



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 23, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: D70B / 75S791-0030

Customer:

TRJ

Document No.:

WI-ENG-PDE-659

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 16

## PARTS:

1. Connector PBVP-12V-S (W) [2pcs]

JIG:

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1

P1

Connector setting to  
insertion jig  
PBVP-12V-S (W)

Visual reference

Upper Button

Upper guide

Lower guide

Lower Button

Connector orientation

Insertion Jig

1. Get the 2 pcs of **PBVP-12V-S** connector using right hand transfer the 1 connector to left hand then insert to insertion jig.  
*Note: Follow the connector orientation.*

Press

2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.

**Safety Instruction**

Be sure to wear prescribed 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. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector


## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Established Date:	Prepared by:	Reviewed by:	Approved by:	Noted by:
05/23/23	1	Change from pre-launch to Masspro. Improve Work procedure illustration on process no. 1 to 12.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
05/04/23	0	Initial issue.	M. Capatang	J. Loterte	C. Villanueva	A. Arañes		M. Ariola	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**



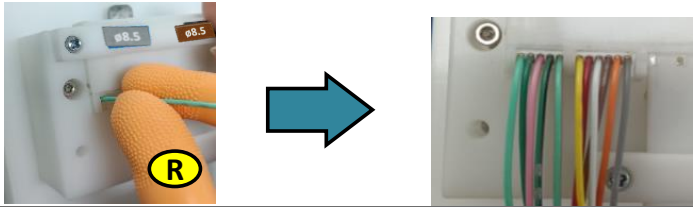


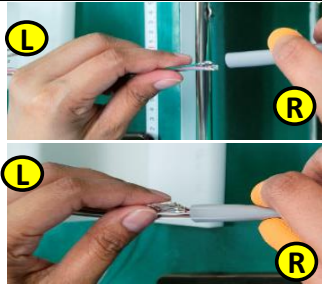

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>May 23, 2023</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity date		<b>n/a</b>	
	Model Code/Part Number: <b>D70B / 75S791-0030</b>		Customer: <b>TRJ</b>		Document No.:		<b>WI-ENG-PDE-659</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1		Page No.: 2 of 16	



  

<b>PARTS:</b>		1. Connector PBVP-12V-S (W); AVSS 0.3 LG L=169±2mm; AVSS 0.3 LG L=169±2mm; AVSS 0.3 LG L=308±2mm; AVSS 0.3 G/B L=308±2mm; AVSS 0.3 LG/R L=308±2mm; AVSS 0.3 Y L=169±2mm; AVSS 0.3 R/L L=308±2mm; AVSS 0.3 W L=308±2mm; AVSS 0.3 R/L L=308±2mm; AVSS 0.3 OR L=308±2mm; AVSS 0.3 GR L=169±2mm; Light Gray (N6GR) VM tube (Sunprene) Ø8.5 L=125±3mm				<b>JIG</b>		1. Insertion jig	
---------------	--	--	--	--	--	------------	--	------------------	--

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS																																				
2	Wire insertion to Connector PBVP-12V-S (W)	<div> <div> <b>INSERTION SEQUENCE FROM LEFT TO RIGHT</b>  </div> <div>  <p>Wire facing</p> </div> <div> <b>WIRE INSERTION ILLUSTRATION</b> <table border="1"> <tr> <td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td> </tr> <tr> <td>LG</td><td>G</td><td>P</td><td>G/B</td><td>LG/R</td><td>X</td><td>Y</td><td>R/L</td><td>W</td><td>BR</td><td>OR</td><td>GR</td> </tr> <tr> <td>169</td><td>169</td><td>308</td><td>308</td><td>308</td><td></td><td>169</td><td>308</td><td>308</td><td>308</td><td>169</td><td>169</td> </tr> </table>  </div> </div> <p>1. Get the <b>LG wire</b> using left hand and transfer to right hand then insert to connector. Repeat the process for <b>G-P-G/B-LG-R-Y-R/L-W-BR-OR-GR wires</b>. Check the wire after insertion.  <i>Note: Follow the insertion sequence based on the illustration.</i></p>	1	2	3	4	5	6	7	8	9	10	11	12	LG	G	P	G/B	LG/R	X	Y	R/L	W	BR	OR	GR	169	169	308	308	308		169	308	308	308	169	169	<div> <b>STEERING NAVIGATION</b>  </div> <div> <b>CONTROLLER</b>  </div>	<ol style="list-style-type: none"> <li>Use provided jig per model</li> <li>No wrong usage of parts</li> <li>One by one insertion</li> <li>No wrong insertion</li> <li>No deformed terminal</li> <li>No stuck of terminal tip</li> </ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"> <li>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</li> <li>Please hold the wire near terminal during insertion.</li> <li>Insertion of wire must be from left to right.</li> </ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"> <li>Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</li> <li>Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</li> <li>Refer to GL-PRO-ASY for Pull-Push procedure.</li> </ol>
1	2	3	4	5	6	7	8	9	10	11	12																													
LG	G	P	G/B	LG/R	X	Y	R/L	W	BR	OR	GR																													
169	169	308	308	308		169	308	308	308	169	169																													
3	Wire insertion to Light Gray (N6GR) VM tube (Sunprene) Ø8.5 L=125±3mm	  <p>1. Get the <b>Light Gray (N6GR) VM tube (Sunprene) Ø8.5 L=125±3mm</b> using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</p>	n/a	<ol style="list-style-type: none"> <li>No wrong usage of parts</li> <li>No deformed terminal</li> <li>No tangled wires</li> </ol>																																				

