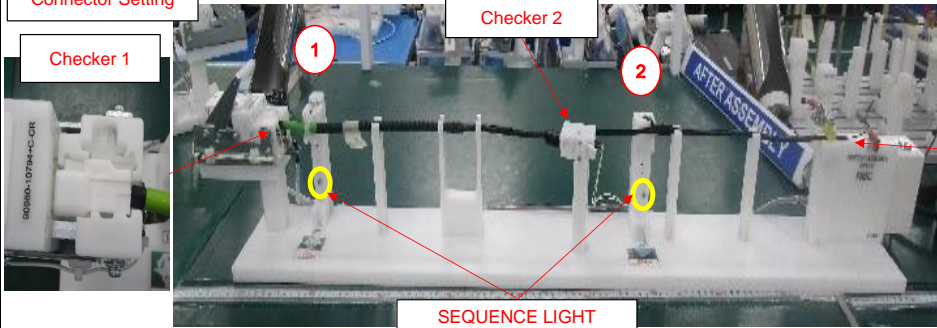

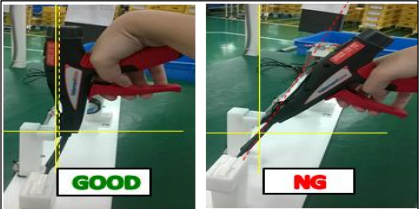
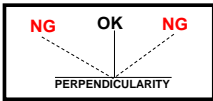

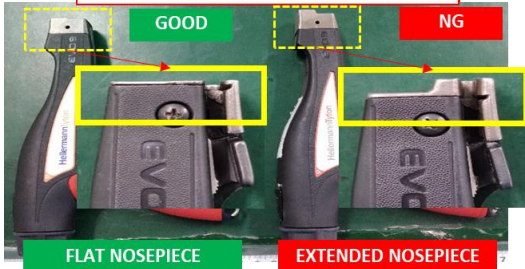
☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

4

Page No.:

5 of 9

PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	⚠ WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Clamp Assembly	<div>Connector Setting</div> <div>Checker 1</div> <div>Checker 2</div> <div>1</div> <div>2</div> <div>SEQUENCE LIGHT</div> 	<div>Stopper</div> <div>⚠</div> <div>Important reminders and Note/s; 1. You will hear the NG buzzer if the sensor detect wrong use of tape and missing tape 2. Make sure no gap between terminal and stopper jig.</div> <div>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</div> <div>Bando Gun</div> 	
			<div>1. Put the assy. First, set the connector to <b>Checker 1</b> then pull the checker fixture for continuity checking. Color sensor light will beep/buzz if sensor detect the <b>Light Green</b> tape. Second, set the connector to <b>Checker 2</b> then push the lock for continuity checking. Last, set the <b>B-B wires</b> with terminal end together within the stopper then press by <b>Toggle clamp</b>. Continue if the sequence light of location ① was on. <b>Note: terminal should touch the aluminum to check the continuity.</b></div>	<div>2. Check if all LED light for <b>POWER ON</b>, <b>WIRE1</b> and <b>WIRE2</b> and <b>CLAMP ON</b> and <b>COLOR SENSOR</b> was <b>ON</b>. Check also if clamp location ① sequence light is ON. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</div>	
			<div>3. Initially tighten the band clamp on location ① using right hand.</div>	<div></div>	
			<div>4. Get the bando gun and cut the band clamp (<b>82711-52070</b>) using right hands. Press the sequence light button after cutting. Continue to location ② if light was on.</div>	<div>BANDO GUN ALIGNMENT</div> <div></div> <div></div> <div>Fixed setting of band clamp cutter: 1 ~ 3</div>	
			<div>5. Hold the tape on clamp location ② and start taping using both hands (<b>3 winds</b>). Press the sequence light button. <b>Go</b> buzzer will be heard.</div>	<div>BANDO GUN ILLUSTRATION</div> <div></div>	
			<div>6. <b>CONDUCT POINT CHECKING</b> before removing from jig.</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**

Effectivity Date:

June 28, 2023

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

-

Model code/Part number:

**D94L / 7N0028-7020A**Customer: **TRJ**Car Model: **DAIHATSU-CAST**

Document No.:

**WI-ENG-PDE-055B**

Purpose:





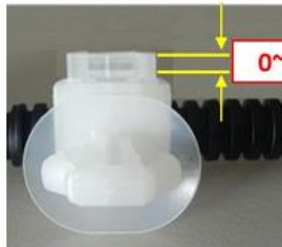

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

4

Page No.:

