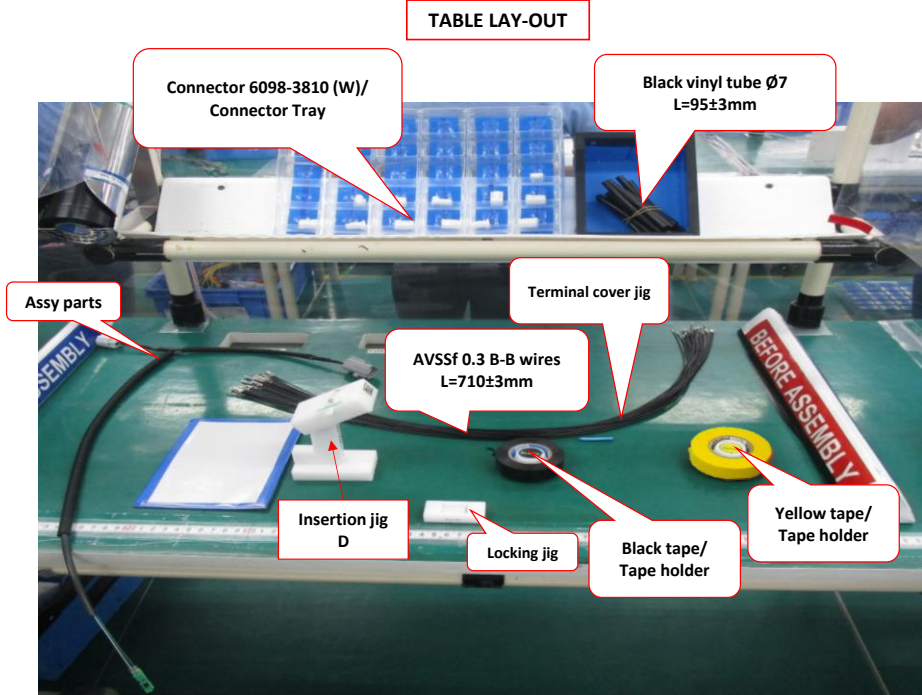




	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	April 26, 2023		
	Process Name/Title:				Validity Date:	n/a		
	Model Code/Part Number: 500B / 7L0084-7023		Customer: TRQSS		Document No.:	WI-ENG-PDE-426B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 10

PARTS:	1. All parts: Connector 6098-3810 (W); B-B wires L=710±3mm; Black vinyl tube Ø7 L=95±3mm; Black tape [1pc.]; Yellow tape [1pc.]			JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<p>TABLE LAY-OUT</p> 		<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/26/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a	
11/12/22	2	Improve quality pointers: Reminders/notes and references in process no.1,23,4,6,9 and 10 due to document improvement. Work procedure/illustration in process no.4 - connector lock	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
03/23/22	1	Change document purpose from Pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
03/21/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 21, 2023			

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	



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 26, 2023

Validity Date:

n/a

Model Code/Part Number:

500B / 7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

2 of 10

PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P2

Connector setting to
Insertion jig
6098-3810 (W)

INSERTION JIG

Holes

Lock

INSERTION JIG ORIENTATION

I-MARK

CONNECTOR ORIENTATION

L

R

Press

Press

Release

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

2. Insert the connector **6098-3810 (W)** into jig using right hand and release the lock.
Note: Follow the connector orientation.

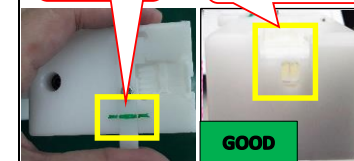
3. Check the holes/terminal slot for **B-B wires**.

n/a

Connector Orientation Illustration

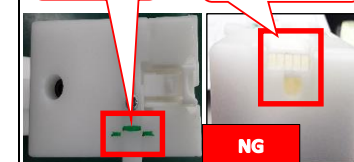
I-mark was align

2 holes were only open



I-mark is NOT align

All holes were open



CONNECTOR ILLUSTRATION



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged 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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 26, 2023

Validity Date:

n/a

Model Code/Part Number:

500B / 7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:


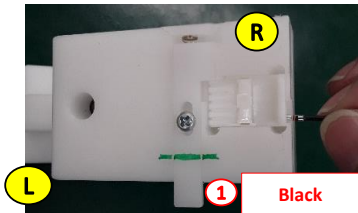
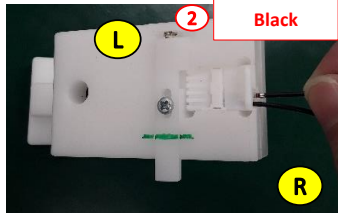
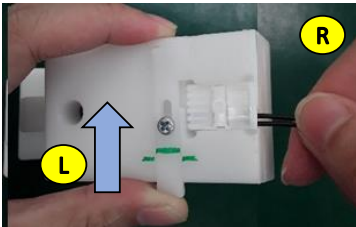
3 of 10

