



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 382D / 7N0175-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 18, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-632A

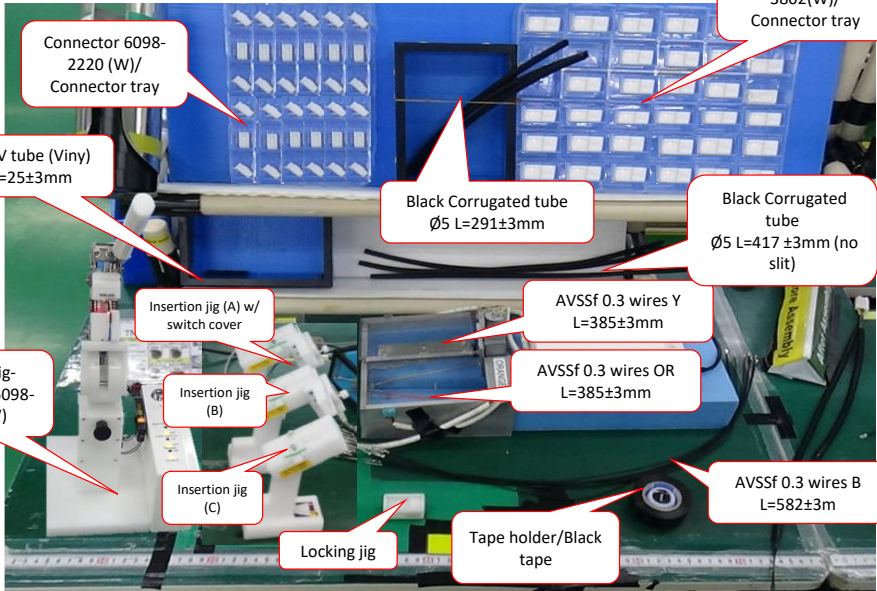
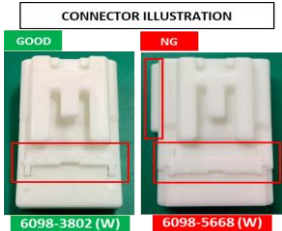
Revision No.:

1

Page No.:

1 of 13

PARTS:	1. AVSSf 0.3 wires Y L=385±3mm; AVSSf 0.3 wires Y L=385±3mm; Black Corrugated tube Ø5 L=291±3mm ; Black Corrugated tube Ø5 L=417 ±3mm (no slit); AVSSf 0.3 wires B L=582±3mm; Black SV tube (Vinyl) Ø5 L=25±3mm; Connector 6098-2220 (W); Connector 6098-3802 (W); Black tape	JIG:	1. Insertion jig with and w/o switch cover 2. Locking jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p>TABLE LAY-OUT</p>  <p>Connector 6098-2220 (W)/ Connector tray</p> <p>Black SV tube (Vinyl) Ø5 L=25±3mm</p> <p>Black Corrugated tube Ø5 L=291±3mm</p> <p>Black Corrugated tube Ø5 L=417 ±3mm (no slit)</p> <p>AVSSf 0.3 wires Y L=385±3mm</p> <p>AVSSf 0.3 wires OR L=385±3mm</p> <p>AVSSf 0.3 wires B L=582±3mm</p> <p>Insertion jig (A) w/ switch cover</p> <p>Insertion jig (B)</p> <p>Insertion jig (C)</p> <p>Locking jig-Connector 6098-2220 (W)</p> <p>Locking jig</p> <p>Tape holder/Black tape</p>	<p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/tools 2. No excess parts/tools.</p> <p>Document reference/s:</p> <p>1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>CONNECTOR ILLUSTRATION</p>  <p>GOOD NG</p> <p>6098-3802 (W) 6098-5668 (W)</p>

