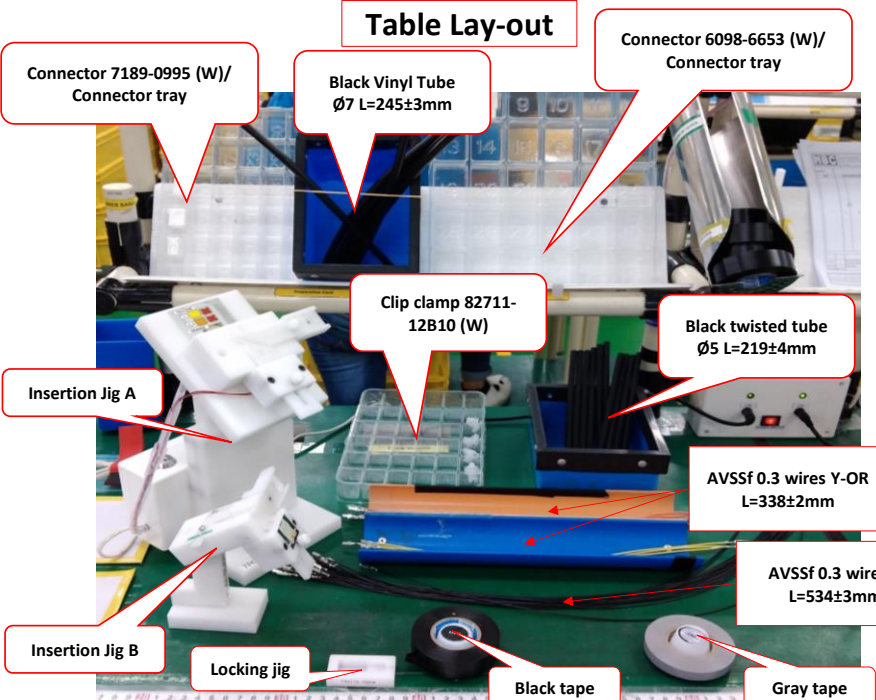
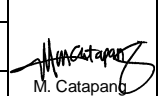






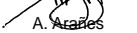
	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>December 3, 2022</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model Code/Part Number: <b>920B / 7R0115-7020A</b>		Customer: <b>TRMX</b>		Document No.:		<b>WI-ENG-PDE-543A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1		Page No.: 1 of 11	

<b>PARTS:</b>		1. All parts: Connector 7189-0995 (W); AVSSf 0.3 wires Y-OR L=338±2mm; AVSSf 0.3 wires B L=534±3mm; Black twisted tube Ø5 L=219±4mm; Black Vinyl Tube Ø7 L=245±3mm; Connector 6098-6653 (W); Clip clamp 82711-12B10 (W); Black tape; Gray tape (10mm)		JIG:		1. Insertion jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>1 WORK PROCEDURE/ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>1 QUALITY POINTERS</b>	
1	P1 Table Lay-out			<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>		<b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>  1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by		Reviewed by		Approved by		Noted by			
12/03/22	1	Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process. Uses of insertion and locking jig during process.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
07/06/22	0	Initial issue.				K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 06, 2022		

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Effectivity Date:

December 3, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: **920B / 7R0115-7020A**Customer: **TRMX**

Document No.:

WI-ENG-PDE-543A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 11

**PARTS:**

1. Connector 7189-0995 (W)

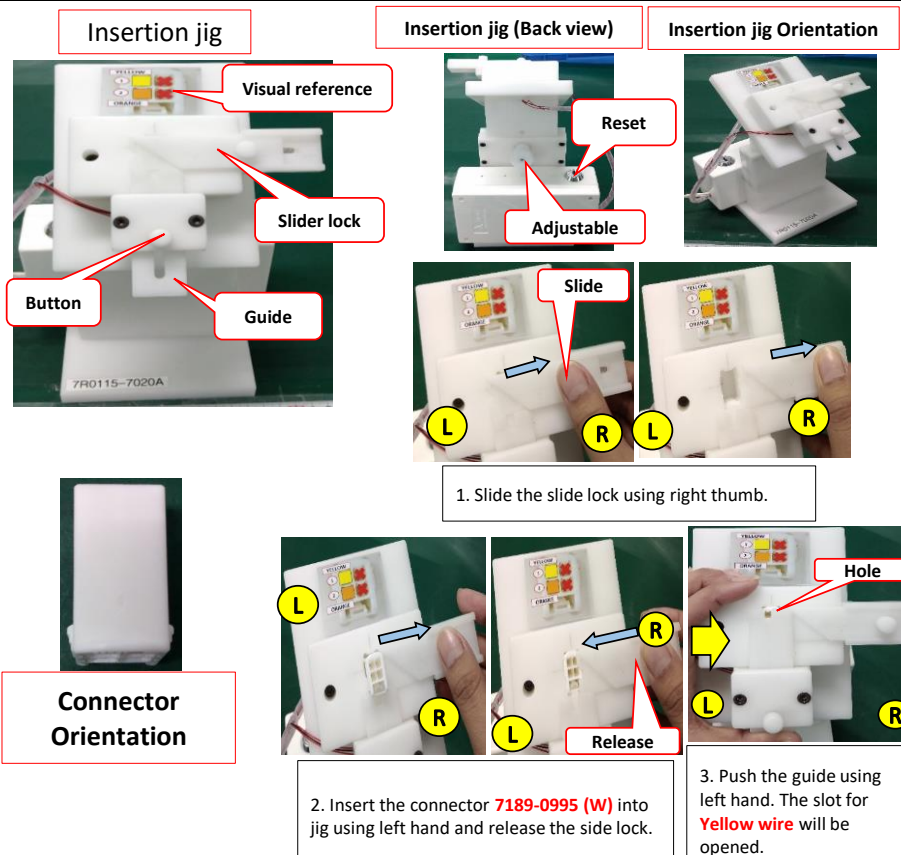
**JIG**

1. Insertion jig

**NO.****PROCESS NAME****1 WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1 QUALITY POINTERS**

2

P1

Connector setting to  
insertion jig  
7189-0995 (W)

n/a

**Important reminders/Note/s:****1. Cannot insert the inverted connector.**

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

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Model Code/Part Number:

920B

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7R0115-7020A

Customer:

TRMX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 3, 2022

Validity Date:

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Document No.:


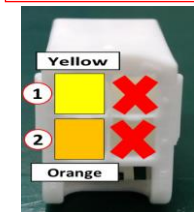
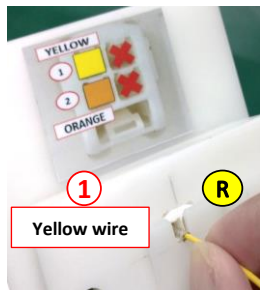
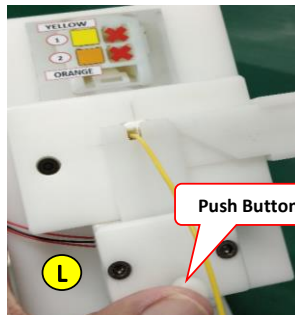
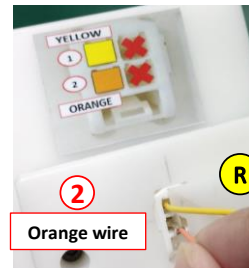
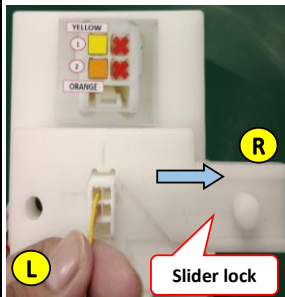
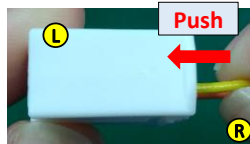
WI-ENG-PDE-543A

Revision No.:

1

Page No.:

3 of 11

PARTS:		1. AVSSf 0.3 wires Y-OR L=338±2mm		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P1 Wire insertion to connector 7189-0995 (W)	<div><div><p>Wire facing</p></div><div><p>Visual Reference</p></div><div><p>1. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand. Conduct <b>Pull-Push-Pull-Push</b> after insertion.</p></div><div><p>2. Press the button using left hand. The slot for <b>Orange wire</b> will be opened.</p></div><div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. <b>GO</b> sound will be heard.</p></div><div><p>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</p></div><div><p>5. After removing the connector from jig, conduct <b>Pushing (1x)</b> of <b>Y wire</b> using right hand to confirm that wire is fully inserted. Repeat the process for <b>OR wire</b>.</p></div></div> <div>n/a</div> <td><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p><b>Important reminders/Note/s:</b></p><p><b>1. Please hold the wire near terminal.</b></p><p><b>2. Make sure wires are properly inserted.</b></p><p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p><p><b>Do not exert extra force.</b></p><p><b>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</b></p><p><b>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</b></p><p><b>5. Conduct Pushing of wires after removing the connector from jig.</b></p><p><b>6. Pushing of wires will be done one by one of every inserted wires</b></p><p><b>Document references:</b></p><p><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p><p><b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p></td>		<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please hold the wire near terminal.</b></p> <p><b>2. Make sure wires are properly inserted.</b></p> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p> <p><b>Do not exert extra force.</b></p> <p><b>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</b></p> <p><b>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</b></p> <p><b>5. Conduct Pushing of wires after removing the connector from jig.</b></p> <p><b>6. Pushing of wires will be done one by one of every inserted wires</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p> <p><b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>	

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## WORK INSTRUCTION

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Model Code/Part Number:

920B

/

7R0115-7020A

Customer:

TRMX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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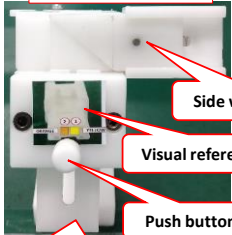


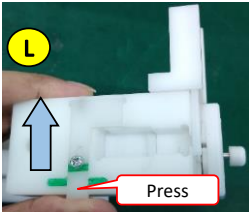
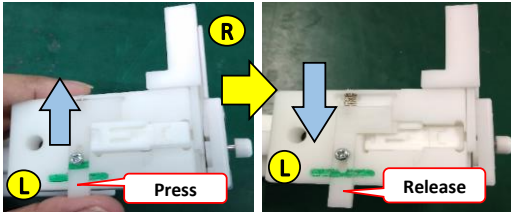
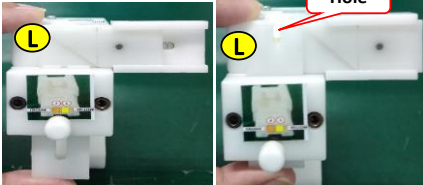
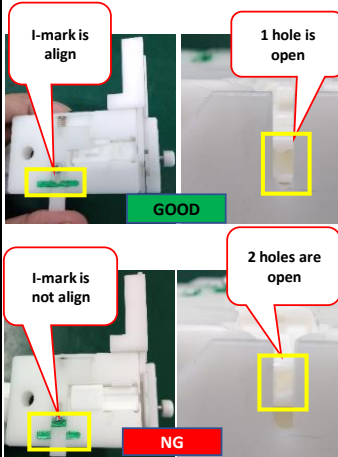
WI-ENG-PDE-543A

Revision No.:

1

Page No.:

4 of 11

PARTS:		1. Assy parts 2. Black Corrugated tube Black Vinyl Tube Ø7 L=245±3mm		3. Connector 6098-6653 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	1 QUALITY POINTERS
4	Wire insertion to Black Vinyl Tube Ø7 L=245±3mm		<div></div> <div>1. Get the Viny tube <b>Ø7 L=245±3mm</b> using right hand then insert the <b>Y-OR wire</b> using left hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal
5	P1	Connector setting to insertion jig 6098-6653 (W)	<div><div></div><div></div><div></div></div> <div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div></div><div>2. Insert the connector <b>4F5450-0000 (W)</b> into jig using right hand and release the lock.</div><div></div><div>3. Push the lower wire guide using left hand, the slot for <b>Yellow wire</b> will be opened.</div></div>			n/a	<div><div></div><div><b>Connector Orientation Illustration</b></div><div>I-mark is align 1 hole is open GOOD</div><div>I-mark is not align 2 holes are open NG</div><div><b>Important reminders/Note/s:</b> 1. Follow the connector orientation</div><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></div>

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## WORK INSTRUCTION

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### TAPING ASSEMBLY PROCESS

Model Code/Part Number:

920B

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Customer:

TRMX

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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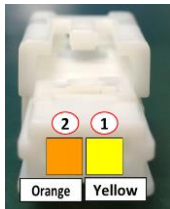
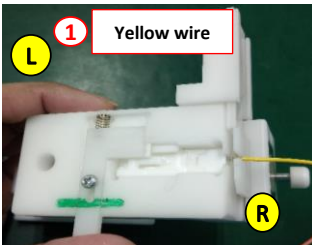
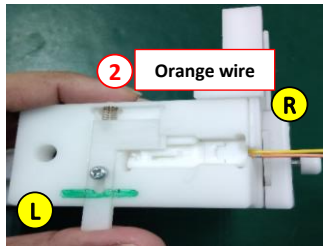

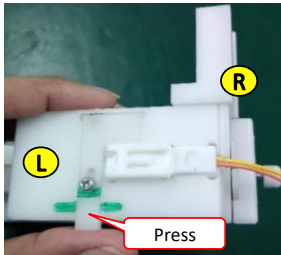
WI-ENG-PDE-543A

Revision No.:

1

Page No.:

5 of 11

PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
6	P1 Wire insertion to Connector 6098-6653 (W)	<div><p><b>VISUAL REFERENCE</b></p></div> <div><p><b>1 Yellow wire</b></p></div> <div><p>1. Get the <b>Yellow wire</b> using right hand then insert to terminal <b>slot 1</b> using right hand.</p></div> <div><p><b>2 Orange wire</b></p></div> <div><p>1. Get the <b>Orange wire</b> using right hand then insert to terminal <b>slot 2</b> using right hand.</p></div> <div><p><b>Wire facing</b></p></div> <div><p>2. Press the button using left hand, the slot for <b>Orange wire</b> will be opened.</p></div> <div><p><b>Press</b></p></div> <div><p>4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>

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Effectivity Date:

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Model Code/Part Number: **920B / 7R0115-7020A**

Customer: **TRMX**

Document No.:

WI-ENG-PDE-543A

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

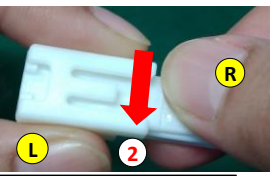
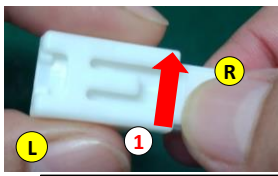

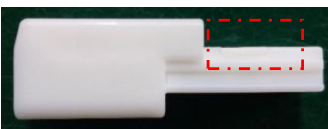
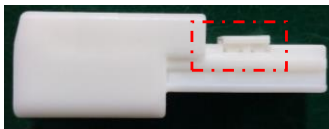



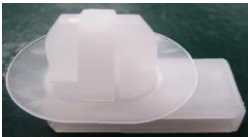
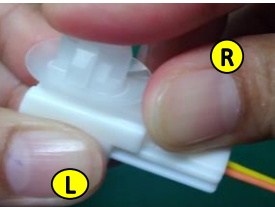
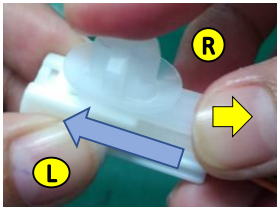
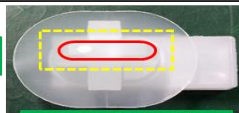
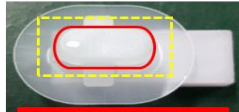
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Revision No.:

1

Page No.:

6 of 11

PARTS:		1. Assy parts 2. Clamp 82711-12B10 (W)			JIG	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS	
7	Connector Lock	<div></div> <div>1. Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Touch the connector lock to confirm if properly locked.</div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div> <div></div> <div>Before PressingAfter Pressing</div>		<div><b>LOCKING JIG</b></div> 	<div><b>Important reminders/Note/s:</b></div> <div><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></div> <div>1. Use the provided locking jig per model</div> <div>2. No unlock/half-locked connector</div> <div><div><b>GOOD</b></div><div>Full Lock</div><div><b>NG</b></div><div>Half Lock</div></div>	
8	Clamp Attachment 82711-12B10 (W)	<div><b>CLAMP ORIENTATION</b></div> <div></div> <div>1. Hold the connector using left hand, get the clip type clamp <b>82711-12B10 (W)</b> then insert the clamp using right hand. <b>Note: Sound will be heard if properly inserted.</b></div>		n/a	<div><b>CLIP CLAMP ILLUSTRATION</b></div> <div><div><b>GOOD</b></div><div>82711-1E360 (W)</div><div><b>NG</b></div><div>82711-12B10 (W)</div></div> <div>1. No wrong use of parts</div> <div>2. No loose attachment</div>	

