| PARTS: 1. Assy parts 2. Block kap parts 1. Assy parts 2. Block Rays parts 2. Block Rays NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION Tool.S/PPE QUALITY POINTERS Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) 1. No lip-out tape 2. Measure from end of COT up to terminal 120-3 mm and PCB 116:3 mm Province in your locker, finger cots, etc.) 1. Hold the COT using left hand, get the Block lamp using right the start ort-oping at the middle of COT and wires using both hands. Revision History Prepared by: Reviewed by: Approved by: Noted by Pr | | | | WORK INSTRUCTION | | | | | Effe | Effectivity Date: | | November 04, 2021 | | |
|--|---|--------|---|---|--|--|--|---|---------------------|---|---|--|-----------|--|
| PARTS: 1. Assy parts 2. Black tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, infiger cots, etc.) Housekeeping 1. Maintain and always practice 5s. 2. Measure from end of COT up to terminal 12083mm and PCB 10 wire now formanial 10 year to represent the taping process using both hands. Rep if in your locker. Alor level 10 year to replace thand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands. Revision No: 0 Page No: 1 of 3 JIG: No. Signature Aler Level For any trouble, inform the hands. Revision No: 0 Page No: 1 of 3 JIG: No. Signature Aler Level For any trouble, inform the taping growth page of the middle of COT and wires using both hands. Revision No: 0 Page No: 1 of 3 Aler Level For any trouble, inform the taping growth page of the middle of COT and wires using both hands. Revision No: 0 Page No: 1 of 3 JIG: No. Signature Aler Level For any trouble, inform the taping growth page of the middle of COT and wires using both hands. Revision No: 0 Page No: 1 of 3 Aler Level For any trouble, inform the taping growth page of the middle of COT and wires using both hands. Revision No: 0 Page No: | | | 7 | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Val | Validity Date: | | n/a | | | |
| PARTS: 1. Assy parts 2. Black tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Safety Instruction Safety Instruction Safety Instruction Safety Instruction Be sure to wear prescribed personal procedure quipment during operation (gloves, infiger cots, etc.) 1. Maintain and always practice 5x. Personal things on the workplace is prohibited. So prohibited. So prohibited to wire near terminal to the model of COT up to terminal 120-3mm and PCB. It is shown the notify the safety in your toder. Alert Level 1. Hold the COT using left hand, get the Black tope using right then start pre-taping at the model of COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using right then start pre-taping at the model of COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using right then start pre-taping at the model of COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using right then start pre-taping at the model of COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using right then start pre-taping at the model of COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using right then start pre-taping at the model of COT and wires using both hands. 1. Hold the COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using the model of COT and wires using both hands. 1. Hold the COT using left hand, get the Black tope using the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT and the start pre-taping at the model of COT | | - 1 (| Л | Model Code/Part Number | 240B/ 7M0514-7020B | Customer: | TRJ | | Doo | cument No.: | | WI-ENG-PDE | -356A | |
| NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE Safety Instruction Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping I. Maintain and always practice 9's. 2. Measure from end of COT up to terminal 120:3mm and PCB 1. Housekeeping I. Maintain and always practice 9's. 2. Personal things on the workplace is prohibited. Reptil to your locker. Alert level 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. 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. Revision History Prepared by: Reviewed by: Approved by: Noted by A | | | 4 | Purpose: | PROTOTYPE | PRE-LAUNCH | MASSPRO |) | Rev | rision No.: | 0 | Page No.: | 1 of 3 | |
| NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE Safety Instruction Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping I. Maintain and always practice 9's. 2. Measure from end of COT up to terminal 120:3mm and PCB 1. Housekeeping I. Maintain and always practice 9's. 2. Personal things on the workplace is prohibited. Reptil to your locker. Alert level 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. 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. Revision History Prepared by: Reviewed by: Approved by: Noted by A | | | | | | | | | | | | | | |
| Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5S. 2. Personal things on the workplace is prohibited. Keep it in your tocker. S. Alert level For any trouble, inform 1. Hold the COT using left hand, get the Black tape using right then start per-taping at the middle of COT and wires using both hands. Revision History Prepared by: Reviewed by: Approved by Noted by Revision History Prepared by: Reviewed by: Approved by Noted by Revision History Prepared by: Reviewed by: Approved by Noted by Revision History Prepared by: Reviewed by: Approved by Noted by Revision History Prepared by: Reviewed by: Approved by Noted by Revision History | | | Black | | | | | | | | | | | |
| Taping 1 Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice Srs. 2. Personal things on the workplace is prohibited. 3. No loose tape 1. No lipi-out tape 2. No peek-off tape 3. No loose tape 4. No worn guise of tape 5. No worn guise of tape 6. No worn guise of tape 6. No worn guise of tape 7. No wor | NO. | | PROCESS NAME WORK PROCEDURE/ ILLUSTRATION | | | | TOOLS/PPE | C | UALITY PO | INTERS | | | | |
| Dofa On Till and | 1 | | | Taping 1 Black Corrugated tube | Start of taping R 1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the | Vinyl tube to PCB 2. Measure from end of C 116±3mm then continue Tape width Tape width | 120±3mm 116±3mm 20T up to termine the taping process 120±3mm 4 5 6 7 1 | Terminal tip R R R R R R R R R R R R R | 2 2 2 3 5 5 5 5 6 6 | Safety Instruction Be sure to wear prescribed personal protective equipment uring operation (gloves, finger cots, etc.) Housekeeping I. Maintain and always practice 5's. Personal things on the vorkplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant upervisor or Line Leader or immediate corrective action. MEASURING TAPE | 1. No flip 2. No pe 3. No loc 4. No mi 5. No wr 6. No wr | o-out tape sel-off tape se tape sissing tape rong dimension rong use of tape se use calibrated/ suring tape when | verified | |
| 11/04/21 0 Initial issue K Dotia I Loterte C Villagueva A Arañas K Poria I Loterte C. Villagueva A Arañas | Revision History Prepared by: Reviewed by: Approved by: Noted by: | | | | | | | | | Noted by: | | | | |
| | 11/04/21 | | itial issu | ie | Dataile of Observe | · | | | A. Arañes | | oterte | C. Villanueva | A. Arades | |
| Eff. Date Rev. No Details of Change Prepared Checked Approved Noted Est. Date: November 04, 2021 | ∟π. Date Re | ev. No | | | Details of Change | | Prepared C | Checked Approved | Noted | Est. Date: | | November 04, 20 |)21 | |