PARTS:

1. AVSSf 0.3 wires B L=710±3mm [2pcs.]

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to connector 6098-3810 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Get the 1st Black wire then insert to connector slot 1 using right hand. Note: insertion process must be from left to right.</p></div> <div><p>2. Get the 2nd Black wire then insert to connector slot 2 using right hand.</p></div> <div><p>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.</p></div>	n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>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. 3. Insertion of wires must be from left to right</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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:

April 26, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: **500B / 7L0084-7023**

Customer: **TRQSS**

Document No.:

WI-ENG-PDE-426B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH


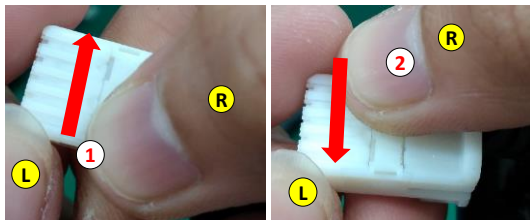
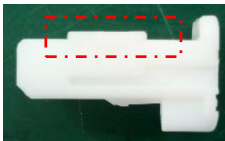
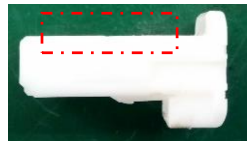

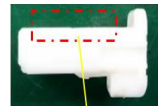
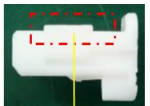

☒ MASSPRO

Revision No.:

3

Page No.:

4 of 10

PARTS:		1. Black vinyl tube Ø7 L=95±3mm			JIG	1. Locking jig	
NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
4	P2	Connector Lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div></div> <div><div></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div> <div><div></div><div>Before Pressing</div><div></div><div>After Pressing</div></div>		<div><div>LOCKING JIG</div></div>	<div><p>Important reminders/Note/s:</p><p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p></div> <div><p>1. Use the provided locking jig per model</p><p>2. No unlock/half-locked connector</p></div> <div><div>CONNECTOR LOCK CONDITION</div><div><div><p>GOOD</p><p>Fully Locked</p></div><div><p>NG</p><p>UnLocked</p></div></div></div>	
5		Wire insertion to Black vinyl tube Ø7 L=95±3mm	<div><div></div><div><p>1. Get the black vinyl tube Ø7 L=95 ± 3mm using right hand and insert the wires.</p></div></div>		n/a	<div><p>1. No wrong usage of parts</p><p>2. No deformed terminal</p></div>	

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:

April 26, 2023

Model Code/Part Number:

500B / 7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

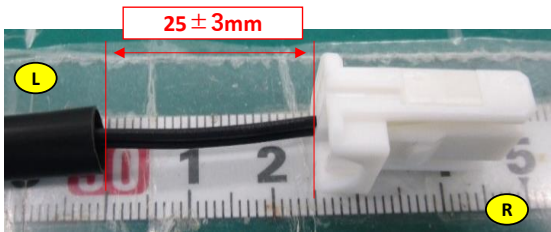
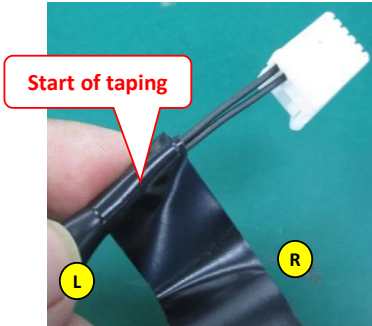
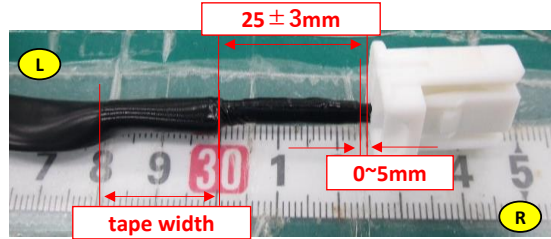

5 of 10

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Taping 1 Vinyl tube to wire near connector	 <p>1. Measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</p>  <p>2. Get the Black tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s: 1. 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**

Effectivity Date:

April 26, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

500B / 7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

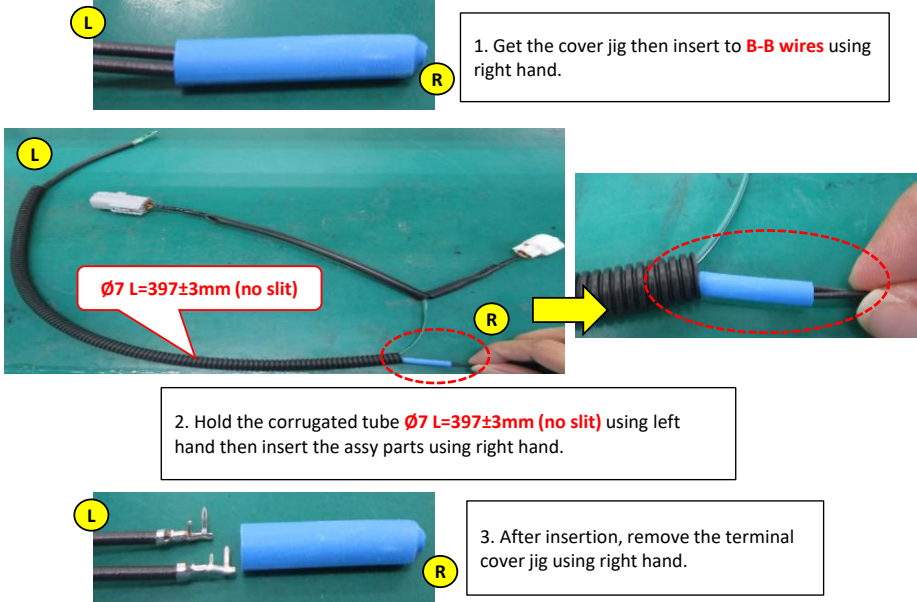

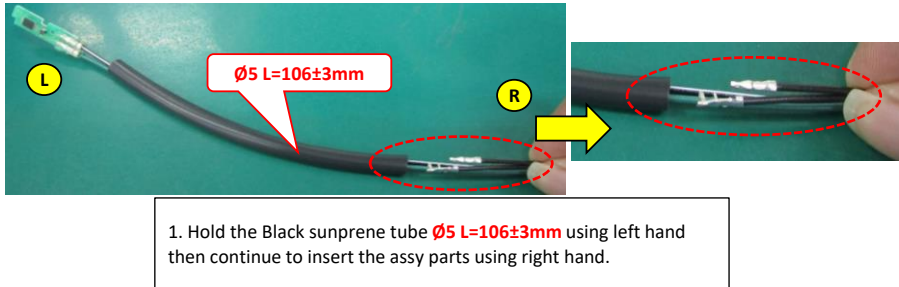
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

6 of 10

PARTS:		1. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	P2	 <p>1. Get the cover jig then insert to B-B wires using right hand.</p> <p>2. Hold the corrugated tube Ø7 L=397±3mm (no slit) using left hand then insert the assy parts using right hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>				1. No wrong usage of parts 2. No wrong insertion
8		 <p>1. Hold the Black sunprene tube Ø5 L=106±3mm using left hand then continue to insert the assy parts using right hand.</p>			n/a	1. No wrong usage of parts 2. No wrong insertion

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: **500B / 7L0084-7023**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 26, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-426B

Revision No.:

3

Page No.:

7 of 10

PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

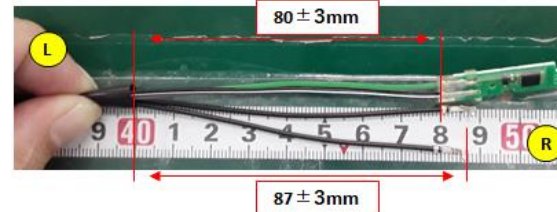
TOOLS/PPE

QUALITY POINTERS

9

P2

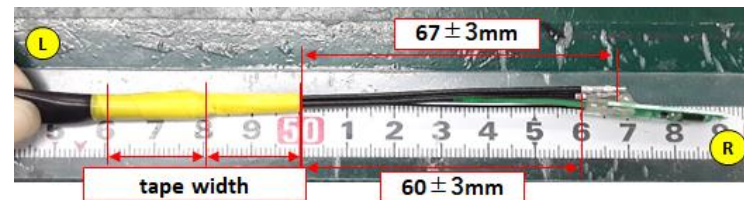
Taping 2
Black sunprene tube to wire
near hotmelted wires and
terminal pointed tip



