			WORK INSTRUCTION						Effectivity Date	Effectivity Date:		May 20, 2022		
		Process Name/Title:	TAPING ASSEMBLY PROCESS						Validity Date:			n/a		
		Model Code/Part Number:	666W /	7H0309V	N7020D Customer:	NBS			Document No.	:		WI-ENG-PDE-	524A	
		Purpose:	PROTOT	YPE	☐ PRE-LAUNCH	MASS	PRO		Revision No.:		1	Page No.:	1 of 5	
PARTS:	1. All pa	rts: Connector 6098-3802 (W	/); AVSSf 0.3 B L=63	1±3mm; Black co	orrugated tube (no slit) ø5 L=46	8±5mm;Black sunpre	ne tube ø9 L	=120±3mm; Bla	ck tape	JIG				
NO.		PROCESS NAME		W	ORK PROCEDURE/ ILL	.USTRATION			TOOL	S/PPE		QUALITY POI	ITERS	
1	P1	Table Lay-out	BI	onnector 6098- 3802 (W)/ onnector tray ack corrugated be (no slit) ø5 =468±5mm Locking Jig	TABLE LAY-OL AVSSf 0.3 B L=631±3mm		BI tape	ack /Tape Ider	Safety Ir Be sure prescribe protective during oper finger c House 1. Maintair pract 2. Personal workplace i Keep it in y Alert For any tro the Asseml Supervisor of for immedia	et level uble, infor	Note. Note. Wire 1. No miss 2. No exce	Refer to WI-PRO and Strip Length sing parts/tools. ess parts/tools.	-CNC-017 for	
	1			Revision H	listory				Prepa	ared by	Reviewed by	Reviewed by	Approved by	
									h	// -	O . I			
05/20/22 1	Change Initial iss	from Pre-Launch to Masspro. Ad	ditional table Lay-out.			K. Doria	J. Loterte		rañes (K. Doria J. Loverte C. V			C. Villanueva	A. Aranes	
05/13/22 0 Eff. Date Rev. No	milliai ISS	uc	Details of	Change		K. Doria Prepared	J. Loterte Checked		Arañes / (K.) Ioted Est. Date		J. Loverte May 13, 2022	С. упіанцеча	/ A. Alanes	
				•			•		•					

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Connector setting to insertion jig 6098-3802 (W) Press 1. Press the lock of insertion jig using left thumb. Press 2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock. Note: Follow the connector orientation. 3. Check the holes/terminal slot for 8-8 wires.									
Model Code/Part Number: 666W / 7H0309W7020D Customer: NBS Document No: Wi-ENG-PDE-524A Purpose: PROTOTYPE PRE-LAUNCH NASSPRO Revision No: 1 Page No: 2 of 5 PARTS: 1. Connector 6098-3802 (W) NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Connector Orientation illustration Il							Effectivity Date:	May 20, 2022	
PARTS: 1. Connector 6098-3802 (W) NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Connector Orientation Illustration I			Process Name/Title:	TAPI	NG ASSEMBLY PROC	ESS	Validity Date:	n/a	
PARTS: 1. Connector 6098-3802 (W) NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Connector Orientation illustration Illustration Insertion jig cose-3802 (W) Press Press Press Press Press Press Press Press Press Release 1. Press the lock of Insertion jig using left thumb. 3. Check the holes/terminal slot for 8-8 wires.			Model Code/Part Number:	666W / 7H0309\	N7020D Customer:	NBS	Document No.:	WI-ENG-PDE-524A	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Connector Orientation Illustration Learly Learly Learly Linsertino Jig Orientation Illustration Insertion Jig Orientation Illustration All holes 1. Press the lock of insertion jig using left thumb. 2. Insert the connector 698-3802 (W) into jig using right hand then release the lock. Note: Follow the connector orientation. 3. Check the holes/terminal slot for 8-8 wires.			Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1 Page No.: 2 of 5	
Connector Orientation Illustration L-mark L									
2 P1 Connector setting to insertion jig 6098-3802 (W) Press 1. Press the lock of insertion jig using left thumb. Press 2. Insert the connector 6998-3802 (W) into jig using right hand then release the lock. Note: Follow the connector orientation. 3. Check the holes/terminal slot for 8-8 wires.	NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	TOOLS/PPE	QUALITY POINTERS		
hand then release the lock. Note: Follow the connector orientation. 3. Check the holes/terminal slot for B-B wires. 1. Use provided jig per model			Connector setting to insertion jig	INSERTION JIG Holes Lock I-mark 1. Press the lock of insertion jig	I-mark INSERTION JIG ORIENTATION R Press	CONNECTOR ORIENTATION Release		Connector Orientation Illustration 2 Holes are GOOD All holes	
					hand then release the lock. Note: Follow the connector or 3. Check the holes/te	ientation.			