6 of 9

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Visual Inspection/By Two's inspection	<div><div>Assembled parts</div><div>Master sample</div><div><div>1. Compare to MASTER SAMPLE.</div><div>2. Check the connector lock.</div><div>3. Check the clamp attachment and taping condition.</div></div><div></div></div>	<div><div>Master Sample</div><div>0~2mm</div></div> <div><div>4</div><div><div>Important reminders and Note/s;</div><div>1. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div></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**

Effectivity Date:

June 28, 2023

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

-

Model code/Part number:

**D94L / 7N0028-7020A**Customer: **TRJ**Car Model: **DAIHATSU-CAST**

Document No.:

**WI-ENG-PDE-055B**

Purpose:





☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

4

Page No.:

7 of 9

PARTS:		1. Assy parts		JIG:	n/a	
NO.		PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6		P2		Visual Inspection/By Two's inspection (continuation)		
				 <div>ACTUAL PRODUCT</div>		<div>Master Sample</div> 
				4. Check the terminal appearance.		5. Check the taping condition.
						

**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:

June 28, 2023

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

-

Model code/Part number:

**D94L / 7N0028-7020A**Customer: **TRJ**Car Model: **DAIHATSU-CAST**

Document No.:

**WI-ENG-PDE-055B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

4

Page No.:

8 of 9

**PARTS:**

n/a

JIG:

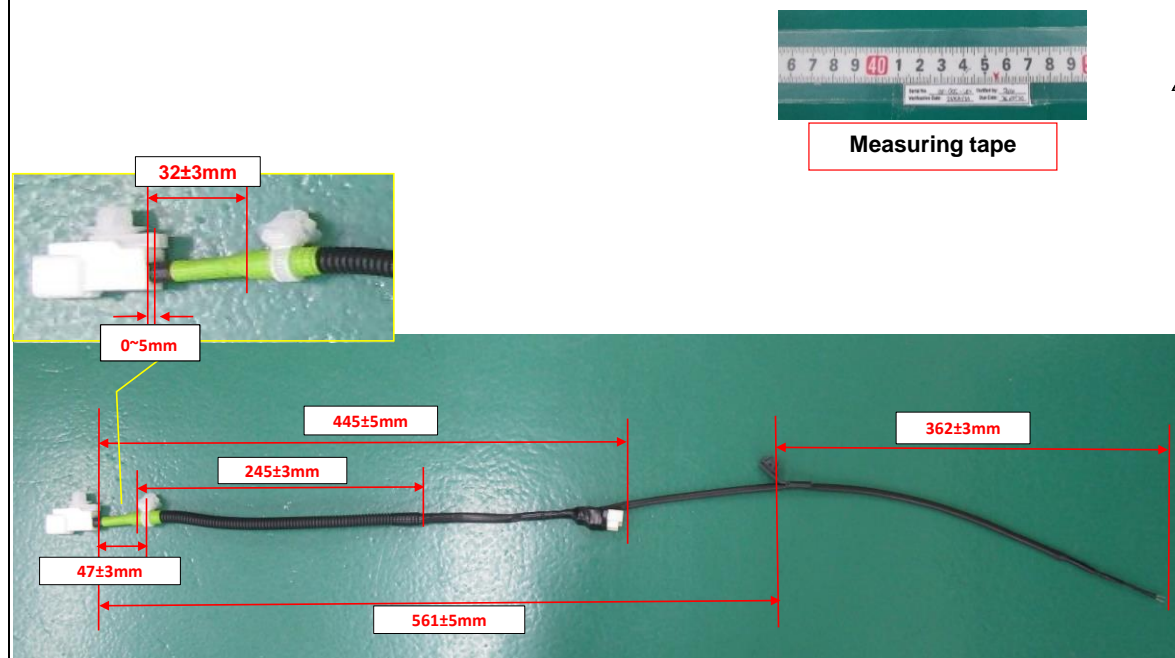
n/a

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

7

P2

Measurement



4

**Important reminders and Note/s;**  
**1. FOR HATSUMONO AND**  
**OWARIMONO**  
**2. 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**

Effectivity Date:

June 28, 2023

Model code/Part number:

**D94L / 7N0028-7020A**Customer: **TRJ**Car Model: **DAIHATSU-CAST**

Validity Date:

-

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Document No.:

**WI-ENG-PDE-055B**

Revision No.:

4

Page No.:

9 of 9

PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P2****7N0028-7020A****GOOD****NO GOOD****5****GOOD****NO GOOD****1** No **Unlock/ Half Lock Connector****3** No **Wrong Insert****2** No **Missing Clip type Clamp****4** No **Missing Tape****5** No **Terminal Backing Out**

**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