
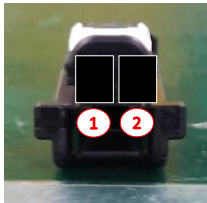

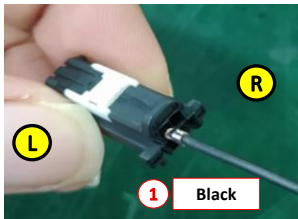
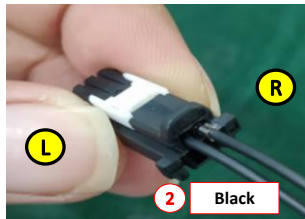
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		March 2, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: 920B / 7R0121-7021		Customer: TRMX		Document No.:		WI-ENG-PDE-642	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 10

PARTS:		1. Connector 6098-6663 (B); AVSSf 0.3 B L=331±2mm [2pcs]		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	n/a Wire insertion to Connector 6098-6663 (B)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>CONNECTOR ORIENTATION</p> </div> <div style="text-align: center;">  <p>VISUAL REFERENCE</p> </div> <div style="text-align: center;">  <p>Wire facing</p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div style="text-align: center;">  <p>1 Black</p> <p>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion.</p> </div> <div style="text-align: center;">  <p>2 Black</p> <p>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</p> </div> </div>		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Pull-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reminder/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
03/02/23	0	Initial issue. Removal of taping from SV tube (Vinyl) to wire near connector. Black Tesa tape (Tesa 51036); Wire length B-B wires from L=316mm to L=331mm; Length of Black twist tube from L=247mm to 257mm						M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:	March 2, 2023		

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 2, 2023

Process Name/Title:

Model Code/Part Number: **920B / 7R0121-7021**

Customer:

TRMX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-642

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

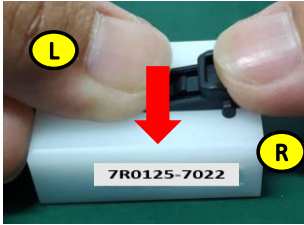
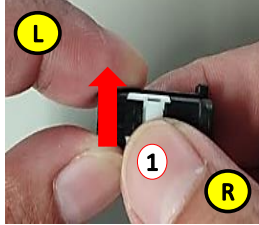
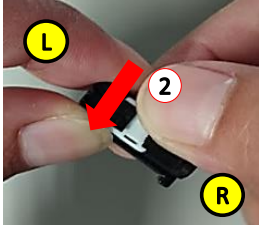
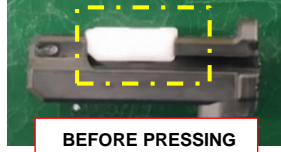
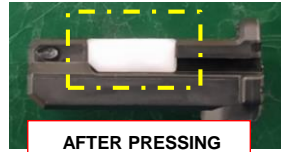


Page No.:

2 of 10**PARTS:**

1. Assy parts
2. Black Twist tube 2420F Ø5 L=257±3mm

JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Connector lock	 <p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector lock if properly locked.</p>   <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>  <p>BEFORE PRESSING</p>  <p>AFTER PRESSING</p>	 <p>LOCKING JIG</p>	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal <p><i>Important reminders/Note/s:</i></p> <ol style="list-style-type: none">1. Manual locking may cause damage connector lock.
3	Wire insertion to Black Twist tube 2420F Ø5 L=257±3mm	 <p>1. Get the Black twist tube 2420F Ø5 L=257±3mm using right hand and insert B-B wires using left hand.</p>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 2, 2023

Process Name/Title:

Model Code/Part Number: 920B / 7R0121-7021

Customer:

TRMX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-642

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:


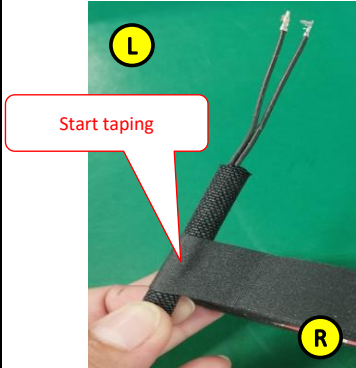
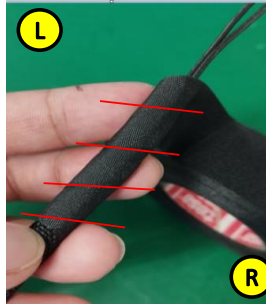


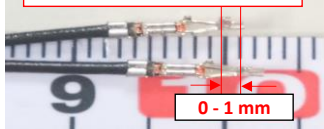
3 of 10

PARTS:

1. Assy parts.
2. Black tesa tape (Tesa 51036)

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a Taping 1 Black twist tube 2420F to Wire near terminal	 <p>1. Measure from Black twist tube 2420F 105±3mm up to terminal tip.</p>  <p>2. Hold the assy parts using left hand . Get Black tesa (51036) using right hand.</p>  <p>3. Make 1 wind before shifting. 1/4 shifting until it reach the wire.</p>  <p>4. Measure from end of Black twisted tube up to terminal tip 66±3mm then continue the taping process using both hands.</p>	<p>MEASURING TAPE</p> 	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement. <p>Wire alignment tolerance</p> 

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

Model Code/Part Number: 920B / 7R0121-7021

Customer:

TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Document No.:

WI-ENG-PDE-642

Revision No.:

0

Page No.:

4 of 10

PARTS:

1. Assy parts

JIG

1. Tape cutter

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

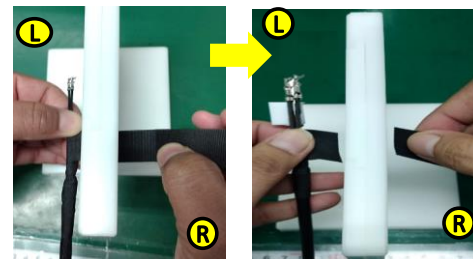
4

n/a

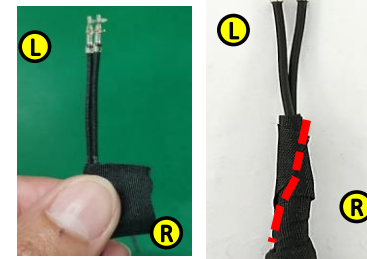
Taping 1
Black twist tube 2420F to
Wire near terminal
(Continuation)



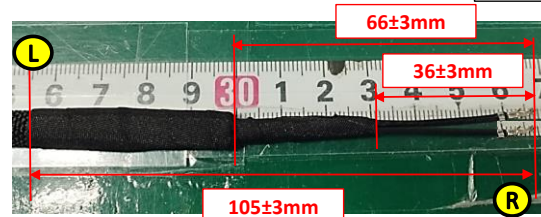
5. Measure from end of Black twisted tube up to terminal tip $36\pm3\text{mm}$ then continue the taping process using both hands.



6. Cut the tape using provided tape cutter when reach the 1 1/2 wind using both hands.



7. After cut, conduct pressing of end tape using both hands.
Note: End tape appearance should be slanted.



8. Check the measurement, taping condition and wire alignment.

TAPE CUTTER



MEASURING TAPE

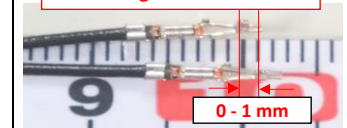


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

Wire alignment tolerance



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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number: **920B / 7R0121-7021**

Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

March 2, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-642

Revision No.:

0

Page No.:

5 of 10

PARTS:

1. Assy parts.
2. Black tesa tape (Tesa 51036)

JIG

1. Tape cutter

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

n/a


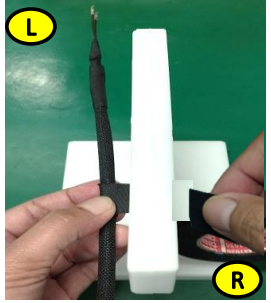
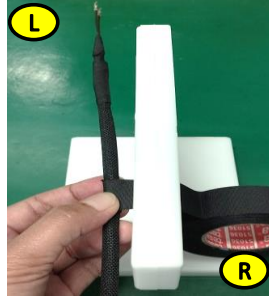


Spot taping

1. Measure from Black twisted tube up to terminal tip $180\pm 3\text{mm}$ using both hands.

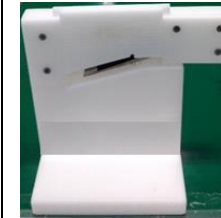
2. Hold the assy parts using left hand. Get Black tesa (51036) using right hand. Make 1 wind of tape before cut. (Must be $20\pm 3\text{mm}$)

3. After cut, conduct pressing of end tape using both hands.

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



TAPE CUTTER



MEASURING TAPE



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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Effectivity Date:

March 2, 2023

Process Name/Title:

Validity Date:

n/aModel Code/Part Number: **920B / 7R0121-7021**

Customer:

TRMX

Document No.:

WI-ENG-PDE-642

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

6 of 10**PARTS:**

1. Clamp 82711-52070 (W)

JIG

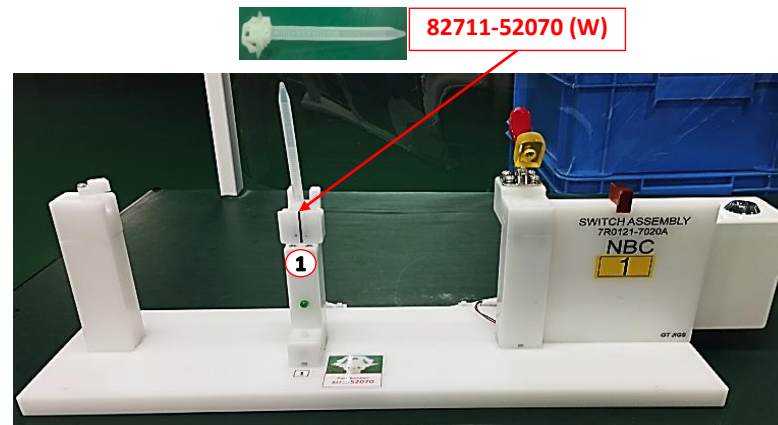
1. Clamp Assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

n/a

Clamp setting



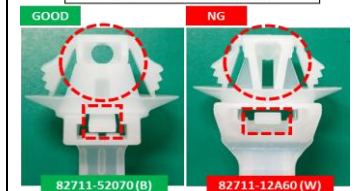
1. Get 1pc of Band clamp **82711-52070(W)** using right hand and set to clamp location **1** using both hands.

n/a

1. No wrong use of clamp
2. No damaged clamp

Important reminders/Note/s:

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

BAND CLAMP ILLUSTRATION

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Effectivity Date:

March 2, 2023

Process Name/Title:

Model Code/Part Number: 920B / 7R0121-7021

Customer:

TRMX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-642

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

7 of 10

PARTS:

1. Assy parts
2. Clamp 82711-52070(W)

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

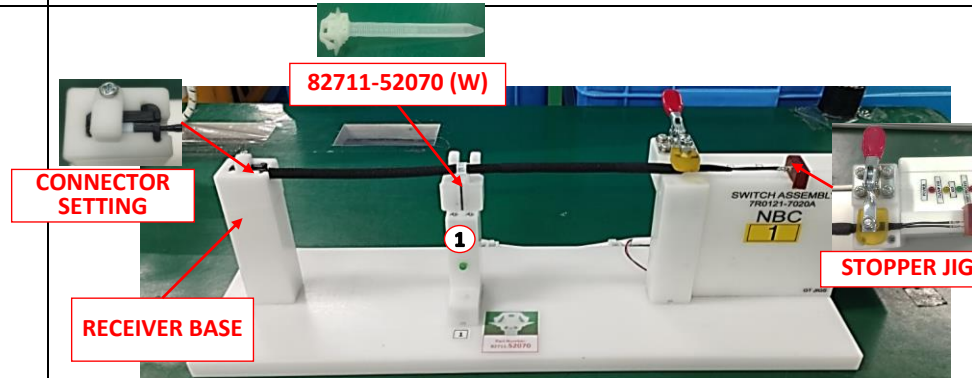
TOOLS/PPE

QUALITY POINTERS

7

n/a

Clamp assembly

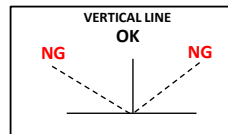


1. Get the assy parts and set into jig using both hands. (See above picture for correct setting). First, set the connector 6098-6663 (B) in Receiver base then lock. Continue to set the harness into jig. Last, set the B-B wires together within the stopper then press by toggle clamp. Continue if the sequence light of location 1 was ON.

2. Check if all LED light for **POWER On**, **Clamp On**, **Wire 1 and 2 was ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

3. Initially tighten the clamp on location 1 using both hands.

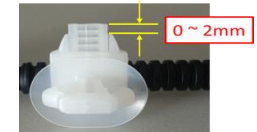
4. Get the Bando Gun (Use **FLAT NOSEPIECE**) using right hand and cut the band clamp on location 1 using both hands. Press the SW button after insertion. **GO** sound will be



5. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:
1. Setting the band clamp cutter depends on the size of the COT/Vinyl Tube.
For: $\phi 5 - 1 \sim 2$, $\phi 7 - 3 \sim 4$



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WORK INSTRUCTION

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Process Name/Title:

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n/a

Model Code/Part Number: 920B / 7R0121-7021

Customer: TRMX

Document No.:

WI-ENG-PDE-642

Purpose: ☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

8 of 10

PARTS:

1. Assembled parts
2. Engineering sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

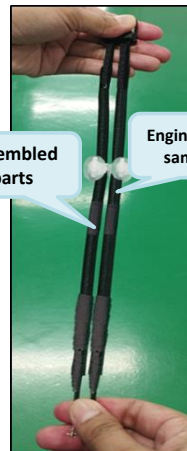
TOOLS/PPE

QUALITY POINTERS

8

n/a

Visual/ By two's Inspection



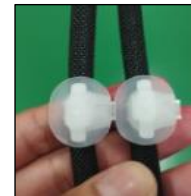
Assembled parts

Engineering sample

1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **connector lock condition** and **insertion** and **taping condition**.



