



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Model Code/Part Number 164B / 7M0610-7021

Customer: TRJ

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 16, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-398B

Revision No.:

1

Page No.:

1 of 7

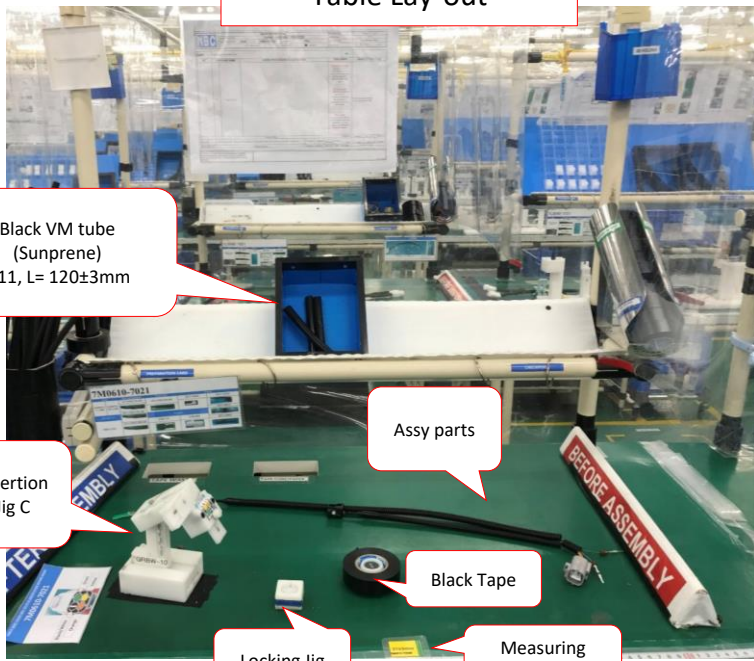
PARTS:



1. All parts: Assy parts; Black VM tube (Sunprene) Ø11, L= 120±3mm; Black tape

JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out 	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping <ol style="list-style-type: none">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.	<ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools3. No wrong positions of parts/tools

Revision History

					Prepared by	Checked by	Approved by	Noted by
02/16/23	1	Work instruction improvement: Update Quality pointers. Change term Black sunprene tube to Black VM tube (Sunprene). Inclusion of Quality checkpoint (Page 7).	D.Castillo	J. Loterte	C. Villanueva	A.Arañes		
02/12/22	0	Initial Issue. PCB from 2 chips (61C619-0002) to 1 chip (7N0994-7060). Wire color from Gray (GR) to Green (G).	K. Doria	J. Loterte	C. Villanueva	A.Arañes		
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	February 12, 2022

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 16, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number **164B / 7M0610-7021**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-398B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7

PARTS:



1. Black VM tube (Sunprene) Ø11, L= 120±3mm
2. Black tape

3. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	 Wire insertion to VM tube (Sunprene) Ø11, L= 120±3mm	<p>1. Get the VM tube (Sunprene) Ø11, L= 120±3mm using right hand then insert the Hotmelted wire (G/BW) using left hand.</p>	n/a	1. No wrong use of parts
3	P2 Taping 1 VM tube (Sunprene) to COT	<p>1. Measure the end of the VM tube (Sunprene) up to the melted wire 31±3mm.</p> <p>2. Hold the corrugated using left hand then start taping using right hand.</p> <p>3. After taping, check the measurement and tape condition.</p>	<p>Measuring Tape</p>	 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure. 1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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 16, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number **164B / 7M0610-7021**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-398B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

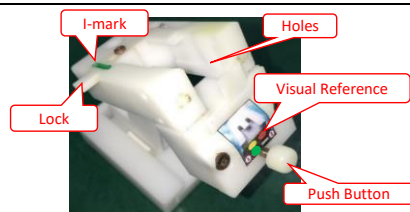
TOOLS/PPE

QUALITY POINTERS

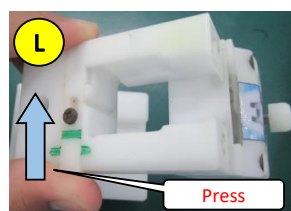
4

P2

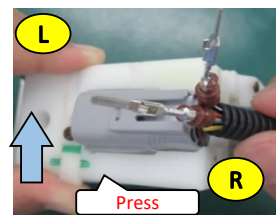
Connector setting to
insertion jig
6188-0066 (GR)



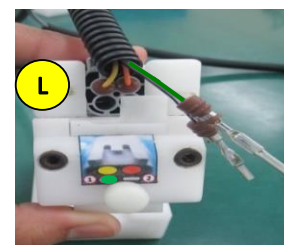
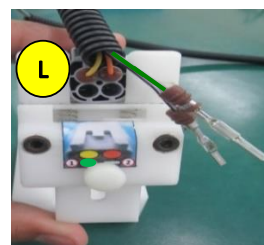
Connector Orientation



