



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

May 13, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 816W / 7H0402W7020A

Customer:

NBS

Document No.:

WI-ENG-PDE-494C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

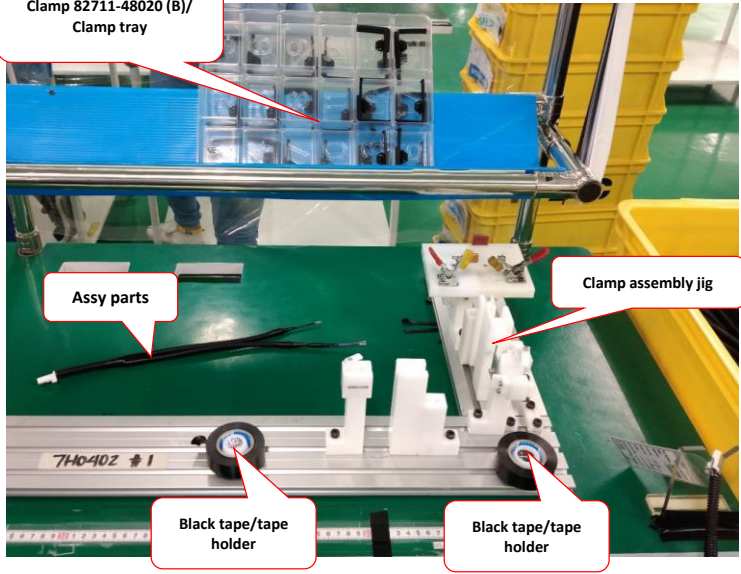
1 of 7

PARTS:

1. Assy parts: Clamp 82711-48020 (B); Black tape [1pc.]

JIG:

1. Temporary Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out 	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. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by:
05/10/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/29/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				

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:

May 13, 2022

Model Code/Part Number:

816W**/****7H0402W7020A**

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

2 of 7**PARTS:**

1. Clamp 82711-48020 (B)
2. Black tape

JIG

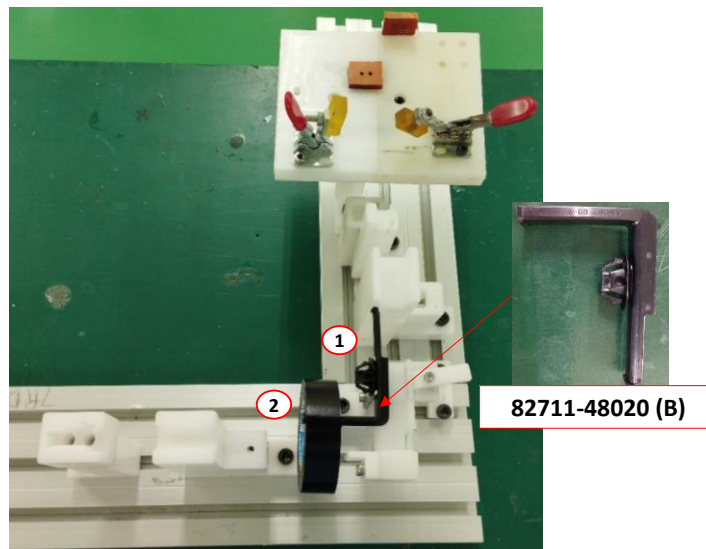
1. Temporary Clamp Assembly jig

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

2

P3

Clamp Setting

**82711-48020 (B)**

1. Get 1 pc. of band clamp **82711-48020 (B)** then set to clamp location **1** using both hands.

2. Initially attach **Black tape** on clamp location **2** using both hands.

Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.