<b>CONFIDENTIAL:</b> 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>  </div>	<div>  </div>
--	--	--



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 23, 2023

Model Code/Part Number:

D70B / 75S791-0030

Customer:

TRJ

Validity date

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-659

Revision No.:

1

Page No.:

3 of 16

## PARTS:

1. AVSS 0.3 B wire L=169±2mm; R wire L=169±2mm; R/W L=169±2mm; W/G wire L=169±2mm; GR/B wire L=169±2mm

## JIG

1. Insertion jig

## NO.

## PROCESS NAME



## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

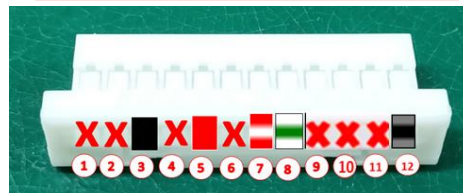
## QUALITY POINTERS

4

P1

Wire insertion to Connector  
PBVP-12V-S (W)

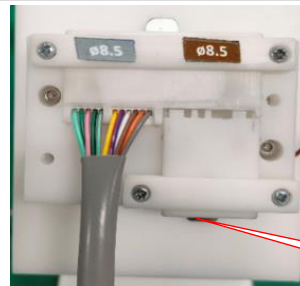
## INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

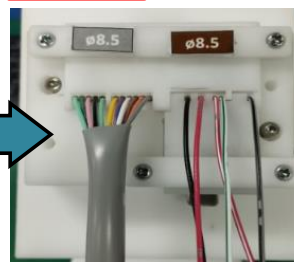
## WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10	11	12
X	X	B	X	R	X	R/W	W/G	X	X	X	GR/B
		169		169		169	169				169



Note: Holes that need to be insert are only open.

Lower guide



1. Get the **B** wire using right hand and insert to connector. Repeat the process for **R-R/W-W/G-GR/B** wires. Check the wire after insertion.

Note: Follow the insertion sequence based on the above illustration.

## STEERING NAVIGATION



## CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

## Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

## Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-029 for Pull-Push-Push procedure.

**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:

May 23, 2023

Process Name/Title:

Model Code/Part Number:

D70B

/

75S791-0030

Customer:

TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-659

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:


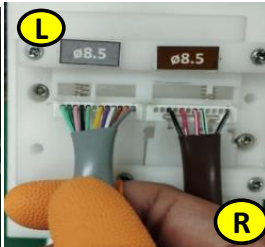
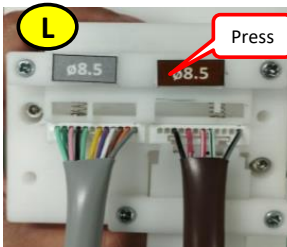
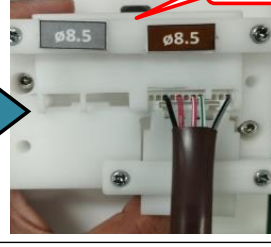
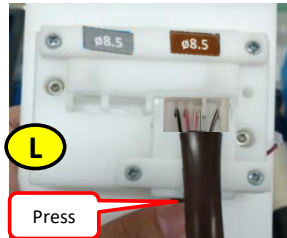
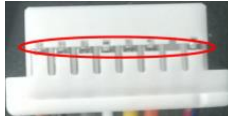
4 of 16

