
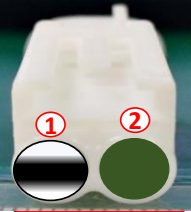

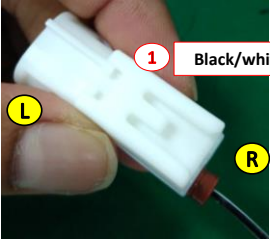
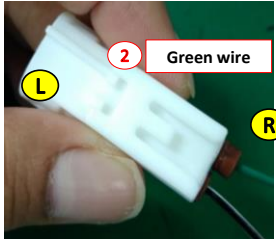
	WORK INSTRUCTION		Effectivity Date:	February 22, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Part Number: 920B / 7R0120-7021	Customer: TRMX	Document No.:	WI-ENG-PDE-639A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

PARTS:		1. Connector 6098-0407 (W) 2. TVSSf 0.3 wires G-B/W L=341±2mm				JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
1	P1 Wire Insertion to Connector 6188-0407 (W)	<div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>CONNECTOR ORIENTATION</p> </div> <div style="text-align: center;">  <p>VISUAL REFERENCE</p> </div> <div style="text-align: center;">  <p>WIRE FACING</p> </div> </div> <div style="display: flex; justify-content: space-around; align-items: flex-start; margin-top: 10px;"> <div style="text-align: center;">  <p>Black/white wire</p> </div> <div style="text-align: center;">  <p>Green wire</p> </div> </div> <div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 48%;"> <p>1. Get the connector 6188-0407 (W) then hold the Black/White wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion.</p> </div> <div style="width: 48%;"> <p>2. Hold the connector 6188-0407 (W) then get the Green wire and insert to terminal slot 2 of connector using right hand. Conduct 2x push pull after wire insertion.</p> </div> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>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.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>		
Revision History						Prepared by	Reviewed by	Approved by	Noted by
02/22/23	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Prepared	Reviewed	Approved	Noted
						Est. Date:	February 22, 2023		

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:

February 22, 2023

Process Name/Title:

Validity date

n/a

Model Code/Part Number: **920B / 7R0120-7021**

Customer: **TRMX**

Document No.:

WI-ENG-PDE-639A

Purpose: ☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

2 of 5



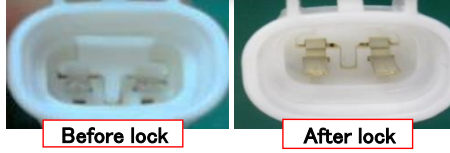



PARTS:

1. Assy parts
2. Black SV tube (Vinyl) Ø5 L=139±3mm

3. Black VM tube (Sunprene) Ø5 L=99±3mm

JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Connector Lock	 <p>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</p>  		<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <ol style="list-style-type: none"> 1. Use the provided locking jig per model 2. No unlock/half-locked connector
3	Wire Insertion to Black SV tube (Vinyl) Ø5 L=139±3mm	 <p>1. Get the Black SV tube (Vinyl) Ø5 L=139±3mm using right hand then insert the G-B/W wires using left hand.</p>	n/a	<ol style="list-style-type: none"> 1. No wrong use of parts
4	Wire Insertion to Black VM tube (Sunprene) Ø5 L=99±3mm	 <p>1. Get the Black VM tube (Sunprene) Ø5 L=99±3mm using right hand then insert the G-B/W wires using left hand.</p>	n/a	<ol style="list-style-type: none"> 1. No wrong use of parts

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:

February 22, 2023

Process Name/Title:

Model Code/Part Number:

920B

/

7R0120-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-639A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

3 of 5

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

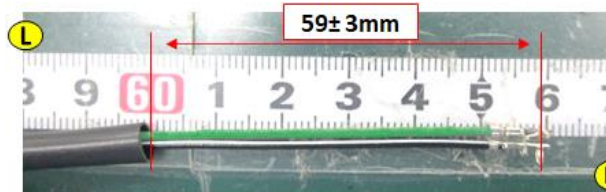
TOOLS/PPE

QUALITY POINTERS

5

P1

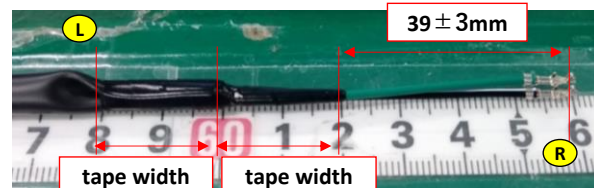
Taping 1
Black VM tube (Sunprene)
to wire near terminal



1. Measure from end of sunprene tube up to end of the terminal pointed tip **59±3mm** using both hands.



2. Hold the tube using left hand, get the **Black tape** using right hand then start taping process using both hands.

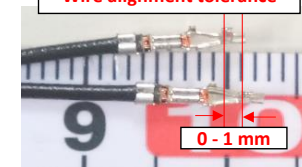


3. After taping, check the taping condition, measurement and wire alignment.

MEASURING TAPE



Wire alignment tolerance



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

Important reminders/Note/s:

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:	February 22, 2023		
Validity date	n/a		
Document No.:	WI-ENG-PDE-639A		
Revision No.:	0	Page No.:	4 of 5

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

Model Code/Part Number: **920B / 7R0120-7021** Customer: **TRMX**

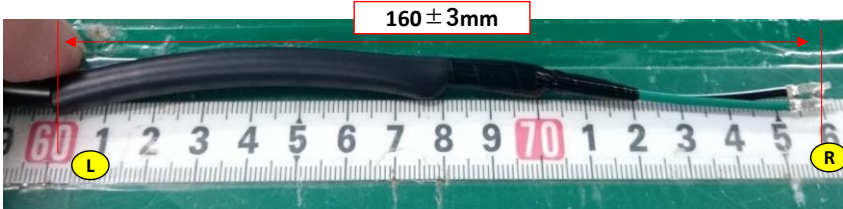
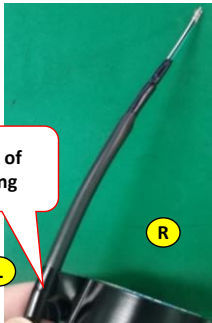


Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 2 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	 <p>1. Measure from end of corrugated tube up to terminal pointed tip 184±3mm using both hands.</p>  <p>2. Hold the corrugated tube and sunprene tube using left hand, get the Black tape then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</p>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. 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

Effectivity Date:

February 22, 2023

Model Code/Part Number:

920B**/****7R0120-7021**

Customer:

TRMX

Validity date

n/a

Document No.:

WI-ENG-PDE-639A

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

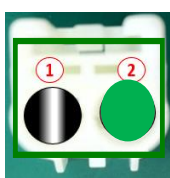
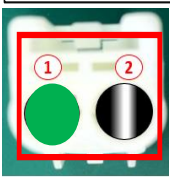
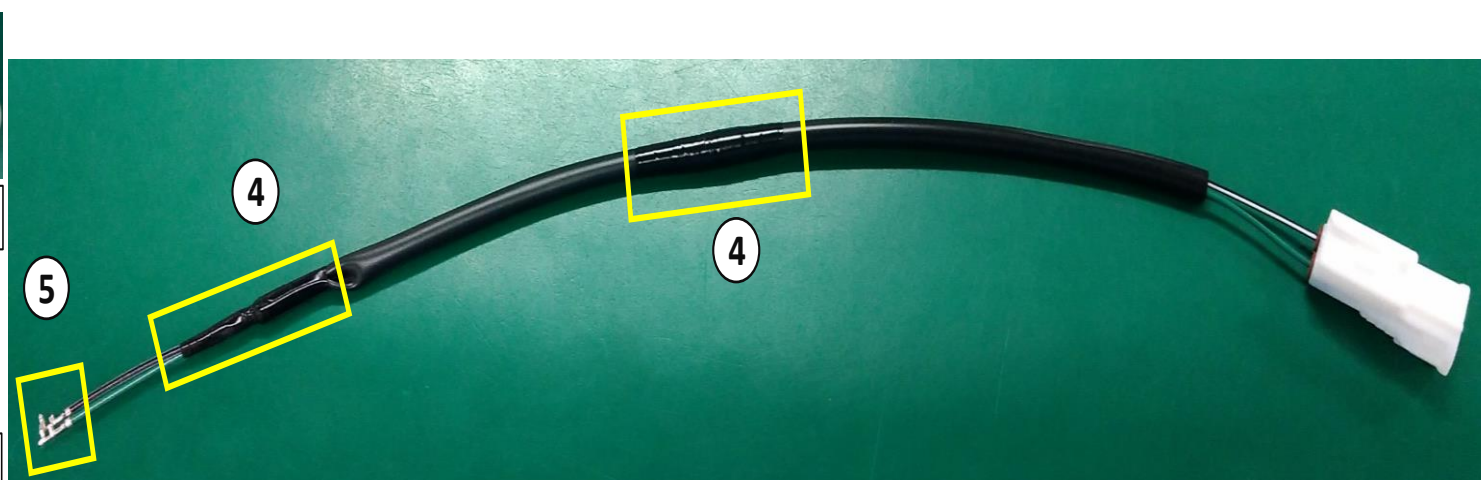
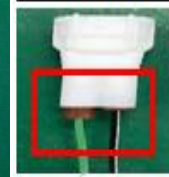
Revision No.:

0

Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG**n/a****QUALITY CHECKPOINTS****P1****7R0120-7021****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****NO GOOD****① No Unlock/ Halflocked Connector****③ No Terminal Backing Out****② No Wrong Insert****④ No Missing tape****⑤ No Deformed Terminal**

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