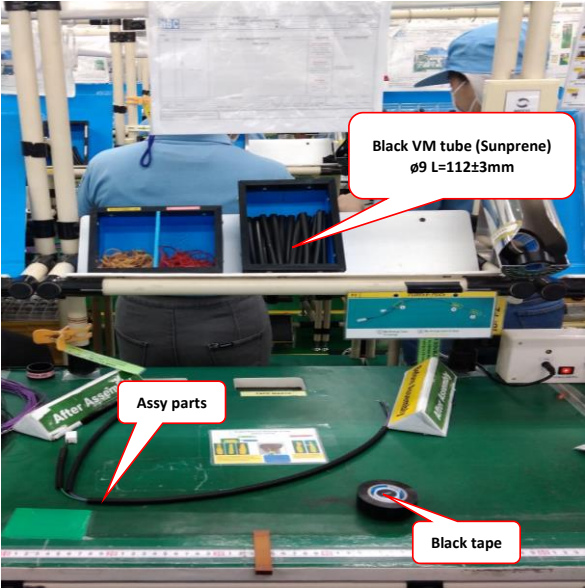
	WORK INSTRUCTION		Effectivity Date:	January 13, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Part Number: 300D / 7N0124-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-604B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.: 1 of 5

PARTS:	1. Assy parts: Black VM tube (Sunprene) ø9 L=112±3mm; Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2 1 Table Lay-out	<div>Table Lay-out</div> 		<div>Safety Instruction</div> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) <div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> 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								Prepared by	Reviewed by	Approved by	Noted by
01/13/23	1	Change document purpose from pre-launch to masspro. Additional table layout. Inclusion of quality checkpoints.						M. Catapang	J. Loterte	C. Villanueva	A. Arañes
12/09/22	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted
								Est. Date:	December 09, 2022		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Document No.:

WI-ENG-PDE-604B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

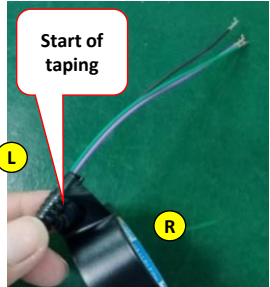
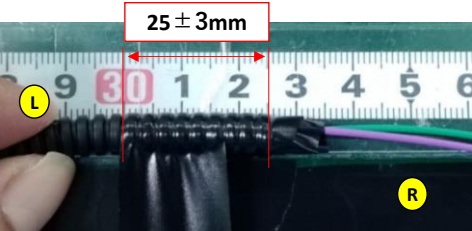
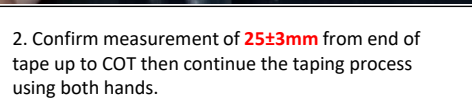
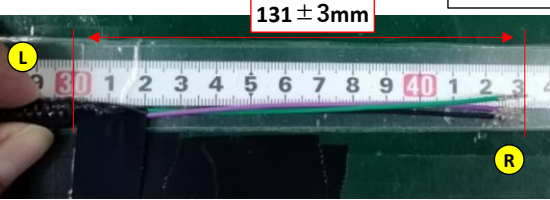
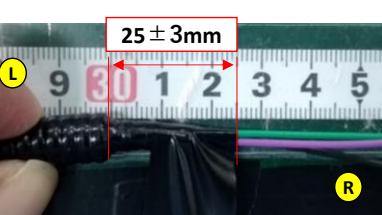
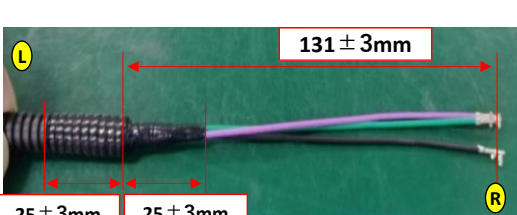

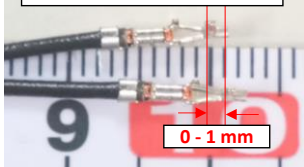
2 of 5

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black COT to wire near terminal	<div><p>Start of taping</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>2. Confirm measurement of 25±3mm from end of tape up to COT then continue the taping process using both hands.</p></div> <div><p>3. Measure from end of COT up to terminal pointed tip 131±3mm then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement of 25±3mm from COT up to end of tape then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, terminal appearance and taping condition.</p></div>	<p>MEASURING TAPE</p> 	<p>Wire alignment tolerance</p>  <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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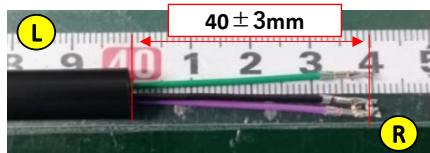

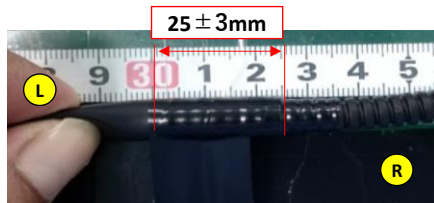
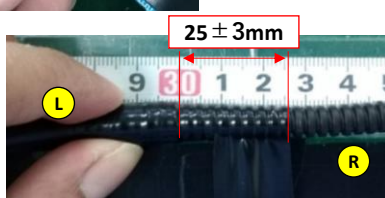


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm		3. Black tape	JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) $\varnothing 9$ L=112\pm3mm using right hand then insert the B-V-G wires using left hand</div>		n/a	1. No wrong use of parts 2. No deformed terminal
4	P2	Taping 2 Black COT to Black sunprene tube near terminal	<div><div></div><div>1. Measure from end of tube up to terminal pointed tip 40\pm3mm using both hands.</div></div> <div><div></div><div>2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div> <div><div></div><div>3. Confirm measurement of 25\pm3mm from end of tape up to end of tube then continue the taping process using both hands.</div></div> <div><div></div><div>4. Confirm measurement of 25\pm3mm from end of tube up to end of tape then continue the taping process using both hands.</div></div> <div><div></div><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div>		 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.	

