



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 4, 2023

Process Name/Title:

Model Code/Part Number: D01L / 75N346-0271

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

1 of 14

PARTS:

1. Connector PBVP-08V-S (W) [2pcs]

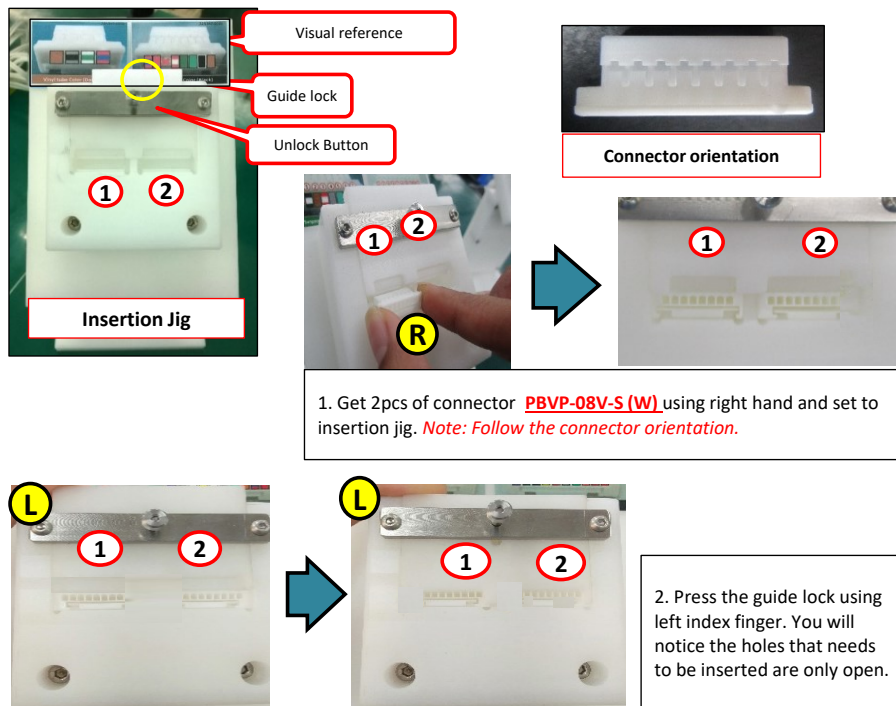
JIG:

1. Insertion jig

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

1

P1

Connector setting to
insertion jig
PBVP-08V-S (W)**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/04/23	6	Change term from sunprene tube to VM tube (Sunprene). Change tube color from Light Gray to N6GR. Correction of wire folding (Page 6). Inclusion of Quality checkpoint (Page 14).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
10/21/22	5	Improve Quality pointers: Reminders/notes and references on page no.2,3,4,5,6,7,8,9,10,11 and 13. Improve work procedure/illustration on process no. 15- Visual/ by two's inspection due to process improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
08/02/22	4	Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
Established Date:			October 9, 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

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **D01L / 75N346-0271**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 4, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Revision No.:

6

Page No.:

2 of 14

PARTS:

1. AVSS 0.3 wires BR L=292±2mm; GR/B L=161±2mm; GR L=161±2mm; W/G L=161±2mm; Y L=161±2mm; OR L=161±2mm; R/L L=292±2mm
2. N6GR VM tube (Sunprene) Ø6.5 L=119±3mm

JIG

1. Insertion jig

NO. **6**

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

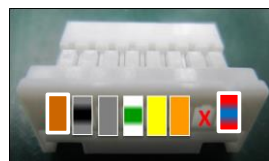
QUALITY POINTERS

2

P1

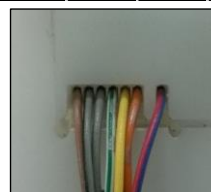
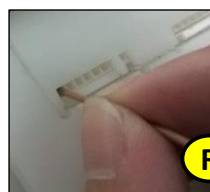
Wire insertion to
Connector
PBVP-08V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE FACING

1	2	3	4	5	6	7	8
BR	GR/B	GR	W/G	Y	OR	X	R/L
292	161	161	161	161	161	X	292



1. Get the **Brown wire** using left hand right hand and insert to connector. Repeat the process for **GR/B-GR-W/G-Y-OR-R/L**. Skip the **7th** terminal slot.
Note: Follow the insertion sequence based on the illustration.

STEERING
NAVIGATION



CONTROLLER



Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
3. Insertion of wire must be from left to right.

Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Refer to GL-PRO-ASY for Pull-Push procedure.

3

Wire insertion to N6GR VM
tube (Sunprene)
Ø6.5 L=119±3mm



1. Hold the wires using left hand, get the **N6GR VM tube (Sunprene) Ø6.5 L=119±3mm** using right hand then insert the wires.