1. Press the lock of
insertion jig using
left thumb.



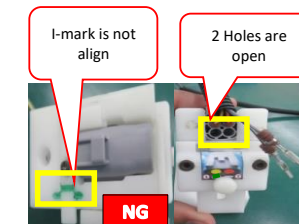
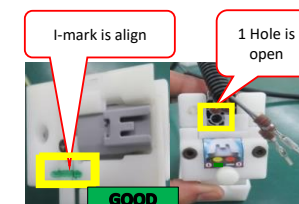
2. Insert the
connector **6188-
0066 (GR)** with
inserted
Yellow/Orange
wire using right
hand.



3. Press the wire guide of insertion jig using left thumb. The slot for **G wire**
will be open.

n/a

Connector Orientation Illustration



1. Use the provided jig per model
2. No wrong facing of connector

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 16, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number **164B / 7M0610-7021**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-398B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

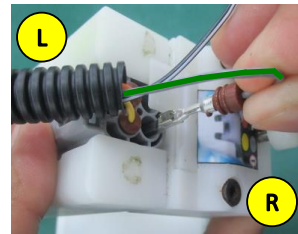
TOOLS/PPE

QUALITY POINTERS

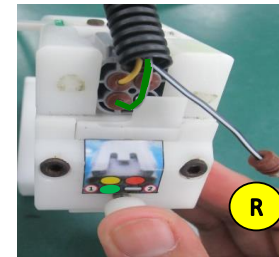
5

P2

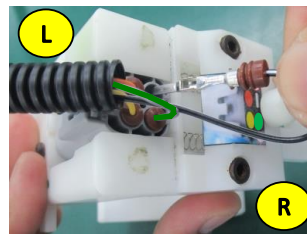
Wire Insertion to
connector
6188-0066
(GR)



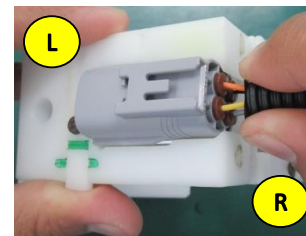
1. Hold the G wire then insert to terminal slot ① using right hand.



2. Press the button using right hand. The slot for B/W wire will be opened.



3. Hold the B/W wire then insert to terminal slot ② using right hand.



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.

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance
2. Please refer to GL-PRO-ASSY-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:

February 16, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number **164B / 7M0610-7021**Customer: **TRJ**

Document No.:

WI-ENG-PDE-398B

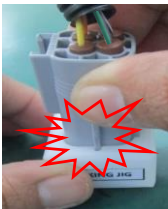




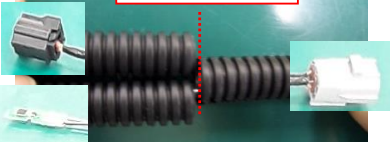
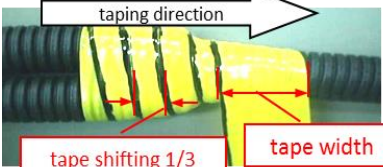

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:		1. Black tape 2. Assy parts		JIG	1. Locking jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Connector lock		<div></div> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Half Lock Condition Full Lock Condition</p></div>		LOCKING JIG 	<div>1</div> <p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model</p> <p>2. No unlock/half-locked connector</p>
7	P2	Y-taping	<div><p>NO GAP</p><p>L R</p><p>1. Fix the corrugated tube .</p></div> <div><p>taping direction</p><p>tape shifting 1/3 below</p><p>tape width</p></div> <div><p>tape width</p><p>Note: Do not exert excessive force during pulling & winding of tape</p><p>2. Start taping at the middle of combined Corrugated tubes , then wind the tape going to 2 corrugated tubes , width must be same with tape (19mm)</p></div> <div><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p></div>		n/a	<div>1</div> <p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1.No flip out tape.</p> <p>2.No tape peeling.</p> <p>3.No loose tape</p> <p>4. No lacking of tape windings</p> <p>5. No wrong use of tape</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:

February 16, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number **164B** / **7M0610-7021**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-398B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

