

	<b>WORK INSTRUCTION</b>						Effectivity Date:		October 05, 2022	
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: <b>096B / A7075D</b>		Customer: <b>TRQSS</b>		Document No.: <b>WI-ENG-PDE-590A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1		Page No.: 1 of 12	

<b>PARTS:</b>	1. All parts: AVSS f 0.3 B-B L=511±3mm; Black corrugated tube ø5 L=76±3mm (with slit in 25mm); Connector 6098-3802 (W); Clip 82711-1E360 (W); MRSW CP AVSSf 0.3 G-B/W wire L=798±3mm with inserted Black sunprene tube L=57±3mm; Black COT ø7 L=85±3mm (no slit); ø7 L=98±3mm (no slit); ø7 L=357±3mm (With slit in 25mm); Connector 6188-0066 (GR); Black tape						JIG:		1. Insertion jig 2. Locking 3. Terminal cover jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Table lay-out	<div style="text-align: center;"> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <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: 5px;"> <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>	<div style="text-align: center;"> <b>Document reference/s: 1</b>            1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance            2. WI-PRO-KIT-005 Wire Taping without Vinyl Tube         </div> 1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by		Reviewed by		Reviewed by		Approved by	
10/05/22	1	Change document status from Pre-launch to masspro. Additional: Table-layout (Work illustration). Note and procedure in process no.7. Work illustration in process no.10.						M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
09/17/22	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		September 17, 2022	

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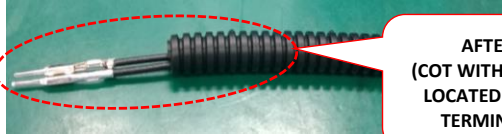
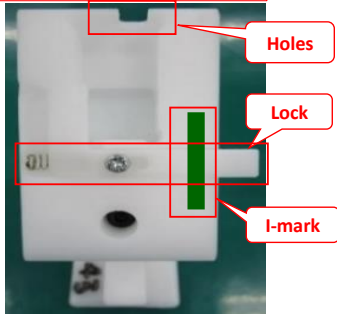
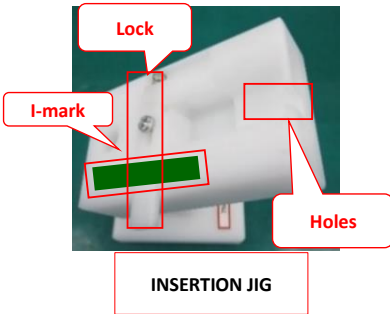
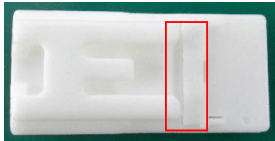
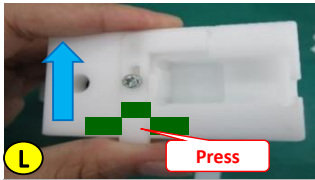

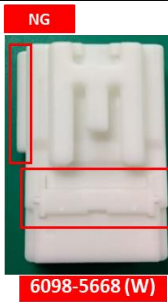
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Revision No.:

1

Page No.:

2 of 12

PARTS:		1. AVSS f 0.3 B-B L=511±3mm (2pcs.) 2. Black corrugated tube ø5 L=76±3mm (with slit in 25mm) 3. Connector 6098-3802 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Black corrugated tube ø5 L=76±3mm (with slit in 25mm)	<div><div></div><div><p>BEFORE (TERMINAL INSERTION AT WITHOUT SLIT IN)</p></div><div></div><div><p>AFTER (COT WITH SLIT IN LOCATED NEAR TERMINAL)</p></div><div><p>1. Get the Black <b>COT ø5 L=76±3mm (with slit in 25mm)</b> using left hand then insert the <b>B-B L=511±2mm</b> wires using right hand. <i>Note: Make sure that COT with slit is near in terminal</i></p></div></div>		n/a	<b>Document references:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>  1. No wrong use of parts
3		Connector setting to insertion jig 6098-3802 (W)	<div><div></div><div></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div></div>		n/a	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector  <div>CONNECTOR ILLUSTRATION</div> <div><div></div><div></div></div>