N/A

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

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

D01L**/****75N346-0271**

Customer:

TRJ

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

April 4, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Revision No.:

6



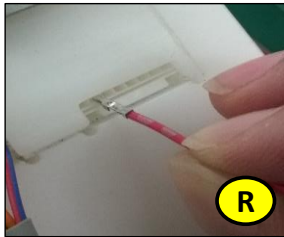
Page No.:

3 of 14**PARTS:**

1. AVSS 0.3 wires R L= 161±2mm; V L=161±2mm; R/W L=161±2mm; G L=161±2mm; LG L=161±2mm; B L=161±2mm

JIG

Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to Connector PBVP-08V-S (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div>Wire facing</div><div>1. Get the the RED wire using right hand and insert to connector. Repeat the process for V-R/W-G-LG-B. <i>Note: Skip the 1st and last terminal slot. Follow the insertion sequence based on the above illustration.</i></div></div>	N/A	<div>1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. COnduct Pull-Push-Pull-Push after insertion. 3. Insertion of wire must be from left to right.</div> <div>Document reference/s: 1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 3. Refer to GL-PRO-ASY for Pull-Push procedure.</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

Effectivity Date:

April 4, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number **D01L / 75N346-0271**

Customer:

TRJ

Document No.:

WI-ENG-PDE-097

Purpose:


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

4 of 14

PARTS: 		1. Black VM tube (Sunprene) Ø7 L=119±3mm 2. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to Black VM tube (Sunprene) Ø7 L=119±3mm	 		N/A	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires Important reminders/Note/s: 1. Refer to GL-PRO-ASY-025 for Inspection standard for coupler insertion
6	Wire insertion to assy parts	 		N/A	1. No deformed terminal 2. No remaining wires outside tube. Important reminders/Note/s 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

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 4, 2023

Model Code/Part Number

D01L

/

75N346-0271

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

5 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

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

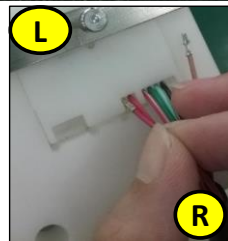
7

P1

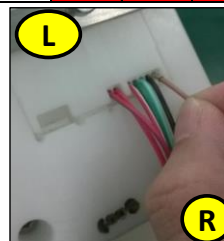
Wire insertion to
Connector
PBVP-08V-S (W)INSERTION SEQUENCE FROM LEFT TO
RIGHT

Wire facing

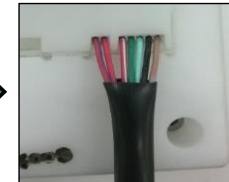
1	2	3	4	5	6	7	8
R/L	X	X	X	X	X	X	BR
292	X	X	X	X	X	X	292



1. Hold the **R/L wire** and insert to connector beside **Red wire** on left side using right hand.

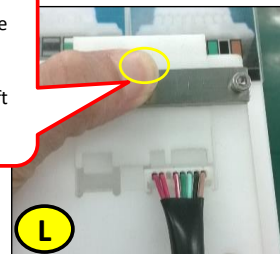


2. Hold the **BR wire** and insert to connector beside **Black wire** on right side using right hand.



3. Remove the harness from jig.
Check the wire insertion condition.

Press the
unlock
button
using left
thumb.



N/A

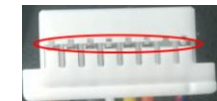
1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
3. Insertion of wire must be from left to right.

Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection standard for coupler insertion
2. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Refer to GL-PRO-ASY for Pull-Push procedure.



Terminal tip must
be visible

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 4, 2023

Validity Date:

n/a

Model Code/Part Number

D01L

/

75N346-0271

Customer:

TRJ

Document No.:

WI-ENG-PDE-097

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

Page No.:

6 of 14

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

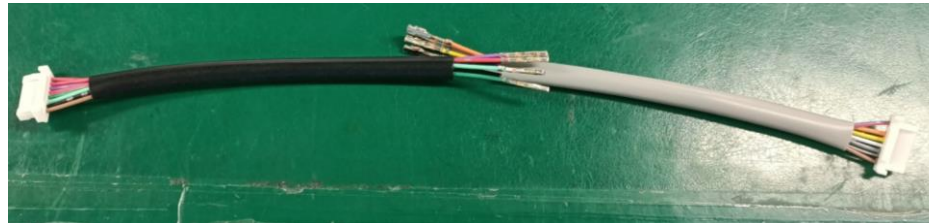
TOOLS/PPE

QUALITY POINTERS

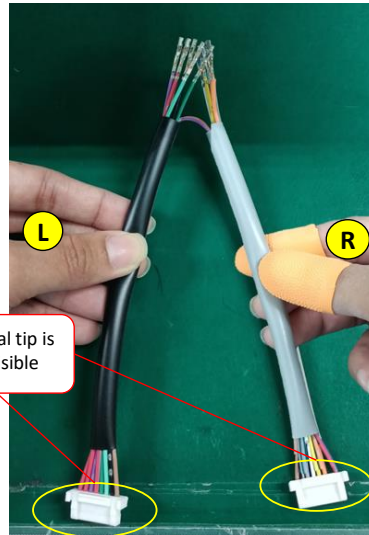
8

P1

Wire Folding



BEFORE FOLDING



AFTER FOLDING

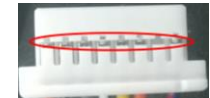
1. Hold the assy parts using both hands then conduct wire arrangement.

N/A

1. No wrong facing of connector
2. No tangled wires

Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection standard for coupler insertion



Terminal tip must be visible

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:

April 4, 2023

Process Name/Title:

Model Code/Part Number: **D01L / 75N346-0271**

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Purpose:

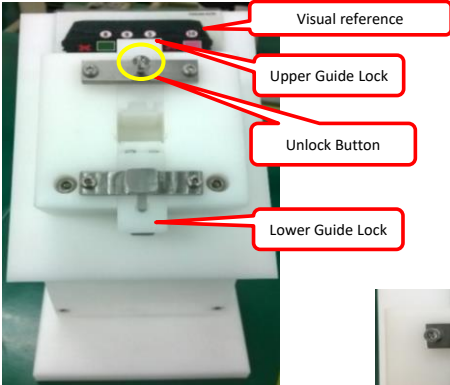
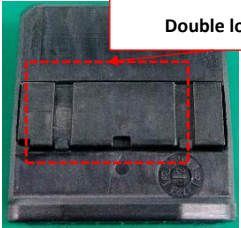





☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

7 of 14

PARTS:		1. Connector 1318386-2 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div>INSERTION JIG</div><div>Visual reference</div><div>Upper Guide Lock</div><div>Unlock Button</div><div>Lower Guide Lock</div></div> <div><div>Double lock</div><div>Note: Check the connector before insertion.</div></div> <div><div>CONNECTOR ORIENTATION</div><div>1. Get the connector 1318386-2 (B) using left hand then insert to insertion jig.</div></div> <div><div></div><div>2. Press the upper and lower guide lock using left thumb and index finger. You will notice the holes that needs to be inserted are only open.</div></div>		N/A	<div>1. Use the provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div> <div>CONNECTOR LOCK APPEARANCE CHECK</div> <div><div>GOOD</div><div>UNLOCK</div></div> <div><div>NG</div><div>HALF-LOCKED</div></div> <div>Important reminders/Note/s:</div> <div>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</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

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **D01L / 75N346-0271**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 4, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Revision No.:

6

Page No.:

8 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

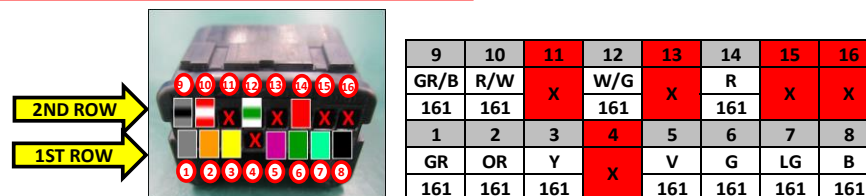
QUALITY POINTERS

10

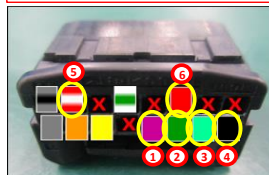
P1

Wire insertion to
connector
1318386-2 (B)

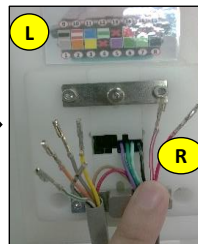
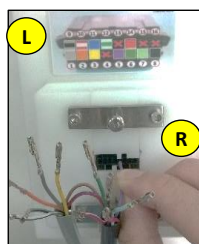
INSERTION SEQUENCE FROM LEFT TO RIGHT



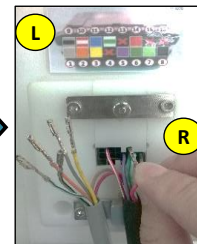
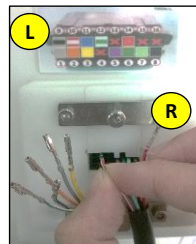
BLACK VM TUBE (SUNPRENE)



FIRST ROW (LEFT TO RIGHT)



SECOND ROW (LEFT TO RIGHT)



6

1. Insert the first wire from Black VM tube (Sunprene). Get the Violet wire and insert to terminal slot 5 using right hand. Repeat the process for G-LG-B wires. Get the R/W wire and insert to terminal slot 10, and Red on terminal slot 14.