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/18/23	1	Changed Purpose from Pre-launch to Masspro. Additional Table lay-out. Improve Work Procedure/ Illustration on 2,3,8,11;Inclusion of Quality Checkpoint on page no.13; Inclusion of Locking process-Connector 6098-2220(W).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
01/31/23	0	Initial issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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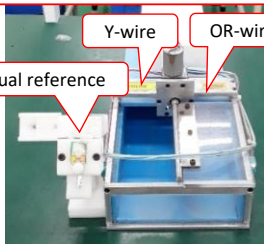
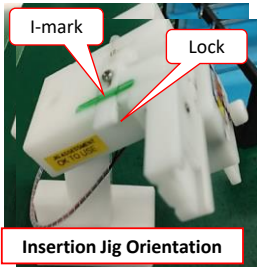
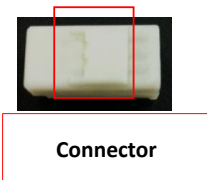
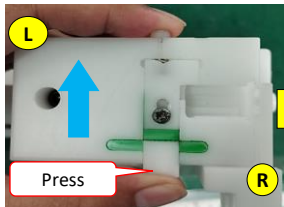
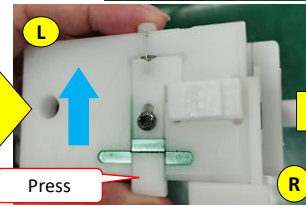
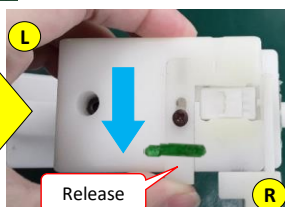
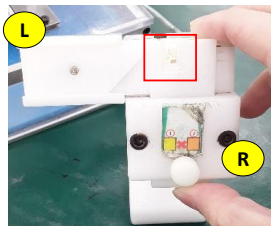


☒ MASSPRO

Revision No.:

1

Page No.:

2 of 13

PARTS:		1. Connector 6098-2220 (W)		JIG	1. Insertion jig with switch cover	
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 6098-2220 (W)	<div><div><div><p>Visual reference</p><p>Y-wire</p><p>OR-wire</p></div><div><p>I-mark</p><p>Lock</p><p>Insertion Jig Orientation</p></div><div><p>Connector</p></div></div><div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div></div><div><div></div><div><p>3. Push the lower guide upward using right thumb. Slot for yellow wire will be open.</p></div></div></div>		n/a	<div><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>1 hole is open</p><p>NG</p></div></div><p>1. Use provided jig per model 2. No wrong orientation of connector</p></div>

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Revision No.:

1

Page No.:

3 of 13

PARTS:		1. AVSSf 0.3 wires Y L=385±3mm 2. AVSSf 0.3 wires Y L=385±3mm	JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	<p>Wire insertion to Connector 6098-2220 (W)</p> <p>VISUAL REFERENCE</p> <p>Wire facing</p> <p>Connector Orientation</p> <p>Yellow wire</p> <p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector slot 1 using right hand. Conduct 2x push-pull after wire insertion.</p> <p>Orange wire</p> <p>3. Get the Orange wire and insert to connector slot 2 using right hand. Conduct 2x push-pull after wire insertion.</p> <p>2. Press the button using right thumb. Slot for Orange wire will be open.</p> <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>	n/a	<p>1. No loose insertion. 2. No wrong insertion 3. One by one insertion. 4. No wrong facing. 5. No wrong deformed terminal.</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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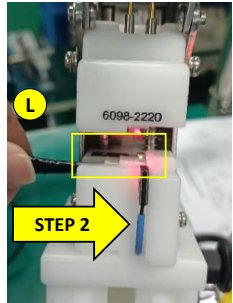
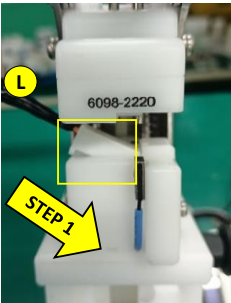
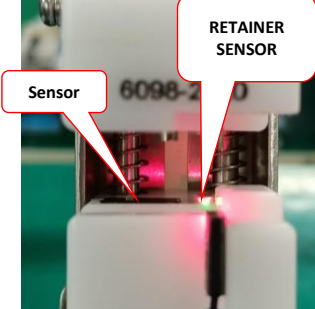
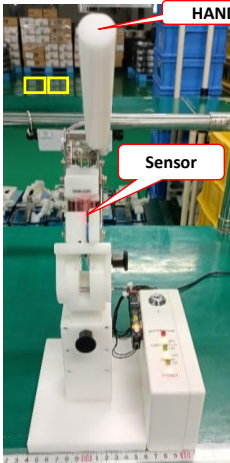
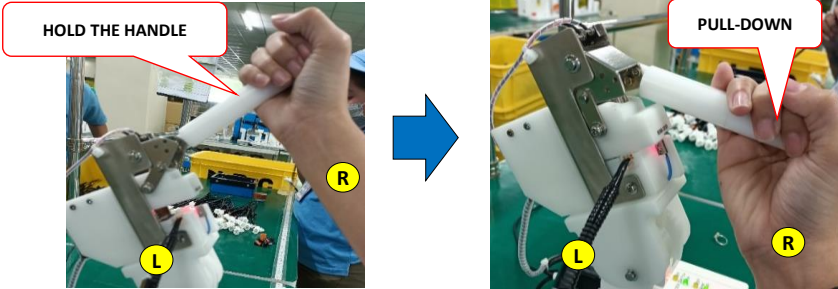
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Revision No.:

1

Page No.:

4 of 13

PARTS:		1. Assy parts		JIG	1. Locking jig Connector 6098-2220 (W)
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P1	Connector Lock		<div><div><div><p>1. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock. NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</p></div><div><div><p>2. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p></div></div></div><div><p>1. Maintain 10mm proper holding of wire to connector 2. Connector must be fully inserted to connector slot. 3. Make sure no offset setting before locking process. 4. No wrong setting of connector. 5. No damaged connector lock 6. No unlocked/ half-locked connector.</p><p>Important reminders/Note/s:</p><p>1. Incomplete locking process will alarm the jig. 2. No retainer in connector cannot proceed. 3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></div></div>	

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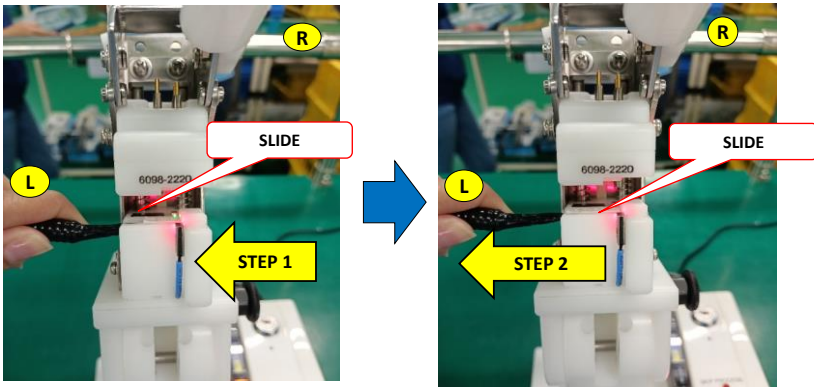

WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 18, 2023		
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Document No.:	WI-ENG-PDE-632A		
Revision No.:	1	Page No.:	5 of 13

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Model Code/Part Number: **382D / 7N0175-7020** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts			JIG	1. Locking jig Connector 6098-2220 (W)
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
4	Connector lock (Continuation)	<p>1. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p>  <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p> 		<p>1. Maintain 10mm proper holding of wire to connector</p> <p>2. Connector must be fully inserted to connector slot.</p> <p>3. Make sure no offset setting before locking process.</p> <p>4. No wrong setting of connector.</p> <p>5. No damaged connector lock</p> <p>6. No unlocked/ half-locked connector.</p> <p>Important reminders/Note/s:</p> <p>1. Incomplete locking process will alarm the jig.</p> <p>2. No retainer in connector cannot proceed.</p> <p>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p>		

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

6 of 13

PARTS:

1. Assy parts
2. Black Corrugated tube Ø5 L=291±3mm

3. Black Tape

JIG

n/a

NO.

PROCESS NAME

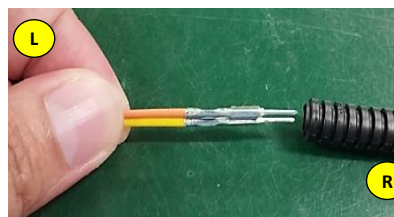
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

Wire insertion to Black Corrugated tube Ø5 L=291±3mm



1. Get the Black Corrugated tube Ø5 L=291±3mm using right hand then insert the Y-OR wires.

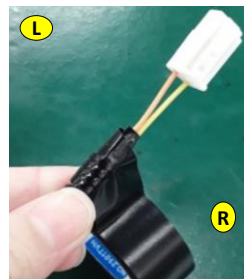
n/a

- 1.No wrong use of parts.
2. No deformed terminals.

6

P1

Taping 1
Black corrugated tube to wire near connector

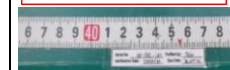


1. hold the assy parts using left hand. Get the black tape using right hand then stat pre-taping.