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| | | | WORK IN | STRUCTION | | Effectivity Date: | | | November | 04, 2021 | | |
|--------|--|---|--------------------------------------|--|--|-------------------|----------------|--|--|----------|--|--|
| | | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | | Validity Date: | | n/a | | | |
| | | Model Code/Part Number | | | | Document No.: | Document No.: | | WI-ENG-PDE-356A | | | |
| | | Purpose: | PROTOTYPE | PRE-LAUNCH | ☐ MASSPRO | Revision No.: | | 0 | Page No.: | 2 of 3 | | |
| | 1 | | | | | | | | | | | |
| PARTS: | PARTS: 1. Assy parts 2. Black sunprene tube Ø9 L=73±3 | | mm 3. Black tape | | | | JIG | | | n/a | | |
| NO. | PI | ROCESS NAME | WORK F | WORK PROCEDURE/ ILLUSTRATION | | | | QUALITY POINTERS | | | | |
| 2 | P1 | Half wrap taping | Start of taping 1/3 shifting | 1. Hold the Corrugated tube begin taping using right hand Repeat the process until the tube. Make 3 windings and to 1/2 shifting | d. Make 1/2 shifting. e end of corrugated then cut the tape. | | | 2. No pe 3. No lo 4. No m 5. No w | p-out tape eel-off tape ose tape iissing tape rong dimension rong use of ta | | | |
| 3 | | Wire insertion to Black sunprene tube ¢9 L=73±3mm | 1. Get the Sunprene using left hand. | tube ϕ 9 L= 73±3mm using right har | R and insert the wires | n/a | | | rong use of pa eformed termi | | | |

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| | | | WORK INSTRUC | Effectivity Date: | November 04, 2021 | | |
|-----|---------------------------|---|--|-------------------|--|----------------|--------------------|
| | | Process Name/Title: | TAPING ASS | EMBLY PROCES | SS | Validity Date: | n/a |
| | | Model Code/Part Number: | | Customer: | TRJ | Document No.: | WI-ENG-PDE-356A |
| | | Purpose: | | PRE-LAUNCH | MASSPRO MASSPRO | Revision No.: | 0 Page No.: 3 of 3 |
| | | | | | | | |
| | Assy parts Black tape | | | | | JI | G n/a |
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P1 | Taping 2 Black Corrugated tube to sunprene tube | Vinyl tube to PCI S8±3mm 1. Hold the assy parts using left hand. Measure from Sunprene tube to terminal pointed tip 62±3mm at 58±3mm. Left tape width t | R 62±3mm 3. A mea | 2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand. Refer to WI-PRO-ASY-001 for taping procedure. ffter taping, check the asurement and taping dition. | MEASURING TAP | 4.No loose tape |

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