



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 7, 2023

Model Code/ Part Number:

D94L / 7N0030-7020

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-054B

Revision No.:

4

Page No.:

1 of 6

PARTS:		1. Assy parts; Clamp 82711-1E360 (W); Black tape; Black SV tube (Vinyl) Ø5 L=434±3mm; Black tape				JIG:		1. Measuring jig					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
1	P2	Table Lay-out	<div><div>TABLE LAY-OUT</div><div>Clamp 82711-1E360 (W)/ Clamp tray</div><div>Black SV tube (Vinyl) Ø5 L=434±3mm</div><div>Assy parts</div><div>Measuring</div><div>Tape holder/Black tape</div></div>				<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div></div> <div><div>NG</div><div>82711-12B10 (W)</div></div> <div>Important reminders/Note/s: 1. Please check the clamp first before start of assembly to avoid wrong used of clamp.</div>				
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
06/07/23	4	Transfer process no. 8, 13 and 14 from P1 to P2; Transfer process of Taping 1 (COT to SV tube (Vinyl) near wire; Pre-taping SV tube (Vinyl) to wire from P2 to P3 due to change process distribution. Standardized tube description; SV tube (Vinyl).Additional table lay-out; Inclusion of Quality Checkpoints. Improve Quality pointers: Reminders/notes and references on page 1to 5				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/26/21	3	Remove validity date; change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
10/07/20	2	Remove cycle time ; Apply some improvements.				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	December 7, 2019		

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:

June 7, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/ Part Number: **D94L / 7N0030-7020**

Customer: **TRJ**

Document No.:

WI-ENG-PDE-054B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

2 of 6

PARTS:



1. Clamp 82711-1E360 (W)
2. Black SV tube (Vinyl) Ø5 L=434±3mm

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2



P2

Clip type clamp attachment
Clamp 82711-1E360 (W)



Clamp Orientation



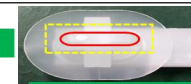
Hold the connector using left hand and insert the Clamp **82711-1E360 (W)** using right hand.

N/A



CLIP CLAMP ILLUSTRATION

GOOD



82711-1E360 (W)

NG



82711-12B10 (W)



Important reminders/Note/s:

1. Please check the clamp first before start of assembly to avoid wrong used of clamp.

3



Wire insertion to Black SV tube (Vinyl)
Ø5 L=434±3mm (B-B)



1. Get the Black SV tube (Vinyl) (**Ø5 L=434±3mm**) using right hand then insert the **B-B wires** using left hand.



n/a

1. No wrong usage of parts

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:

D94L / 7N0030-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 7, 2023

Validity Date:

n/a

Document No.:

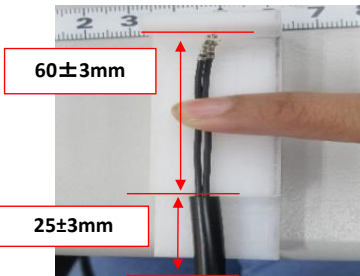
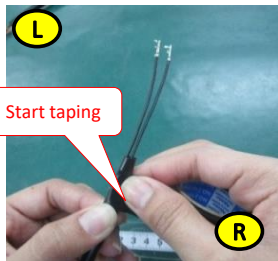
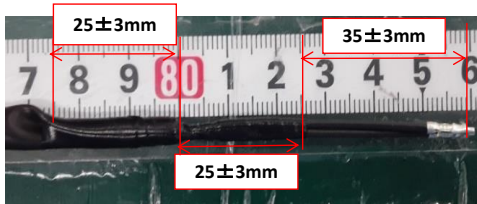


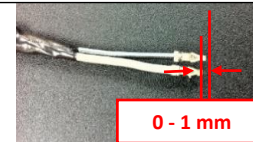
WI-ENG-PDE-054B

Revision No.:

4

Page No.:

3 of 6

PARTS:		1. Black tape		JIG	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div><p>1. Get the assy part and measure the end of the SV tube (Vinyl) up to the terminal tip 60mm. Then, measure 25mm from the end of SV tube (Vinyl) using measuring jig.</p></div><div><p>2. Hold the SV tube (Vinyl) using left hand and get the Black tape then start taping using right hand.</p></div></div> <div><p>3. After taping, check the wire alignment, tape condition & measurement.</p></div>		<div><div><p>MEASURING JIG</p></div><div><p>MEASURING TAPE</p></div></div>	<div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension</p><div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div></div> <div><p>4 Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</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