Note: Follow the insertion sequence based on the illustration stated above.

N/A

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
3. Insertion of wire must be from left to right
4. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

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

Effectivity Date:

April 4, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number **D01L / 75N346-0271**

Customer:

TRJ

Document No.:

WI-ENG-PDE-097

Purpose:

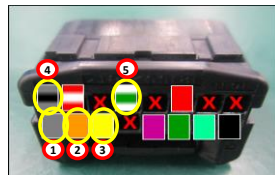

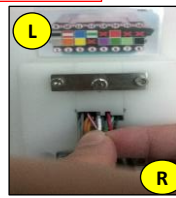
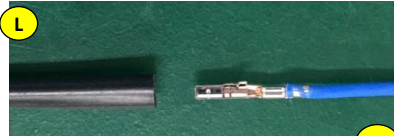

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

9 of 14

PARTS:		1. AVSS 0.5 wires L=129±2mm 2. Black VM tube (Sunprene) Ø3 L=113±3mm			3. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
11	P1	Wire insertion to connector 1318386-2 (B)	<div><div>LIGHT GRAY VM TUBE (SUNPRENE)</div><div></div><div>FIRST ROW (LEFT TO RIGHT)</div><div></div><div>SECOND ROW (LEFT TO RIGHT)</div><div></div><div>2. Insert the wires from N6GR VM tube (Sunprene). Get the Gray wire and insert to terminal slot 1 using right hand. Repeat the process for OR-Y wires. Get the GR/B wire and insert to terminal slot 9 and W/G to terminal slot 12. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></div></div> <div>6</div> <div>N/A</div> <div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip Important reminders/Note/s: <i>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</i></div>					
12	P1	<div><div>6</div><div>Wire insertion to Black VM tube (Sunprene) Ø3 L=113±3mm</div></div>	<div><div>L</div><div></div><div>R</div><div>1. Get the Blue wire using right hand and insert to Black VM tube (Sunprene) Ø3 L=113±3mm</div><div>2. Measure the VM tube (sunprene) up to the tip of the terminal, it should be 11mm.</div><div>6</div></div> <div>MEASURING TAPE</div> <div></div> <div>1. No wrong use of parts Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement. 2. Peel-off wire should be covered by sunprene tube (Black)</i> Document reference/s: <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></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

Effectivity Date:

April 4, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

D01L / 75N346-0271

Customer:

TRJ

Document No.:

WI-ENG-PDE-097

Purpose:

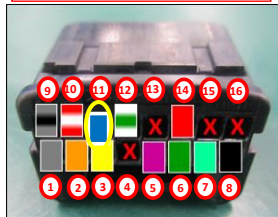



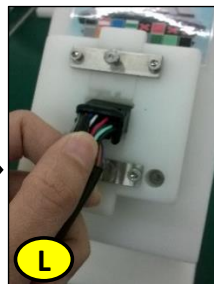

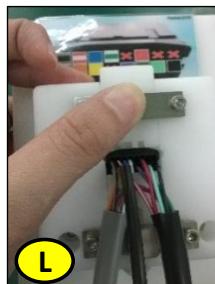
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

10 of 14

PARTS:		1. Assy parts			JIG	1. Insertion jig																																									
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS																																								
13	P1	Wire insertion to Connector 1318386-2 (B)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div>WIRE FACING</div><div></div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>9</td><td>10</td><td>11</td><td>12</td><td>13</td><td>14</td><td>15</td><td>16</td></tr><tr><td>X</td><td>X</td><td>L</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td></tr><tr><td></td><td></td><td>129</td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td></tr></table><div><div>1. Get the BLUE WIRE with inserted tube and insert to connector at slot no.11 using right hand.</div></div><div><div>2. Push the unlock button and press the lower guide unlock lever using left thumb and slightly pull out the inserted wires from insertion jig.</div></div></div>			9	10	11	12	13	14	15	16	X	X	L	X	X	X	X	X			129						1	2	3	4	5	6	7	8	X	X	X	X	X	X	X	X	N/A	<div>1. No wrong insertion 2. No deformed terminal 3. No stuck-up of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div>2. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div>
9	10	11	12	13	14	15	16																																								
X	X	L	X	X	X	X	X																																								
		129																																													
1	2	3	4	5	6	7	8																																								
X	X	X	X	X	X	X	X																																								

