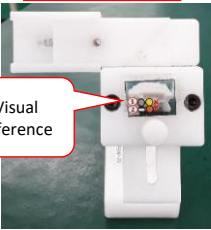


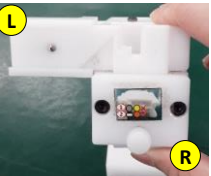

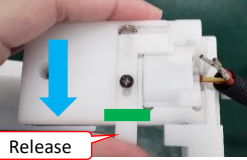
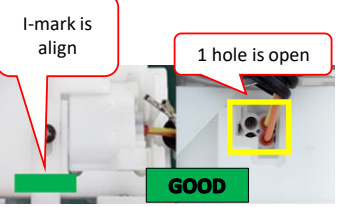

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: June 16, 2021	
	Process Name/Title:				Validity Date: n/a	
	Product Name/Code: 480A / A7045D		Customer: TRQSS		Document No.: WI-ENG-PDE-298B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 4		Page No.: 1 of 4	

PARTS: 1. Assy parts		JIG: 1. Insertion jig	
-----------------------------	--	------------------------------	--

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Connector setting to Insertion jig 6189-1142 (W)	<div>  <p>Visual reference</p>  <p>Insertion Jig Orientation</p>  <p>Connector Orientation</p>  <p>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</p>  <p>2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.</p>  <p>3. After insertion, release the insertion jig lock using left thumb.</p> </div>	<div> <p>Safety Instruction</p> <p>Be sure to wear prescribed 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> </div>	<div> <p>CONNECTOR ORIENTATION ILLUSTRATION</p>  <p>I-mark is align</p> <p>1 hole is open</p> <p>GOOD</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p> </div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
06/16/21	4	Transfer process owner from Production (WI-PRO-ASY-010B) to Engineering (WI-ENG-PDE-298B); Change the process illustration	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes			
07/30/19	3	Change wire length in wire procedure/taping COT to Vinyl	J. Silang	A. Morcozo	O. Merin	n/a			
07/01/19	2	Include the Process Distribution/ Include Insertion Jig	J. Silang	A. Morcozo	O. Merin	n/a			
07/10/17	n/a	Initial issue	J. Montealto L. Briones	O. Merin	T. Sugiyama	n/a	J. Loterte	C. Villanueva	A. Shimamura
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	July 10, 2017	

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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **480A / A7045D**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 16, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-298B

Revision No.:

4

Page No.:

2 of 4

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P2

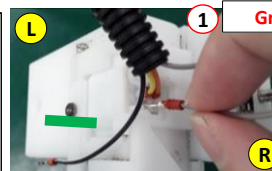
Wire insertion to
Connector
(Assy parts)



1. Hold the assy parts upward using left hand. Slot for GR wire must be open.

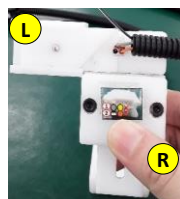


Wire facing



1 Gray wire

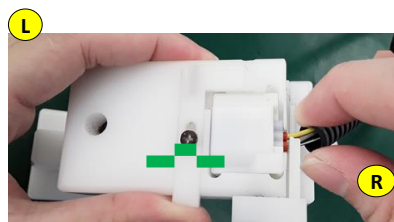
2. Insert the GR wire using right hand.



2 B/W wire

4. Insert the B/W wire using right hand.

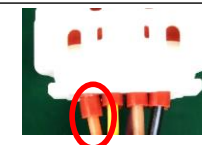
3. Press the push button using right hand. Slot for B/W wire will be open.



5. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

Note: During insertion, hold the wire not rubber seal to prevent sagging.



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

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

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**

Process Name/Title:

Product Name/Code: **480A / A7045D**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 16, 2021

Validity Date:

n/a

Document No.:




WI-ENG-PDE-298B

Revision No.:

4

Page No.:

3 of 4

PARTS:		1. Assy parts 2. Black tape		JIG	1. Locking jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Connector lock	<div></div> <div>1. Put the connector into locking jig and push down to lock using right thumb.</div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div>		<div></div> <div>LOCKING JIG</div>	1. No unlock/Half-locked connector 2. No damaged lock
4		Taping COT to Vinyl tube	<div><div><div>196±3mm</div><div>L</div><div>R</div></div><div>1. Hold the COT using left hand. Measure the end of COT up to the edge of Hotmelt 196±3mm using right hand.</div></div> <div><div><div>Tape width</div><div>196±3mm</div><div>Tape width</div></div><div>3. After taping, check the measurement and tape condition.</div></div> <div><div>L</div><div>R</div><div>2. Hold the COT using left hand then start taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></div></div>		<div>LOCKING JIG</div> <div></div>	1. No peel-off tape 2.No flip out tape 3.No loose tape 4. No wrong dimension Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i>

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

Process Name/Title:

Product Name/Code: **480A / A7045D**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 16, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-298B

Revision No.:

4

Page No.:


4 of 4

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Y-Taping	n/a	<p>Note: Used Yellow tape to easily visualize the tape shifting. But actual should be Black.</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wide interval between the COT5. No wrong use of tape <p>CONNECTOR ORIENTATION</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