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				WORK INSTRU	JCTION				Effectivity Date:		T	May 20,	2022
		Process Name/Title:	Validity Date:		n/a								
		Model Code/Part Number:	666W /	7H0309W702	20D Custom	er:	NBS		Document No.:			WI-ENG-P	DE-524A
		Purpose:	☐ PROTOTY	PE	PRE-LAU	NCH	M.	ASSPRO	Revision No.:		1	Page No.:	3 of 5
	1								-	ı			
PARTS:	1. AVS	Sf 0.3 B-B L=631±3mm [2pcs	.]							JIG	1. Inser 2. Lock	rtion jig ing jig	
NO.	F	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION							PPE	QUALITY POINTERS		
3	P1	Wire insertion to connector 6098-3802 (W)	1. Get the 1st Black of connector using ri	Black Wire then insert to termi ight hand. The irres must be from left to		2. Get the 2 terminal slo	3. After insertio	or using right hand. on, push the lock b and then hold the y pull out the	n/a		1. No lo 2. No w 3. One 4. No di 5. No w Make si Conductinsertion Do not di	cond Strip Length coose insertion wrong insertion by one insertion leform terminal wrong wire facilitations were wires are pot Pull-Push-P	n on al cing properly inserted. Pull-Push after rce."
4		Connector lock	1. Put the connector in hands then press 2x thands. Touch the conif properly locked. Note: Please refer to the verification of continuous property.	to lock using both nnector lock to confirm GL-PRO-ASY-017 for	Before pr		GOOD Full Lock	NG Half Lock	LOCKING	3 JIG	1. Use to modle 2. No un	SE DAMAGED K the provided lo	OCKING MAY O CONNECTOR ocking jig per ocked connector

After pressing

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<u> </u>				WOR	K INSTRUCTION	ONI		Effectivity Date:		May 20	2022		
	Process N	lame/Title:			APING ASSE)CESS	Validity Date:			<i>J</i> , 2022 /a		
		de/Part Number:	666W			Customer:	NBS	Document No.:		WI-ENG-F			
	Purpose:	ac, r are rrainibor.		OTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		1 Page No.:	4 of 5		
	т игросс.							1.101.0.011.1011		i ago itan			
PARTS:	Assy parts Black corrugated	d tube (no slit) ø5	L=468±5mm		;	3. Black tape			JIG	1. Terminal cover jig)		
NO.	PROCES	SNAME		WC	ORK PROCEDI	URE/ ILLUST	RATION	TOOLS/	PPE	QUALITY F	QUALITY POINTERS		
5	Black cor	insertion to rugated tube (no slit) =468±5mm		erminal cover jig u the B-B wires.	R Ising right hand	L=468±5mi B-B wires.	Black corrugated tube (no slit) ø5 m using right hand and insert the n, remove the terminal ght hand.	TERMINAL (COVER	No wrong usage of the contract of the con			
6	Black co	Faping 1 rrugated tube to near terminal	the Black tape right hand.	R T using left hand, at then start taping to the start taping	get using for 3.7	Measure from end 1±3m then continu 6 7 8 9 0 1 1 tape width	of COT up to the terminal tipe the taping process. 131±3mm 2 3 4 5 6 7 8 9 10 1 2 3	6 7 8 9 1 1 2 3 4		Note: Please use calibra measuring tape w measurement. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimens 6. No wrong use of the wire alignme	tion		