3. Check the **presence of clamp attachment** and **band clamp cut**.



4. Check the **spot taping condition**. Must be no



5. Check the **Tesa taping condition**.



6. Check the **terminal appearance**. Must be no deformed terminals.

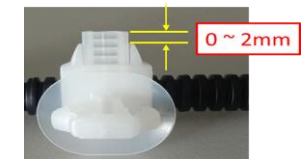
MASTER SAMPLE



1. No skip checking during inspection.

Important reminders/Note/s:

1. Using steel rule, check if the **band cut measurement** is within the required dimension and should not exceed the allowable range (0~2mm).



BAND CLAMP ILLUSTRATION



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Customer:

TRMX

Document No.:

WI-ENG-PDE-642

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

9 of 10

PARTS:

n/a

JIG

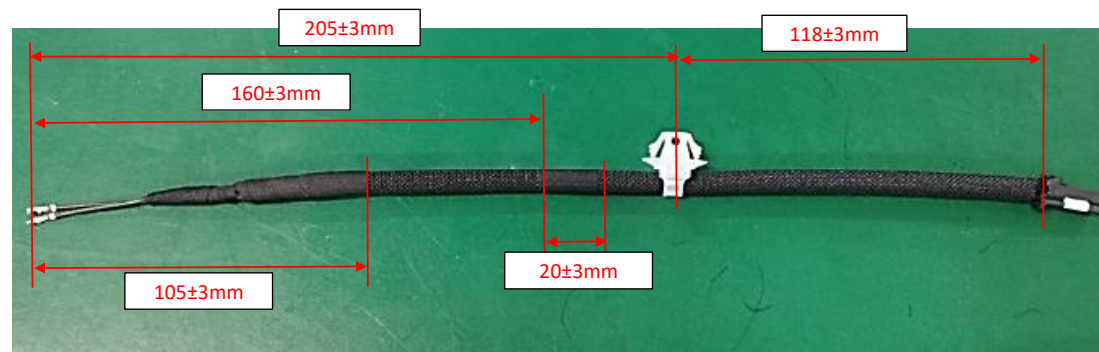
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

9

n/a

Measurement

**MEASURING TAPE**

1. No wrong dimension.

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Fot Hatsumono and Owarimono.

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Customer: TRMX

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n/a

Document No.:

WI-ENG-PDE-642

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

10 of 10

PARTS:

n/a

JIG

n/a

QUALITY CHECKPOINTS

P1

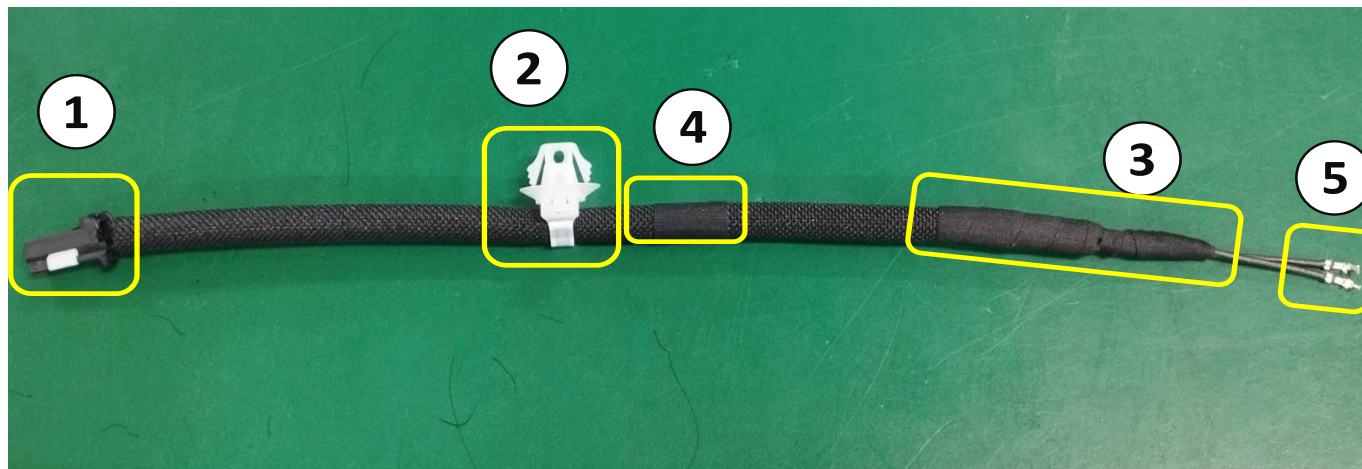
7R0121-7021



GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock/
Halflock Connector

3 No Missing Tesa Tape

5 No Deformed Terminal

2 No Missing clamp

4 No Missing Spot tesa tape

6 No Terminal Backing Out

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