



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **310B / 7M0557-7020B**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 26, 2021

Validity Date:

-

Document No.:

WI-ENG-PDE-162A

Revision No.:

2

Page No.:

1 of 5

PARTS: 2 1. Connector 6189-0451 (W)



JIG:

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 2 Connector setting to insertion jig 6189-0451 (W)	<p>INSERTION JIG WITH SWITCH COVER</p> <p>1. Press the lock of insertion jig using left thumb. </p> <p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock. </p> <p>3. Push the guide using left hand. The slot for B/W wire will be opened. </p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Connector Orientation Illustration</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
02/26/21	2	Change connector colours in accordance with color standardization for plastic parts refer to GL-COM-003; Remove Cycle time; Change 2x pulling to Pull-Push-Pull-Push in insertion quality pointers; Put assy parts on pg 3-5	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
08/19/20	1	Transferred process owner from Production (WI-PRO-ASY-117) to Engineering; Add cycle time; Apply some improvements; Changed vinyl tube from ø7 L=248±3mm to ø5 L=273±3mm; Changed COT Diameter from 7 to 5; Removal of taping process on Vinyl tube to wire near connector; Transfer insertion process from Kitting (WI-PRO-ASY-067) to Sub-assy P1.	J. Loterte	R. Peñalozaa	A. Shimamura	A. Arañes				
Established Date:							October 23, 2018			

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:

February 26, 2021

Process Name/Title:

Product Name/Code:

310B / 7M0557-7020B

Customer:

TRQSS

Validity date:

-

Document No.:

WI-ENG-PDE-162A

Purpose:

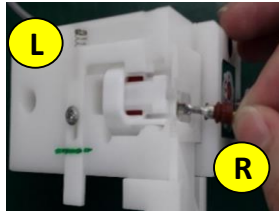
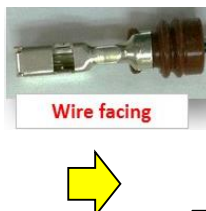
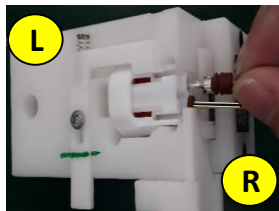

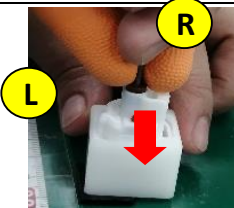
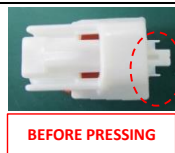




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

2 of 5

PARTS:		1. TVSSf 0.3 GR and B/W L=549±3mm		JIG	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6189-0451 (W)	<div><div><div><p>1. Get the B/W wire then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of B/W wire press the button using right hand. The slot for GR wire will be open.</p></div><div><p>3. Get the GR wire then insert to terminal slot ② 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></div> <div>N/A</div> <div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal</div><div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div></div>			
3	Connector Lock	<div><div><p>1. Put the connector into locking jig then press 2x.</p></div><div><div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p></div><div><div><p>GOOD</p><p>NG</p><p>Check the double lock deformation</p></div></div></div></div> <div>LOCKING JIG</div> <div></div> <div><div>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div><div>1. No half-locked and unlock 2. No lock deformation 3. Use provided jig tool to lock the connector</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:

February 26, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity date

-

Product Name/Code:

310B / 7M0557-7020B

Customer:

TRQSS

Document No.:

WI-ENG-PDE-162A

Purpose:


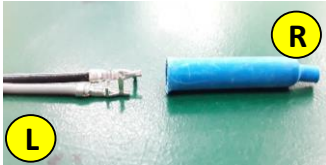



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

3 of 5

PARTS:		1. Black Vinyl tube $\phi 5$ L=273 \pm 3mm 2. Black Corrugated tube $\phi 5$ L=149 \pm 3mm (no slit)			3. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
4	<div>2</div> Wire insertion to Black vinyl tube $\phi 5$ L=273 \pm 3mm	<div>L</div>  <div>R</div> <div>1. Get the Black vinyl tube $\phi 5$ L=273\pm3mm using right hand then insert the wires using left hand.</div>				n/a		1. No wrong use of parts
5	P1 <div>2</div> Wire insertion to Black Corrugated tube $\phi 5$ L=149 \pm 3mm (no slit)	<div>L</div>  <div>R</div> <div>1. Get the terminal cover jig using right hand and insert wires using left hand.</div> <div>L</div>  <div>R</div> <div>2. Get the black corrugated tube (no slit) $\phi 5$ L=149\pm3mm using right hand and insert to wires.</div> <div>L</div>  <div>R</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>				TERMINAL COVER JIG 		1. No wrong use of parts

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:

February 26, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

-

Product Name/Code: **310B / 7M0557-7020B**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-162A

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

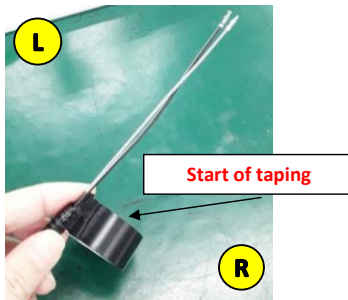
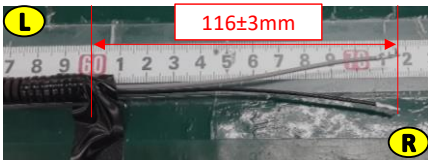
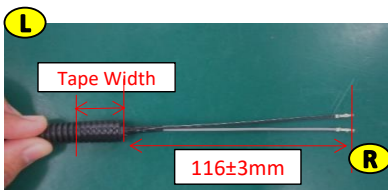

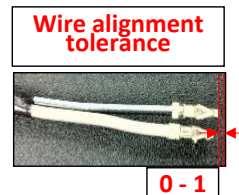
4 of 5

PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 COT to wire near terminal	 <p>Start of taping</p> <p>1. Get Black tape using right hand. Conduct pre-taping between COT and wire using both hands.</p>  <p>116±3mm</p> <p>2. Measure the end of COT up to the terminal pointed tip $L = 116 \pm 3\text{mm}$. Continue taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>Tape Width</p> <p>116±3mm</p> <p>3. After taping, check the dimension, taping condition and wire alignment</p>	<p>MEASURING TAPE</p> 	 <p>Wire alignment tolerance</p> <p>0 - 1</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong dimension <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></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

Effectivity Date:

February 26, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

-

Product Name/Code:

310B

/

7M0557-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-162A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

5 of 5

PARTS:

2

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P1

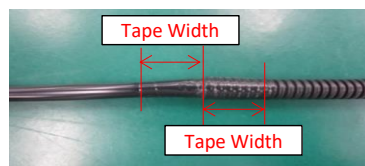
Taping 2
COT to Vinyl tube

NO GAP between COT and Vinyl



Start of taping

1. Hold the corrugated tube using left hand then start taping using right hand.
Note: Refer to WI-PRO-ASY-001 for taping procedure.



Tape Width

Tape Width

2. After taping, check the taping condition.

MEASURING TAPE



*Note:
Please use calibrated/verified
measuring tape when getting the
measurement.*

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. 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