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/ Part Number: D94L / 7N0030-7020

Customer: TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 7, 2023

Validity Date:

n/a

Document No.:

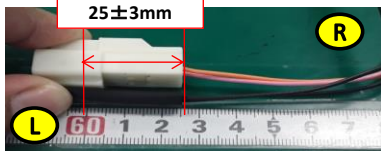

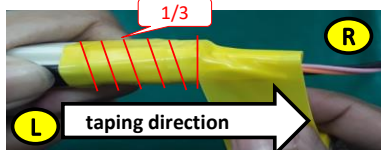
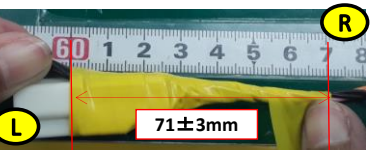
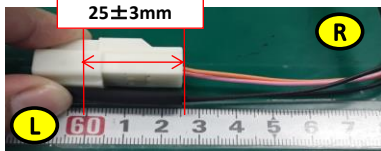

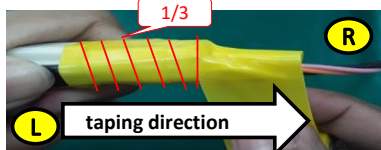
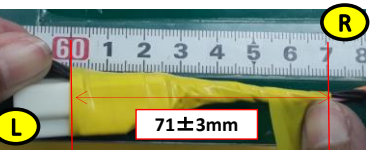
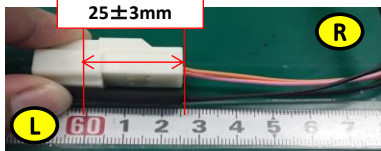

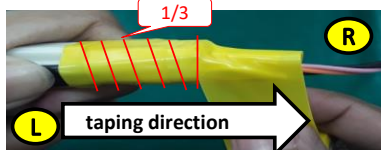
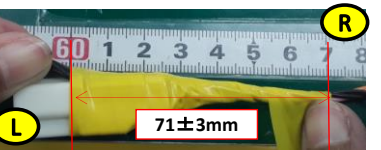
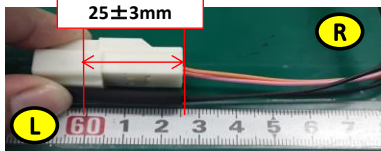

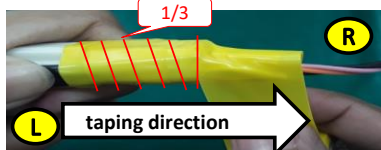
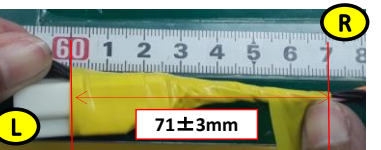
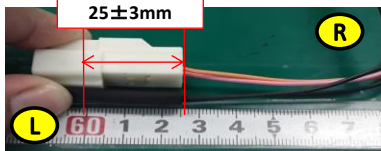

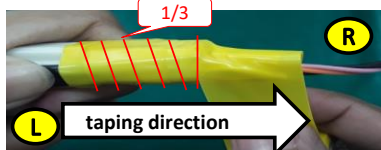
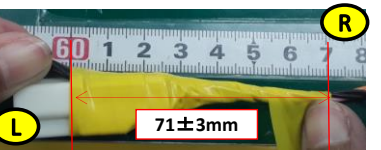
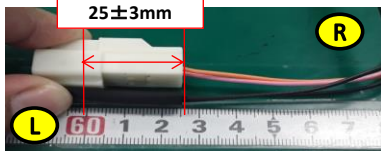

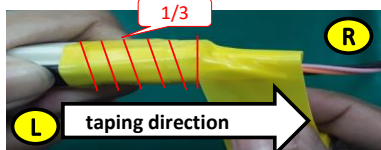
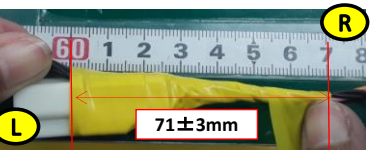
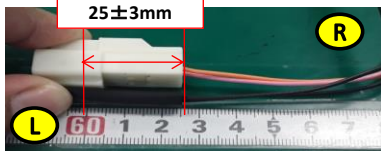

