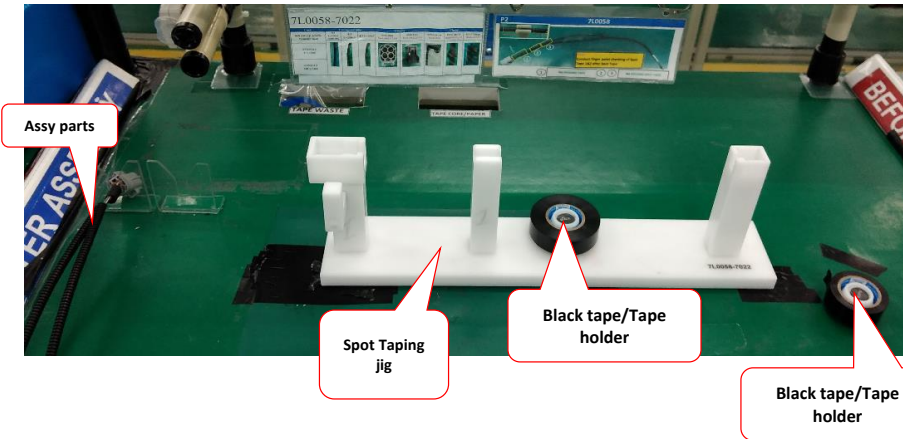




	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:		March 10, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: <b>150B / 7L0058-7024</b>		Customer: <b>TRQSS</b>		Document No.:		WI-ENG-PDE-400B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 5

<b>PARTS:</b>		1. Assy parts; Black tape [2pcs.]		<b>JIG:</b>		1. Spot taping jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
1	P2	<p style="text-align: center;">Table Lay-out</p> 	<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools			

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
03/10/23	1	Inclusion of quality checkpoints. Improve quality pointers				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes		
02/12/22	0	Initial issue Wire color from Gray (Gr) to Green (G) (MRSW CP TVSSf 0.3 GR-B/W to MRSW CP TVSSf 0.3 G-B/W) Refer to CL-ENG-PDE-296B				M. Catapang	J. Loterte	C. Villanueva	A. Arañes						
Eff. Date	Rev. No	Details of Change				Prepared	Reviewed	Approved	Noted	Est. Date:	February 12, 2022				

<b>CONFIDENTIAL:</b> Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.	<b>NBC (Philippines)</b> <b>MASTER COPY</b>		DCC Stamp



# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROPCESS

Effectivity Date:

March 10, 2023

Model Code/Part Number:

150B / 7L0058-7024

Customer:

TRQSS

Document No.:

WI-ENG-PDE-400B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION


TOOLS/PPE

1 QUALITY POINTERS

2

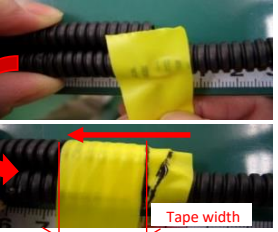
P2

Y-taping



NO WIDE INTERVAL

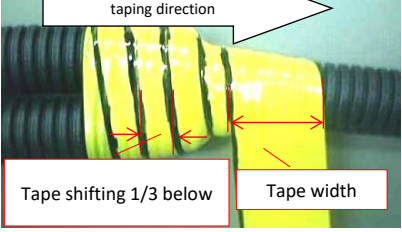
1. Fix the corrugated tube .



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)

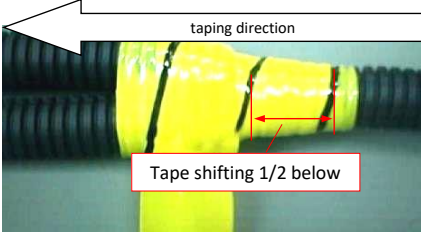


taping direction

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)



taping direction

Tape shifting 1/2 below

4. Wind the tape backward 1/2 shifting

MEASURING TAPE



Y-TAPING ORIENTATION



**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 PROPCESS

Effectivity Date:

March 10, 2023

Model Code/Part Number:

150B / 7L0058-7024

Customer:

TRQSS

Document No.:

WI-ENG-PDE-400B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 5

### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

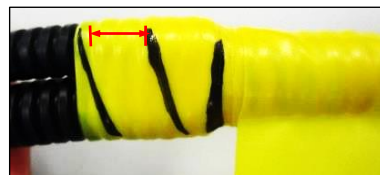
TOOLS/PPE

1 QUALITY POINTERS

2

P2

Y-taping  
(continuation)

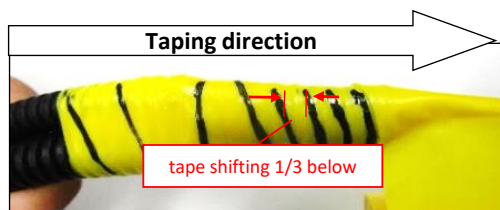


5. Wind the tape  $\frac{1}{2}$  shifting going to other side of corrugated tube.



Taping direction

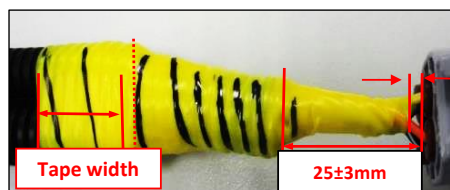
6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.



