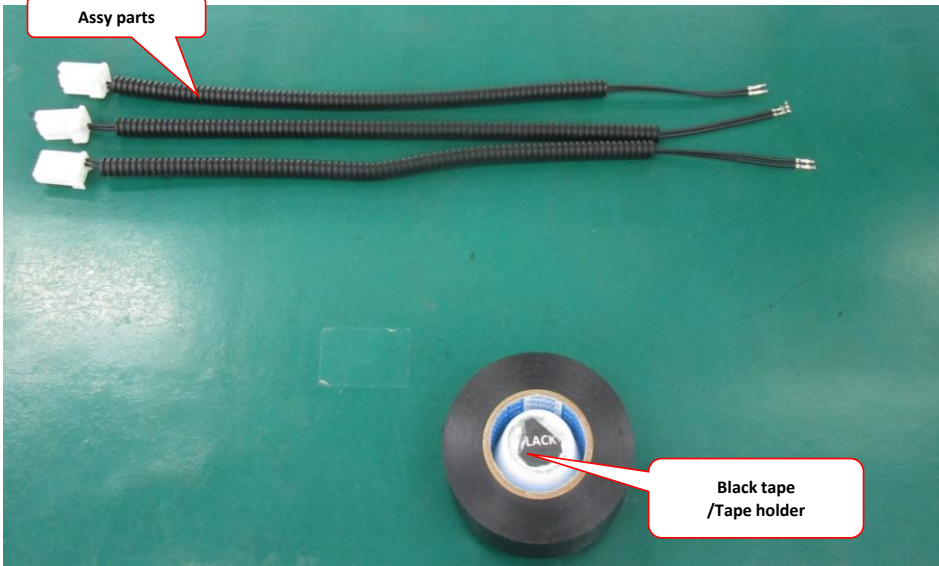



	WORK INSTRUCTION				Effectivity Date: April 28, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Model Code/Part Number: 817B / 7N0052-7020B		Customer: TRJ		Document No.: WI-ENG-PDE-260A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 5		Page No.: 1 of 6	

PARTS: 1. Assy parts 2. Black tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table lay-out	<div style="text-align: center;"> <div>TABLE LAY-OUT</div>  </div>	<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>

04/28/23	5	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	Prepared by  J. Loterte	Reviewed by  C. Villanueva	Approved by  A. Arañes	Noted by n/a
09/20/22	4	Improve quality pointers: Reminders/notes and references in process no.1,2, 3,4 and 5 due to document improvement. Change tolerance in taping process from L=33+2mm/-1mm to 33+3mm/-1mm as countermeasure due to encountered minimum dimension.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
01/03/22	3	Change COT length from L=245±3mm to L=243±2mm (Refer to WI-ENG-PDE-264). Change tolerance to range in taping process from L=53±3mm to L=55±1mm and from L=33±3mm to L=33+2mm/-1mm; from L=46±3mm to L=43-49mm due to encountered minimum dimension from end tape to terminal tip.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
09/28/21	2	Add notes on taping of COT to wire near connector and update the illustration	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date: April 17, 2021

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 28, 2023

Validity Date:

n/a

Model Code/Part Number:

817B / 7N0052-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-260A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

5

Page No.:

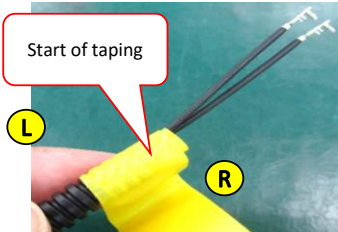
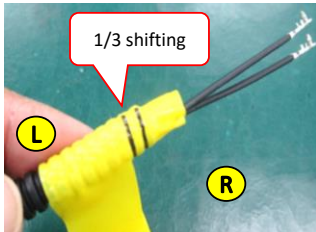
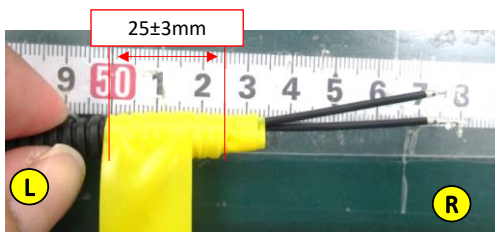
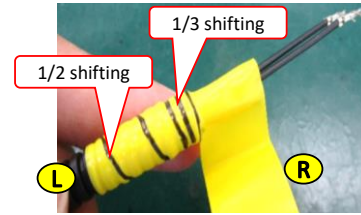

2 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Black corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div><p>1/3 shifting</p></div> <div><p>25±3mm</p></div> <div><p>1/2 shifting 1/3 shifting</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p><p>2. Make 1/3 shifting going to the side of COT until it reach 25mm.</p><p>3. Confirm 25mm measurement from end of tape up to end of COT then make 2 windings of tape using both hands before shifting to other side.</p><p>4. Make 1/2 shifting using both hands going to other side of COT and 1/3 shifting going to wires</p></div>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <ol style="list-style-type: none">1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape

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 28, 2023

Model Code/Part Number:

817B / 7N0052-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-260A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

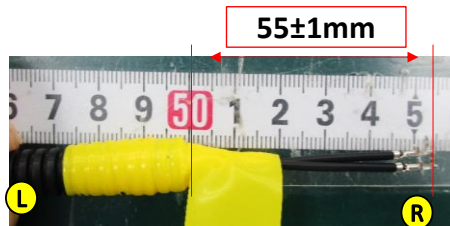
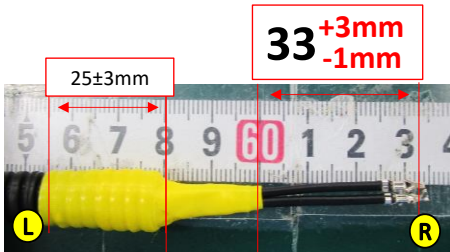

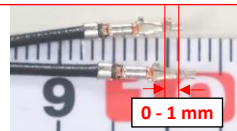
3 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Black corrugated tube to wire near terminal (Continuation)	 	MEASURING TAPE 	 <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension Important reminders/Note/s: <ol style="list-style-type: none">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. Document references: <ol style="list-style-type: none">1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance

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 28, 2023

Model Code/Part Number:

817B / 7N0052-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-260A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

5

Page No.:


4 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 2 Black corrugated tube to wire near connector	<p><i>Note:</i> Avoid pulling down the COT to adjust the dimension if still within the tolerance during measurement. If encountered abnormality STOP the process, CALL the Leader and WAIT for instruction.</p> <p>Start of taping</p> <p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p> <p>2. Make 1/3 shifting going to the side of COT until it reach 25mm.</p> <p>3. Confirm 25mm measurement from end of tape up to end of COT then make 2 windings of tape using both hands before shifting to other side.</p>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape

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 28, 2023

Model Code/Part Number:

817B / 7N0052-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-260A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

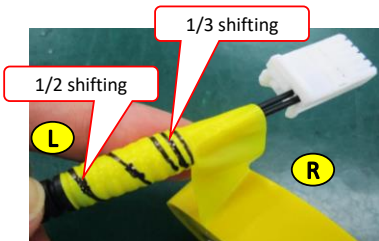
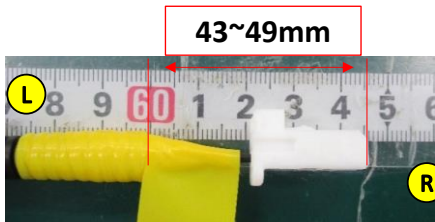
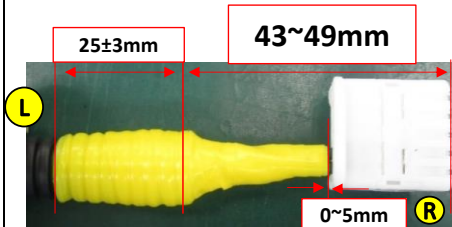

5 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 2 Black corrugated tube to wire near connector (Continuation)	 <p>1/2 shifting</p> <p>1/3 shifting</p> <p>4. Make 1/2 shifting using both hands going to other side of COT and 1/3 shifting going to wires.</p>  <p>43~49mm</p> <p>5. Measure from end of COT up to end of connector 43~49mm then continue the taping process using both hands.</p>  <p>25±3mm</p> <p>43~49mm</p> <p>0~5mm</p> <p>6. After taping, check the measurement and taping condition.</p>	MEASURING TAPE 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape

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 28, 2023

Validity Date:

n/a

Model Code/Part Number:

817B

/

7N0052-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-260A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

5

Page No.:

6 of 6

PARTS:

1. Assy parts

JIG

n/a



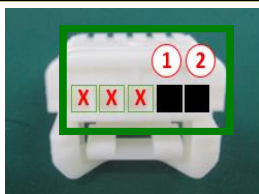
QUALITY POINTERS

P1

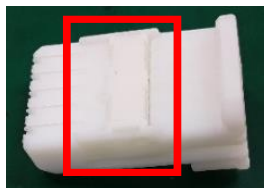
7N0052-7020B



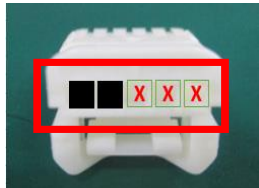
GOOD



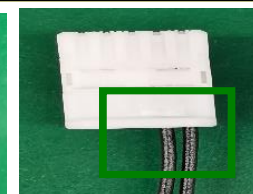
GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock/
Halflocke
Connector

2 No Wrong Insert

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