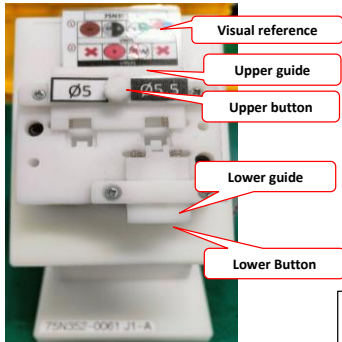
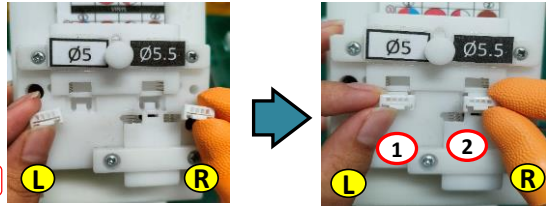
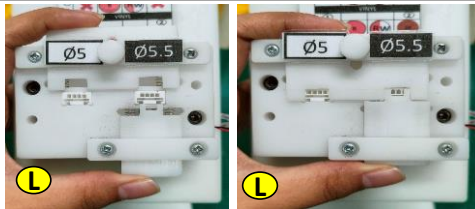
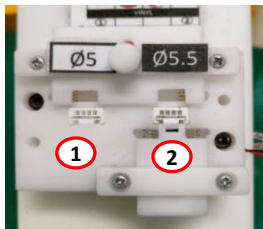




WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	June 10, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-115		
Revision No.:	7	Page No.:	1 of 16

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	D01L / 75N352-0061	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Connector PBVP-04V-S (W) [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 <div>Connector setting to insertion jig PBVP-04V-S (W)</div>	<div><div>INSERTION JIG</div><div><div>CONNECTOR ORIENTATION</div><div><div>1. Get the 2 pcs of PBVP-04V-S connector using right hand tranfer the 1 connector to left hand then insert to insertion jig. Note: Follow the connector orientation.</div></div><div><div>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</div></div></div></div>	<div>Safety Instruction Be sure to wear prescribed 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>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div>

Revision History				Prepared by		Reviewed by	Approved by	Noted by
06/10/23	7	Improve the insertion jig and procedure. Improved work procedure/illustration. Update Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	-		
04/28/23	6	Inclusion of quality checkpoints; standardize VM tube (Sunprene) term.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
10/14/22	5	Improve Quality Pointes: Reminders/notes and references on page no.2,4,5,6,7,8,9,10,12,13. Improve work procedure/illustration on process no.13- Visual/by two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	March 13, 2019

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

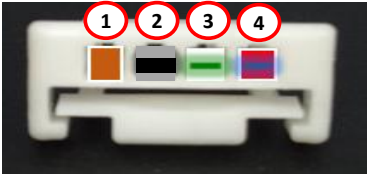




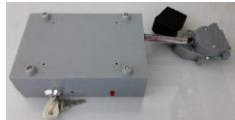

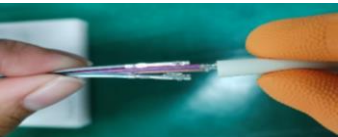
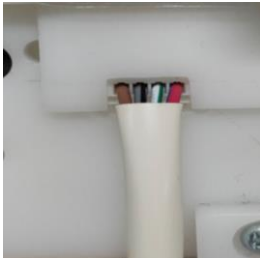
2 of 16

PARTS:

1. AVSS 0.3 BR L=282±2mm; GR/B L=158±2mm; W/G L=158±2mm; R/L L=282±2mm
2.. White VM tube (Sunprene) Ø5 L=116±3mm

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS												
2	<div><div><div>7</div></div><div>Wire insertion to connector PBVP-04V-S (W)</div><div>P1</div></div>	<div><div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div><div><div>1</div><div>2</div><div>3</div><div>4</div></div></div></div><div><div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td></tr><tr><td>BR</td><td>GR/B</td><td>W/G</td><td>R/L</td></tr><tr><td>282</td><td>158</td><td>158</td><td>282</td></tr></table><div><div>WIRE FACING</div></div></div></div><div><div><div></div><div>1. Get the BR wire using right hand and insert to connector. Repeat the process for GR/B-W/G-R/L. Note: Follow the insertion sequence based on the illustration.</div></div></div></div>	1	2	3	4	BR	GR/B	W/G	R/L	282	158	158	282	<div><div>n/a</div><div><div>STEERING NAVIGATION</div><div></div><div><div>CONTROLLER</div><div></div></div></div></div>	<div><div>1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip</div><div><div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion.</div><div><div>Document reference/s: 1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div></div></div></div>
1	2	3	4													
BR	GR/B	W/G	R/L													
282	158	158	282													
3	<div><div>Wire insertion to connector White VM tube (Sunprene) Ø5 L=116±3mm</div></div>	<div><div><div></div><div></div><div>1. Get the White VM tube (Sunprene) Ø5 L=116±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hands.</div></div></div>	<div><div>n/a</div></div>	<div><div>1. No wrong usage of parts 2. No deformed terminal</div></div>												

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

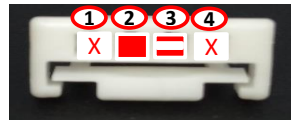
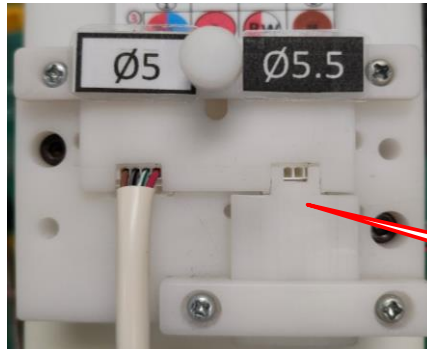

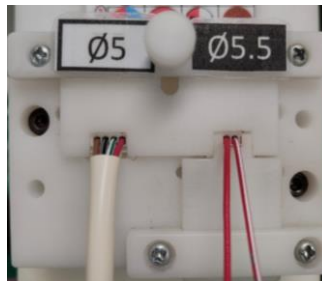
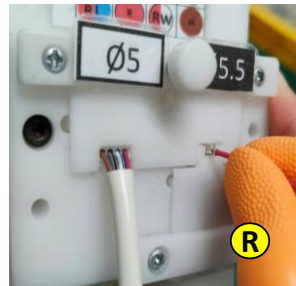
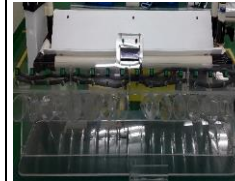
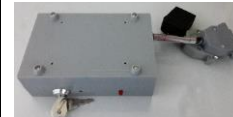
3 of 16

PARTS:

1. AVSS 0.3 R L=154±2mm; R/W L=154±2mm

JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS												
4	P1	Wire insertion to connector PBVP-04V-S (W)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td></tr><tr><td>X</td><td>R</td><td>R/W</td><td>X</td></tr><tr><td></td><td>154</td><td>154</td><td></td></tr></table><div></div><div>Wire facing</div><div>Note: Holes that need to be insert are only open.</div><div>Lower guide</div></div> <div><div></div><div>1. Get the R wire using right hand and insert to connector. Repeat the process for R/W wire. Check the wire insertion. Note: Follow the insertion sequence based on above illustration.</div></div>		1	2	3	4	X	R	R/W	X		154	154		<div>STEERING NAVIGATION</div> <div></div> <div>CONTROLLER</div> <div></div>	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div> <div>2. Please hold the wire near terminal during insertion.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div> <div>2.Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div> <div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
			1	2	3	4												
X	R	R/W	X															
	154	154																

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:


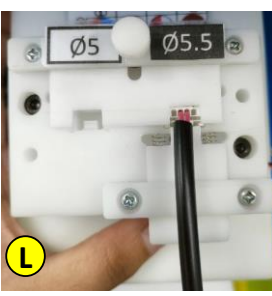
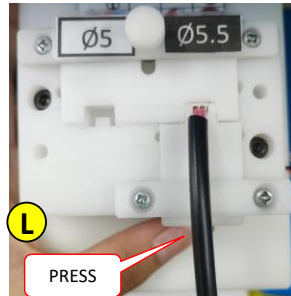
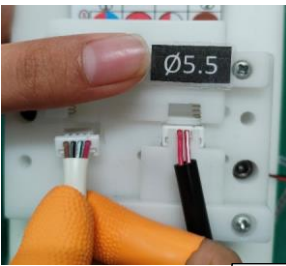
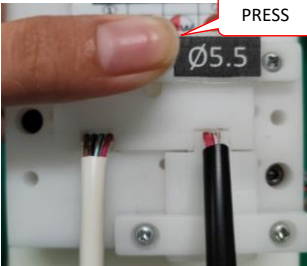
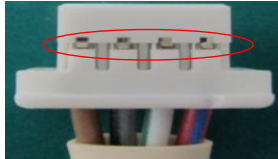
WI-ENG-PDE-115

Revision No.:

7

Page No.:

4 of 16

PARTS:				JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	<div><div>7</div><div>P1</div><div>Wire insertion to Black VM tube (Sunprene) Ø5.5 L=112±3mm</div></div>	<div><div><div>1. Get the Black VM tube (Sunprene) Ø5.5 L=112±3mm using right hand. Hold the wires using left hand then insert wires.</div></div><div><div></div><div><div>2. Press the Upper button using left hand. Remove the first connector inserted wires and White VM tube (Sunprene) using left hand.</div><div>3. Press the upper guide using left hands. Check the wire insertion condition. Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</div><div>4. Press the lower button using left hand. Holes that need to be insert are only open.</div></div></div></div>		n/a	<div><div>Important reminders/Note/s:</div><div>1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion</div><div></div><div>Terminal tip must be visible</div></div>

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

Model Code/Part Number:

D01L / 75N352-0061

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

5 of 16

PARTS:

1. Assy parts
2. Black VM tube(Sunprene) Ø5.5 L=112±3mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

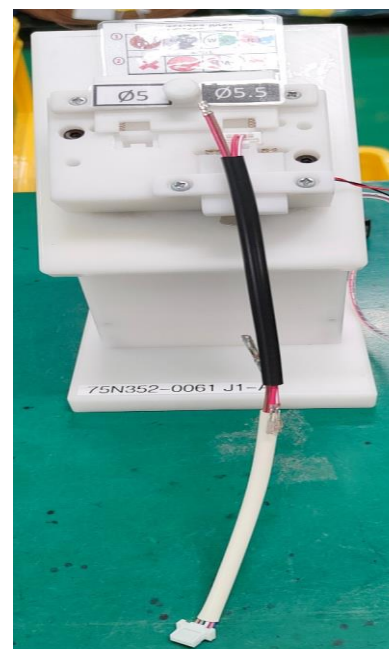
6

P1

Wire insertion to assy parts



1. Hold the **Black VM tube(Sunprene)** using left hand, and insert the wires from **White Sunprene tube** using right hand.



n/a

1. No wrong usage of parts
2. 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



WORK INSTRUCTION

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

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

6 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

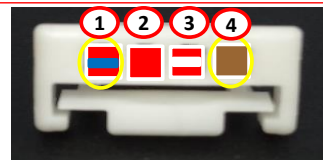
QUALITY POINTERS

7

P1

Wire insertion to
connector
PBVP-04V-S (W)

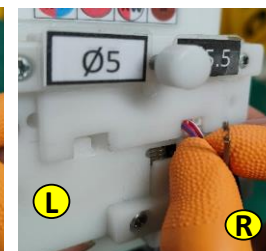
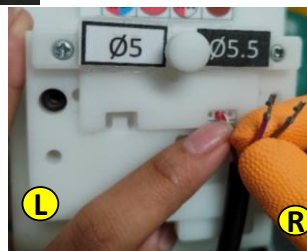
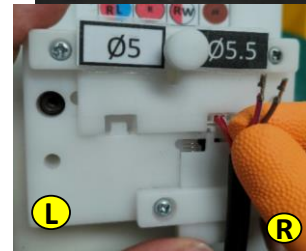
INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE INSERTION ILLUSTRATION

