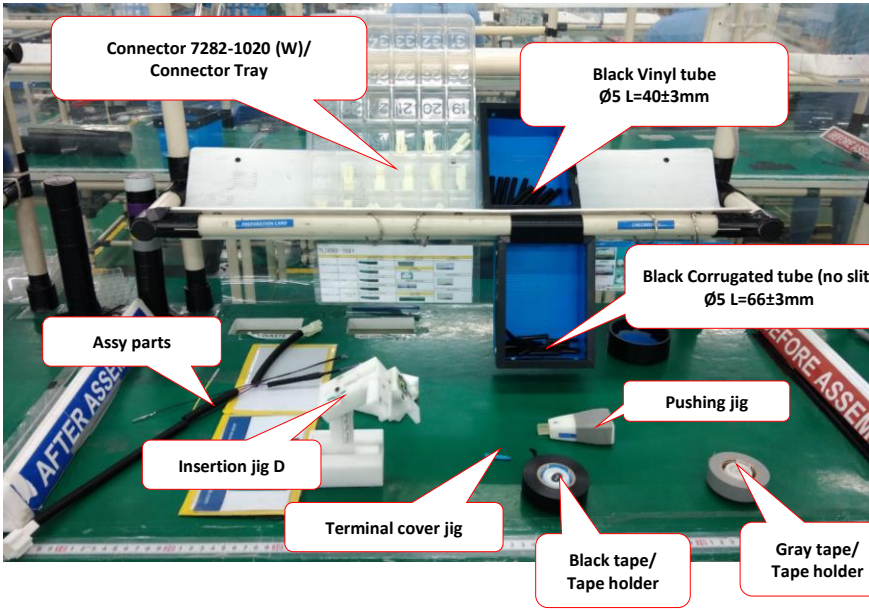
	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>October 07, 2022</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		<b>n/a</b>	
	Model Code/Part Number: <b>TP1 / 7L0092-7021</b>		Customer: <b>TRQSS</b>		Document No.:		<b>WI-ENG-PDE-063B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7		Page No.: 1 of 7	

<b>PARTS:</b>		1. Assy parts: Connector 7282-1020 (W); Black Vinyl tube Ø5 L=40±3mm; Black Corrugated tube (no slit) Ø5 L=66±3mm; Black tape [1pc.]; Gray tape [1pc.]		<b>JIG:</b>		1. Insertion jig 2. Pushing jig 3. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P2	<div style="text-align: center;"> <b>Table Lay-out</b> </div> 		<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
10/07/22	7	Improve quality pointers: References in process no.2,4,5,8 and 9 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.5 - connector lock.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
04/12/22	6	Additional table layout. Transfer process no. 7 and 8 from P1 to P2 as improvement in overall process.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
02/15/21	5	Change part number from 7L0092-7020A to 7L0092-7021 due to change in tape color from Black tape to Gray tape in process COT to wire near connector. Change COT length from ø7 L=200±3mm to L=195±3mm due to encounter maximum dimension from T-taping to terminal. Conduct review of documents.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:	January 03, 2020

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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **TP1 / 7L0092-7021**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Customer:

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Document No.:

**WI-ENG-PDE-063B**

Revision No.:

**7**

Page No.:

**2 of 7**

PARTS:

1. Connector 7282-1020 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

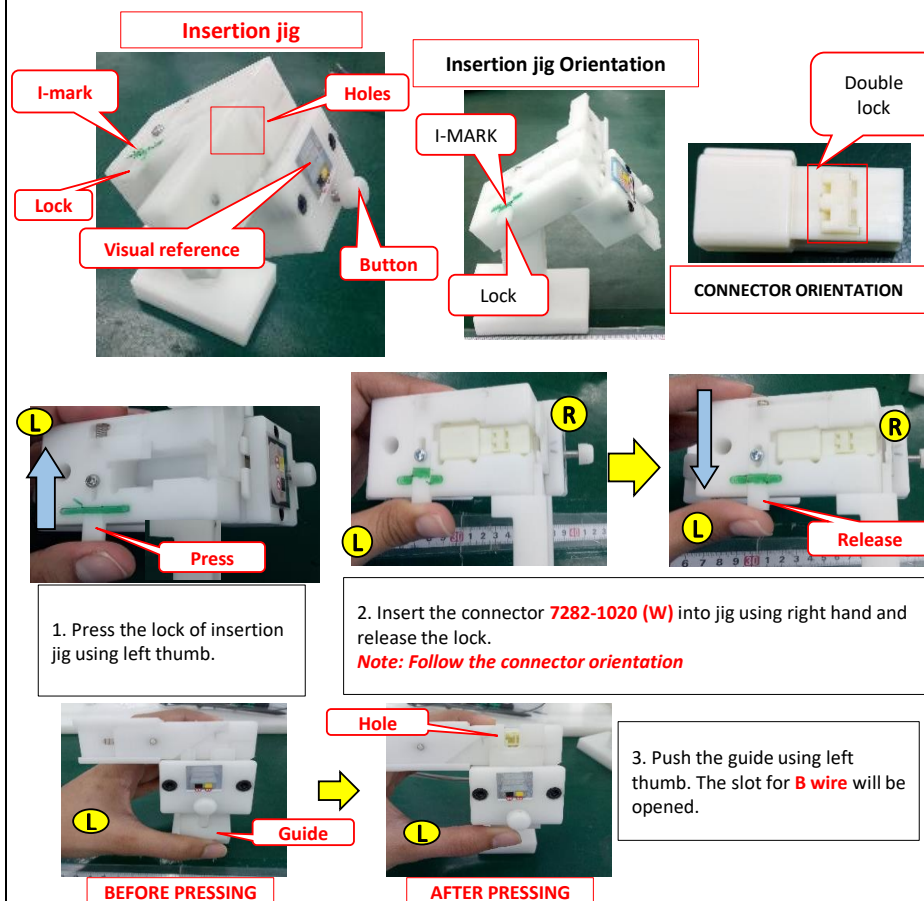
TOOLS/PPE

QUALITY POINTERS

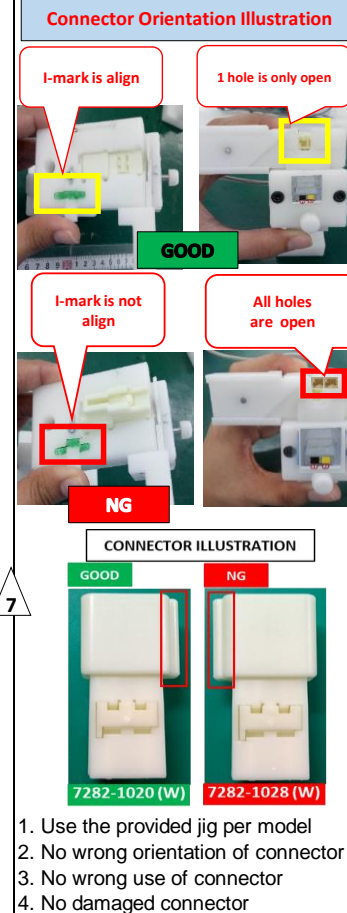
2

P2

Connector setting to  
insertion jig  
7282-1020 (W)



n/a



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

Effectivity Date:

**October 07, 2022**

Process Name/Title:

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**TRQSS**

Document No.:

**WI-ENG-PDE-063B**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

**7**

Page No.:

**3 of 7****PARTS:**

1. Assy parts
2. Black Vinyl tube Ø5 L=40±3mm

**JIG**

1. Insertion jig

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

3

Wire insertion to  
Black Vinyl tube  
Ø5 L=40±3mm

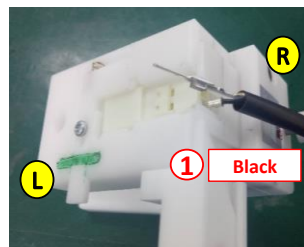
1. Get the Black vinyl tube **Ø5 L=40±3mm** using right hand then insert the **Y and B wire**.

n/a

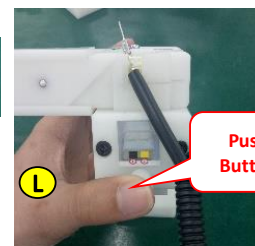
1. No wrong usage of parts
2. No deformed terminal

4

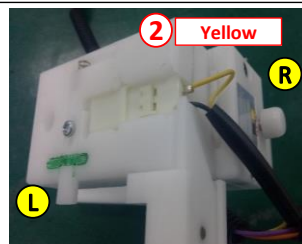
P2

Wire insertion to  
Connector  
7282-1020 (W)

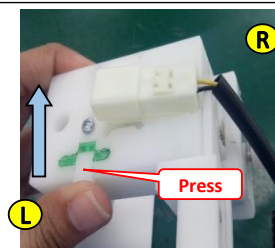
1. Hold the **B wire** then insert to terminal slot **1** using right hand.