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TAPING ASSEMBLY PROCESS Model Code/Part Number: 666W					WORK INSTRUCT	ION		Effectivity Date:		May 20	, 2022	
PARTS: 1. Assy parts 2. Black supprese tube e9 L=12029mm 3. Black lapo NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 7. Wire insertion to Black supprese tube e9 L=12029mm using right hand then insert the assy parts using left hand. NOTE: COT must be inserted to supprese tube e1 L2025mm, insert the assy parts using left hand. NOTE: COT must be inserted to supprese tube e1 L2025mm, insert the assy parts using left hand. NOTE: COT must be inserted to supprese tube e1 L2025mm, insert the assy parts using left hand. NOTE: COT must be inserted to supprese tube using left hand, get the links supprese tube to Black corrupted tube to Black tube then start tuping using right hand, get the Black tube then start tuping using right hand, get tube tube tube tube tube tube tube tu		- I	Process Name/Title:		TAPING ASSI	EMBLY PRO	OCESS	Validity Date:		n/a		
PARTS: 1. Assy parts 2. Black supprene tube e9 L=120±3mm 3. Black tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. No wrong use of parts 2. No deformed terminal 1. Get the supprene tube e9 L=120±3mm using right hand then insert the assy parts using left hand. NOTE: COT must be inserted to sunprene tube (Pdf:5mm). 1. Measure from end of supprene tube up to the terminal pointed by 31±3mm. 1. Measure from end of supprene tube up to the terminal pointed by 31±3mm. Mote: Please use calibrated/verified measurement. 1. No filp-out tape 2. No peel-off tape 3. No loose tape 3. No loose tape 3. No loose tape 3. No wrong use of parts 2. No deformed terminal 1. No stip-out tape 3. No loose tape 3. No loose tape 3. No wrong disension 5. No wrong use of lape 6. No wrong use of lape 6. No wrong use of lape 6. No wrong use of lape 7. Measure from end of supprene tube up to the terminal pointed by 31±3mm. MEASURING TAPE 7. No loose tape 7. No wrong use of lape 8. No wrong diseases.		r	Model Code/Part Number:	666W /	7H0309W7020D	Customer:	NBS	Document No.:		WI-ENG-P	DE-524A	
NO. PROCESS NAME WORK PROCEDURE! ILLUSTRATION TOOLS/PPE QUALITY POINTERS No. PROCESS NAME With inserted CDT Black supprene tube of L=120±3mm 1. Get the supprene tube of L=120±3mm using right hand then insert the assy parts using left hand. NOTE: COT must be inserted to supprene tube (20±5mm). Note: Please use calibrated/wrifled measure gate gate gate gate gate gate gate gat			Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		1 Page No.:	5 of 5	
NO. PROCESS NAME WORK PROCEDURE! ILLUSTRATION TOOLS/PPE QUALITY POINTERS No. PROCESS NAME With inserted CDT Black supprene tube of L=120±3mm 1. Get the supprene tube of L=120±3mm using right hand then insert the assy parts using left hand. NOTE: COT must be inserted to supprene tube (20±5mm). Note: Please use calibrated/wrifled measure gate gate gate gate gate gate gate gat												
With insertion to Black surprene tube e9 L=120±3mm using right hand then insert the assy parts using left hand. 1. No wrong use of parts 2. No deformed terminal 1. Get the surprene tube e9 L=120±3mm using right hand then insert the assy parts using left hand. NOTE: COT must be inserted to surprene tube (20±5mm). Note: Please use calibrated/verified measuring tape when getting the measurement. Note: Please use calibrated/verified measuring tape when getting the measurement. Note: Please use calibrated/verified measurement. No peel-off tape 2. No peel-off tape 3. No loose tape 3. No loose tape 3. No wrong dimension 6. No wrong use of sape 3. After taping, check the taping condition and measurement.				mm		3. Black tape			JIG n	/a		
Wire insertion to Black surprene tube #9 L=120±3mm using right hand then insert the assy parts using left hand. **Note:** Please use colibrated/verified measuring tope when getting the terminal pointed up \$1±3mm. **Indicate the surprene tube up to the terminal pointed up \$1±3mm. **Indicate the surprene tube up to the terminal pointed up \$1±3mm. **Indicate the surprene tube up to the terminal pointed up \$1±3mm. **Indicate the surprene tube up to the terminal pointed up \$1±3mm. **Indicate the surprene tube up to the terminal pointed up \$1±3mm. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Note:* Refer to Wi-PRO-ASY-001 for taping procedure. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Note:* Refer to Wi-PRO-ASY-001 for taping on the surprene tube using left hand, get the Black tape then start taping using right hand. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Indicate the surprene tube using left hand, get the Black tape then start taping using right hand. **Indicate the surprene tube using left hand. **Indicate the surp	NO.	PF	ROCESS NAME		WORK PROCED	URE/ ILLUS	TRATION	TOOLS/PP	PE	QUALITY POINTERS		
1. Measure from end of sunprene tube up to the terminal pointed tip 31±3mm. 1. Measure from end of sunprene tube up to the terminal pointed tip 31±3mm. 1. Measure from end of sunprene tube up to the terminal pointed tip 31±3mm. 1. Measure from end of sunprene tube up to the terminal pointed tip 31±3mm. 1. No flip-out tape 2. No peel-off tape 2. No peel-off tape 3. No loose tape 4. No missing tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape 5. No wrong use of tape 4. No wrong use of tape 5. No wrong use of tape 6. No wrong use of tape 6. No wrong use of tape 7. No wrong use of tape 7. No wrong use of tape 8. No wrong use 1. No wrong use 1. No wrong use 1. No wrong use 1	7		Black sunprene tube	1. Get the sunpren	R e tube ø9 L=120±3mm using	right hand then ins	R	n/a				
	8	P1	Black Sunprene tube to Black corrugated tube	Start of ta L tape width) 1 2 3	1. Measure terminal poor R 2. Hold the Sunprethe Black tape the hand. Note: Refer to Wiprocedure.	ene tube using left hand, get in start taping using right PRO-ASY-001 for taping 3. After taping, check the taping	67894012345	3 4 6 7 8 9 1 5	Please use calibrat measuring tape wheasurement. . No flip-out tape is. No peel-off tape is. No loose tape is. No missing tape is. No wrong dimensi	nen getting the	

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