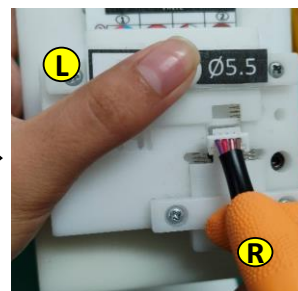
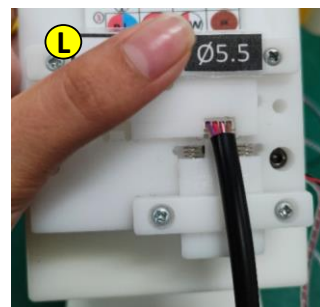
1	2	3	4
R/L	R	R/W	BR
282	154	154	282

WIRE FACING



1. Hold the **R/L wire** using right hand and support the wire by left index finger then insert to the connector slot 1 using right hand. Repeat the process on **BR** Check the wire after insertion.

Note: Follow the insertion sequence based on the illustration.



2. Press the upper button using left hand then remove the assy part using right hand. Check the insertion condition.

STEERING NAVIGATION



CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. **Make sure wires are properly inserted.**
2. **Conduct Pull-Push-Pull-Push after insertion.**
3. **Do not exert extra force.**
4. **Please hold the wire near terminal during insertion**
5. **Insertion must be from left to right.**

Document references:

1. Refer to **WI-ENG-PDE-044** for **Steering Navigation Controller procedure.**
2. Refer to **WI-PRO-CNC-017** for **Wire and Strip Length Tolerance.**
3. Refer to **GL-PRO-ASY-025** for **Inspection Standard for connector insertion**
4. Refer to **GL-PRO-ASY-029** for **Pull-Push procedure.**



Terminal tip must be visible

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

7 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

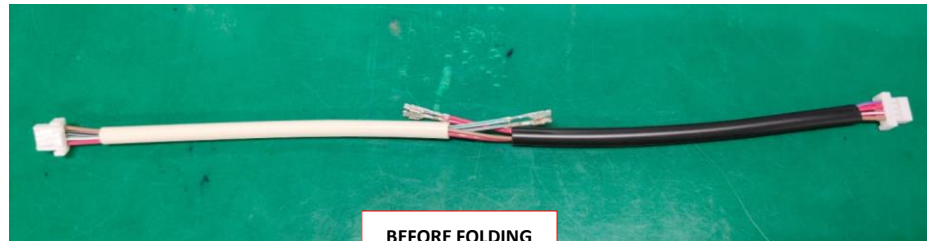
TOOLS/PPE

QUALITY POINTERS

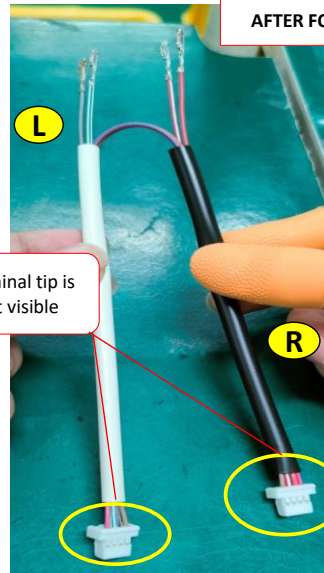
8

P1

Wire Folding



AFTER FOLDING



1. Hold the Assy parts using both hands and then conduct wire arrangement.

n/a

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion

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:

June 10, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

D01L / 75N352-0061

Customer:

TRJ

Document No.:

WI-ENG-PDE-115

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

8 of 16

PARTS:

1. Connector 1318386-2 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

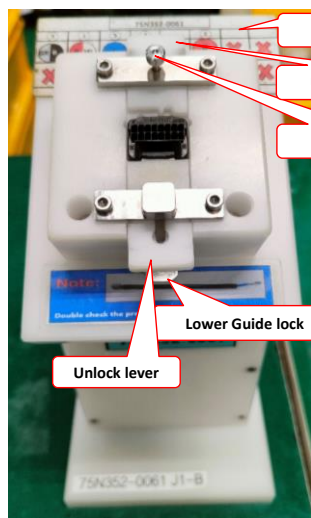
QUALITY POINTERS

9

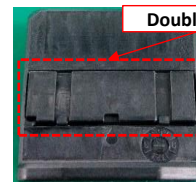
P1

Connector setting to
insertion jig
1318386-2 (B)