6 of 7

PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

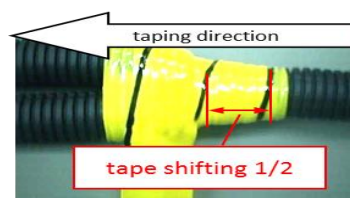
TOOLS/PPE

QUALITY POINTERS

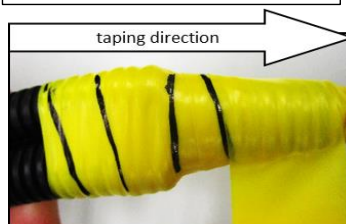
7

P2

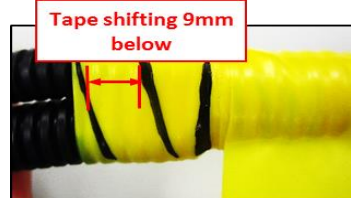
Y-taping
(continuation)



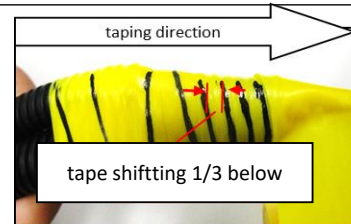
4. Wind the tape backward 1/2 shifting.



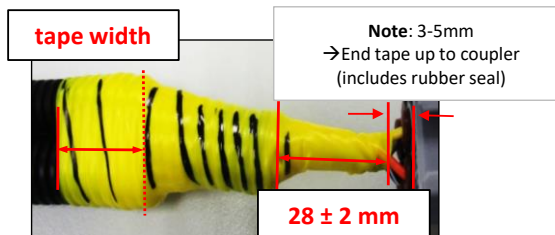
6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.



5. Wind the tape 1/2 shifting going to other side of corrugated tube.



7. Make 1/3 shifting until it reached the wire, make 3 windings to wire then cut.



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 tape peeling.
3. No loose tape
4. No lacking of tape windings
5. No wrong use of tape

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:

February 16, 2023

Model Code/Part Number: **164B / 7M0610-7021**

Customer: **TRJ**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-398B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7

PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS

P2

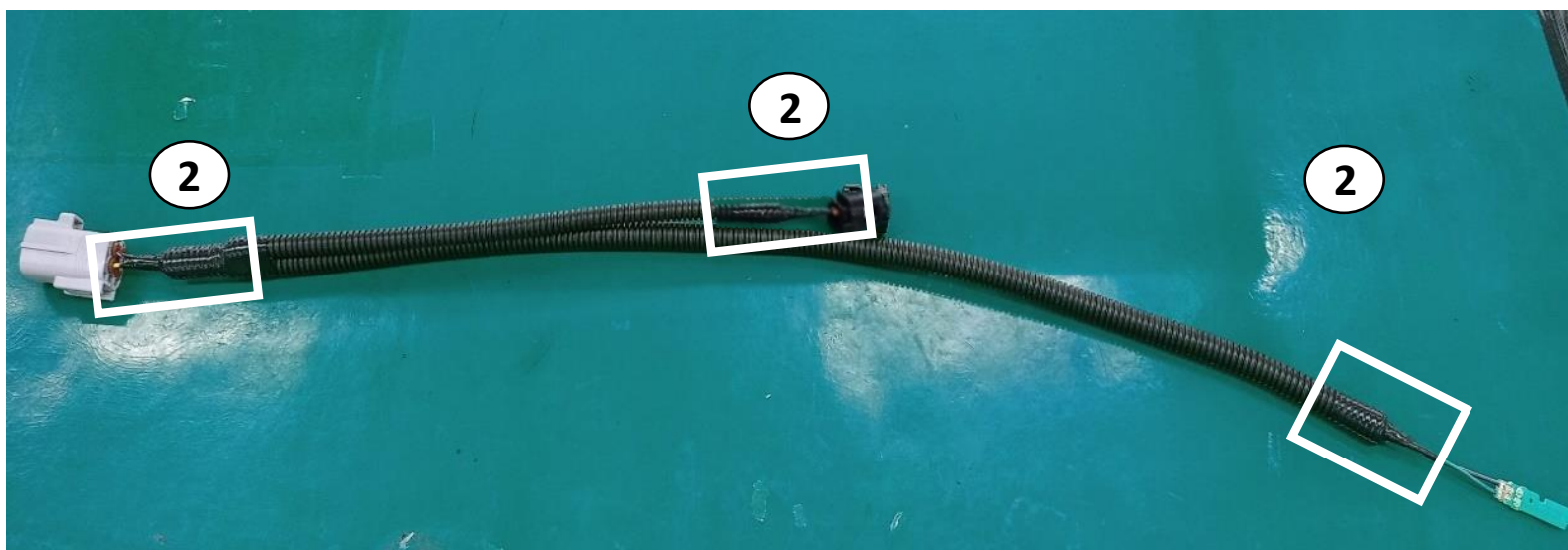
7M0610-7021



NO GOOD



GOOD



1 No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
NO **TBO**

2 No **Missing tape**

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