Taping direction

tape shifting 1/3 below

7. Wind the tape  $\frac{1}{3}$  shifting until it reach the wire , make 3 winds to wires then cut.



Tape width

25±3mm

Note: 0 - 5mm  
→End tape up to coupler (includes rubber seal)

8. After taping, check the measurement and taping condition.

MEASURING JIG



Important reminders/Note/s:

1. Use **YELLOW** tape for easy visualization of shifting lines, But actual should be **BLACK** tape.
2. Please use calibrated/verified measuring tape when getting the measurement.

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

**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 PROPCESS

Effectivity Date:

March 10, 2023

Model Code/Part Number:

150B / 7L0058-7024

Customer:

TRQSS

Document No.:

WI-ENG-PDE-400B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 5

### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Spot Taping jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

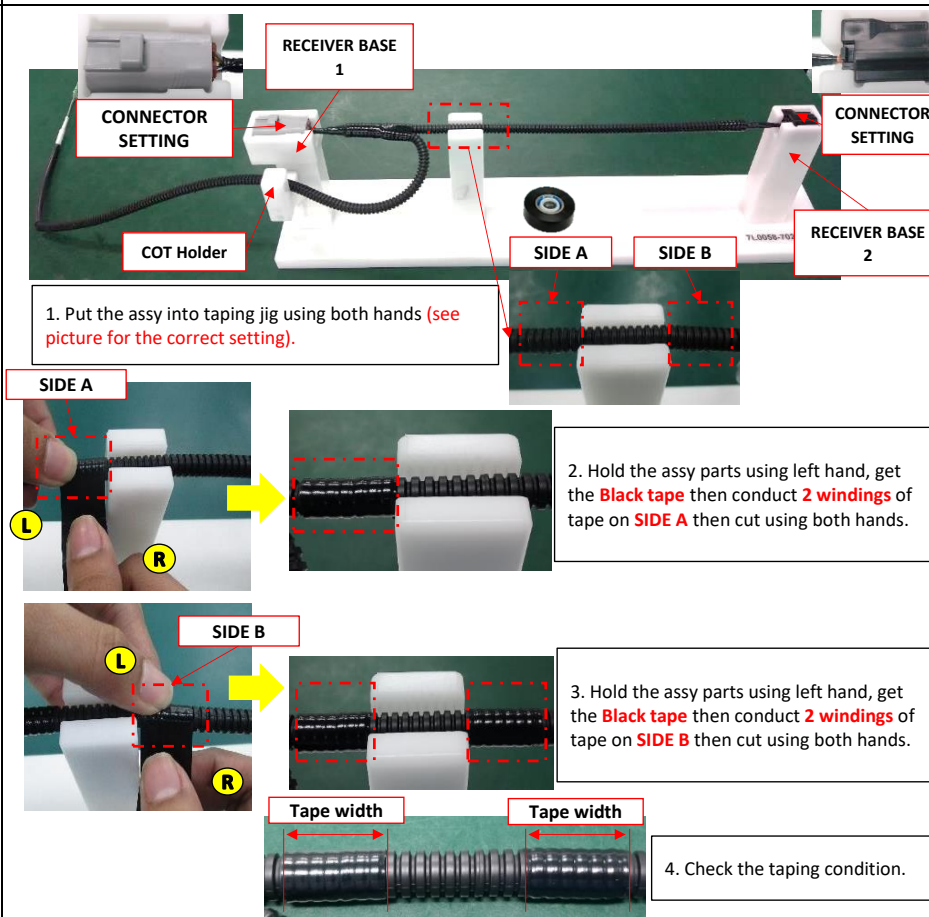
### TOOLS/PPE

### QUALITY POINTERS

3

P2

Spot taping



n/a

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

**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 PROPCESS

Effectivity Date:

March 10, 2023

Validity Date:

n/a

Model Code/Part Number:

150B / 7L0058-7024

Customer:

TRQSS

Document No.:

WI-ENG-PDE-400B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5

PARTS:

1. Assy parts

JIG

n/a



## QUALITY CHECKPOINTS

P2

7L0058-7024

NO MISSING SPOT TAPE



① ② ③ No MISSING TAPE

**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