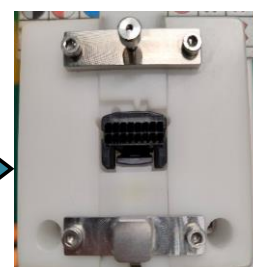
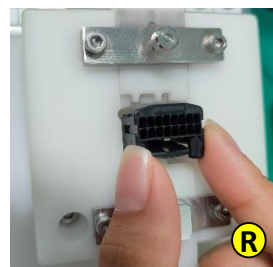
INSERTION JIG



Double lock



CONNECTOR ORIENTATION



1. Get the connector **1318386-2 (B)** using right hand and set to insertion jig.

Note: Follow the connector orientation.

2. Press the upper and lower guide lock using left hand. Holes that needs to be inserted are only open.

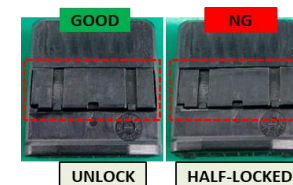
n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

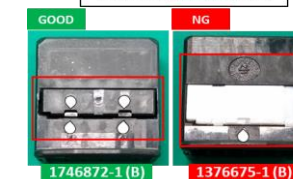
Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Check the connector before insertion.

CONNECTOR LOCK APPEARANCE CHECK



CONNECTOR ILLUSTRATION



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:

June 10, 2023

Model Code/Part Number:

D01L / 75N352-0061

Customer:

TRJ

Document No.:

WI-ENG-PDE-115

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

9 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

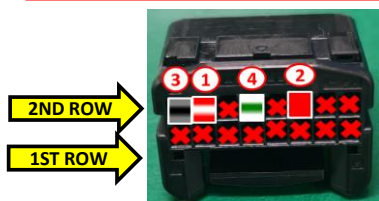
NO.**PROCESS NAME**

7

WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

10

P1

Wire insertion to
connector
1318386-2 (B)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

	1				2		
X	R/W	X	X	X	R	X	X
	154				154		
X	X	X	X	X	X	X	X

BLACK VM TUBE (SUNPRENE)**Wire facing****SECOND ROW (LEFT TO RIGHT)**

1. Insert the wires from **Black VM tube (Sunprene)**.
Get the **R/W wire** and insert to terminal **slot 1** using
right hand.
**Note: Follow the insertion sequence based on the
illustration stated above.**

2. Hold the **R wire** and insert to terminal **slot 2**.
**Note: Follow the insertion sequence based on the
illustration stated above.**

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. **Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
 2. **Please hold the wire near terminal during insertion.**
 3. **Make sure wires are properly inserted.**
- Conduct Pull-Push-Pull-Push after insertion.**
Do not exert extra force.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

10 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

7

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

10

P1

Wire insertion to
connector
1318386-2 (B)
(Continuation)

WHITE VM TUBE (SUNPRENE)



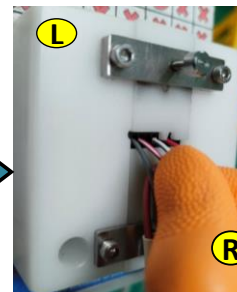
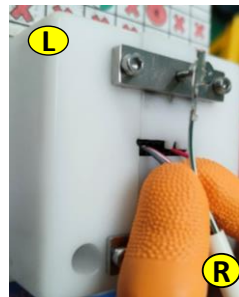
WIRE INSERTION ILLUSTRATION

3	1	4	2
GR/B	R/W	W/G	R
158	154	158	154
X	X	X	X



Wire facing

SECOND ROW (LEFT TO RIGHT)



3. Insert the wires from **White VM tube (Sunprene)**. Get the **GR/B wire** and insert to terminal slot 3 using right hand. Get the **W/G wire** and insert to terminal slot 4.

Note: Follow the insertion sequence based on the illustration stated above.