### PARTS:

1. Brown (DBR) VM tube (Sunprene) Ø8.5 L=125±3mm

### JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Brown (DBR) VM tube (Sunprene) Ø8.5 L=125±3mm	<div><div><p>1. Get the <b>Brown (DBR) VM tube (Sunprene) Ø8.5 L=125±3mm</b> using right hand. Hold the wire using left hand then insert the wires.</p></div><div><div></div><div><div><p>3. Press the upper guide using left hand. Check the wire insertion condition.</p><p><b>Note: Second connector with inserted wire and Dark Brown (DBR) VM tube (Sunprene) will stay in the jig.</b></p></div><div><div><p>4. Press the Lower button using right hand. Holes that need to be insert are only open.</p></div></div></div></div></div>	N/A	<div><div>1. No wrong usage of parts</div><div>2. No deformed terminal</div><div>3. No tangled wires</div><div><b>Document reference/s:</b> <i>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</i></div><div></div><div><b>Terminal tip must be visible</b></div></div>

N/A

1. No wrong usage of parts  
2. No deformed terminal  
3. No tangled wires

**Document reference/s:**  
1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.



**Terminal tip must be visible**

**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:

May 23, 2023

Process Name/Title:

Model Code/Part Number: **D70B / 75S791-0030**

Customer: **TRJ**

Validity date

n/a

Document No.:

**WI-ENG-PDE-659**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


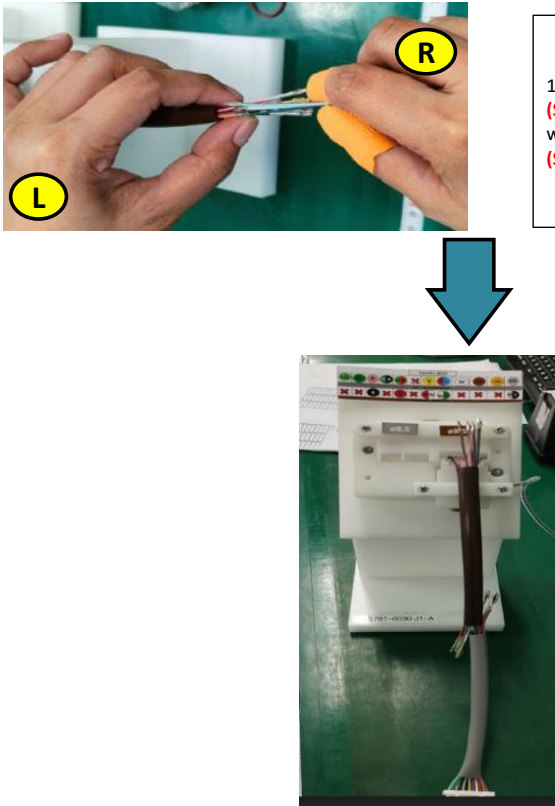
☒ MASSPRO

Revision No.:

1

Page No.:

5 of 16

PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME		 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE		QUALITY POINTERS	
6	P1	Wire insertion to assy parts	<div></div> <div>1. Hold the <b>Brown (DBR) VM tube (Sunprene)</b> using left hand and insert the wires from <b>Light Gray (N6GR) VM tube (Sunprene)</b> using right hand.</div>	N/A		1. No wrong use of parts 2. No deformed terminal 3. No tangled wires	

**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









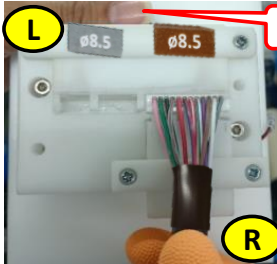
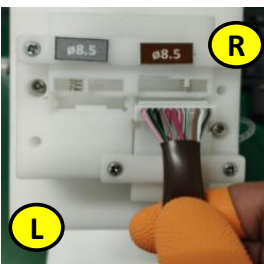


# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	May 23, 2023	
Validity date	n/a	
Document No.:	WI-ENG-PDE-659	
Revision No.:	1	Page No.: 6 of 16

