Table Lay-out  Table											Effect	tivity Date:			April 26, 202	23
Model CodesPan Number: 373D																
ARTS: 1. Assy parts: Black SV tube (Vinyl) Ø5 L=108±3mm; Black tape; White tape (10mm)  NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS  Table Lay-out  Safety Instruction Be size to wear required personal profective equipment during operation (10%s, ringer of the overlapes by profitted 5's. 2. Personal things on the workplace by prohibited. (keep it in your focker.)  Alter Level For any trouble, inform the Assembly Assistant to the separation of the days to the form with all the profit and the promotion of the days to the form of the form			Model Code/Part Number:	373D	1	7N0174-7020A	Customer:	TRJ			Docu	ment No.:			WI-ENG-PDE-6	558B
Table Lay-out    Page   Process Name   Work Procedure   Process			Purpose:	☐ PRO	OTOTYPE	: [	PRE-LAUNCH	MASSE	PRO		Revis	sion No.:		1	Page No.:	1 of 8
Table Lay-out    Page   Process Name   Work Procedure   Process		1									1		ı			
Table Lay-out  Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger COS, etc.)  Housekeeping I. Mointain and always present light on the configuration of the configuration of the protection of the protection of the layout foctor.  Revision History  Revision History  Revision History  Revision History  Revision History  Proposed by Revision of the layout footer.  Approved by Approved by Revision of the layout Modified the assembly (a) Change of Yigang of Control of the layout footer.  Change document purpose from proteurch to massing parts/hools  Revision History  Revision History  Proposed by Revision do the layout Modified the assembly (a) Change of Yigang of Yig	PARTS:	1. Ass	y parts: Black SV tube (Vinyl) Ø5	L=108±3mm;	Black ta	ape; White tape (10mm)						JIG:	1. As:	sembly	/ jig	
1 P2 Table Lay-out    P2   Table Lay-out   P3   P4   P4   P4   P4   P5   P5   P5   P5	NO.		PROCESS NAME			WORK PR	OCEDURE/ ILLU	STRATION				TOOLS/PPE		Q	UALITY POIN	NTERS
Change document purpose from prelaunch to masspro. Inclusion of table layout. Modified the assembly jig. Change of Y-taping measuring (COT and vinyl) from tape width to range (20-22mm) to meet the required dimension of end tape up to terminal pointed tip.  D.Castillo J. Loterte C. Villanueva A. Arañes	1		T		After A	Sac and Sac an		Black SV tube (Vii Ø5 L=108±3mn	Continuit  Continuit  White tape (10m with slit)		Be:  For the left series of the	sure to wear requipersonal protective equipment during eration (gloves, fin, cots, etc.)  Housekeeping Maintain and alwa practice 5's. Personal things on orkplace is prohibiteep it in your locke  Alert level r any trouble, inforce Assembly Assista Supervisor or Line eader for immediat corrective action.	red leger lays 1. No ed. 2. No er. leger lant	exces	s parts/tools	
1 measuring (COT and vinyl) from tape width to range (20-22mm) to meet the required dimension of end tape up to terminal pointed tip.  D.Castillo J. Loterte C. Villanueva A. Arañes D. Castillo J. Loterte C. Villan		1				Kevision History			1	1		Prepared by	Reviewed	by	Approved by	Noted by
D. Oddillo   C. Edicito   C. Villandova   A. Mandova   C. Villandova   A. Madrico		measur pointed	ring (COT and vinyl) from tape width tip.					D.Castillo					Q.	J	of fort House	
The sample with the sample wi			sue	Dot-:	ilo of Ch-	nnan						_			C. Villanueva	/ A. Arañes
	ii. Dale Rev. No	O L		Detai	ils of Cha	ange		Revised	Reviewed	Approved	Noted	Est. Date:	March 24, 20	23		

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				V	WORK INSTRUCTI	ON			Effectivity Date:			April	l 26, 20	23	
		Process Name/Title:			TAPING ASS	EMBLY P	ROCESS		Validity date			-	n/a		
		Model Code/Part Number:	373D	/ 7	7N0174-7020A	Customer:	TF	<b>3</b> J	Document No.:			WI-ENG	3-PDE-	658B	
		Purpose:	☐ PF	ROTOTYPE		PRE-LAUNCH		MASSPRO	Revision No.:		1	Page No	o.:	2 of 8	
									ı						
PARTS:	1. Assy 2. Blac	parts k tape				3. Black SV	tube (Vinyl) Ø5 L	=108±3mm		JIG	n/a				
NO.		PROCESS NAME			WORK PROCE	OURE/ ILLU	ISTRATION		TOOLS/	PPE	C	QUALITY	/ POI	NTERS	
2		Wire insertion to Black SV tube (Vinyl) Ø5 L=108±3mm	L			L=	Get the <mark>Black SV tu</mark> 108±3mm using rig B wire using left ha	tht hand then insert the	n/a		1. No w	rong use o	of parts		
3	<u>/</u> P2	Y-taping		the COT angeen.  Pre		e no gap in	2. Measureme (Vinyl) up to te 40±3mm.	ant from end of SV tube erminal tip. Must be  20~22mm  R	MEASURING	G TAPE	1. Use visuali actual 2. Plea measu measu 1. No fli 2. No pri 3. No lo 4. No m 5. No w	tant remir YELLOW 1 ization of s I should be use use calli ring tape w rement. ip-out tape eel-off tape oose tape nissing tap rrong dime	TAPE for shifting the BLACK of	or easy g lines, but K TAPE. (verified tting the	ıt

