

	WORK INSTRUCTION						Effectivity Date:		May 17, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 666W / 7H0320W7020C		Customer: NBS		Document No.: WI-ENG-PDE-471A	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 2	
Page No.: 1 of 5										

PARTS:	1. Connector 6098-3810 (W); AVSSf 0.3 B L=315±2mm; Black corrugated tube (no slit) ø5 L=230±3mm; Black tape [1pc.]					JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig				
---------------	--	--	--	--	--	------	---	--	--	--	--

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History								Prepared by		Reviewed by		Reviewed by		Approved by	
05/17/22	2	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
05/13/22	1	Change taping measurement from end of tape up to terminal tip L=35±1mm to L=33±2/-1mm due to encountered maximum dimension	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
05/04/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted									
								Est. Date:		May 04, 2022					

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: 666W / 7H0320W7020C

Customer:

NBS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 17, 2022

Validity Date:

n/a

Document No.:

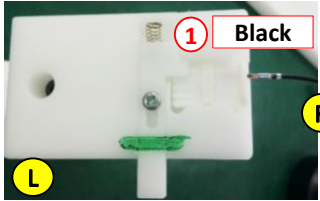
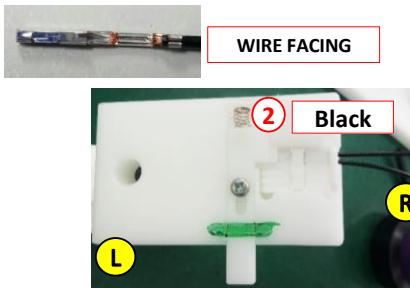
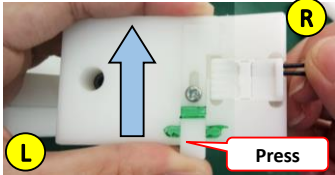

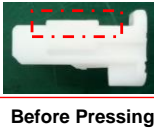
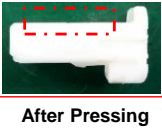
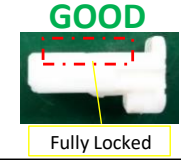


WI-ENG-PDE-471A

Revision No.:

2

Page No.:

3 of 5

PARTS:	1. AVSSf 0.3 B L=315±2mm [2pcs.]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3810 (W) P1	<div></div> <div></div> <div></div> <div><p>1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand. Note: Insertion of wires must be from left to right</p><p>2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</p><p>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force."</p> <p>Note: Please hold the wire near terminal during insertion.</p>
4	Connector lock	<div></div> <div></div> <div></div> <div></div> <div></div> <div><p>1. Put the connector into locking jig using both hands then press 2x using both hands. Touch the connector lock to confirm if properly locked. Refer to GL-PRO-ASY-017 for the verification of lock.</p></div>		LOCKING JIG 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</p> <p>1. Use the provided locking jig per modle 2. No unlocked/half-locked connector 2. No damaged lock</p>

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 17, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 666W / 7H0320W7020C

Customer:

NBS

Document No.:

WI-ENG-PDE-471A

Purpose:





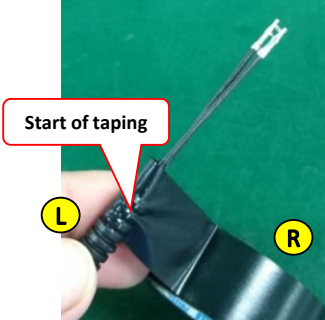
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

4 of 5

PARTS:	1. Assy parts 2. Black corrugated tube (no slit) $\phi 5$ L=230 \pm 3mm 3. Black tape			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to corrugated tube (no slit) $\phi 5$ L=230 \pm 3mm	<div data-bbox="669 424 981 601"></div> <div data-bbox="613 606 1032 713"><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div> <div data-bbox="1151 424 1464 601"></div> <div data-bbox="1048 606 1523 713"><p>2. Get the corrugated tube (no slit) $\phi 5$ L=230\pm3mm using right hand then insert the B-B wires using left hand.</p></div> <div data-bbox="734 730 1059 908"></div> <div data-bbox="1066 766 1442 873"><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div data-bbox="1554 635 1767 659">TERMINAL COVER JIG</div> <div data-bbox="1541 671 1776 751"></div>	1. No wrong usage of parts 2. No deformed terminal
6	Taping 1 Black corrugated tube to wire near terminal	<div data-bbox="692 962 1016 1283"></div> <div data-bbox="707 1070 842 1094">Start of taping</div> <div data-bbox="1023 1070 1489 1184"><p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p></div>		n/a	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. 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

Effectivity Date:

May 17, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 666W / 7H0320W7020C

Customer:

NBS

Document No.:

WI-ENG-PDE-471A

Purpose:


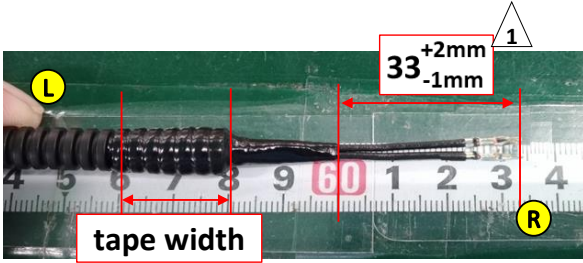

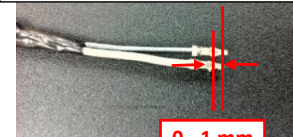
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

5 of 5

PARTS:		1. Assy parts 2. Black tape	3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Taping 1 Black corrugated tube to wire near terminal (Continuation) P1	 <p>55±1mm</p> <p>2. Measure from end of COT up to terminal pointed tip 55±1mm then continue the taping process using both hands.</p>  <p>33^{+2mm}_{-1mm}</p> <p>tape width</p> <p>3. After taping, check the measurement and taping condition.</p>			 <p>0 - 1 mm</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 <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p>

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