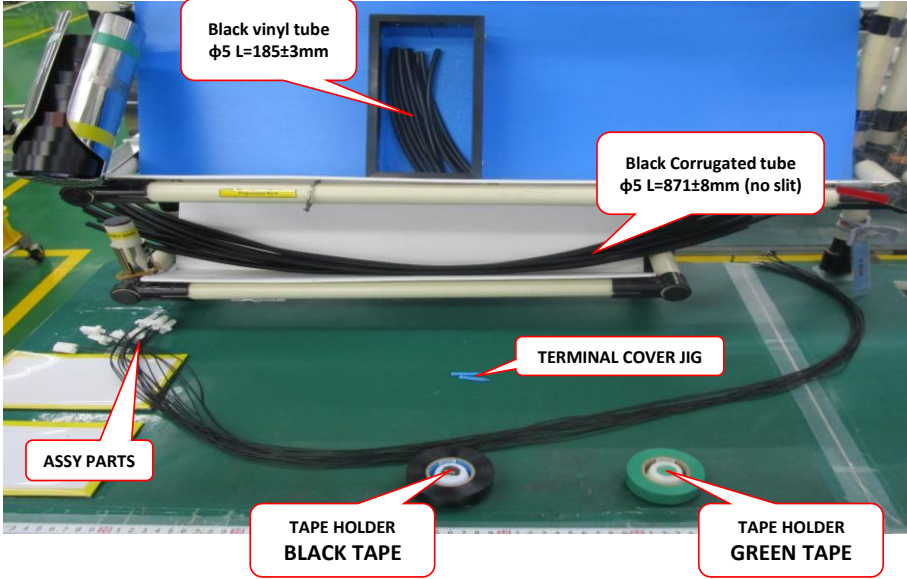
	<b>WORK INSTRUCTION</b>				Effectivity Date:		January 3, 2022	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model Code/Part Number: <b>840B / 2 7N0121-7020B</b>		Customer: <b>TRJ</b>		Document No.:		<b>WI-ENG-PDE-319A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 5

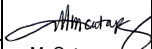



  

<b>PARTS:</b> 1. All parts: Assy parts: Connector 6098-3810 (W); AVSSf 0.3 B L=1175±3mm; Black Corrugated tube $\phi 5$ L=871±8mm (no slit); Black vinyl tube $\phi 5$ L=185±3mm; Black tape [1pc.]; Green tape [1pc.]			<b>JIG:</b> 1. Terminal cover jig	
--	--	--	-----------------------------------	--

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	<b>Table Lay-out</b> 	<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <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> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<div> <b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b> </div> <div>           1. No missing parts/tools            2. No excess parts/tools         </div>

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
01/03/22	2	Change part number from 7N0121-7020A to 7N0121-7020B due to change orientation of clamp. Additional quantity of band clamp 82711-12A60 (W) from n=4pcs. to n=5pcs; Reduced quantity of clamp 82711-12A80 (W) from n=4pcs. to n=3pcs Refer to WI-ENG-PDE-319B. Additional checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance).				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
09/10/21	1	Revise due to transfer of insertion process to Kitting process (Refer to WI-ENG-PDE-333); Improve process illustration; Interchange taping process of COT to vinyl; COT to wire near terminal. Change from pre-launch to masspro.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
08/09/21	0	Initial issue				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 09, 2021		

<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.	<b>NBC (Philippines)</b> <b>MASTER COPY</b>	DCC Stamp
--	--	-----------



# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

January 3, 2022

Model Code/Part Number:

840B

/ 2

7N0121-7020B

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-319A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

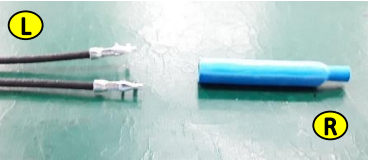




☒ MASSPRO

Revision No.:

2

Page No.:

2 of 5

PARTS:	1. Assy parts 2. Black corrugated tube $\phi 5$ L= 871 $\pm$ 8mm (no slit) 3. Black vinyl tube $\phi 5$ L=185 $\pm$ 3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1  Wire insertion to Black corrugated tube $\phi 5$ L=871 $\pm$ 8mm (no slit)	<div data-bbox="607 448 974 608">  <p>1. Get the terminal cover jig using right hand then insert to <b>B/B wires</b>.</p> </div> <div data-bbox="1025 448 1509 724">  <p>2. Get the corrugated tube (no slit) <math>\phi 5</math> L=871<math>\pm</math>8mm using right hand and insert to <b>B/B wires</b>.</p> </div> <div data-bbox="680 761 1043 920">  <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>		<div data-bbox="1559 587 1767 616">           TERMINAL COVER JIG         </div> 	1. No wrong use of parts 2. No deformed terminal
3		<div data-bbox="611 1034 1099 1246">  </div> <div data-bbox="1106 1075 1514 1198"> <p>1. Get the Black Vinyl tube <math>\phi 5</math> L=185<math>\pm</math>3mm using right hand then insert the <b>B/B wires</b>.</p> </div>		n/a	

**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

Model Code/Part Number:

840B

/ 2 7N0121-7020B

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 3, 2022

Validity Date:

n/a

Document No.:

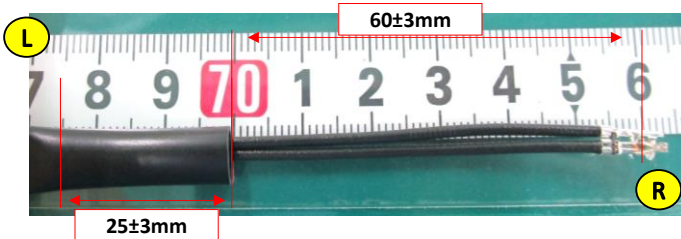
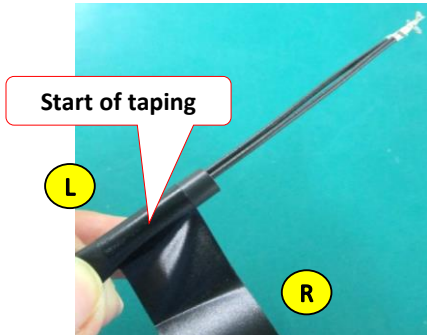
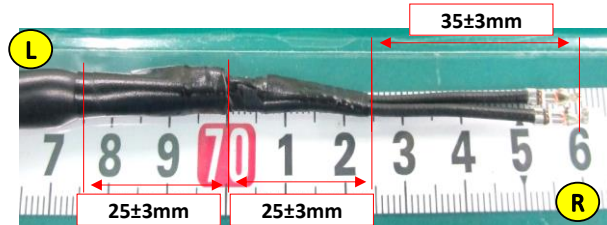

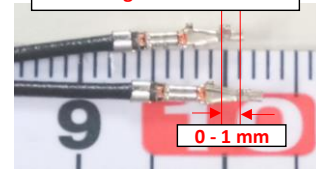
WI-ENG-PDE-319A

Revision No.:

2

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	P1 Taping 1 Black vinyl tube to wire near terminal	<div></div> <div><p>1. Hold the vinyl tube using left hand, measure from end of vinyl tube up to terminal tip <b>60±3mm</b>.</p></div> <div></div> <div><p>2. Hold the assy parts using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</p></div> <div></div> <div><p>3. After taping, check the measurement, taping condition and wire alignment.</p></div>	<div></div> <p><b>MEASURING TAPE</b></p>	<div></div> <p><b>Wire alignment tolerance</b></p> <p>0 - 1 mm</p> <ul style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ul> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</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:

January 3, 2022

Model Code/Part Number:

840B

/ 2

7N0121-7020B

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

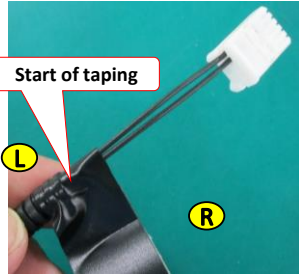
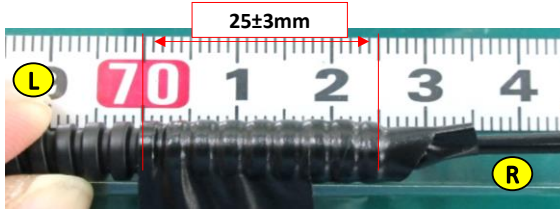
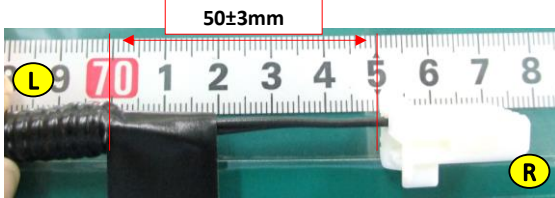
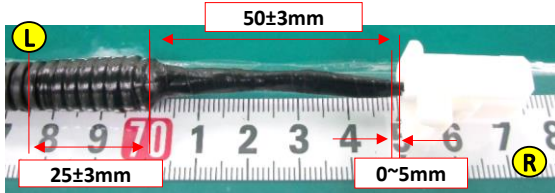

☒ MASSPRO

Revision No.:

2

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	<p>Taping 2 Black COT to wire near connector</p> <div><p>Start of taping</p><p>1. Hold the assy parts, get the <b>Black tape</b> using right hand then start taping process using both hands.</p></div> <div><p>25±3mm</p><p>2. Confirm measurement of <b>25±3mm</b> from end of tape up to end of COT then continue the taping process using both hands.</p></div> <div><p>50±3mm</p><p>3. Measure from end of COT up to edge of connector <b>50±3mm</b> then continue the taping process using both hands.</p></div> <div><p>50±3mm</p><p>25±3mm</p><p>0~5mm</p><p>4. After taping, check the measurement and taping condition.</p></div>			<div><b>MEASURING TAPE</b></div> 	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol>

**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:

January 3, 2022

Model Code/Part Number:

840B

/ 2

7N0121-7020B

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

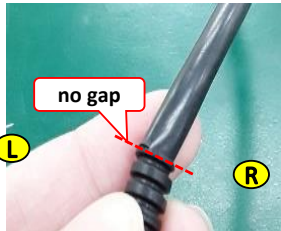
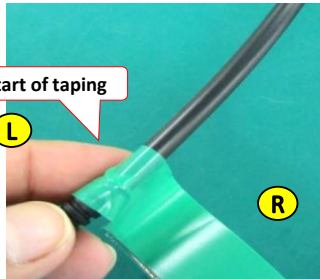
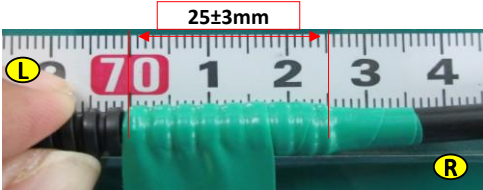
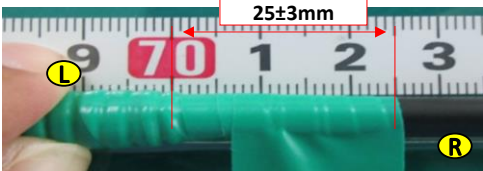
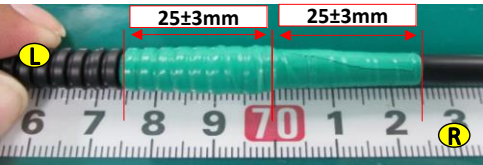

☒ MASSPRO

Revision No.:

2

Page No.:

5 of 5

PARTS:		1. Assy parts 2. Green tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><div><p>1. Fix the COT and vinyl tube using both hands.</p></div><div><p>2. Hold the assy parts, get the <b>Green tape</b> using right hand then start taping process using both hands.</p></div></div> <div><div><p>3. Confirm measurement of <b>25±3mm</b> from end of tape up to end of COT then continue the taping process using both hands.</p></div><div><p>4. Confirm measurement of <b>25±3mm</b> from end of COT up to end of tape using both hands.</p></div><div><p>5. After taping, check the measurement and taping condition.</p></div></div>		<div><p><b>MEASURING TAPE</b></p></div>	<p><b>NOTE: USE <u>GREEN TAPE</u> ONLY.</b></p> <p>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</p> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</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