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			WORK IN	ISTRUCTION		Effectivity Date:	April 26, 2023
		Process Name/Title:	TAPI	ING ASSEMBLY PROCES	S	Validity date	n/a
		Model Code/Part Number:	373D / 7N0174-	<b>-7020A</b> Customer:	TRJ	Document No.:	WI-ENG-PDE-658B
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1 Page No.: 3 of 8
PARTS:	1. Assy 2. Black					JIG	n/a
NO.	l	PROCESS NAME	WORK	( PROCEDURE/ ILLUSTRATIO	ON	TOOLS/PPE	QUALITY POINTERS
3	P2	Y-taping (Continuation)	1/3 shifting  tape width  6. Make 1/3 shifting to the right side until tape width on SV tube (Vinyl).  1/2 shifting  R	ri	5. Confirm measurement from end of tape up to terminal pointed tip 170±3mm using both hands then continue the taping process.  1/2 shifting  20~22mm  R  width then wind the tape 2x.  Make 1/2 shifting to the ght until tape width on SV ube (Vinyl), wind the tape 2x nen cut the tape.  8. After taping, check the measurement from SV tube (Vinyl) up to terminal pointed 40±3mm and taping condition.	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 1	Important reminders/Note/s:  1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.  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 6. No wrong use of tape

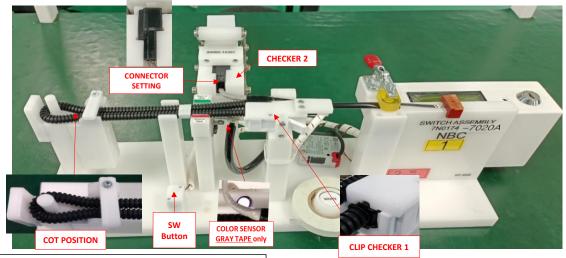
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					WORK INSTRUCTION	ON		Effectivity Date:			April 26	, 2023
		Process Name/Title:			TAPING ASS	EMBLY PRO	CESS	Validity date			1	
		Model Code/Part Number:	373D	1	7N0174-7020A	Customer:	TRJ	Document No.:			WI-ENG-PI	DE-658B
		Purpose:	☐ PF	ROTOTYP	E $\square$	PRE-LAUNCH	MASSPRO	Revision No.:		1	Page No.:	4 of 8
PARTS:	,	parts e tape (10mm)							JIG	1. Asse	embly jig	
NO.		PROCESS NAME			WORK PROCED	OURE/ ILLUST	RATION	TOOLS	PPE	C	QUALITY P	OINTERS



Important reminders/Note/s:

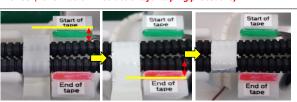
1. Make sure no gap between stopper and terminals

- 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

1. Get the assy part and then put into jig. (See above illustration). First, set the connector 6098-6663 (B) to Clip Checker 1 then lock. Second, set the connector 6098-6663 (B) to Checker 2 then oull the checker fixture for continuity checking. Next, set the B-B wires together within the stopper jig and then press by toggle clamp. Color sensor light will bee/buzz if sensor detects Gray tape. Last set the Y-taping in hook.

2. Check if all LED light for POWER ON, COLOR SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.

3. Get the WHITE NITTO TAPE 2107TVH (with slit) and begin taping using both hands. Make 1.5 windings of tape then cut using both hands. (Follow below instructions for taping procedure)



windings using both hands then cut within RED MARK.