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of indertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

11 of 16

PARTS:	1. Assy parts 2. AVSS 0.5 L L=129±1mm 3. Black VM tube (Sunprene) Ø3 L=113±3mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Wire insertion to Black VM tube (Sunprene) Ø3 L=113±3mm	<div data-bbox="779 432 1227 595"></div> <div data-bbox="808 651 1211 699">1. Get the Blue wire using right hand then insert to Black VM tube (Sunprene) Ø3 L=113±3mm.</div> <div data-bbox="808 738 1272 967"></div> <div data-bbox="808 1023 1205 1070">2. Measure the end of sunprene tube up to the tip of the terminal, it should be 11mm.</div> <div data-bbox="788 1126 1263 1318"></div>		<div data-bbox="1794 443 2002 491">1. No wrong use of parts 2. No deformed terminal</div> <div data-bbox="1794 539 2063 566"><i>Important reminders/Note/s:</i></div> <div data-bbox="1794 627 2107 703"><i>1. Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div data-bbox="1805 759 2092 868"></div> <div data-bbox="1805 927 2107 975"><i>Peel-off wire should be covered by Sunprene tube (Black)</i></div> <div data-bbox="1541 1070 1749 1098">MEASURING TAPE</div> <div data-bbox="1525 1114 1771 1198"></div>	

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:

Model Code/Part Number: **D01L / 75N352-0061**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

12 of 16

PARTS:

1. Assy parts

JIG

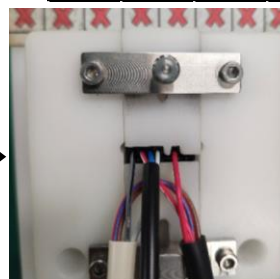
1. Insertion jig

NO.**PROCESS NAME**

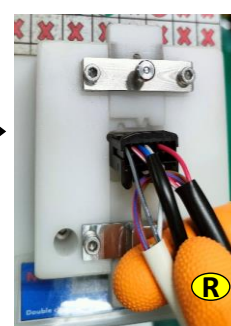
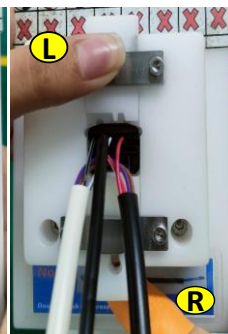
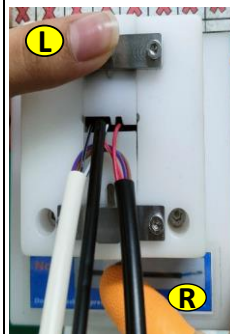
7

WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS****INSERTION SEQUENCE FROM LEFT TO RIGHT****Wire facing****WIRE INSERTION ILLUSTRATION**

3	1	5	4		2		
GR/B	R/W	L	W/G	X	R	X	X
158	154	129	158		154		
X	X	X	X	X	X	X	X



4. Get the **Blue wire** with inserted tube and insert to connector at **slot 5** using right hand.



5. Press the upper and lower guide (same timing) using both hands then remove the assy part using right hand.

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. **Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
 2. **Make sure wires are properly inserted.**
- Conduct Pull-Push-Pull-Push after insertion.**
- Do not exert extra force.**
3. **Please hold the wire near terminal during insertion.**

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
- 2.1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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**

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

13 of 16

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

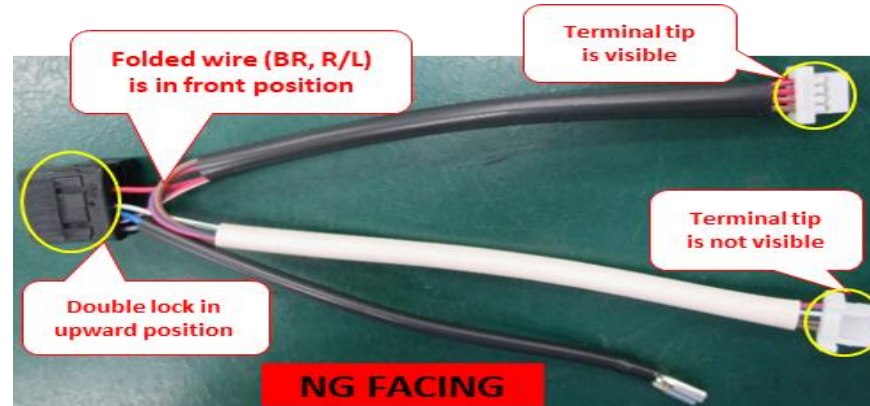
QUALITY POINTERS

13

P1

Wire arrangement

1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires.
Refer to below illustration for Good wire arrangement and facing.