2. Measure from COT to Connector 25±3mm using both hands and continue the taping process.

MEASURING TAPE



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

Important reminders/Note/s:

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

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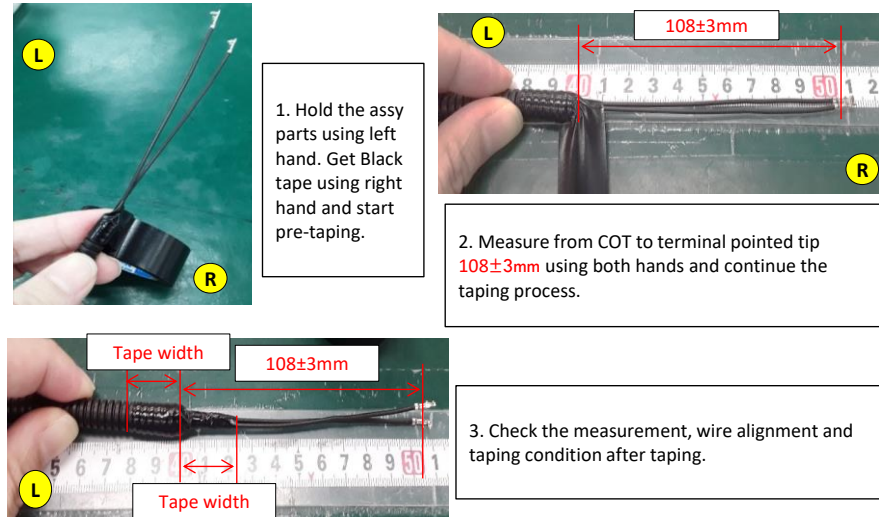

1

Page No.:

7 of 13**PARTS:**

1. Black Corrugated tube Ø5 L=417±3mm (no slit)
2. AVSSf 0.3 wires B L=582±3mm [2pcs]

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Black Corrugated tube Ø5 L=417 ±3mm (no slit)	 <div>1. Get the Black Corrugated tube $\varnothing 5$ L= 417 ±3mm (no slit) using left hand then insert the 2 Black wires by using right hand.</div>	n/a	<ol style="list-style-type: none">1.No wrong use of parts.2. No deformed terminals. <p>Document references:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
8	Taping 2 Black corrugated tube to Wire near terminal	 <div>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</div> <div>2. Measure from COT to terminal pointed tip 108 ± 3mm using both hands and continue the taping process.</div> <div>3. Check the measurement, wire alignment and taping condition after taping.</div>	<div>MEASURING TAPE</div> 	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.

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☐ PRE-LAUNCH

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Revision No.:

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Page No.:

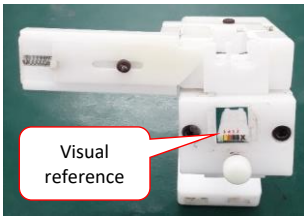
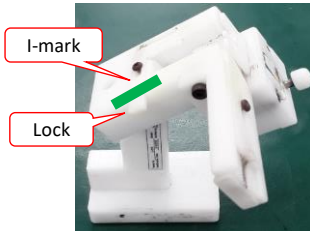

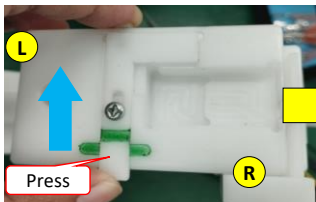
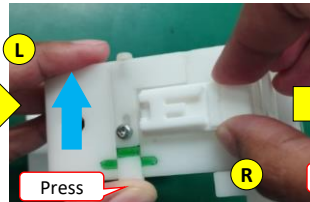
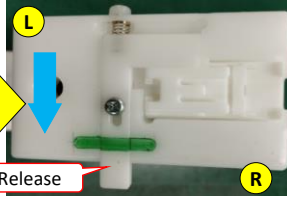






8 of 13

PARTS:

1. Connector 6098-3802 (W)

JIG

1. Insertion jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Connector setting to Insertion jig 6098-3802 (W)	<div><div><div><p>Insertion Jig</p><p>Visual reference</p></div><div><p>I-mark</p><p>Lock</p><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div></div><div><div><p>L</p><p>R</p><p>Press</p><p>1. Press the insertion jig lock using left hand.</p></div><div><p>L</p><p>R</p><p>Press</p><p>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p></div><div><p>L</p><p>R</p><p>Release</p><p>3. Push the guide using left hand The Slot for Yellow wire will be opened.</p></div></div></div>	n/a	<div><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><p>I-mark is align</p></div><div><p>2 holes are open</p></div><div><p>GOOD</p></div></div><div><div><p>I-mark is not align</p></div><div><p>4 holes are open</p></div><div><p>NG</p></div></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p></div></div>