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

Model Code/Part Number: **D70B / 75S791-0030** Customer: **TRJ**


Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts			JIG	1. Insertion jig																																		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS																																	
7	P1	Wire insertion to Connector PBVP-12V-S (W)																																					
<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div>Wire facing</div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td></tr><tr><td>P</td><td>G/B</td><td>B</td><td>LG/R</td><td>R</td><td>R/L</td><td>R/W</td><td>W/G</td><td>BR</td><td>W</td><td>GR/B</td></tr><tr><td>308</td><td>308</td><td>169</td><td>308</td><td>169</td><td>308</td><td>169</td><td>169</td><td>308</td><td>308</td><td>169</td></tr></table><div><div></div><div></div><div></div><div></div><div></div></div><div><div>1. Hold the <b>P wire</b> using right hand and support the wire by left index finger then insert to connector <b>slot 11</b> using right hand. Repeat the process on <b>G/B-LG/R-R/L-W/G-BR-W</b>. Check the wire after insertion</div><div><i>Note: Follow the insertion sequence based on the above illustration.</i></div><div>2. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.</div></div></div> <div><div>STEERING NAVIGATION</div><div></div><div>CONTROLLER</div><div></div></div> <div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. One by one insertion</div><div>4. No wrong insertion</div><div>5. No deformed terminal</div><div>6. No stuck of terminal tip</div><div><b>Important reminders/Note/s:</b></div><div>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div><div>2. Please hold the wire near terminal during insertion.</div><div>3. Insertion of wire must be from left to right.</div><div><b>Document reference/s:</b></div><div>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</div><div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div><div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></div>							1	2	3	4	5	6	7	8	9	10	11	P	G/B	B	LG/R	R	R/L	R/W	W/G	BR	W	GR/B	308	308	169	308	169	308	169	169	308	308	169
1	2	3	4	5	6	7	8	9	10	11																													
P	G/B	B	LG/R	R	R/L	R/W	W/G	BR	W	GR/B																													
308	308	169	308	169	308	169	169	308	308	169																													


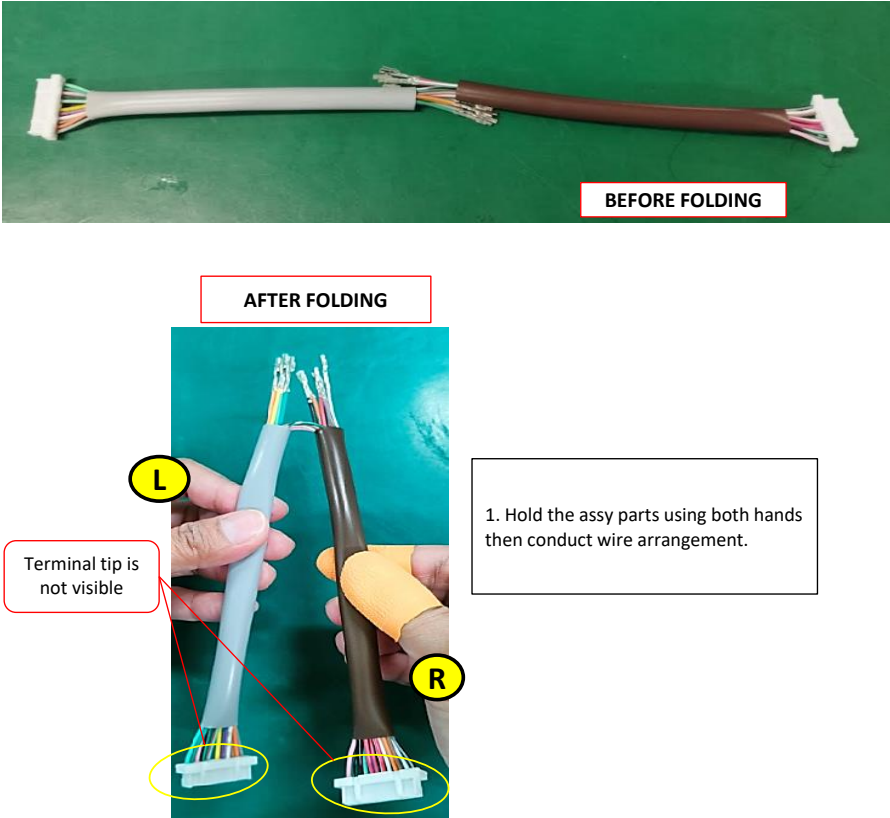
**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp

	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>May 23, 2023</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity date	<b>n/a</b>		
	Model Code/Part Number: <b>D70B / 75S791-0030</b>		Customer: <b>TRJ</b>	Document No.:	<b>WI-ENG-PDE-659</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	7 of 16

<b>PARTS:</b>	1. Assy parts				<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	 <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
8	P1	Wire folding  	N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing		

<b>CONFIDENTIAL:</b> 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; text-align: center;"> <b>NBC (Philippines)</b>  <b>MASTER COPY</b> </div>	<div style="text-align: right;">DCC Stamp</div>
--	--	---