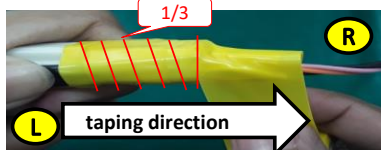
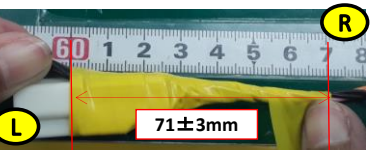
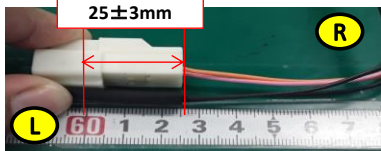

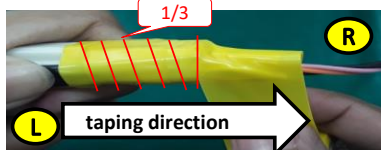
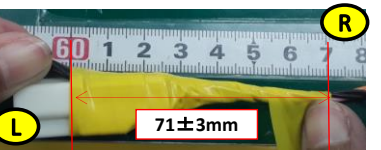
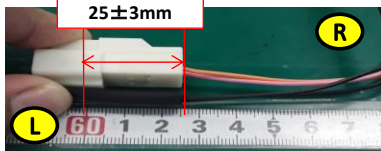

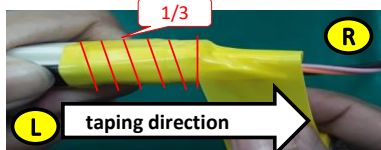
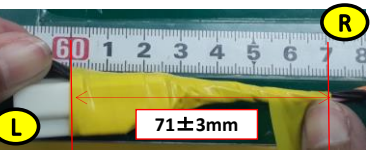
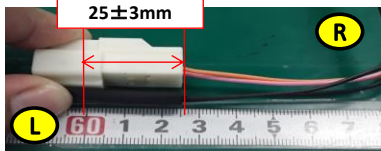

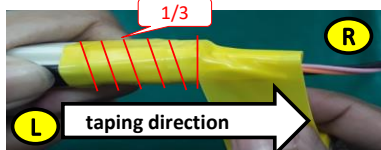
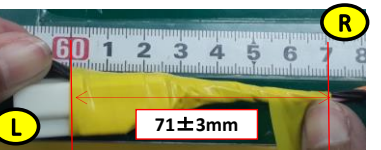
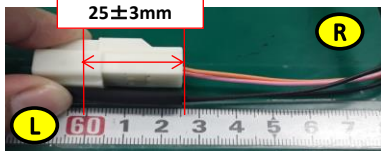

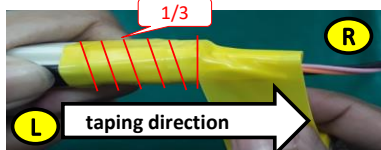
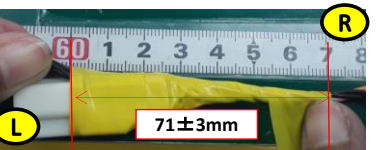
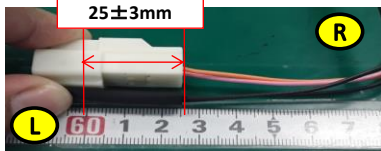

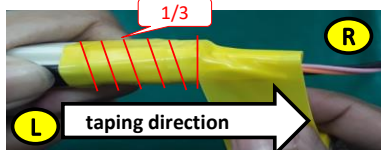
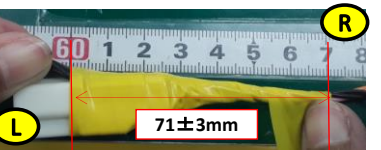
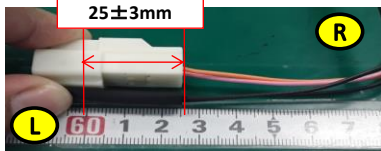