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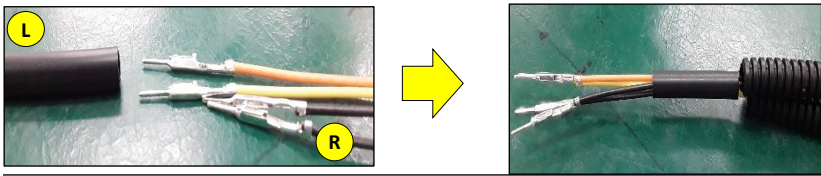
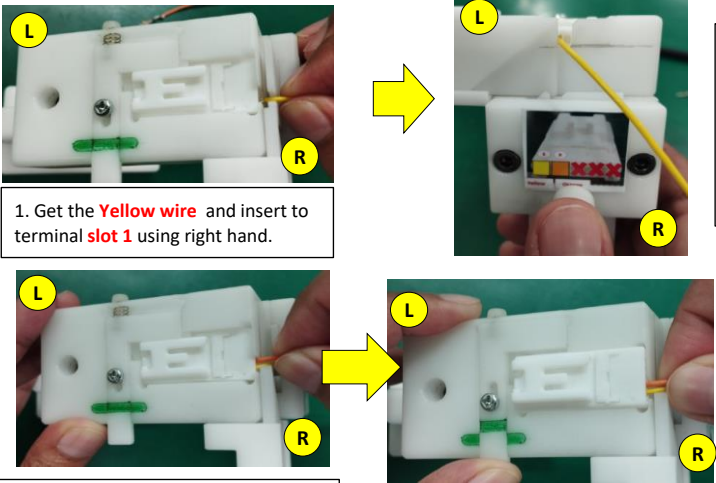
9 of 13

PARTS:

1. Assy parts
2. Black SV tube (Vinyl) Ø5 L=25±3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	Wire insertion to Black SV tube (Vinyl) Ø5 L=25±3mm	 <p>1. Combine the assy parts (Y-OR wires with COT Ø5 L=291±3mm and 2 Black wires with COT Ø5 L=417±3mm) then get the Black SV tube (Vinyl) Ø5 L=25±3mm using left hand and insert the wires using right hand.</p>	n/a	1.No wrong use of parts. 2. No deformed terminals.
11	Wire insertion to Connector 6089-3802 (W)	 <p>1. Get the Yellow wire and insert to terminal slot 1 using right hand.</p> <p>2. After insertion of Yellow wire. Press the button using right thumb. Slot for Orange Wire will be opened.</p> <p>3. Get the Orange wire and insert to terminal slot 2 using right hand.</p> <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>	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. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

10 of 13

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

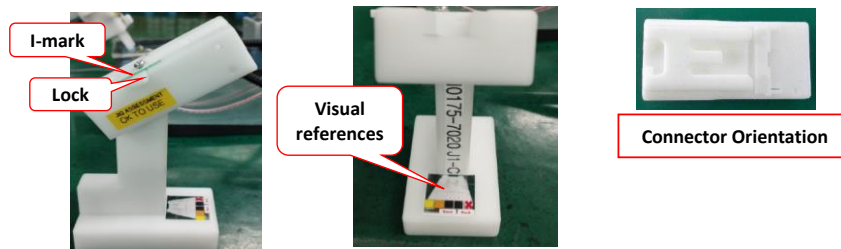
TOOLS/PPE

QUALITY POINTERS

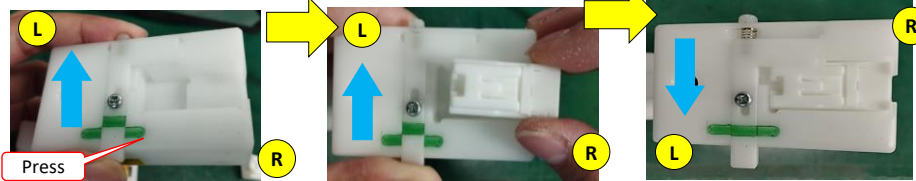
12

P1

Connector setting to
Insertion jig
6098-3802 (W)



Insertion Jig Orientation



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

2. Get the connector 6098-3802 (W) (with inserted Y-OR wire)
using right hand and insert to insertion jig. Release the lock after

n/a

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

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 18, 2023

Process Name/Title:

Model Code/Part Number: 382D / 7N0175-7020

Customer: TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-632A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