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 23, 2023

Process Name/Title:

Validity date

n/a

Model Code/Part Number: **D70B / 75S791-0030**

Customer: **TRJ**

Document No.:

**WI-ENG-PDE-659**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

8 of 16

PARTS:

1. Connector 1318386-2 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

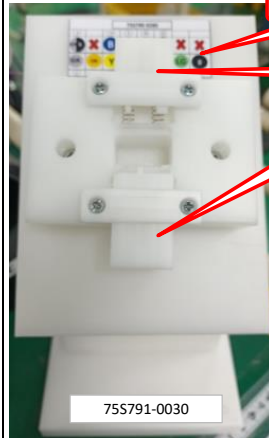
QUALITY POINTERS

9

P1

Connector setting to  
insertion jig  
1318386-2 (B)

INSERTION JIG

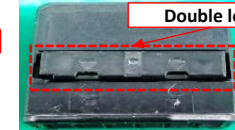


Visual reference

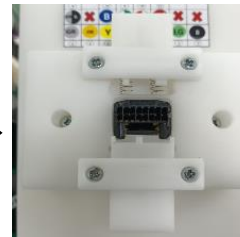
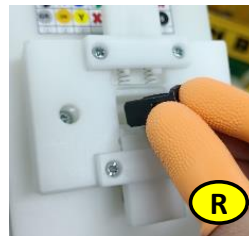
Upper guide

lower guide

Double lock



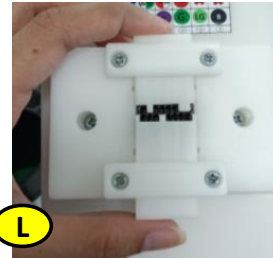
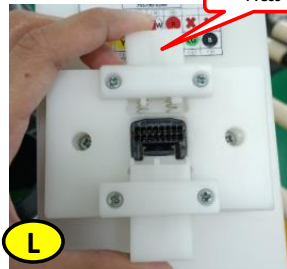
CONNECTOR ORIENTATION



1. Get the connector **1318386-2 (B)** and insert to insertion jig using right hand.

*Note: Follow the connector orientation*

Press



2. Press the upper and lower guide using left hand (same timing). Holes that need to be inserted are only open.

N/A

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

CONNECTOR LOCK APPEARANCE  
CHECK

GOOD

NG



UNLOCK

HALF-LOCKED

**Important reminders/Note/s:**

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Check the connector before insertion.

**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:

May 23, 2023

Process Name/Title:

Model Code/Part Number:

D70B

/

75S791-0030

Customer:

TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-659

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

9 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

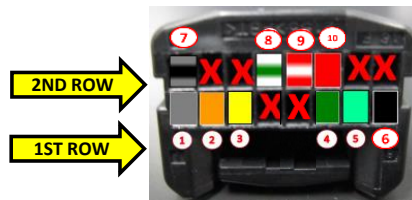
QUALITY POINTERS

10

P1

Wire insertion to Connector  
1318386-2 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



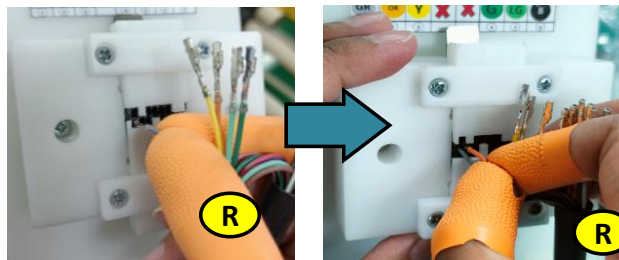
WIRE INSERTION ILLUSTRATION

7	8	9	10			
GR/B	X	X	W/G	R/W	R	X
169			169	169	169	
1	2	3			4	5
GR	OR	Y	X	X	G	LG
169	169	169			169	169

Dark Brown (DBR) VM tube  
(Sunprene)



FIRST ROW (LEFT TO RIGHT)



1. Insert first the wires from  
**Dark Brown (DBR) VM tube  
(Sunprene)**. Hold the **GR** wire  
and insert to terminal **slot 1**  
using right hand. Repeat the  
process for **OR-Y-G-LG** wires.  
*Note: Follow the insertion  
sequence based on the  
illustration stated above.*

N/A

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

### Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Please hold the wire near terminal during insertion.

### Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

**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:

May 23, 2023

Process Name/Title:

Model Code/Part Number: D70B / 75S791-0030

Customer:

TRJ

Validity date

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-659

Revision No.:

1

Page No.:

10 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

10

P1

Wire insertion to Connector  
1318386-2 (B)  
(Continuation)Light Gray (N6GR) VM TUBE  
(SUNPRENE)

## WIRE INSERTION ILLUSTRATION

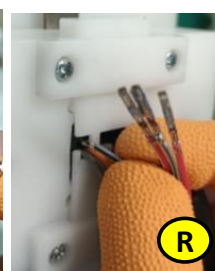
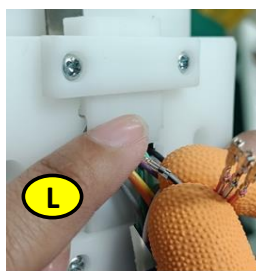
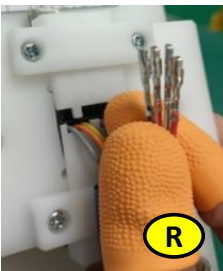
7	8	9	10			
GR/B	X	X	W/G	R/W	R	X
169			169	169	169	
1	2	3	4	5	6	
GR	OR	Y	X	X	G	LG
169	169	169			169	169

## FIRST ROW (LEFT TO RIGHT)



2. Hold the **B wire** using right hand and support the wire by left index finger then insert to terminal **slot 6** using right hand.  
*Note: Follow the insertion sequence based on the above illustration.*

## SECOND ROW (LEFT TO RIGHT)



3. Hold the **GR/B wire** using right hand and support the wire by left index finger then insert to terminal **slot 7** using right hand. Repeat the process for **W/G-R/W-R wires**.  
*Note: Follow the insertion sequence based on the above illustration.*

n/a

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

## Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Please hold the wire near terminal during insertion.


## Document reference/s:


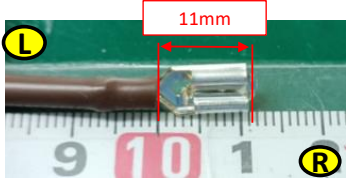



1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

**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:	May 23, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity date	n/a	
	Model Code/Part Number: D70B / 75S791-0030	Customer: TRJ	Document No.:	WI-ENG-PDE-659	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:	1. Assy parts 2. Brown (DBR) VM tube (Sunprene) Ø3 L=113±3mm 3. AVSS 0.5 L L=129±2mm			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1  Wire insertion to Brown (DBR) VM tube (Sunprene) Ø3 L=113±3mm	<div></div> <div>1. Get the <b>Blue wire</b> using right hand and insert to <b>Brown (DBR) VM tube (Sunprene) Ø3 L=113±3mm</b>.</div> <div></div> <div>2. Measure the VM tube (Sunprene) up to the tip of the terminal, it should be <b>11mm</b>.</div> <div></div>		<div>MEASURING TAPE</div>   n/a	<div></div> <div>Peel-off wire should be covered by Sunprene tube (White)</div>  <div><b>Important Reminder/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></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

Effectivity Date:

May 23, 2023

Model Code/Part Number: D70B / 75S791-0030

Customer:

TRJ

Document No.:

WI-ENG-PDE-659

Purpose:

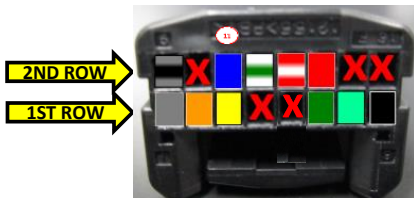

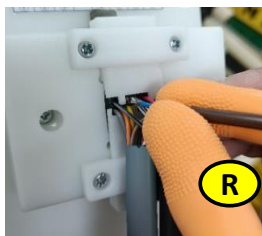
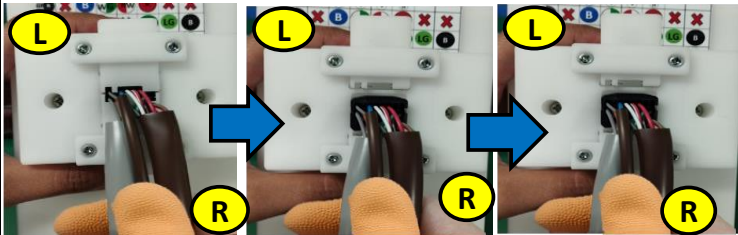
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