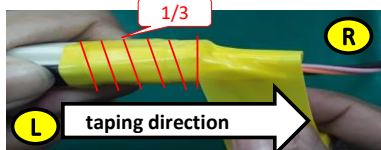
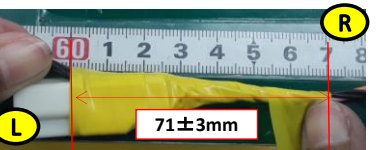
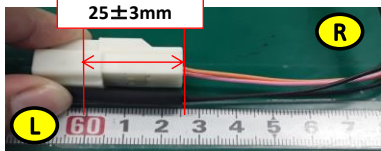

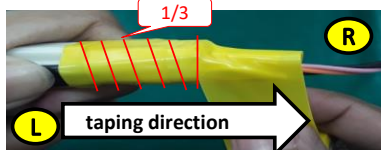
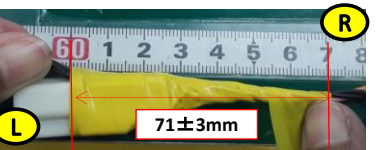
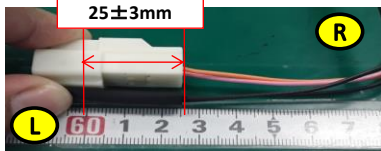

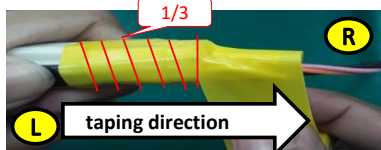
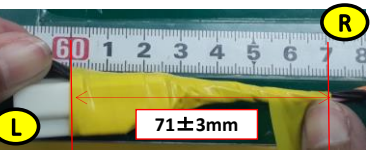
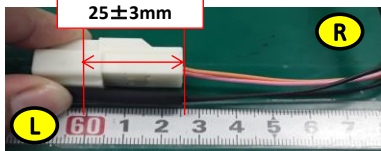

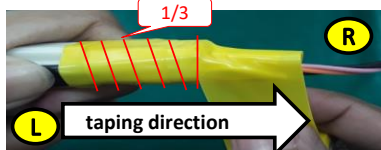
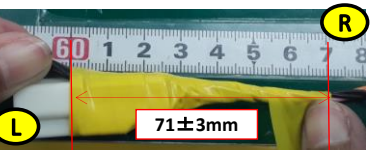
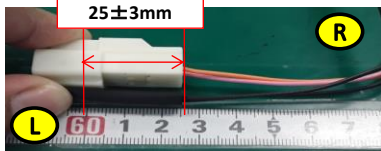

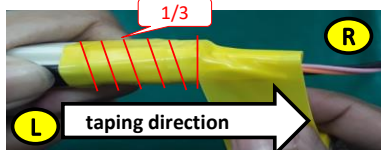
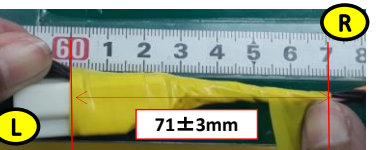
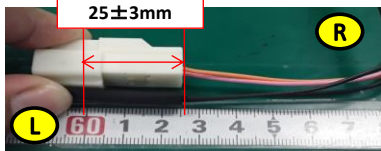

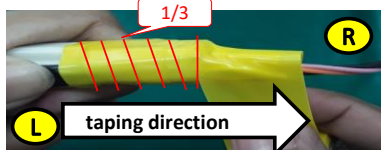
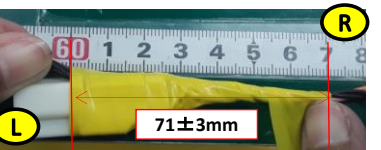
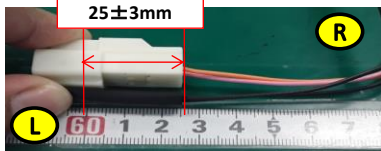

