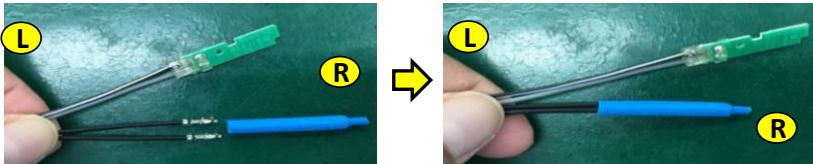
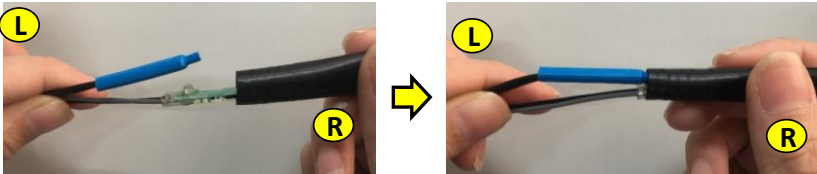
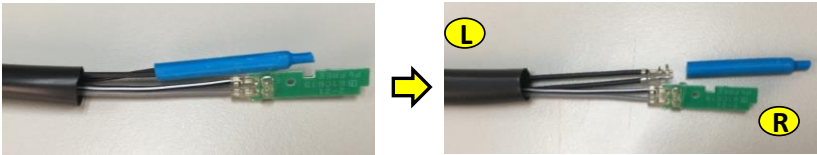





WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	May 21, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-180C		
Revision No.:	3	Page No.:	1 of 8

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	100B / 7M0595-7020B	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Black Sunprene tube $\varnothing 9$ L=93 \pm 3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3 Wire insertion to Black Sunprene tube $\varnothing 9$ L=93 \pm 3mm	 <p>1. Get the terminal cover jig using right hand then insert the terminal B/B wires using left hand.</p>  <p>2. Hold the Black Sunprene tube $\varnothing 9$ L=93\pm3mm using right hand then Insert first the hotmelted wires and then next the B/B wires with cover jig using left hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>		<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div>TERMINAL COVER JIG </div>	1. No wrong use of parts 2. No deformed terminal 3. No wires left during insertion

Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/21/21	3	Revise due to removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes			
10/20/20	2	Transfer process owner from Production (WI-PRO-ASY-120C) to Engineering (WI-ENG-PDE-180C). Apply some improvements/update pictures.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes			
05/02/18	0	Previously established as Engineering instruction (EI-ENG-PDE-034). Initial issue	D. Castillo	R. Alcantara	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	May 02, 2018	

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 21, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

100B / 7M0595-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-180C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

2 of 8

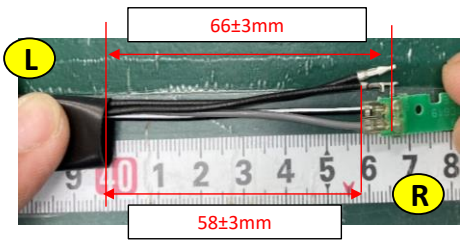
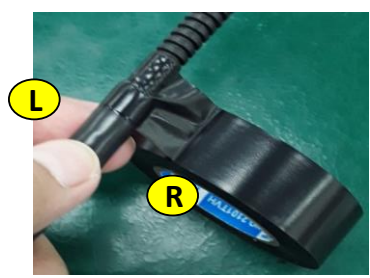
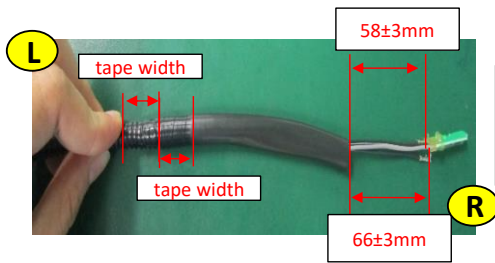

PARTS:

3

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 1 Black Corrugated tube to Black Sunprene tube	<div><p>1. Measure the end of the sunprene tube up to the edge of hotmelt 58±3mm and sunprene tube up to terminal pointed tip 66±3mm.</p></div> <div><p>2. Hold the sunprene tube using left hand then start taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure</i></p></div> <div><p>3. After taping, check the dimension, terminal appearance and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <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

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

Process Name/Title:

Product Name/Code: **100B / 7M0595-7020B**Customer: **TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 21, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180C

Revision No.:

3

Page No.:

3 of 8

PARTS:

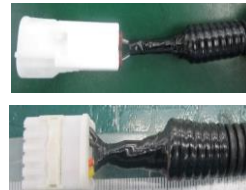
3

1. Assy parts
2. Black tape

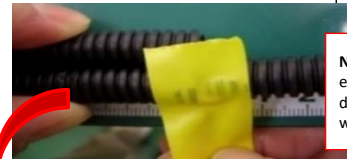
JIG

n/a

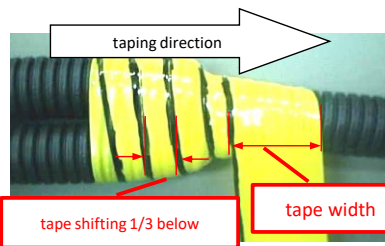
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Y-Taping	n/a	<div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension

**No wide interval**

1. Fix the corrugated tube . Follow the correct orientation of connectors.

**Note:** Do not exert excessive force during pulling & winding of tape**tape width**

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)

**tape shifting 1/3 below****tape width**

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

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 21, 2021

Process Name/Title:

Product Name/Code:

100B / 7M0595-7020B

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

4 of 8

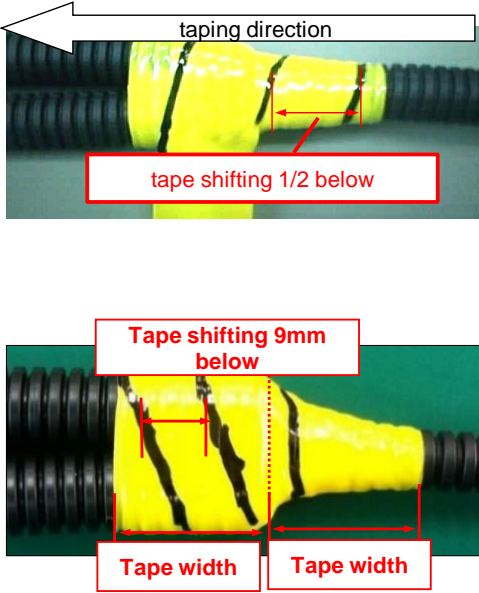
PARTS:

3

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Y-taping (Continuation)	 <p>4. Wind the tape backward 1/2 shifting</p> <p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p>	n/a	<p>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> <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

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**

Product Name/Code: **100B / 7M0595-7020B**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 21, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180C

Revision No.:

3

Page No.:

5 of 8

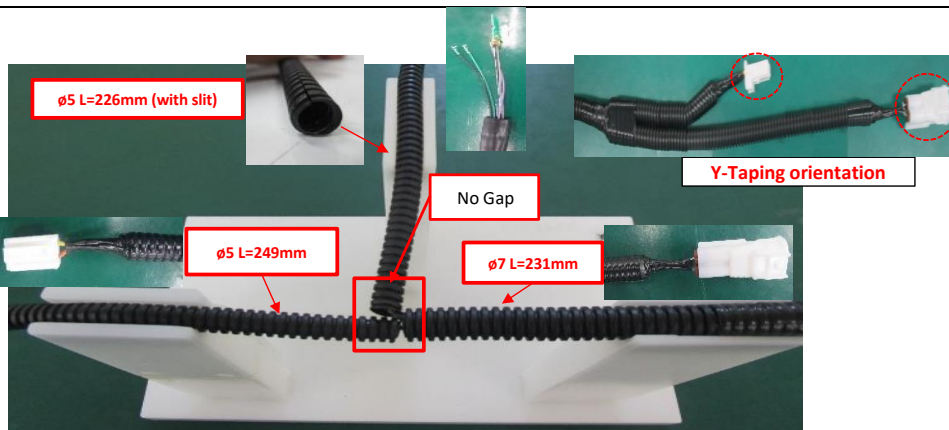
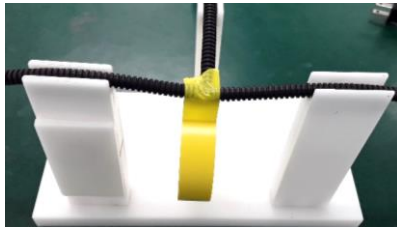


