

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**May 17, 2022**

Model Code/Product Number:

**740B / 7H0425W7020**

Customer:

**NBS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-526C**

Revision No.:

1

Page No.:

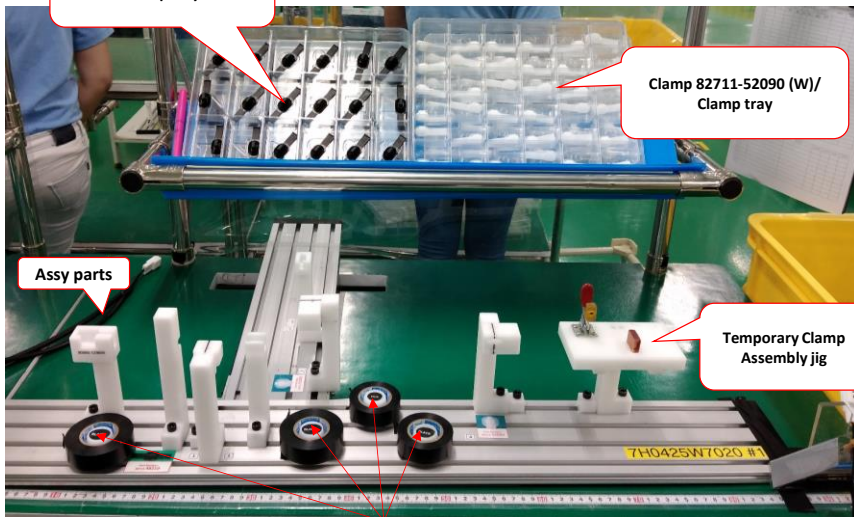
1 of 6

**PARTS:**

1. Assy parts: Clamp 82711-48210 (B); Clamp 82711-52090 (W); Black tape [4pcs.]

JIG:

1. Temporary Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out 	<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/17/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
05/13/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

**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:

**May 17, 2022**Model Code/Product Number: **740B / 7H0425W7020**Customer: **NBS**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-526C**

Revision No.:

**1**

Page No.:

**2 of 6**

PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-52090 (W) [2pcs.]			3. Black tape [4pcs.]		JIG	1. Temporary clamp assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
2	P3	Clamp Setting	<div></div>				n/a		<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</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:

May 17, 2022

Model Code/Product Number: **740B / 7H0425W7020**

Customer:

**NBS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

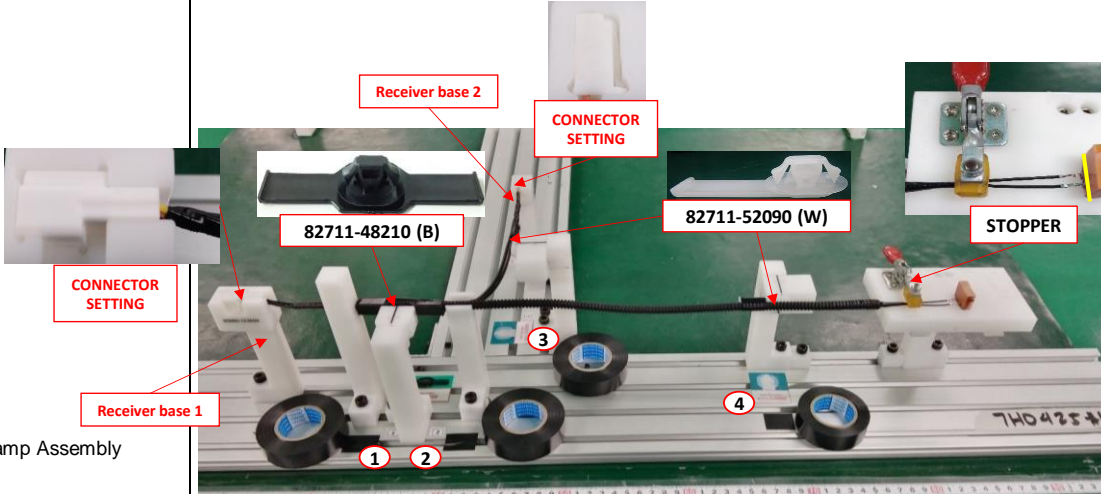
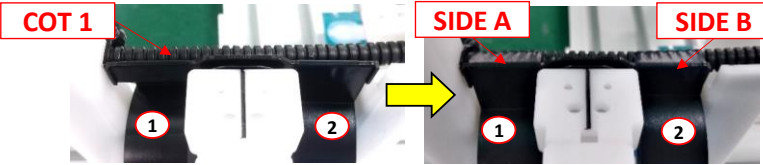

**WI-ENG-PDE-526C**

Revision No.:

1

Page No.:

3 of 6

PARTS:		1. Assy parts 2. Black tape	JIG	1. Temporary clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Clamp Assembly	 <p>1. Set the assy parts into jig. (See above picture for correct setting). First, set the connector <b>6098-3802 (W)</b> to <b>Receiver base 1</b>. Continue to set the harness in jig. Set the <b>B-B wires</b> together within the stopper then press by <b>Toggle clamp</b>. Last, set the connector <b>6098-2220 (W)</b> to <b>Hook</b>.</p>  <p>2. Conduct pre-taping on <b>COT 1</b> at <b>Side A</b> and <b>Side B</b>. Make <b>2 windings</b> of tape and <b>do not cut</b> the tape. (See below illustration)</p>	n/a	 <p>Note: Make sure no gap between stopper jig and terminals.</p> <ol style="list-style-type: none"><li>1. No wrong use of tape</li><li>2. No missing tape</li><li>3. No damage clamp</li><li>4. No missing clamp</li><li>5. No skip process</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:

May 17, 2022

Model Code/Product Number:

740B

/

7H0425W7020

Customer:

NBS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

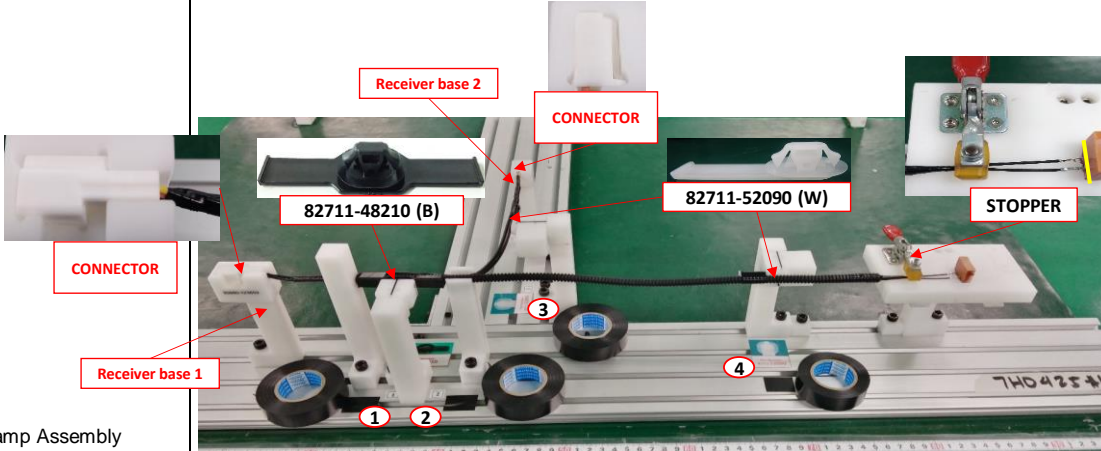
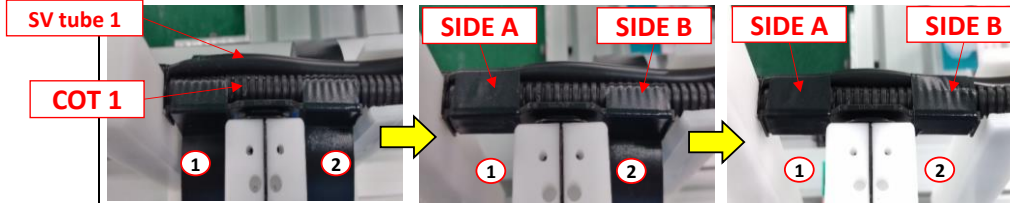

WI-ENG-PDE-526C

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Assy parts 2. Black tape	JIG	1. Temporary clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Clamp Assembly (Continuation)	 <p>3. Remove the assy part of connector <b>6098-2220 (W)</b> in Hook then combine the <b>SV tube 1 to COT 1</b> then set the connector <b>6098-2220 (W)</b> to <b>Receiver base 2</b>.</p> <p>4. Hold the tape on clamp location <b>1</b>, make <b>3 windings</b> of tape for <b>Side A</b> then cut the tape using both hands. Continue to clamp location <b>2</b>. <i>(See below illustration)</i></p> <p>5. Hold the tape on clamp location <b>2</b>, make <b>3 windings</b> of tape for <b>Side B</b> then cut the tape using both hands. Continue to clamp location <b>3</b>. <i>(See below illustration)</i></p> 	n/a	 <p>Note: Make sure no gap between stopper jig and terminals.</p> <ol style="list-style-type: none"><li>1. No wrong use of tape</li><li>2. No missing tape</li><li>3. No damage clamp</li><li>4. No missing clamp</li><li>5. No skip process</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**

Model Code/Product Number: **740B / 7H0425W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**May 17, 2022**

Validity Date:

**n/a**

Document No.:

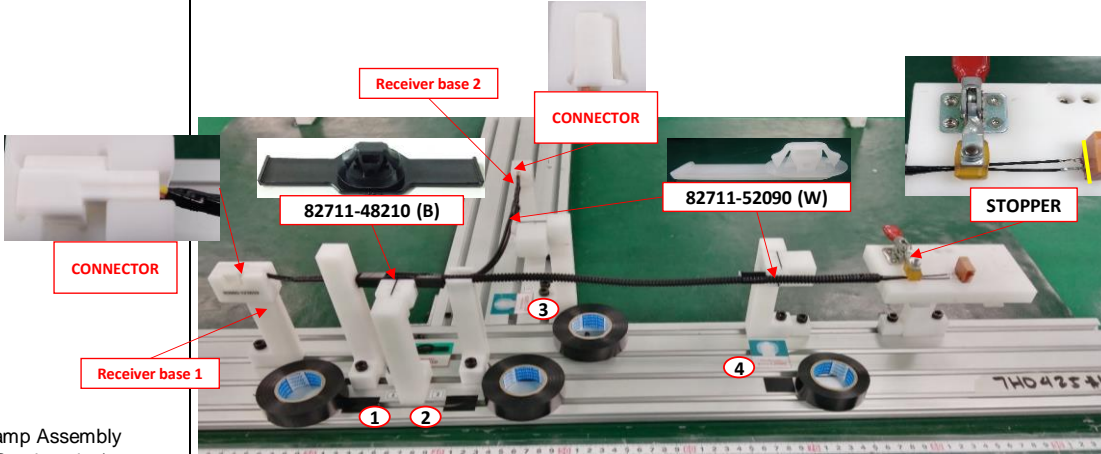

**WI-ENG-PDE-526C**

Revision No.:

**1**

Page No.:

**5 of 6**

PARTS:		1. Assy parts 2. Black tape	JIG	1. Temporary clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Clamp Assembly (Continuation)	 <p>6. Hold the tape on clamp location <b>3</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Continue to clamp location <b>4</b>.</p> <p>7. Hold the tape on clamp location <b>4</b>, make <b>3 windings</b> of tape then cut the tape using both hands.</p> <p>8. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</p>	n/a	 <p><i>Note: Make sure no gap between stopper jig and terminals.</i></p> <ol style="list-style-type: none"><li>1. No wrong use of tape</li><li>2. No missing tape</li><li>3. No damage clamp</li><li>4. No missing clamp</li><li>5. No skip process</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:

**May 17, 2022**

Model Code/Product Number:

**740B****/****7H0425W7020**

Customer:

**NBS**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-526C**

Purpose:

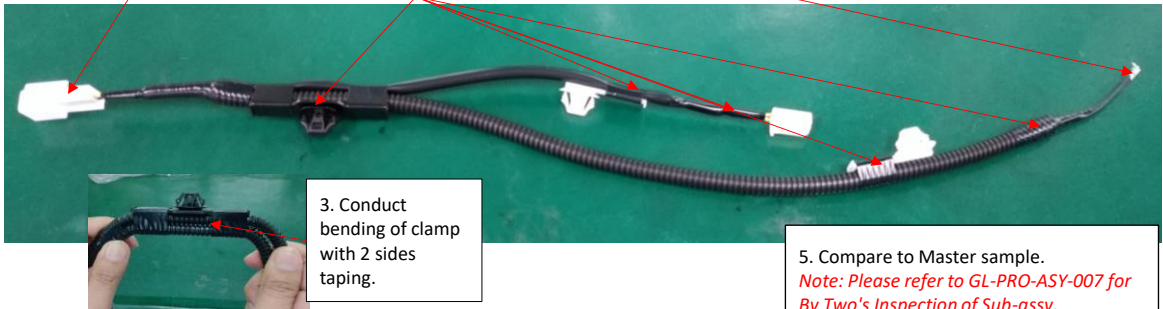


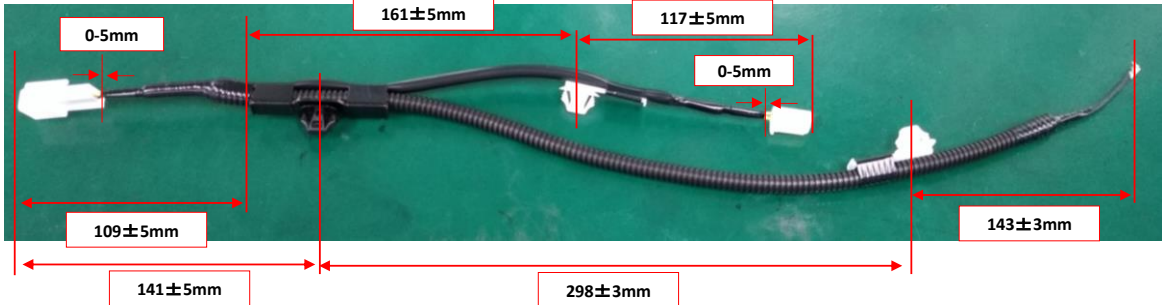
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**6 of 6**

PARTS:		n/a		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Visual/By two's inspection	<div>1. Check the double lock.</div> <div>2. Check the taping condition and clamp attachment.</div> <div>3. Conduct bending of clamp with 2 sides taping.</div> <div>4. Check the terminal appearance, make sure no deformed terminal.</div> <div>5. Compare to Master sample. <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div> 			<b>MASTER SAMPLE</b> 
5	Measurement	<div></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> 			<b>FOR HATSUMONO AND OWARIMONO ONLY</b>  1. No wrong 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