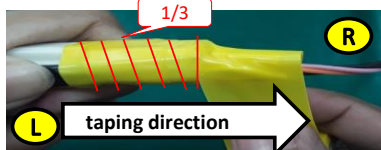
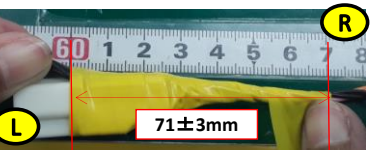
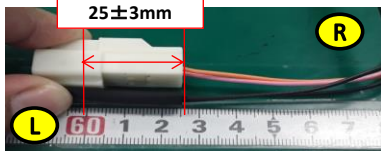

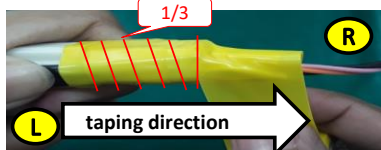
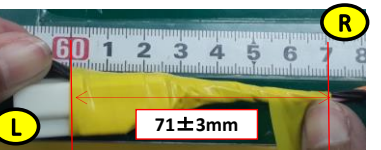
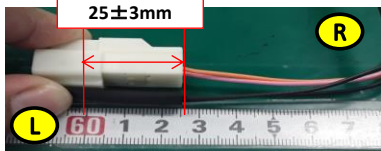

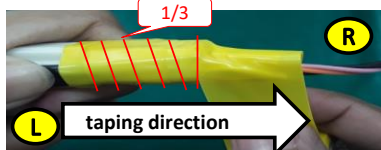
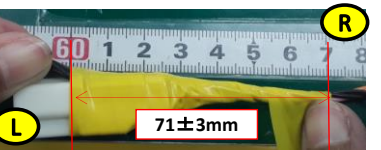
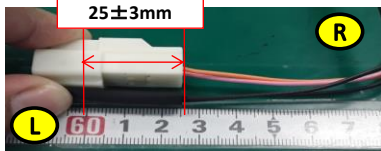

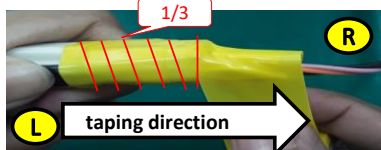
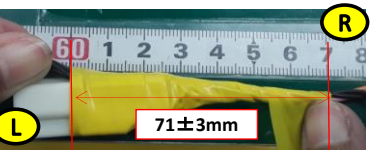
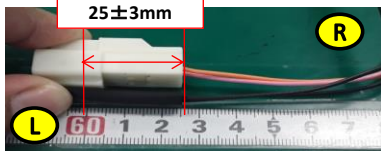

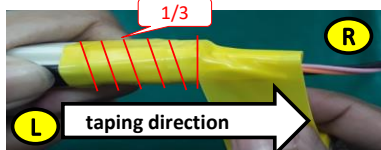
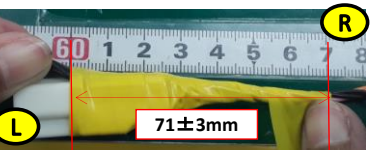
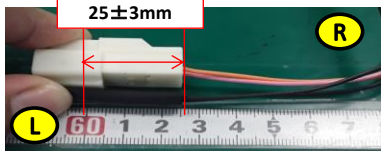

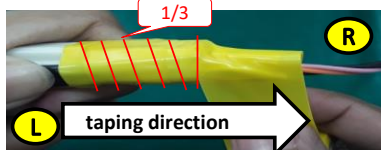
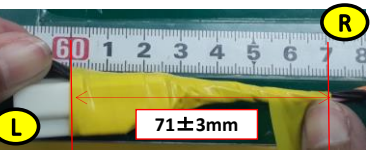
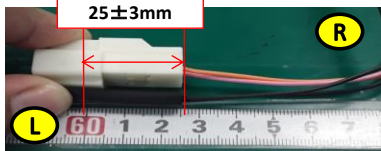

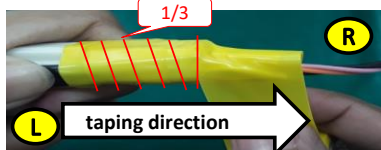
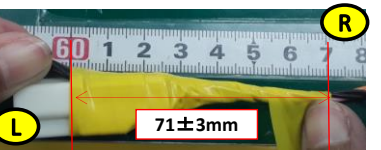
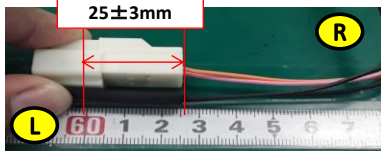