1. Hold vinyl tube using left hand, measure from Sunprene tube to end of hotmelted wire **80 ± 3mm** and from sunprene tube to terminal tip **87 ± 3mm**



2. Get the **Yellow tape** using right hand then start taping process using both hands.

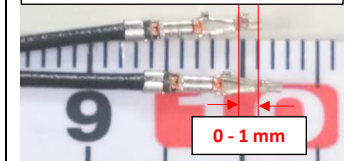


3. After taping, check the measurement and taping condition.

MEASURING TAPE



Wire alignment tolerance



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

Important reminders/Note/s:

1. Use **YELLOW TAPE** only
2. Please use calibrated/verified measuring tape when getting the measurement.

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:

April 26, 2023

Validity Date:

n/a

Model Code/Part Number:

500B / 7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

8 of 10

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

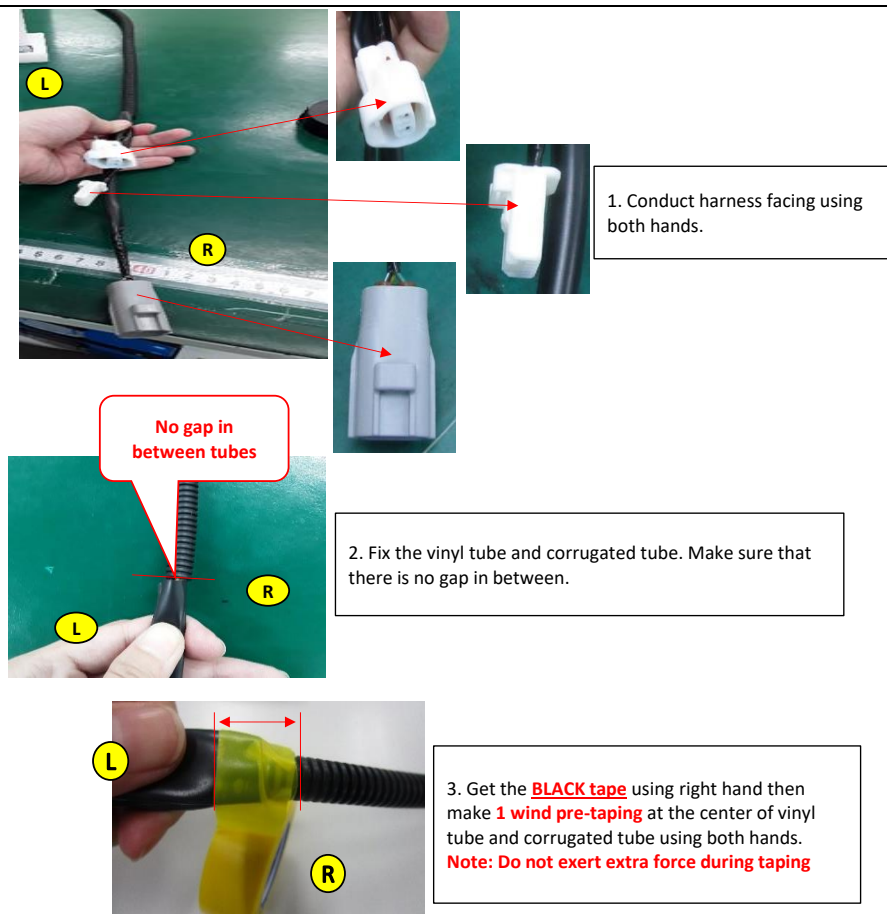
TOOLS/PPE

QUALITY POINTERS

10

P2

Y-Taping



n/a

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 use of tape
6. No wrong dimension

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:

April 26, 2023

Model Code/Part Number:

500B / 7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

9 of 10

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

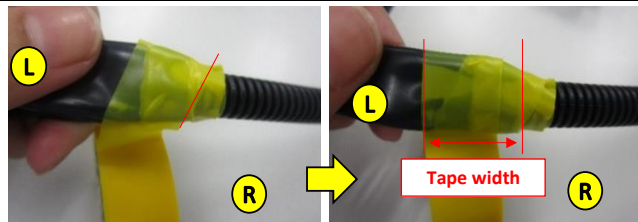
TOOLS/PPE

QUALITY POINTERS

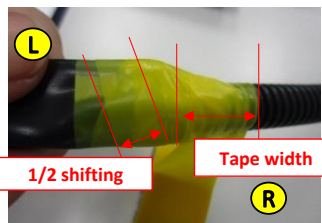
10

P2

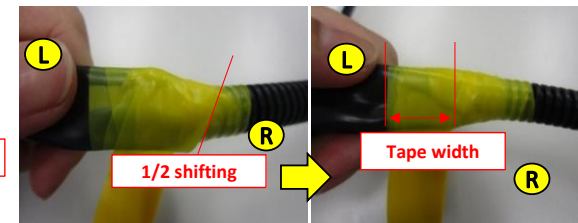
Y-Taping
(Continuation)