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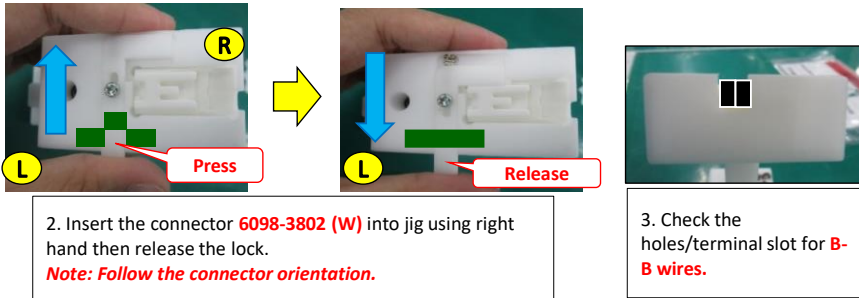
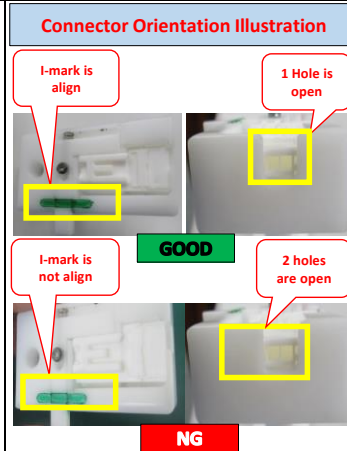
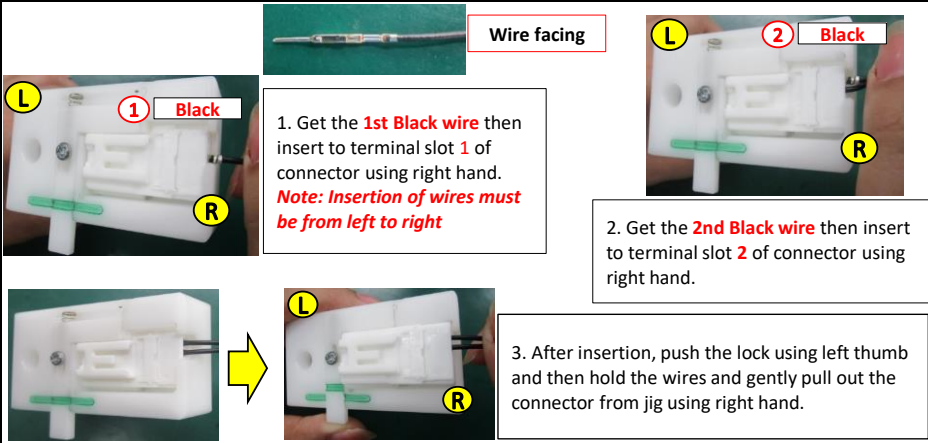
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Revision No.:

1

Page No.:

3 of 12

PARTS:		n/a		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector setting to insertion jig 6098-3802 (W) (Continuation)	 <p>2. Insert the connector <b>6098-3802 (W)</b> into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></p> <p>3. Check the holes/terminal slot for <b>B-B</b> wires.</p>		n/a	
5	Wire insertion to connector 6098-3802 (W)	 <p>Wire facing</p> <p>1. Get the <b>1st Black wire</b> then insert to terminal slot <b>1</b> of connector using right hand. <i>Note: Insertion of wires must be from left to right</i></p> <p>2. Get the <b>2nd Black wire</b> then insert to terminal slot <b>2</b> of connector using right hand.</p> <p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <i>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></p> <p><b>Document references:</b> <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>

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Document No.:

WI-ENG-PDE-590A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 12

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

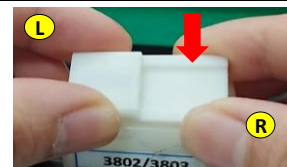
6

P1

Connector Lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower  
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



Right thumb-upper  
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle  
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG

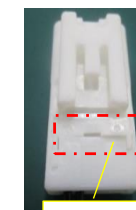


Before pressing

After pressing

GOOD

NG



Important reminders/Note/s:

**1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR**

1. Use the provided jig tool to lock the connector.

2. No unlock/half-locked connector

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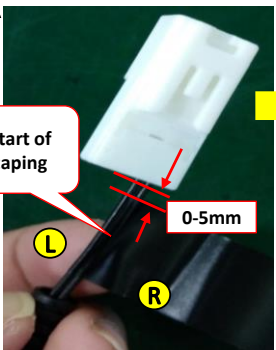
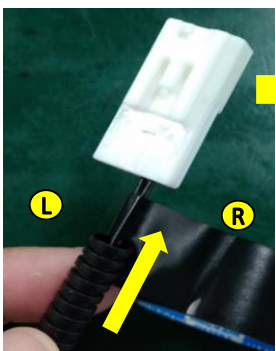

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Revision No.:

1

Page No.:

5 of 12

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1  Taping 1 Wire to COT (with slit in 25mm) near connector	<div><div>1</div><div></div><div></div></div> <div><div>1</div><div>1. Hold the COT and wires using left hand, get the <b>Black tape</b> then conduct <b>6 windings</b> of tape using both hands. Do not cut the tape. <b>Note: Attachment of tape on wires must be from 0-5mm.</b></div></div> <div><div>1</div><div>2. Insert the <b>COT (with slit in 25mm)</b> to tape then push upward until it reach the edge of connector.</div></div>	<div>MEASURING TAPE</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><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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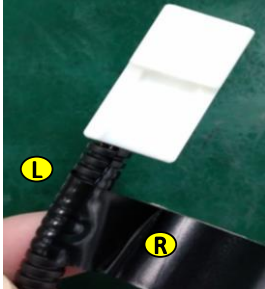
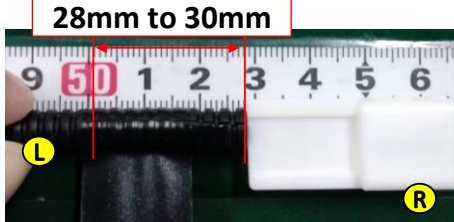
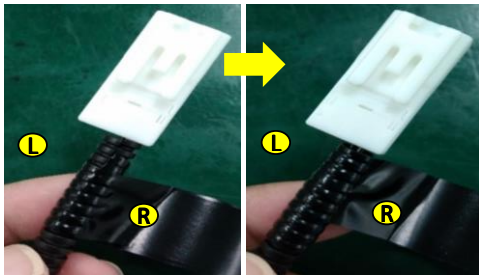
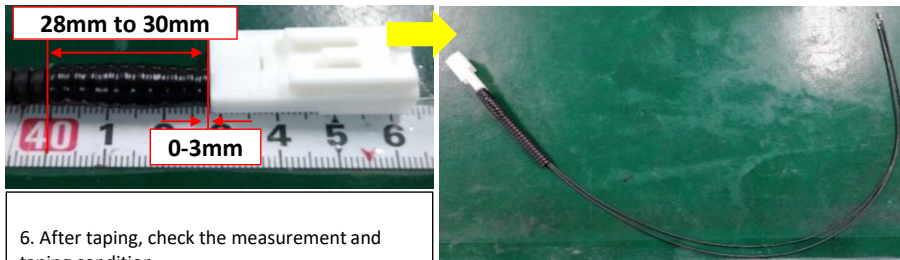

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Revision No.:

**1**

Page No.:

**6 of 12**

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1  Taping 1 Wire to COT (with slit in 25mm) near connector (Continuation)	<div><p>3. Wind the tape going down to COT to ensure that slit in of COT will covers the tape.</p></div> <div><p>28mm to 30mm</p><p>4. Confirm measurement from end of tape up to end of COT <b>28mm to 30mm</b> using both hands.</p></div> <div><p>5. Make <b>2 windings</b> of tape before shifting then make <b>1/3 shifting</b> going to COT until it cover the slit in. Make <b>3 windings</b> of tape before cut.</p></div> <div><p>28mm to 30mm 0-3mm</p><p>6. After taping, check the measurement and taping condition.</p></div>	<div><b>MEASURING TAPE</b></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><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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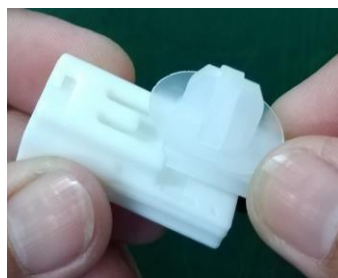
Page No.:

**7 of 12****PARTS:**

1. Assy parts
2. Clip 82711-1E360 (W)

**JIG****n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****8****P1**

Clip clamp attachment

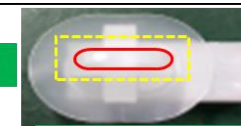
**CLIP CLAMP ORIENTATION**

1. Hold the connector using left hand. Get the clip type clamp **82711-1E360 (W)** then insert the clamp using right hand.

*Note: Follow above instruction. Sound will be heard if properly inserted.*

**NOTE: SET ASIDE THE ASSY PARTS****n/a**

1. No missing clip
2. No wrong use of parts

**CLIP CLAMP ILLUSTRATION****GOOD****82711-1E360 (W)****NG****82711-12B10 (W)**

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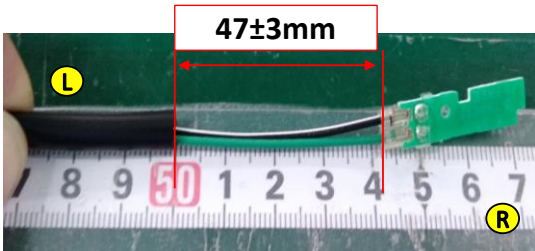
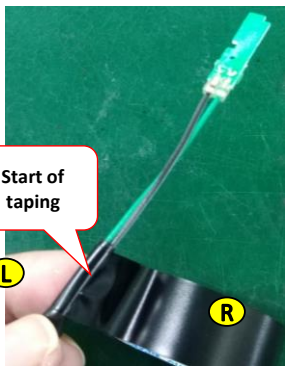
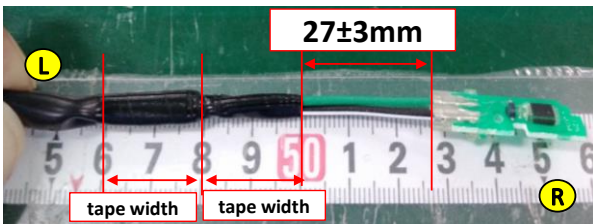

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

8 of 12

PARTS:		1. Assy parts 2. MRSW CP AVSSf 0.3 G-B/W wire L=798±3mm with inserted Black sunprene tube L=57±3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Taping 2 Black sunprene tube to wire near PCB	 <p>47±3mm</p> <p>1. Hold the Sunprene tube using left hand. Measure the end of Sunprene up to the edge of hotmelted wires 47±3mm using both hands.</p>  <p>Start of taping</p> <p>2. Hold the Sunprene tube using left hand. Get the <b>Black tape</b> using right hand then start taping process using both hands.</p>  <p>27±3mm</p> <p>tape width</p> <p>3. After taping, check the measurement and taping condition.</p>		<p>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</p> <p><b>Document references:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p><b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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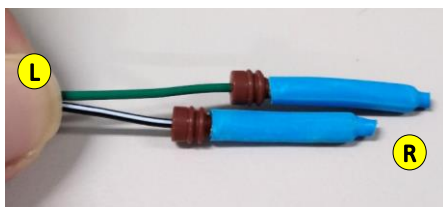



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Revision No.:

**1**

Page No.:

**9 of 12**

PARTS:		1. Assy parts 2. Black COT $\varnothing 7$ L=85 $\pm$ 3mm (no slit)		3. Black COT $\varnothing 7$ L=98 $\pm$ 3mm (no slit) 4. Black COT $\varnothing 7$ L=357 $\pm$ 3mm (With slit in 25mm)		JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
10	P1	Wire insertion to Black COT $\varnothing 7$ L=85 $\pm$ 3mm (no slit) <b>(FIRST)</b> $\varnothing 7$ L=98 $\pm$ 3mm (no slit) <b>(SECOND)</b> $\varnothing 7$ L=357 $\pm$ 3mm (With slit in 25mm) <b>(THIRD)</b>	<div><div>1. Get the terminal cover jig using right hand then insert to both terminals <b>(G-B/W wires)</b> using right hand.</div></div> <div><div>2. Get the corrugated tube <math>\varnothing 7</math> L=85<math>\pm</math>3mm (no slit) using right hand then insert the <b>G-B/W wires</b> using left hand.</div></div> <div><div>3. Get the corrugated tube <math>\varnothing 7</math> L=98<math>\pm</math>3mm (no slit) using right hand then insert the <b>G-B/W wires</b> using left hand.</div></div>			<div>TERMINAL COVER JIG</div> 	1. No deformed terminal 2. No wrong usage of parts 3. No wrong insertion

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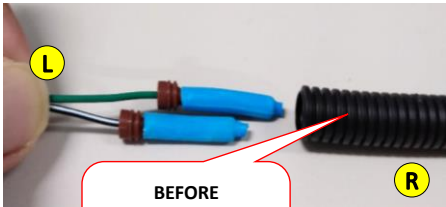
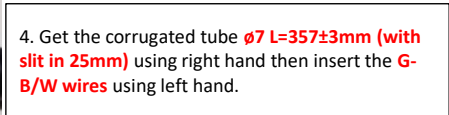

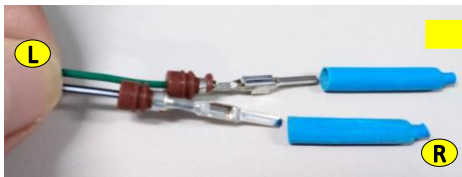
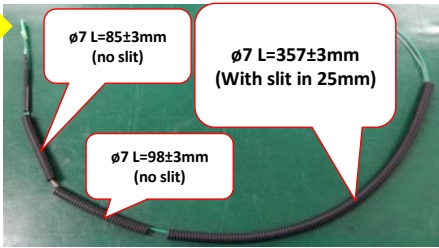

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Revision No.:

**1**

Page No.:

**10 of 12**

PARTS:		1. Assy parts 2. Black COT $\phi 7$ L=85 $\pm$ 3mm (no slit) 3. Black COT $\phi 7$ L=98 $\pm$ 3mm (no slit) 4. Black COT $\phi 7$ L=357 $\pm$ 3mm (With slit in 25mm)			JIG	1. Terminal cover jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
10	P1  Wire insertion to Black COT $\phi 7$ L=85 $\pm$ 3mm (no slit) <b>(FIRST)</b>  $\phi 7$ L=98 $\pm$ 3mm (no slit) <b>(SECOND)</b>  $\phi 7$ L=357 $\pm$ 3mm (With slit in 25mm) <b>(THIRD)</b>  (Continuation)	<div></div> <div></div> <div></div> <div></div> <div></div>			<div></div>	1. No deformed terminal 2. No wrong usage of parts 3. No wrong insertion

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# WORK INSTRUCTION

Effectivity Date:

October 05, 2022

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number: **096B / A7075D**

Customer: **TRQSS**

Document No.:

WI-ENG-PDE-590A

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

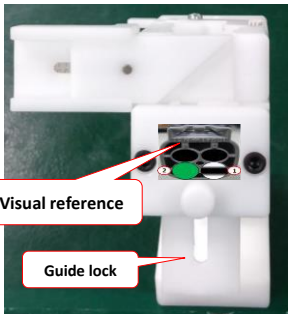
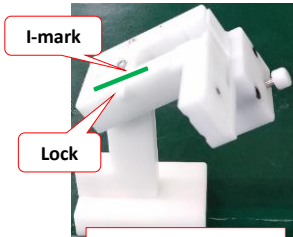

