

	WORK INSTRUCTION					Effectivity Date:		May 13, 2022	
	Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Model Code/Product Number: 749W / 7H0335W7020D			Customer: NBS		Document No.:		WI-ENG-PDE-488B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		1	Page No.: 1 of 5

PARTS:	1. Assy parts; Black corrugated tube $\phi 5$ L=136 \pm 3mm (no slit); Clamp 82711-52090 (W); Black tape					JIG	1. Terminal cover jig 2. Clamp Assembly Jig		
---------------	--	--	--	--	--	-----	--	--	--

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS																				
1	P2 Table Lay-out		<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Housekeeping</p> <ol style="list-style-type: none"> Maintain and always practice 5's. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<ol style="list-style-type: none"> No Missing parts/tools. No excess parts/tools 																				
<div style="display: flex; justify-content: space-between;"> <div> <p>Revision History</p> <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td>05/13/22</td> <td>1</td> <td>Change from Pre-Launch to Masspro. Additional Table Lay-out.</td> <td>K. Doria</td> <td>J. Loterte</td> <td>C. Villanueva</td> <td>A. Arañes</td> </tr> <tr> <td>04/25/22</td> <td>0</td> <td>Initial Issue.</td> <td>K. Doria</td> <td>J. Loterte</td> <td>C. Villanueva</td> <td>A. Arañes</td> </tr> <tr> <td>Eff. Date</td> <td>Rev. No</td> <td>Details of Change</td> <td>Revised</td> <td>Reviewed</td> <td>Approved</td> <td>Noted</td> </tr> </table> </div> <div> <p>Prepared by: <i>K. Doria</i></p> <p>Reviewed by: <i>J. Loterte</i></p> <p>Approved by: <i>C. Villanueva</i></p> <p>Noted by: <i>A. Arañes</i></p> <p>Est. Date: April 25, 2022</p> </div> </div>					05/13/22	1	Change from Pre-Launch to Masspro. Additional Table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes	04/25/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes	Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved
05/13/22	1	Change from Pre-Launch to Masspro. Additional Table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes																		
04/25/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes																		
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted																		

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 13, 2022

Process Name/Title:

Model Code/Part Number: 749W / 7H0335W7020D

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-488B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

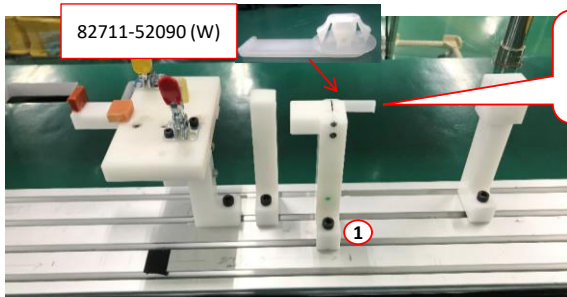
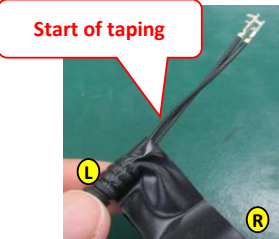
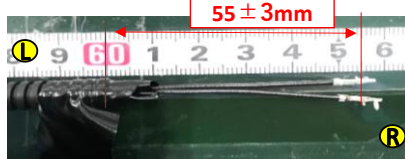


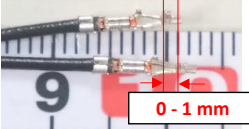
PARTS:

1. Assy parts
2. Black corrugated tube $\phi 5$ L=136 \pm 3mm (no slit)

3. Clamp 82711-52090 (W)
4. Black tape

JIG

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp setting	 <p>82711-52090 (W)</p> <p>Note: No need pre-tape on clamp.</p> <p>1. Get 1pc. of clamp 82711-52090 (W) using right hand then set to clamp location 1 using both hands.</p>	n/a	<p>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <ol style="list-style-type: none">1. No wrong use of parts2. No damaged clamp3. No wrong clamp position
3	Taping 1 Black corrugated tube $\phi 5$ L=136 \pm 3mm (no slit) to wire near terminal	 <p>Start of taping</p> <p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p>  <p>55 \pm 3mm</p> <p>2. Measure from end of COT up to terminal pointed tip 55\pm3mm then continue the taping process using both hands.</p>  <p>tape width</p> <p>35 \pm 3mm</p> <p>3. After taping, check the measurement, terminal appearance and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Wire alignment tolerance</p>  <p>0 - 1 mm</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 13, 2022

Model Code/Part Number: 749W / 7H0335W7020D

Customer:

NBS

Document No.:

WI-ENG-PDE-488B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

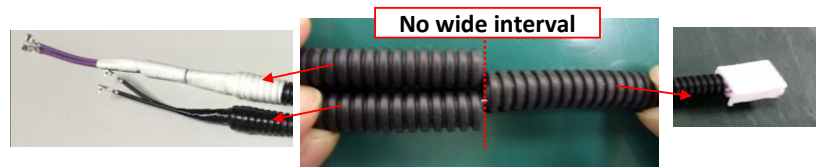
TOOLS/PPE

QUALITY POINTERS

4

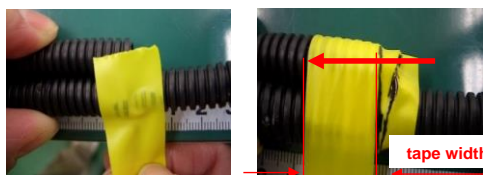
P2

Y-Taping

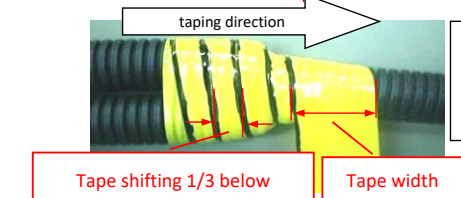


1. Fix the corrugated tube.

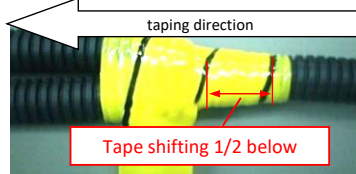
Note: Do not exert excessive force during pulling & winding of tape



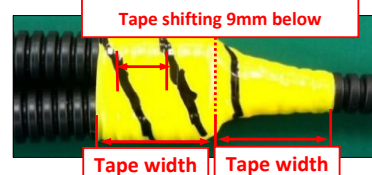
2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side (must be tape width)



3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



4. Wind the tape backward 1/2 shifting.



5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

MEASURING TAPE

NOTE: USED **YELLOW TAPE** FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE **BLACK TAPE**.

Note:

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 use of tape
6. No wrong dimension



Y- Taping Orientation

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



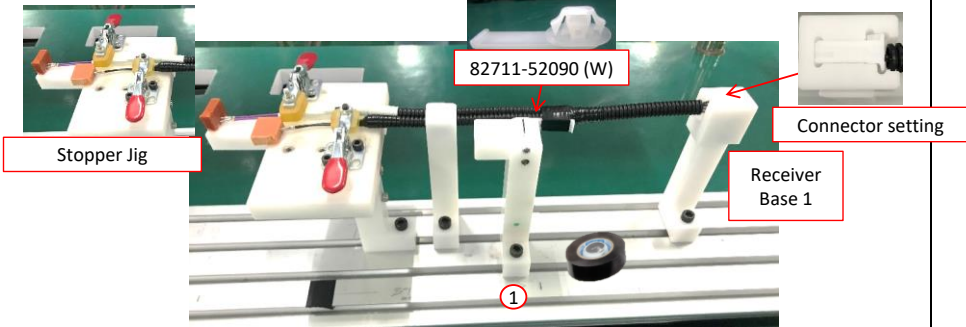
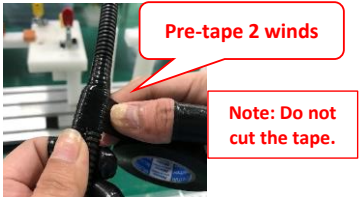
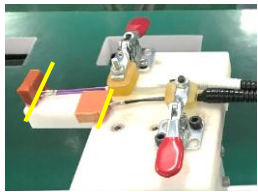
WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	May 13, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-488B		
Revision No.:	1	Page No.:	4 of 5

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

Model Code/Part Number: **749W / 7H0335W7020D** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	<div><p>1. Get the assy part using left hand and black tape using right hand. Make Pre-tape 2 winds on Y-Taping location. <i>Note: Please refer to below illustration for your reference.</i></p><p>2. Put the assy parts to jig using both hands. First, put the connector into receiver base and lock. Second, set the assy part to clamp receiver base and the 2 COT to COT guide. Last, put the terminal into stopper jig then pull down the toggle clamp. If encountered abnormality, STOP the process, CALL the attention of leaders and WAIT for instruction. <i>Note: Please refer to above illustration for correct setting.</i></p><p>3. Hold the clamp on location 1 using left hand and start taping using right hand. Make 3 winds and cut the tape.</p><p>4. Conduct POINT CHECKING using right hand before removal from jig.</p></div>		n/a	<div><p><i>Make sure no clearance between terminal and stopper jig</i></p><p>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. No gap between terminal and stopper</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**

Effectivity Date:

May 13, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: **749W / 7H0335W7020D**

Customer:

NBS

Document No.:

WI-ENG-PDE-488B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5

PARTS:

1. Assy parts

JIG

n/a

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

6

Visual/By Two's Inspection

1. Check the connector lock

2. Check the taping condition, clamp attachment and alignment.

4. Check the terminal appearance, make sure no deformed terminal.

5. Compare to Master Sample
Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy

MASTER SAMPLE

7

Measurement

MEASURING TAPE

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

145 ± 3mm

39 ± 5mm

195 ± 3mm

155 ± 3mm

0~5mm

NOTE: FOR HATSUMONO AND OWARIMONO

1. 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