1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape
4. No missing clamp

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:

May 13, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: **816W / 7H0402W7020A**

Customer:

NBS

Document No.:

WI-ENG-PDE-494C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:

1. Assy part
2. Black tape

JIG

n/a

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

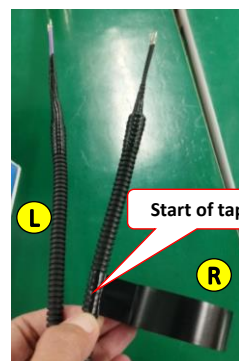
3

P3

Spot taping



1. Hold the assy parts using both hands then measure from end of connector up to COT (with inserted B-B wires) **202±1mm**.

**Start of taping**

2. Get the **Black tape** then conduct **2 windings** of tape using both hands.
Note: Do not cut the tape

MEASURING TAPE

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

Note:

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

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:

May 13, 2022

Process Name/Title:

Model Code/Part Number: 816W / 7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:

1. Assy parts
2. Black tape

JIG

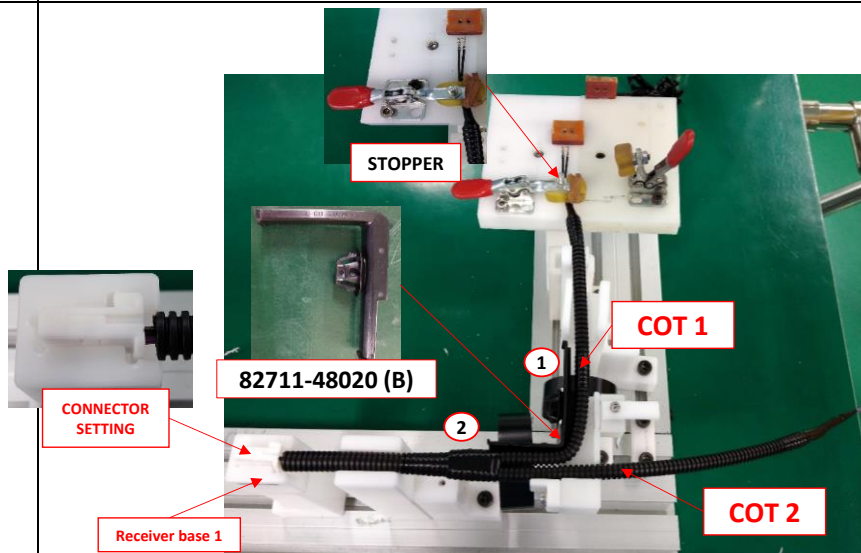
1. Temporary clamp assembly jig

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

4

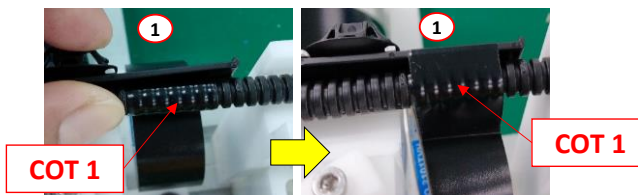
P3

Clamp Assembly



1. Set the assy parts into jig. *(See above picture for correct setting)*. First, set the connector 6098-3810 (W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp.

2. Continue the taping process for clamp location 1. Make 2 windings of tape together with clamp. Do not cut the tape. *(See below picture)*



n/a

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

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:

May 13, 2022

Process Name/Title:

Model Code/Part Number: 816W / 7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:

1. Assy parts
2. Black tape

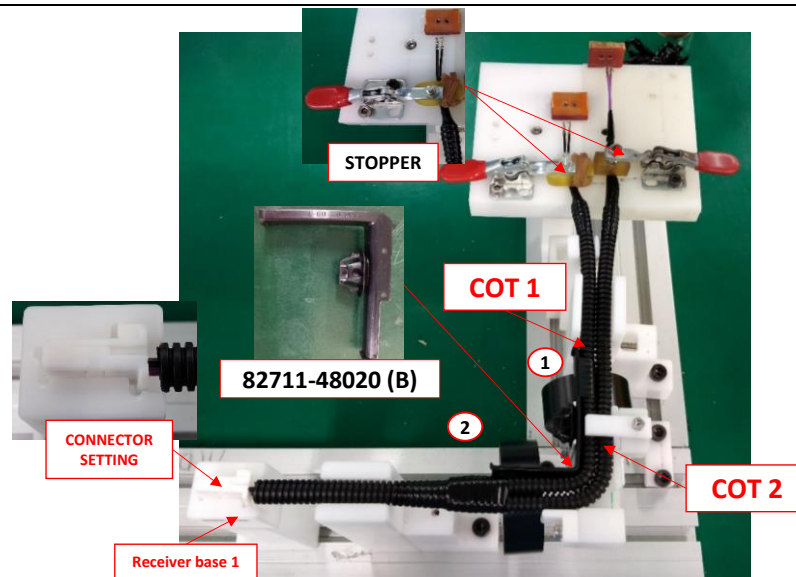
JIG

1. Temporary clamp assembly jig

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

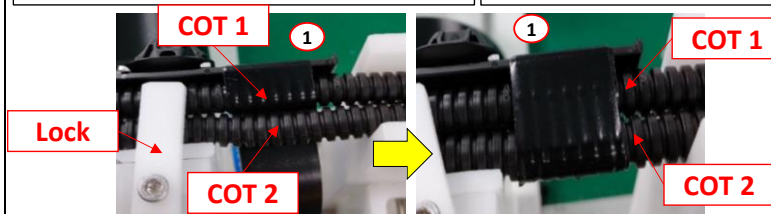
4

P3

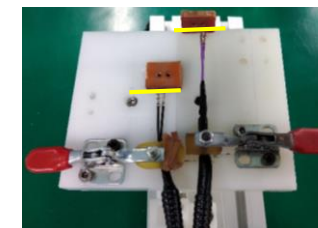
Clamp Assembly
(Continuation)

3. Combine the **COT 2 to COT 1** then lock. Set the **V-V wires** together within the stopper then press by **Toggle clamp**. (See correct setting of harness)

4. Hold the tape on clamp location **1**, make **3 windings** of tape then cut the tape using both hands. (See below picture)



n/a



Note: Make sure no gap between stopper jig and terminals.

1. No wrong use of tape
2. No missing tape
3. No damage clamp
4. No missing clamp
5. No skip process

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:

May 13, 2022

Process Name/Title:

Model Code/Part Number: 816W / 7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494C

Purpose:

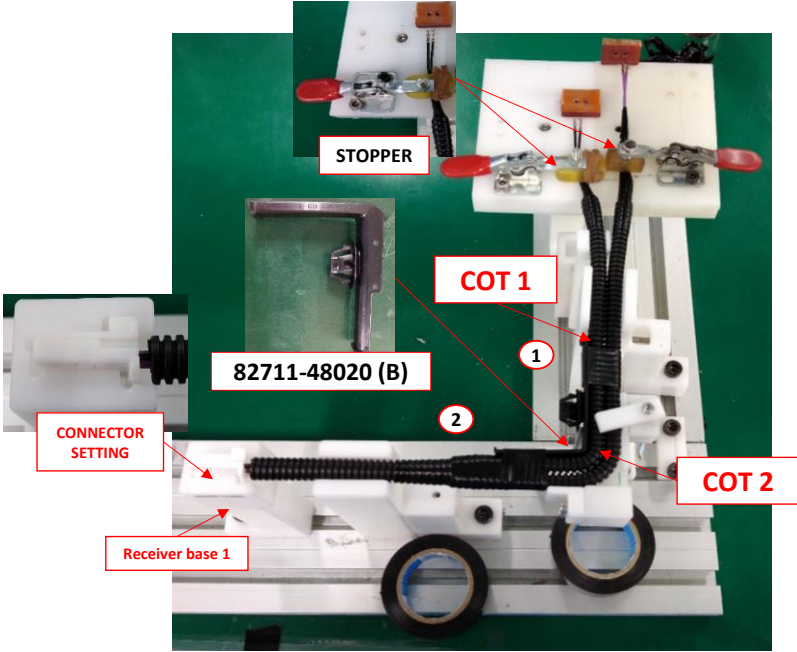
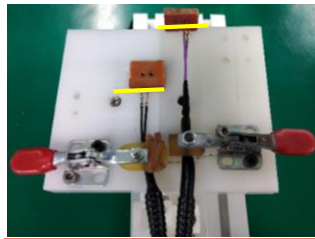
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