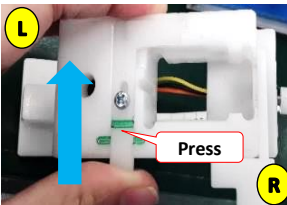
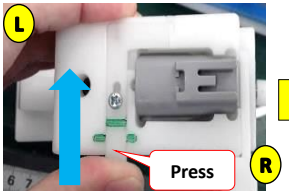
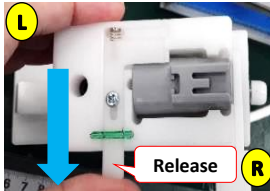
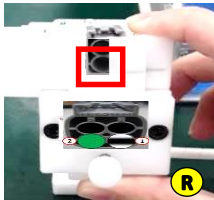

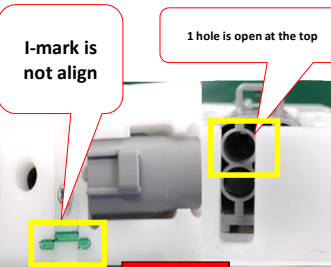
☒ MASSPRO

Revision No.:

1

Page No.:

11 of 12

PARTS:		1. Connector 6188-0066 (GR)		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Connector setting to insertion jig 6188-0066 (GR)	<div><div><p>Visual reference</p><p>Guide lock</p></div><div><p>I-mark</p><p>Lock</p><p>INSERTION JG ORIENTATION</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><div><p>Press</p><p>1. Press the lock using left hand.</p></div><div><div><p>Press</p><p>2. Get the connector <b>6188-0066 (GR)</b> using right hand and insert to insertion jig. Release the lock after insertion.</p></div><div><div><p>Release</p><p>3. Push the lower wire guide upward using right hand. Slot for <b>Green wire</b> will be opened.</p></div><div><p></p></div></div></div></div></div>		n/a	<div><b>CONNECTOR ORIENTATION ILLUSTRATION</b></div> <div><div><p>I-mark is align</p><p>1 hole is open at the bottom</p><p>GOOD</p></div><div><div><p>I-mark is not align</p><p>1 hole is open at the top</p><p>NG</p></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div><div><b>Important reminders/Note/s:</b> <b>1. Follow the connector orientation</b></div></div>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 05, 2022

Process Name/Title:

Validity date

n/a

Model Code/Part Number: 096B / A7075D

Customer:

TRQSS

Document No.:

WI-ENG-PDE-590A

Purpose:

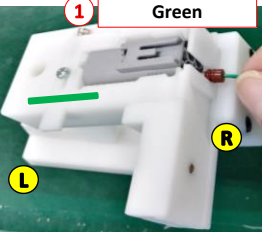

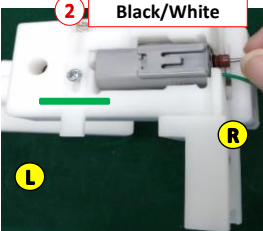
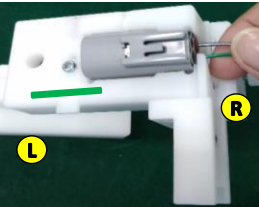

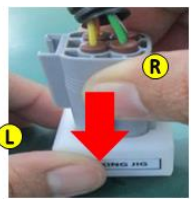


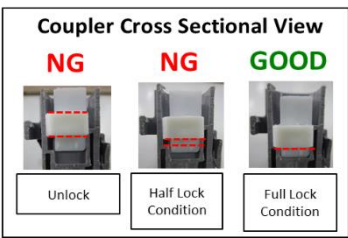

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

12 of 12

PARTS:	1. Assy parts			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	Wire insertion to connector 6188-0066 (GR)  P1	<div><p>1. Hold the insertion jig using left hand. Get the <b>Green wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>Black/White wire</b> will be opened.</p></div> <div><p>3. Get the <b>Black/White wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div> <div><p>WIRE FACING</p></div>		n/a	<p><b>Document references:</b></p> <p>1. Refer to <b>GL-PRO-ASY-029</b> for <b>Pull-Push procedure</b>.</p> <p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p>
13	Connector Lock	<div><p>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Half Lock Condition Full Lock Condition</p></div>		<p>Locking jig</p> 	<p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</p>

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