2. After insertion of **B wire** press the button using left hand. The slot for **Y wire** will be opened.



3. Hold the **Y wire** then insert to terminal slot **2** using right hand.



4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

7

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

**Important reminders/Note/s:**

1. **Please hold the wire near terminal.**
  2. **Make sure wires are properly inserted.**
- Conduct Pull-Push-Pull-Push after insertion.**  
**Do not exert extra force.**

**Document references:**

1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.

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Effectivity Date:

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Purpose:

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☐ PRE-LAUNCH

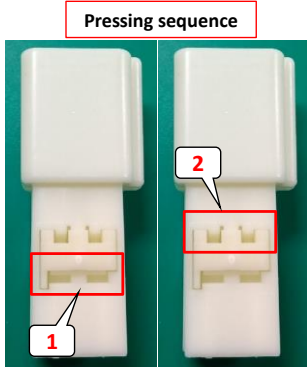
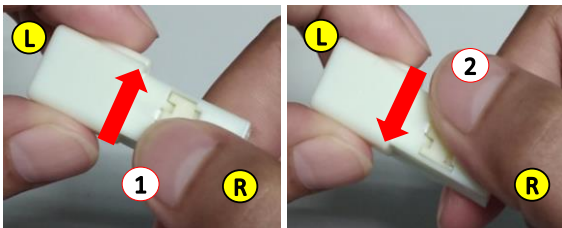
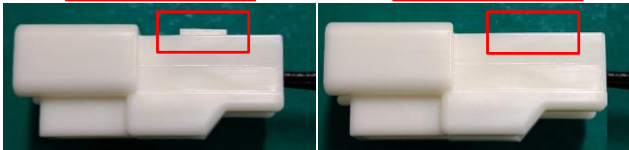
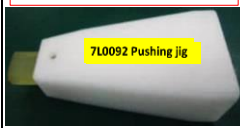
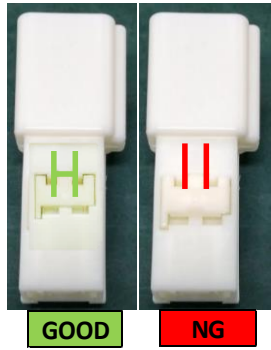
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Revision No.:

7

Page No.:

4 of 7

PARTS:		1. Assy parts		JIG	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Connector lock	<div><p><b>Pressing sequence</b></p><p>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</p><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p><p><b>Before pressing</b>      <b>After pressing</b></p></div>	<div><p><b>Pushing jig</b></p></div>	<div><p><b>Important reminders/Note/s:</b></p><ul style="list-style-type: none"><li>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</li><li>2. Use the provided jig tool to lock the connector.</li><li>3. Position of pushing jig during locking must be slanted</li></ul><p>1. No unlocked/half-locked connector 2. No damage connector</p><p><b>LOCKED CONDITION</b></p></div>

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**WORK INSTRUCTION**

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**TAPING ASSEMBLY PROCESS**

Effectivity Date:

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Model Code/Part Number:

**TP1 / 7L0092-7021**

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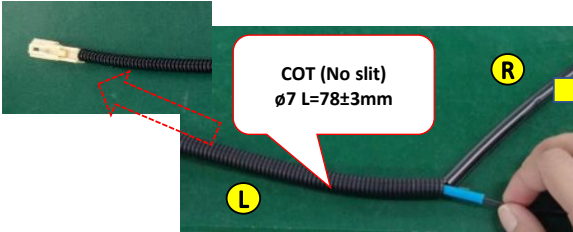





**WI-ENG-PDE-063B**

Revision No.:

**7**

Page No.:

**5 of 7**

PARTS:		1. Assy part 2. Black Corrugated tube (no slit) $\phi 5$ L=66 $\pm$ 3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Wire insertion to assy parts	<div><div>1. Get the cover jig then insert to <b>B-B wires</b> using right hand.</div></div> <div><div>COT (No slit) <math>\phi 7</math> L=78<math>\pm</math>3mm</div></div> <div>2. Hold the corrugated tube (no slit) <b><math>\phi 7</math> L=78<math>\pm</math>3mm</b> using left hand then insert <b>B-B wires</b> using right hand.</div>		<div>TERMINAL COVER JIG</div>  <div>n/a</div>	1. No wrong insertion 2. No deformed terminal
7		Wire insertion to Black Corrugated tube (no slit) $\phi 5$ L=66 $\pm$ 3mm	<div><div>1. Get the corrugated tube(no slit) <b><math>\phi 5</math> L=66<math>\pm</math>3mm</b> using right hand and insert the wires using left hand.</div></div> <div><div>2. Remove the terminal cover jig after insertion using right hand.</div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal

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Document No.:

WI-ENG-PDE-063B

Purpose:



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PRE-LAUNCH



MASSPRO

Revision No.:

7

Page No.:

6 of 7

### PARTS:

1. Assy part
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

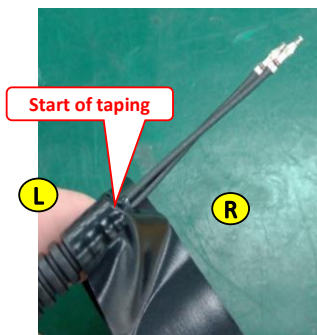
TOOLS/PPE

QUALITY POINTERS

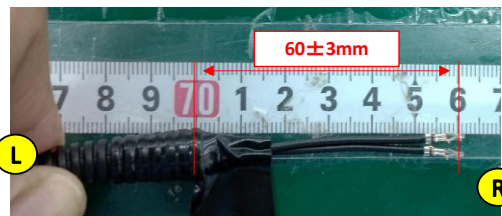
8

P2

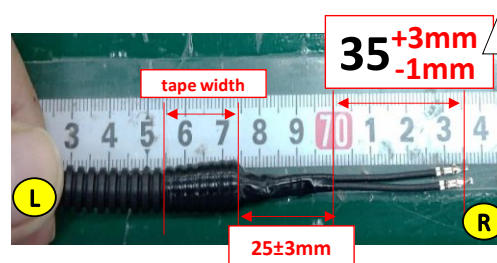
Taping 1  
COT to wire near terminal



1. Hold the corrugated tube using left hand and get the **Black tape** then start taping using right hand.



2. Measure from end of COT up to terminal pointed tip **60±3mm** then continue taping process using both hands.



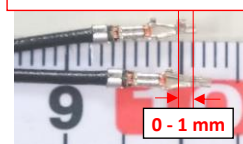
3. After taping, check the dimension, taping condition and wire alignment.

### MEASURING TAPE



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

### Wire alignment tolerance



**Important reminders/Note/s:**  
1. Please use calibrated/verified measuring tape when getting the measurement.

**Document references:**  
1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance

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# WORK INSTRUCTION

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7L0092-7021

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Document No.:

WI-ENG-PDE-063B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

7

Page No.:

7 of 7

### PARTS:

1. Assy parts
2. Gray tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

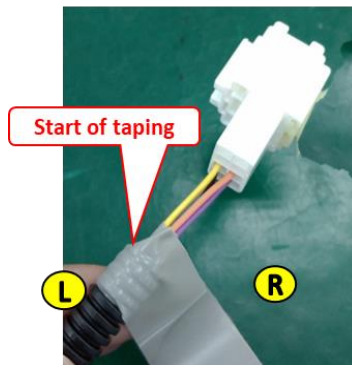
TOOLS/PPE

QUALITY POINTERS

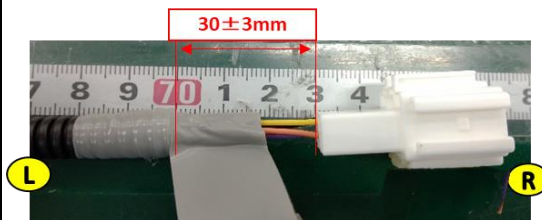
9

P2

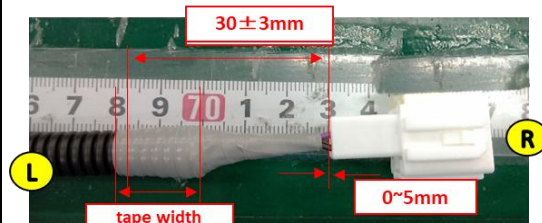
Taping 2  
COT to wire near  
connector



1. Hold the corrugated tube using left hand and get the **Gray tape** then start taping using right hand.



2. Measure from end of COT up to end of connector **30±3mm** then continue taping process using both hands.



3. After taping, check the dimension and taping condition.

MEASURING TAPE



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

**Important reminders/Note/s:**  
**1. Please use calibrated/verified measuring tape when getting the measurement.**

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