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Model Code/Part Number: **300D / 7N0124-7020**

Customer:

TRJ

Validity date

n/a

Document No.:

WI-ENG-PDE-604B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

4 of 5

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Y-Taping

No gap in between

1. Fix the 3 corrugated tube .

taping direction

tape shifting 1/3 below

25 ± 3mm

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (25mm)

taping direction

tape shifting 1/2 below

3. Wind the tape **1/3 shifting** until it reach the other side of corrugated tube (**must be tape width**)

Tape shifting 9mm below

25±3mm

25±3mm

4. Wind the tape backward **1/2 shifting**

5. Wind the tape **1/2 shifting** going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

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 dimension
 6. No wrong use of tape

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	January 13, 2023		
Validity date	n/a		
Document No.:	WI-ENG-PDE-604B		
Revision No.:	1	Page No.:	5 of 5

Process Name/Title:		Model Code/Part Number: 300D / 7N0124-7020		Customer: TRJ
Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:

1. Assy parts

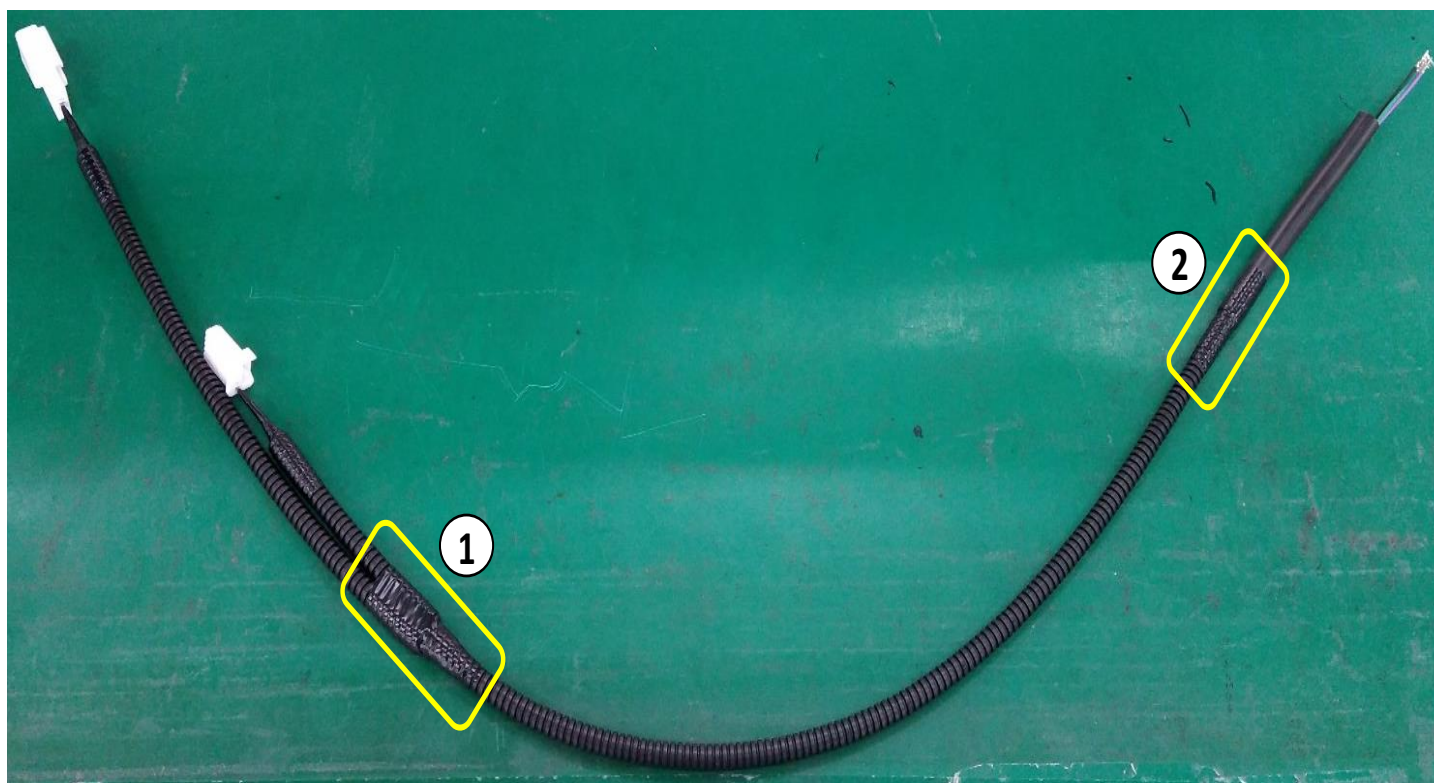
JIG

n/a

1 QUALITY CHECKPOINTS

P2

7N0124-7020



- ① ② No MISSING TAPE
③ Correct Facing of Y-taping

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