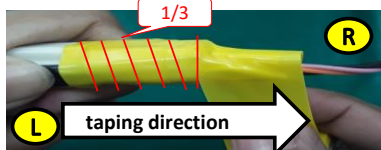
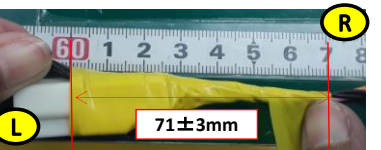
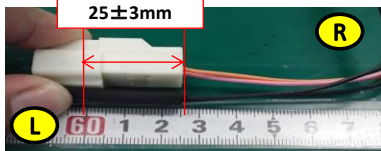

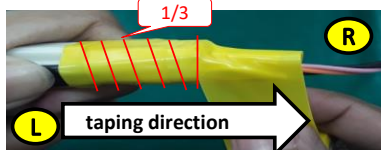
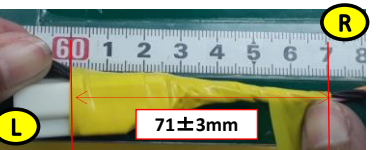
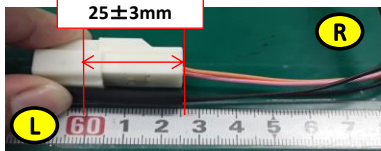

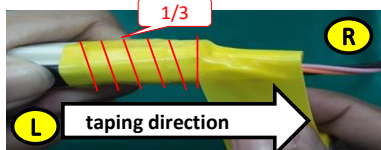
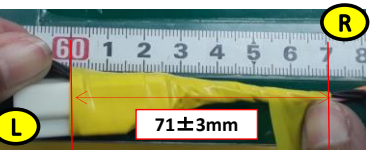
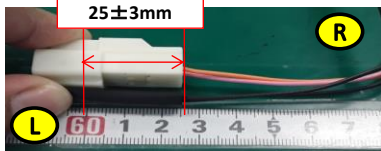

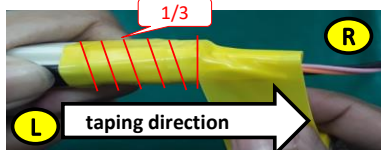
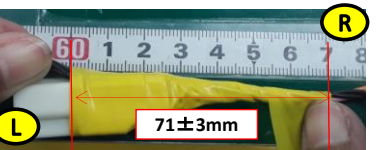
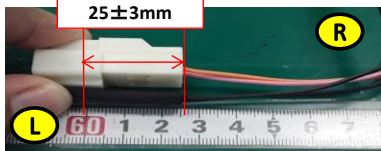

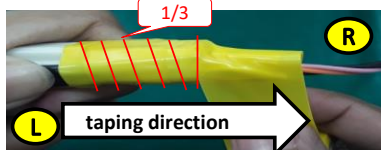
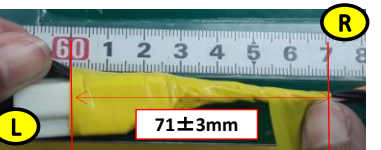
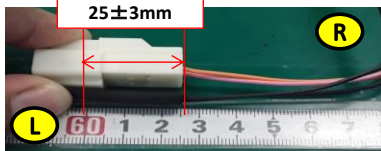

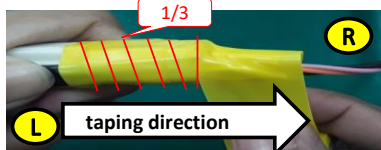
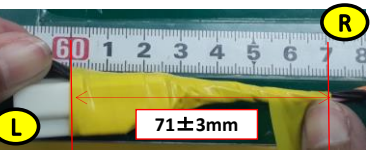
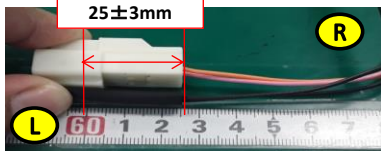