4. Start of tape must be within the GREEN MARK. Wind the tape 1.5

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P2

Assembly

				WOF	RK INSTRUCTI	ON		Effectivity	Date:		April 26,	2023
	Process Na	ame/Title:		,	TAPING ASS	<b>EMBLY PRO</b>	CESS	Validity d	ite		n/a	
	Model Cod	e/Part Number: 3	373D	/ 7N0	174-7020A	Customer:	TRJ	Documen	No.:		WI-ENG-PD	E-658B
	Purpose:		☐ PR	ОТОТҮРЕ		PRE-LAUNCH	MASSPRO	Revision	lo.:	1	Page No.:	5 of 8
								•	ı			
PARTS:	1. Assy parts								JIG	1. Asse	embly jig	
NO.	PROCES	SNAME		٧	ORK PROCEI	OURE/ ILLUSTF	RATION	ТО	DLS/PPE	C	QUALITY PO	DINTERS
4	1 D')	ssembly ntinuation)		OT POSITION	6. Conduct POINT First, unlock the Clamp. Third, pus	CHECKING before re	CLIP CHECKER 1  The heard if the result is GOOD  moving the harness from jig. assy. Second, remove the toggethen remove the connector n remove the connector foogs.	le		1. No fli 2. No po 3. No lo 4. No m 5. No w 6. No w		p between als  n pe

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					WORK INSTR	UCTION				Effe	ectivity Date:			April 26	, 2023
		Process Name/Title:			TAPING	<b>ASSEMI</b>	<b>BLY PF</b>	ROCESS		Val	idity date			n/a	1
		Model Code/Part Number:	373D	/	7N0174-702	<b>OA</b> Cust	stomer:	TF	٤J	Doo	cument No.:			WI-ENG-PI	DE-658B
		Purpose:	☐ F	ROTOTYPE	E	☐ PRE-	-LAUNCH		MASSPRO	Rev	vision No.:		1	Page No.:	6 of 8
<u> </u>	1														
PARTS:	1. Assy	parts										JIG	n/a		
NO.		PROCESS NAME			WORK PR	OCEDURI	E/ ILLUS	TRATION			TOOLS/	PPE	Q	UALITY P	OINTERS
5	P2	Visual/By two's inspection	Assemble parts	annun (	con	neck the terminector lock, in any condition.	nsertion and		E Cheshate		3. Check the taping co	the Y-ndition.		ip checking o	G SAMPLE

5. Check the **presence** 

of spot tape (White

10mm with slit)

appearance. Must

be no deformed

terminal.

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1. Conduct alignment of

parts) using both hands.

harness (Engineering sample vs. assembled

				WORK INSTR	RUCTION		Et	ffectivity Date:			April 26	, 2023
		Process Name/Title:			ASSEMBLY PR	OCESS	V	alidity date			n/a	a
		Model Code/Part Number:	373D /	7N0174-702	20A Customer:	TRJ	De	ocument No.:			WI-ENG-P	DE-658B
		Purpose:	□ ргото	ГҮРЕ	☐ PRE-LAUNCH		MASSPRO R	evision No.:		1	Page No.:	7 of 8
PARTS:	1. Assy	parts							JIG	n/a		
NO.		PROCESS NAME		WORK PR	OCEDURE/ ILLUS	TRATION		TOOLS/I	PPE	Q	UALITY P	OINTERS
6	P2	Measurement			65±3i 0~3 0~5mm	imm		EASURING TA	789	1. FOI OWAI 2. Plet measu measu	rtant reminder HATSUMOI RIMONO ase use calibrating tape who urement.	NO AND  ated/verified  en getting the
					45±3mr	Y	-Taping to Spot tape					

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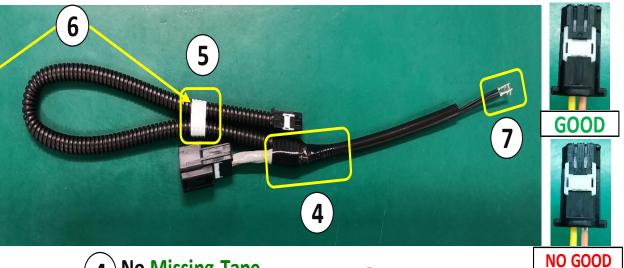
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	Draces Name/Title		WORK INSTR	RUCTION ASSEMBLY PROC	YESS .	Effectivity Date: Validity date		<u> </u>	April 26, 2	023
NB	Process Name/Title:  Model Code/Part Number:	373D	/ 7N0174-702		TRJ  MASSPRO	Document No.:  Revision No.:			<b>E-658B</b> 8 of 8	
PARTS:	Purpose:  1. Assy parts			I THE BONGH	— WASPING	TOVISION NO.	JIG	n/a	Page No.:	3 01 0
	•		C	QUALITY CHECKPO	DINTS					
			7N	0174-70	)20A					



- **2** No Wrong Insert Connector (2 connector)
  - **3** No Terminal Backing Out



- (4) No Missing Tape (for y-taping)
- No Wrong Used of Tape (Spot Taping white tape)
- ) Spot Taping must be 1.5 windings
- No Deformed Terminal

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1) No Unlock/Halflock