11 of 13

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

P1

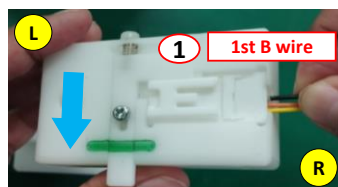
Wire insertion to Connector
6098-3802 (W)



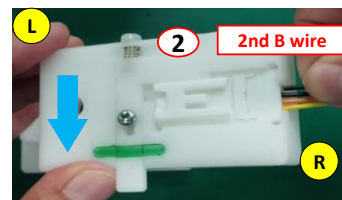
Connector Orientation



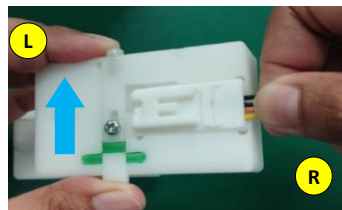
Wire facing



1. Hold the **1st Black wire** and insert to terminal slot 3 using right hand. Conduct **2x push-pull** after insertion.



2. Hold the **2nd Black wire** and insert to terminal slot 3 using right hand. Conduct **2x push-pull** after insertion.



3. 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.
 2. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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Document No.:

WI-ENG-PDE-632A

Revision No.:

1

Page No.:

12 of 13

PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

P1

Connector lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



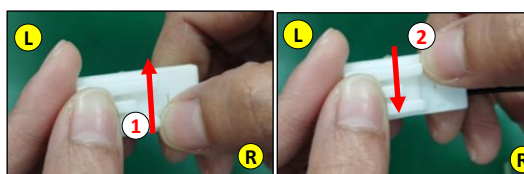
Right thumb-upper
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



Before pressing



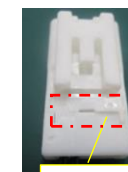
After pressing

GOOD

NG



Full Lock



Half Lock

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

Effectivity Date:

May 18, 2023

Model Code/Part Number:

382D / 7N0175-7020

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Document No.:

WI-ENG-PDE-632A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

13 of 13

PARTS:

n/a

JIG

n/a

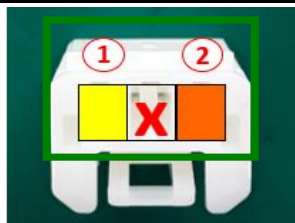
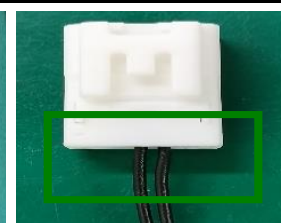
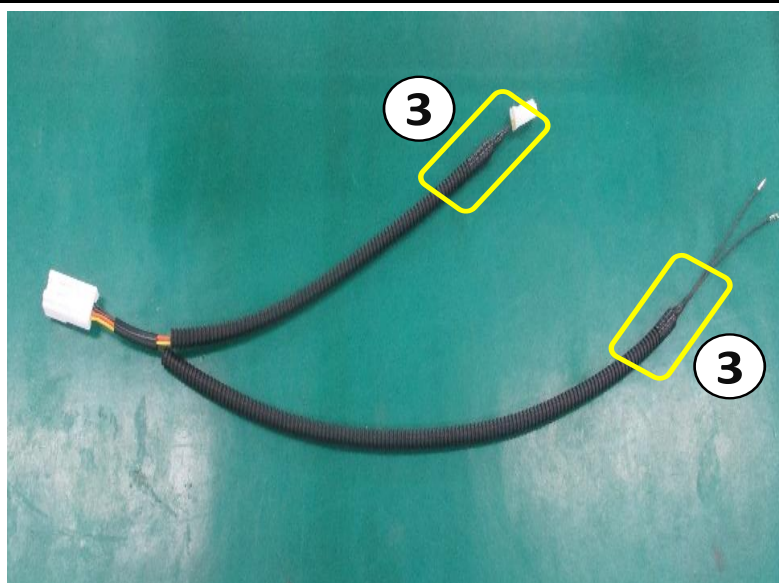
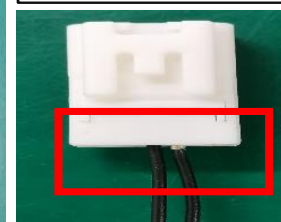
NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

P1**7N0175-7020****GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****NO GOOD****NO GOOD**

1 No **Unlock/Halflock Connector**
(on 2 connector)

2 No **Wrong Insert**
(on 2 connector)

3 No **Missing Tape**

4 No **Terminal Backing Out**

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