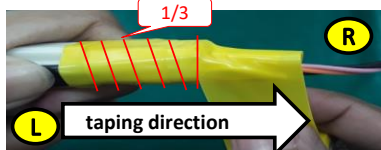
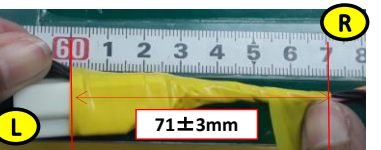
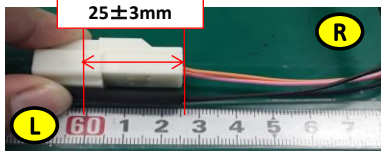

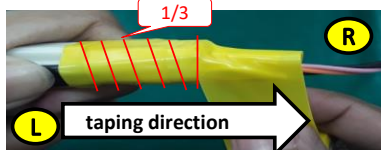
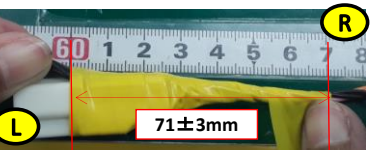
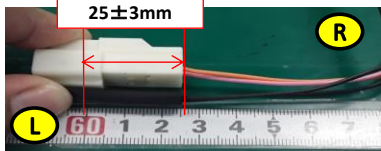

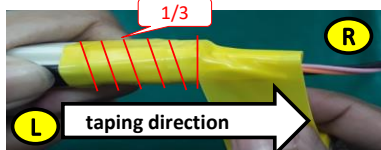
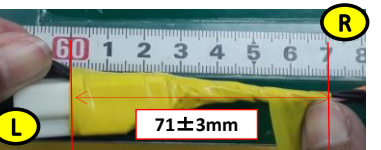
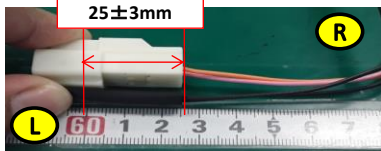

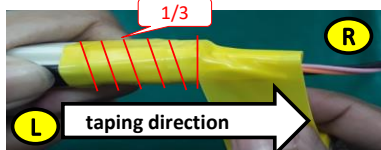
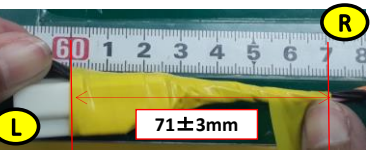
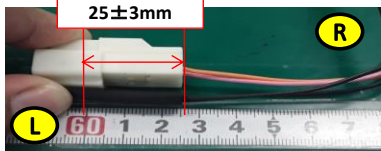

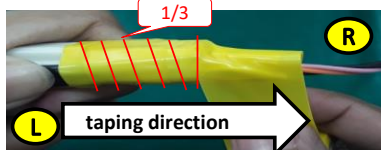
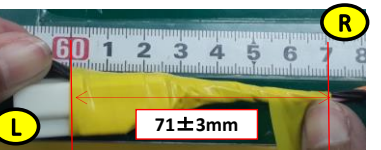
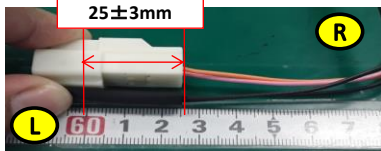

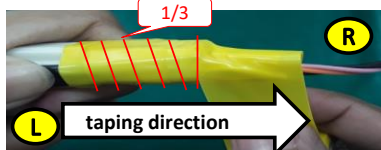
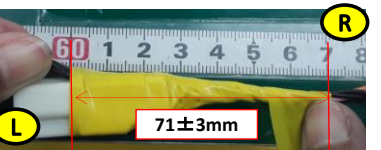
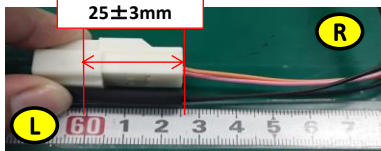

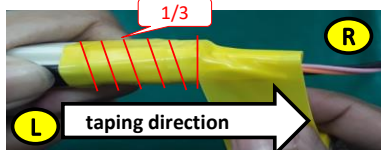
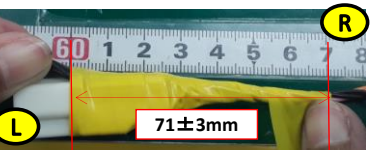
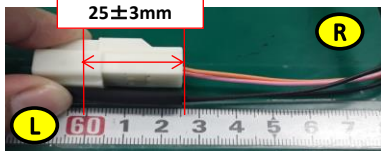