12 of 16

PARTS:		1. Assy parts			JIG	1. Insertion jig																																																
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																																
12	P1	Wire insertion to connector 1318386-2 (B) (Continuation)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div>2ND ROW</div><div>1ST ROW</div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>7</td><td></td><td>11</td><td>8</td><td>9</td><td>10</td><td></td><td></td></tr><tr><td>GR/B</td><td>X</td><td>L</td><td>W/G</td><td>R/W</td><td>R</td><td>X</td><td>X</td></tr><tr><td>169</td><td></td><td>129</td><td>169</td><td>169</td><td>169</td><td></td><td></td></tr><tr><td>1</td><td>2</td><td>3</td><td></td><td></td><td>4</td><td>5</td><td>6</td></tr><tr><td>GR</td><td>OR</td><td>Y</td><td>X</td><td>X</td><td>G</td><td>LG</td><td>B</td></tr><tr><td>169</td><td>169</td><td>169</td><td></td><td></td><td>169</td><td>169</td><td>169</td></tr></table><div></div><div>Wire facing</div></div> <div><div>SECOND ROW (LEFT TO RIGHT)</div><div></div><div>4. Get the <b>L wire</b> using right hand and insert to terminal slot 11 using right hand. <i>Note: Follow the insertion sequence based on the above illustration.</i></div></div> <div><div></div><div>5. Press the upper guide and lower guide (same timing) using both hands then remove the assy part using right hand.</div></div>		7		11	8	9	10			GR/B	X	L	W/G	R/W	R	X	X	169		129	169	169	169			1	2	3			4	5	6	GR	OR	Y	X	X	G	LG	B	169	169	169			169	169	169	n/a	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div><b>Important reminders/Note/s:</b></div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</div> <div>Do not exert extra force.</div>
			7		11	8	9	10																																														
GR/B	X	L	W/G	R/W	R	X	X																																															
169		129	169	169	169																																																	
1	2	3			4	5	6																																															
GR	OR	Y	X	X	G	LG	B																																															
169	169	169			169	169	169																																															

**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 23, 2023

Model Code/Part Number:

D70B / 75S791-0030

Customer:

TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-659

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

13 of 16

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

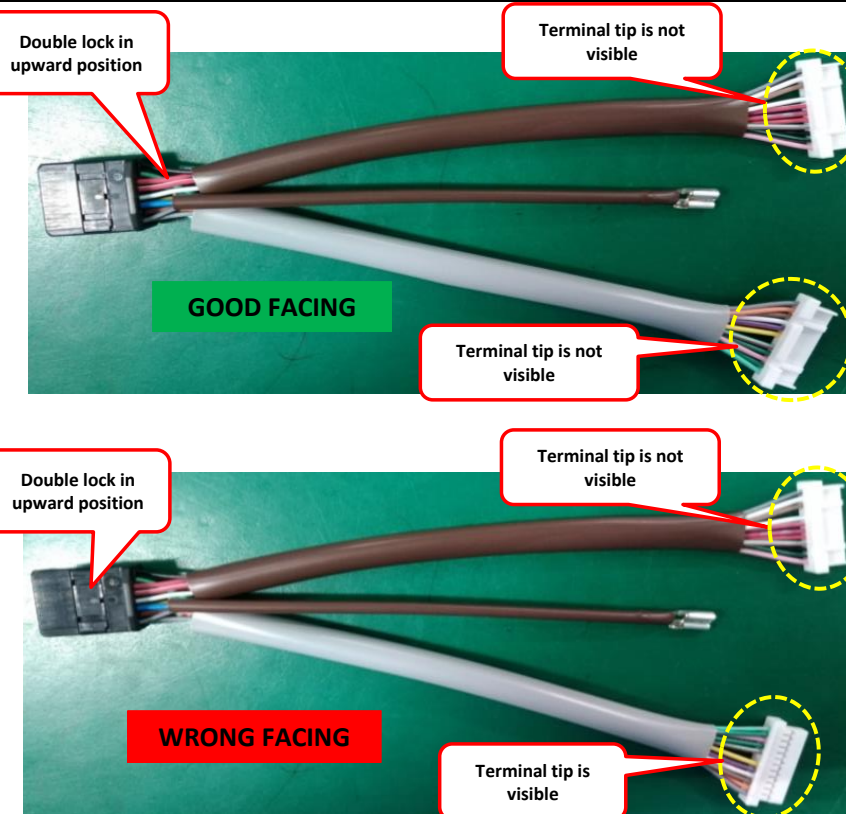
TOOLS/PPE

QUALITY POINTERS

13

n/a

Wire arrangement



n/a

1. No wrong orientation of connector.
2. No tangled wires.
3. 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





# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 23, 2023

Process Name/Title:

Model Code/Part Number:

D70B / 75S791-0030

Customer:

TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-659

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

14 of 16

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

n/a

Visual/By two's inspection

1. Check the Connector lock, locking of connector is included to Steering electrical test.

2. Check the wire alignment. Make sure no tangled wires.

3. Check the presence of clamp attachment and band clamp cut condition.

Brown (DBR) VM tube (Sunprene)

Brown (DBR) VM tube (Sunprene)

Light Gray (N6GR) VM tube (Sunprene)

4. Check the terminal if with backing out (not fully inserted) or deformed terminal.

5. Check the orientation of harness.

6. Compare to **Engineering sample** by tapping.

n/a

1. No wrong orientation of connector.
2. No tangled wires.
3. Terminal backing out

### Document References:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

**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




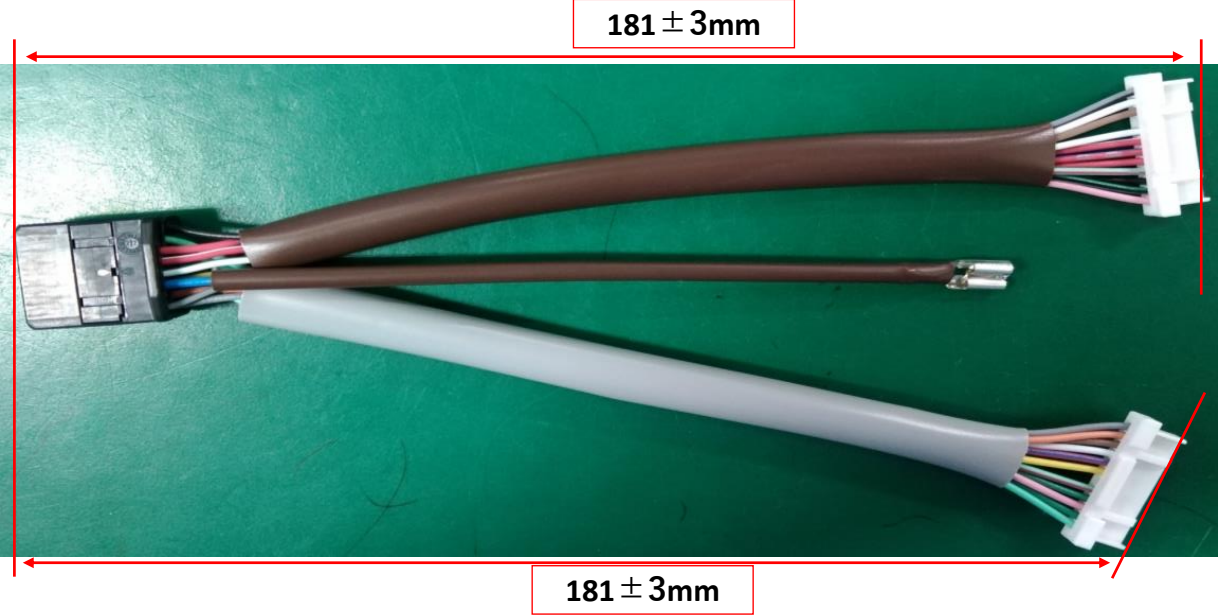
**WORK INSTRUCTION**  
**TAPING ASSEMBLY PROCESS**

Effectivity Date:	May 23, 2023	
Validity date	n/a	
Document No.:	WI-ENG-PDE-659	
Revision No.:	1	Page No.: 15 of 16

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

Product Name/Code: **D70B / 75S791-0030** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

<b>PARTS:</b>		1. Assy parts		<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
15	n/a	Measurement	<div><div>MEASURING TAPE</div><p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p></div>  <p>181 ± 3mm</p> <p>181 ± 3mm</p>		<p><b>Important reminders/Note/s:</b></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

## TAPING ASSEMBLY PROCESS

Effectivity Date:	May 23, 2023		
Validity date	n/a		
Document No.:	WI-ENG-PDE-659		
Revision No.:	1	Page No.:	16 of 16

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

Product Name/Code: **D70B / 75S791-0030** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:

n/a

JIG

n/a

### QUALITY CHECKPOINTS

# 75S791-0030

1. Check the connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

Brown VM tube (Sunprene)

Brown VM tube (Sunprene)

5. Check the terminal if with backing out (no fully inserted) or deformed terminal

3. Check the orientation of harness.

Light Gray VM tube (Sunprene)

4. Check if no missing parts.

6. Compare to master sample.

**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