PARTS:

3

1. Assy parts
2. Black tape

JIG

1. T-Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping	<div><p>1. Arrange the 3 corrugated tube to form inverted T into jig using left and right hand.</p><p>2. Start taping at the middle to fix the 3 corrugated tubes using both hands. The tape must attached to all corrugated tubes.</p><p>3. Wind the tape from front to back at the right side.</p></div>	<div>T-TAPING JIG</div> 	<div>NOTE: USE <u>YELLOW TAPE</u> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</div> <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

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

Process Name/Title:

Product Name/Code: **100B / 7M0595-7020B**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 21, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180C

Revision No.:

3

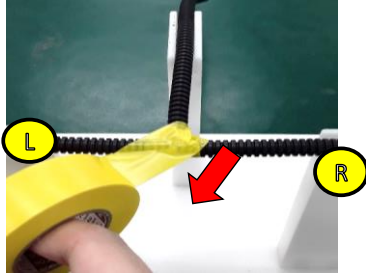
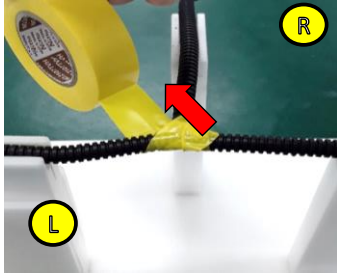
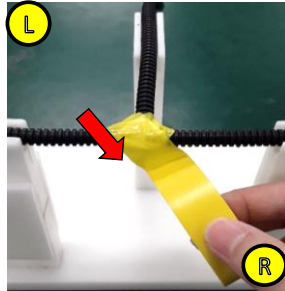
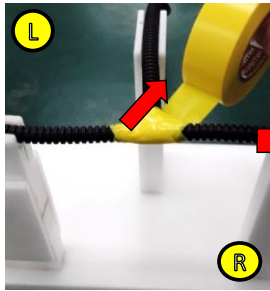
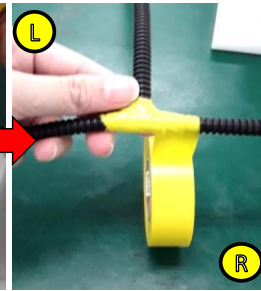

Page No.:

6 of 8**PARTS:****3**

1. Assy parts
2. Black tape

JIG

1. T-Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping (Continuation)	<div><p>4. Wind the tape from back to front (cross pattern).</p></div> <div><p>5. Wind the tape from front to back at the left side.</p></div> <div><p>6. Wind the tape from back to front (cross pattern).</p></div> <div><p>7. Repeat the process from (3)~(6) 3 times.</p></div> <div><p>8. Remove the harness for T-taping jig then tape the right side corrugated tube (3 windings), width must be same as tape (19mm).</p></div>	<div>T-TAPING JIG</div> 	<div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div> <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

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

Process Name/Title:

Product Name/Code: **100B / 7M0595-7020B**Customer: **TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 21, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180C

Revision No.:

3

Page No.:

7 of 8

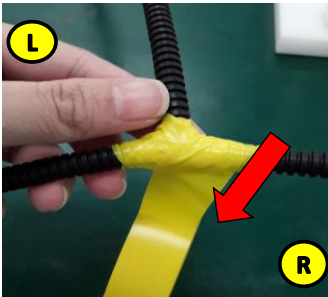
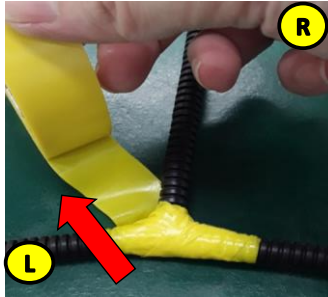
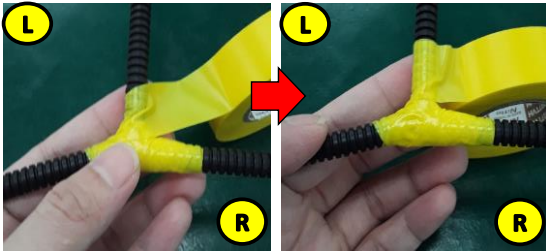
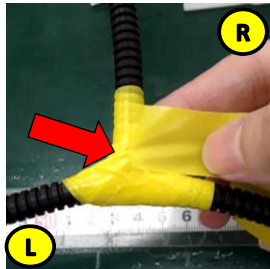
PARTS:

3

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping (Continuation)	<div><p>9. From the right side, wind the tape 2/3 shifting going to center.</p></div> <div><p>10. Wind the tape from front to back side (cross pattern).</p></div> <div><p>11. Tape the top side corrugated tube (3 windings), width must be same as tape (19mm).</p></div> <div><p>12. From the top side, wind the tape 2/3 shifting going to center.</p></div>	n/a	<div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div> <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

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

Process Name/Title:

Product Name/Code: **100B / 7M0595-7020B**Customer: **TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 21, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180C

Revision No.:

3

Page No.:

8 of 8

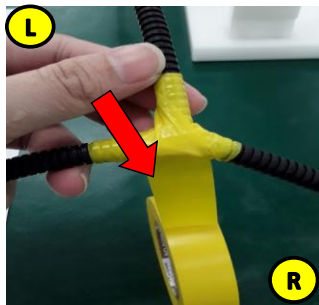
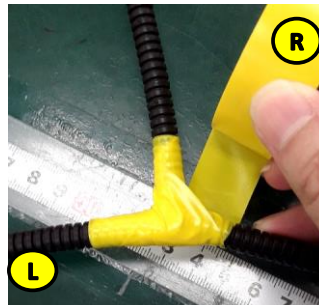
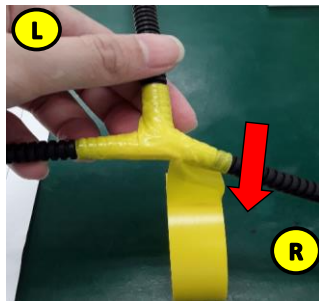
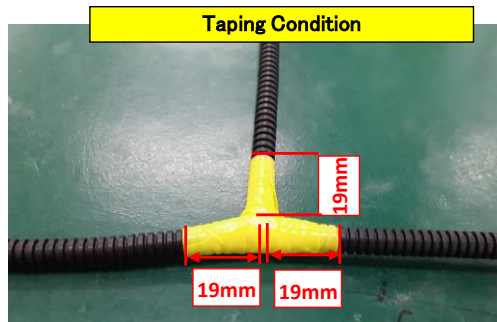
PARTS:

3

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping (Continuation)	<div><p>13. Wind the tape going to front side (cross pattern).</p></div> <div><p>14. Wind the tape from front to back side (cross pattern).</p></div> <div><p>15. Tape the right side corrugated tube (3 windings), width must be same as tape (19mm).</p></div> <div><p>16. After taping check the taping condition</p></div>	n/a	<div>NOTE: USE <u>YELLOW TAPE</u> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</div> <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

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