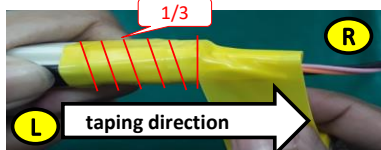
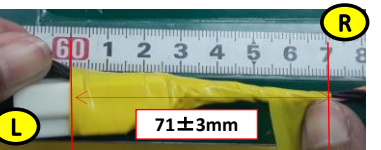
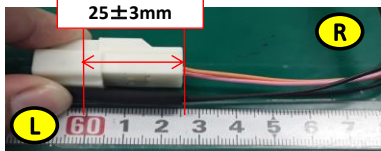

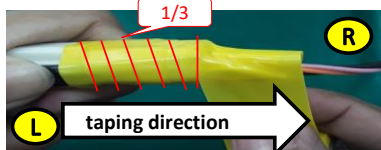
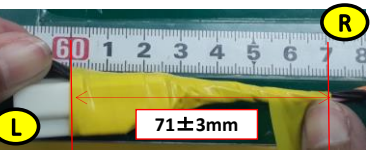
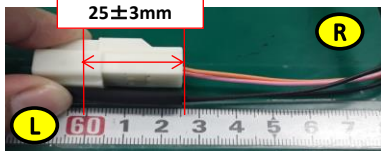

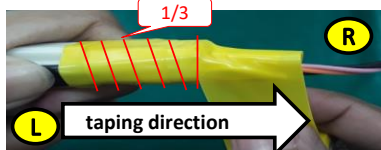
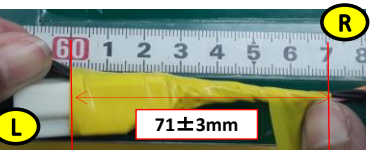
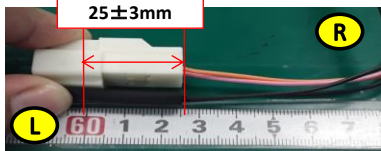

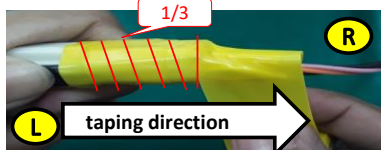
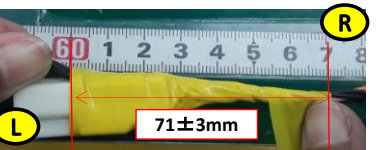
WI-ENG-PDE-054B

Revision No.:

4

Page No.:

4 of 6

PARTS:		1. Black tape		JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Y-Taping 1	<div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div></div></div>		





































































































































































































































































































WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/ Part Number: **D94L / 7N0030-7020**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 7, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-054B

Revision No.:

4

Page No.:

5 of 6

PARTS:

1. Black tape

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

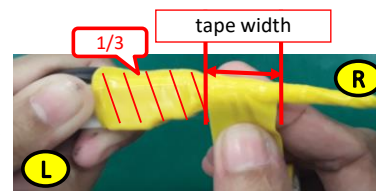
TOOLS/PPE

QUALITY POINTERS

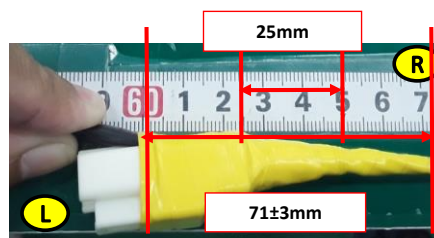
5

P2

Y-Taping 1
(continuation)



5. Make **1 wind** and then **1/3** shifting to the right and make **3 windings** then cut.
Note: End of taping must be in center



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

MEASURING TAPE



4

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. After taping, make sure that vinyl tube must be on the center of connector



GOOD FACING



NG FACING

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: **D94L / 7N0030-7020**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 7, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-054B

Revision No.:

4

Page No.:

6 of 6

PARTS:

n/a

JIG

n/a



QUALITY CHECKPOINTS

P2

7N0030-7020



- ① **No Missing Clip Clamp** ② **No Wrong Dimension (71mm)** ③ **No Missing Tape** ④ **No Terminal Backing Out**

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