n/a

1. No wrong facing
2. No tangled wires

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

Model Code/Part Number:

D01L / 75N352-0061

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

14 of 16

PARTS:

1. Assembled parts
2. Master sample

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

P1

Visual/By Two's Inspection

1. Check the connector lock. Locking of connector is included in Steering electrical test.

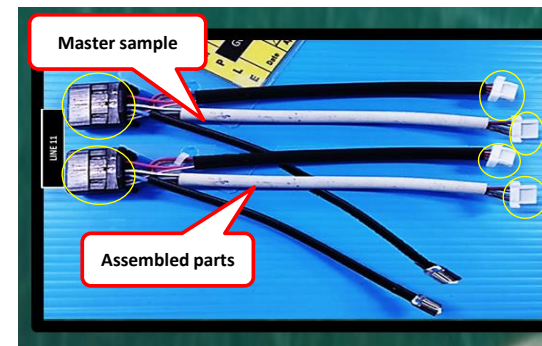
2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.



4. Check the orientation of harness.

5. Compare to **Master Sample** by tapping.



1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

Document references:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

MASTER SAMPLE



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:

June 10, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

D01L / 75N352-0061

Customer:

TRJ

Document No.:

WI-ENG-PDE-115

Purpose:

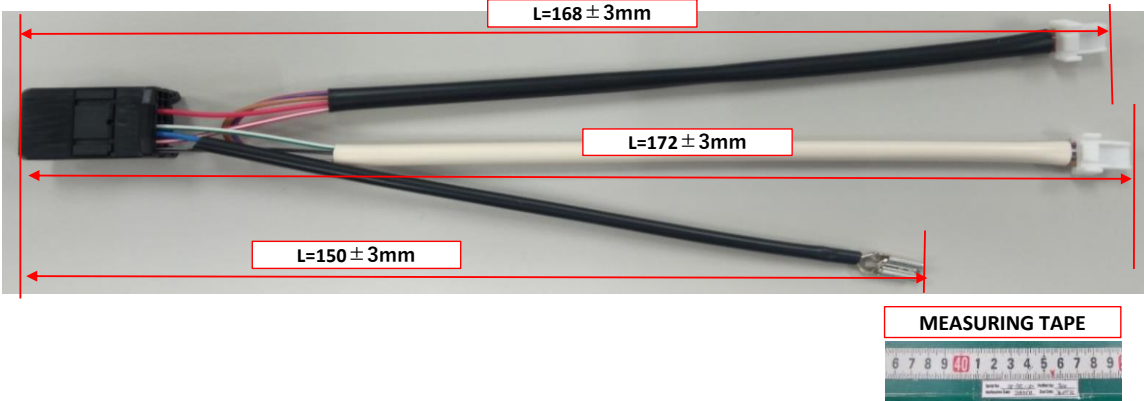
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

15 of 16

PARTS:	n/a			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
15	P1 Measurement			1. No wrong dimension. Important reminders/Note/s: 1. For Hatsumono and Owarimono. 2. 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

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

Model Code/Part Number: **D01L / 75N352-0061**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-115

Revision No.:

7

Page No.:

16 of 16

PARTS:

1. Assy parts

JIG:

n/a



QUALITY CHECKPOINTS

75N352-0061

1. Check the connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

Black VM Tube (Sunprene)

Black VM Tube (Sunprene)

White VM Tube (Sunprene)

3. Check the orientation of harness.

4. Check if no missing parts.

5. Check the terminal if with backing out (no fully inserted) or deformed

6. Compare to master sample.



FOLDED WIRES MUST BE IN BACK POSITION

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