6 of 7

PARTS:		1. Assy parts 2. Black tape	JIG	1. Temporary clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Clamp Assembly (Continuation)	 <p>5. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands.</p> <p>6. Conduct POINT CHECKING before removing the harness from jig.</p>	n/a	 <p><i>Note: Make sure no gap between stopper jig and terminals.</i></p> <p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</p>

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:

May 13, 2022

Model Code/Part Number:

816W

/

7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494C

Purpose:

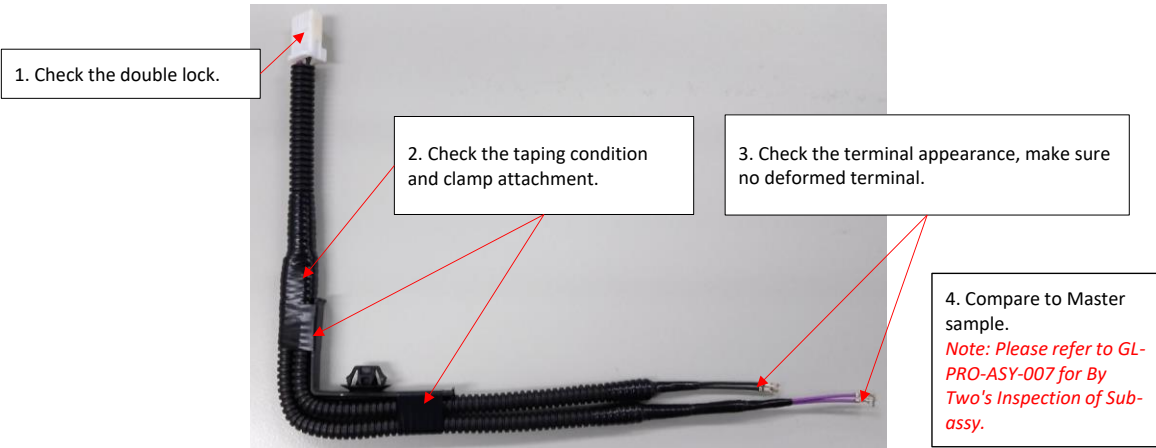

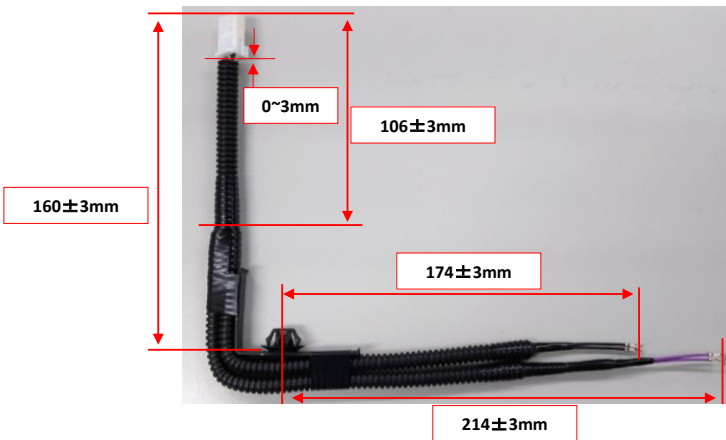

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7

PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Visual/By two's inspection				MASTER SAMPLE 
6	Measurement			 Note: Please use calibrated/verified measuring tape when getting the measurement.	FOR HATSUMONO AND OWARIMONO ONLY 1. No wrong measurement

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