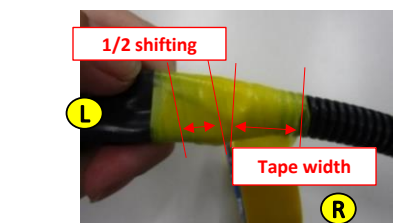
4. Make **1/3 shifting** going to vinyl tube until tape width then make **1 winding** of tape before shifting.



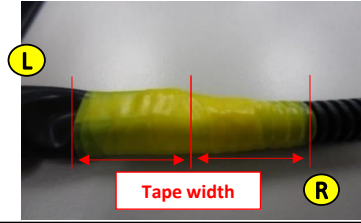
5. Make **1/2 shifting** going to COT until tape width then make **1 winding** of tape before shifting.



6. Make **1/2 shifting** going to vinyl tube until tape width then make **2 windings** of tape before final shifting.

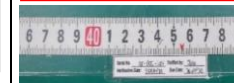


7. Make **1/2 shifting** going to COT until tape width then make **2 windings** of tape then cut the tape.



8. After taping, check the measurement and taping condition.

MEASURING TAPE



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 use of tape
6. No wrong dimension

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:

April 26, 2023

Validity Date:

n/a

Model Code/Part Number:

500B

/

7L0084-7023

Customer:

TRQSS

Document No.:

WI-ENG-PDE-426B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

10 of 10

PARTS:

1. Assy parts

JIG

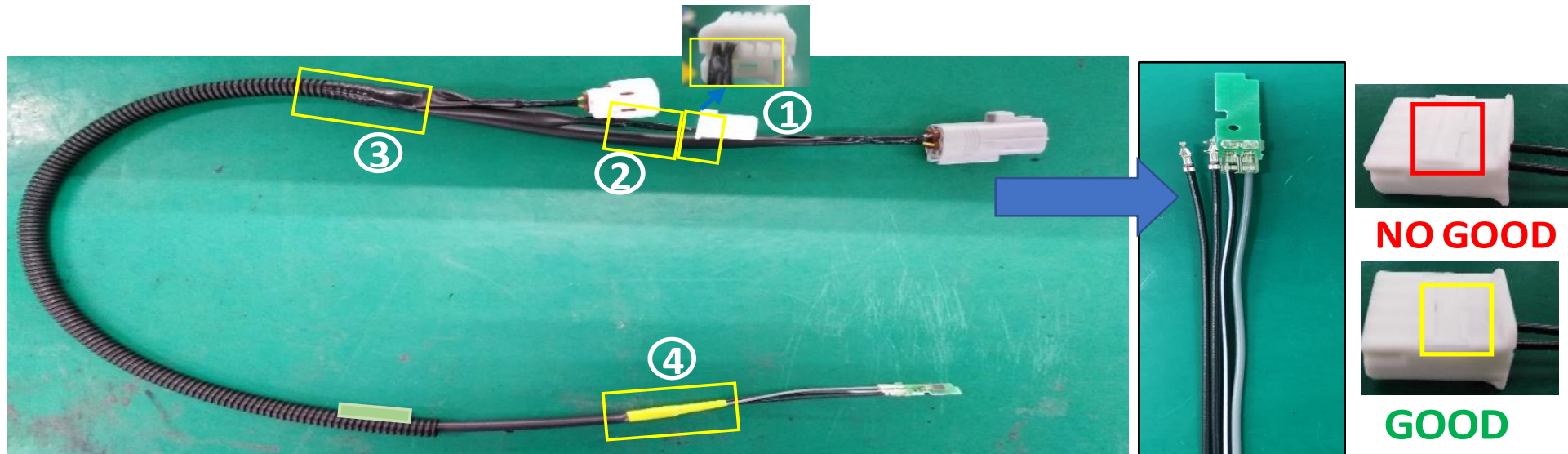
n/a



QUALITY CHECKPOINTS

P2

7L0084-7023



1

NO WRONG INSERT

NO UNLOCKED/ HALFLOCKED

2

3

4

No MISSING tape

Proper alignment of
B-B wires and hotmelt

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