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:

April 4, 2023

Process Name/Title:

Model Code/Part Number: **D01L / 75N346-0271**

Customer:

TRJ

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

6

Page No.:

11 of 14

PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		<div><div></div>6</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
13	P1	Wire arrangement	<div><div>Double lock in upward position</div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div></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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

D01L

/

75N346-0271

Customer:

TRJ

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

April 4, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-097

Revision No.:

6

Page No.:

12 of 14

PARTS:

1. Assembled parts
2. Master sample

JIG:

N/A

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

15

P1

Visual/By Two's Inspection

1. Check the connector lock, locking of connector is included in Steering electrical test.

2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if no backing out (not fully inserted) or deformed terminal.

Black VM tube (Sunprene)

N6GR VM tube (Sunprene)

Black VM tube (Sunprene)

4. Check the orientation of harness.

5. Compare to **Master sample** by tapping.

Master sample

Assembled parts

1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

MASTER SAMPLE



Document reference/s:

1. Refer to **WI-ENG-PDE-431** for **Steering Electrical Test** after assembly.

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

Effectivity Date:

April 4, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number

D01L / 75N346-0271

Customer:

TRJ

Document No.:

WI-ENG-PDE-097

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

Page No.:

13 of 14

PARTS:

N/A

JIG:

N/A

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

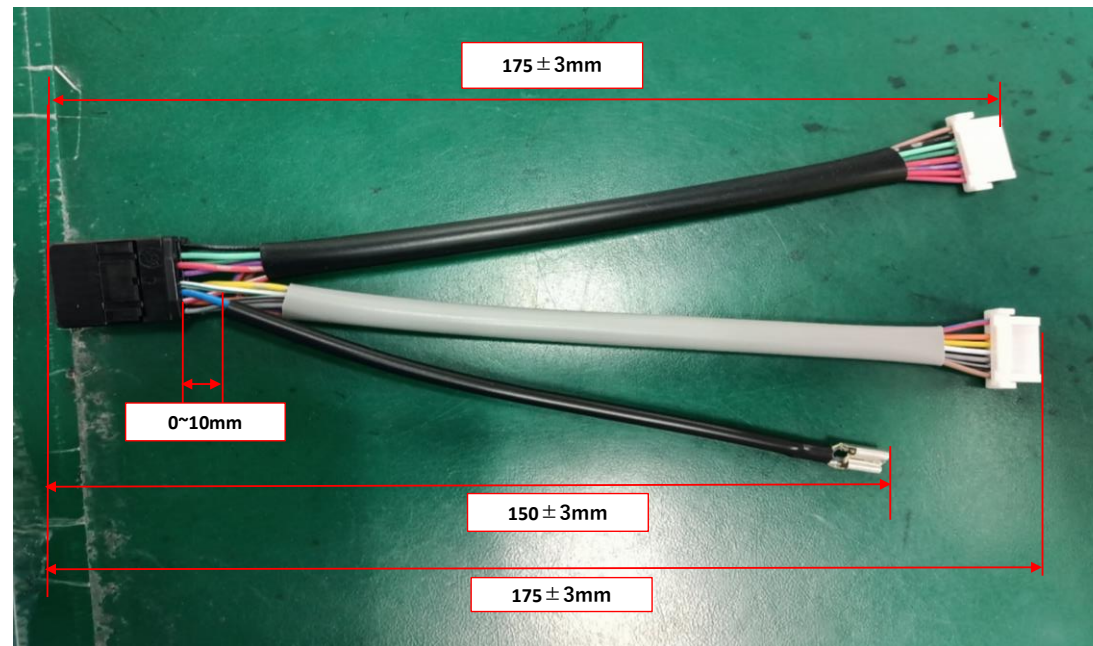
TOOLS/PPE

QUALITY POINTERS

16

P1

Measurement



MEASURING TAPE



Important reminders/Note/s:

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

1. No wrong dimension.

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

Effectivity Date:

April 4, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: **D01L / 75N346-0271**

Customer:

TRJ

Document No.:

WI-ENG-PDE-097

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

Page No.:

14 of 14

PARTS:

n/a

JIG

n/a



QUALITY CHECKPOINTS

75N346-0271

1. Check the connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

Black VM Tube (Sunprene)

N6GR VM Tube (Sunprene)

Black VM Tube (Sunprene)

3. Check the orientation of harness.

4. Check if no missing parts.

5. Check the terminal if with backing out (no fully inserted) or deformed terminal

6. Compare to master sample.



**FOLDED WIRES
MUST BE IN
BACK POSITION**

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