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## WORK INSTRUCTION

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Process Name/Title:

## TAPING ASSEMBLY PROCESS

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Model Code/Part Number: 920B / 7R0115-7020A

Customer: TRMX

Document No.:

WI-ENG-PDE-543A

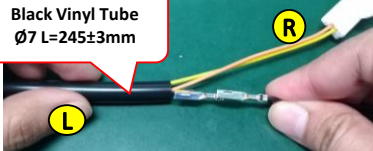
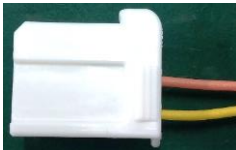

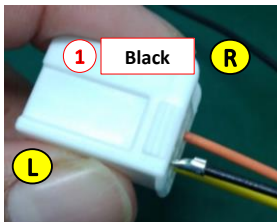
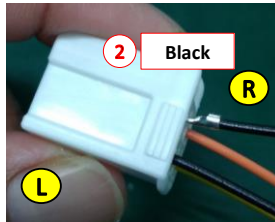
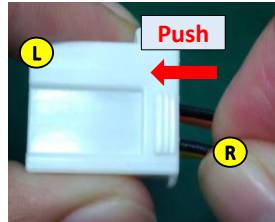
Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

7 of 11

PARTS:		1. Assy parts 2. AVSSf 0.3 wires B-B L=534±3mm		JIG	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS	
14	1 Wire insertion to assy parts	<div><div>Black Vinyl Tube Ø7 L=245±3mm</div><div></div><div>1. Hold the Viny tube Ø7 L=245±3mm using left hand then insert the B-B wire using right hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal	
9	P1 Wire insertion to connector 7189-0995 (W)	<div><div><div>Connector Orientation</div></div><div><div><div>Wire facing</div></div><div><div><div>1 Black</div></div><div><div><div>2 Black</div></div><div><div><div>Push</div></div><div>1. Hold the connector 7189-0995 (W) then hold the first Black wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. <b>Note: Insertion of wire must be from left to right</b></div><div>2. Hold the connector 7189-0995 (W) then hold the second Black wire and insert to terminal slot 2 of connector using right hand. Conduct 2x push pull after wire insertion.</div><div>3. Conduct Pushing (1x) of B wire using right hand to confirm that wire is fully inserted. Repeat the process for B wire.</div></div></div></div></div></div>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b> <b>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</b> <b>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</b> <b>5. Conduct Pushing of wires after removing the connector from jig.</b> <b>6. Pushing of wires will be done one by one of every inserted wires</b>  <b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>	

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# WORK INSTRUCTION

Effectivity Date:

December 3, 2022

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0115-7020A

Customer: TRMX

Document No.:

WI-ENG-PDE-543A

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

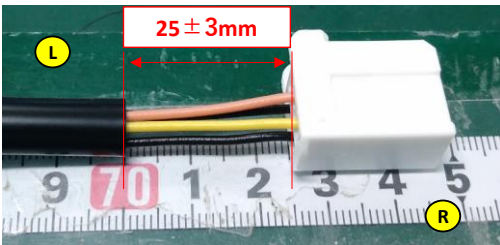
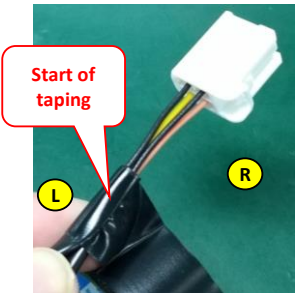
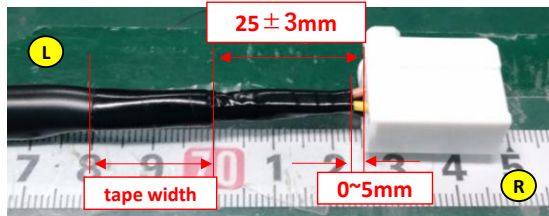

☒ MASSPRO

Revision No.:

1

Page No.:

8 of 11

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
10	P1  Taping 1 Black Vinyl tube to wire near connector	<div><p>1. Measure from end of vinyl tube up to edge of connector <b>25±3mm</b> using both hands.</p></div> <div><p>2. Get the <b>Black tape</b> using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<div>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</div> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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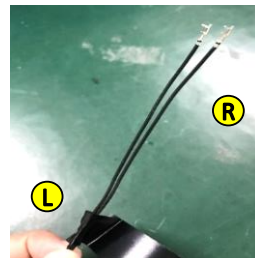
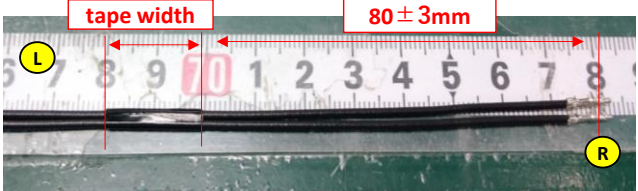

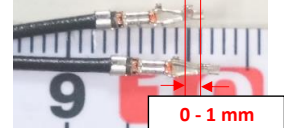

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Revision No.:

1

Page No.:

9 of 11

PARTS:		1. Assy parts 2. Black tape		3. Black twisted tube Ø5 L=219±4mm		JIG	n/a
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		1 QUALITY POINTERS
11	1 Spot taping 1  P1		<div><p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip <b>100±3mm.</b></p></div> <div><p>2. Get the <b>Black tape</b> and start taping on the Black wires. Conduct <b>2x windings</b> of tape before cutting using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div> <b>MEASURING TAPE</b></div>		<div><p><b>Wire alignment tolerance</b> <b>0 - 1 mm</b></p></div> <div>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</div> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>
12	Wire insertion to Black twisted tube Ø5 L=219±4mm		<div><p>1. Get the Viny tube <b>Ø5 L=219±4mm</b> using right hand then insert the <b>B-B wire</b> using left hand.</p></div>		n/a		1. No wrong use of parts 2. No deformed terminal

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1

Page No.:


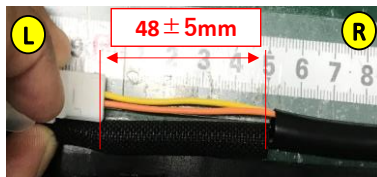
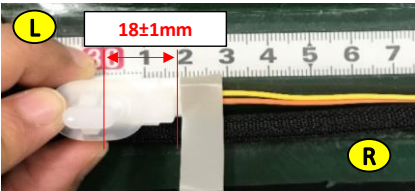
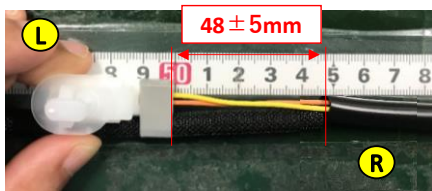

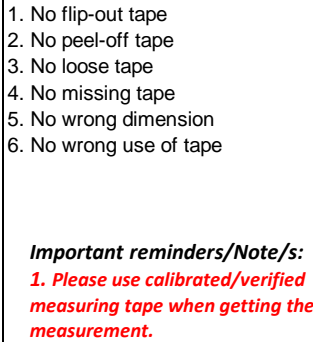
10 of 11

### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1 Spot Taping 2	<div><p>1. Fix the Connector and the twisted tube. <b>Note:</b> Alignment of twisted tube must be beside the Connector.</p></div> <div><p>2. Measure from end of connector up to end of twisted tube <b>48±5mm</b> using both hands.</p></div> <div><p>3. Measure <b>18±1mm</b> from end of clamp up to connector using both hands, get the <b>Gray tape (10mm)</b> using right hand the conduct <b>2 windings</b> of tape using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>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</p><p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p></div>

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Revision No.:

1

Page No.:

11 of 11

### PARTS:

1. Assy parts

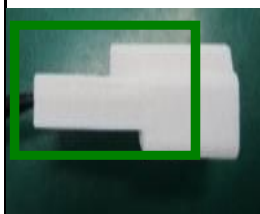
JIG

n/a

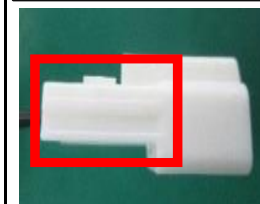
### 1 QUALITY CHECKPOINTS

P1

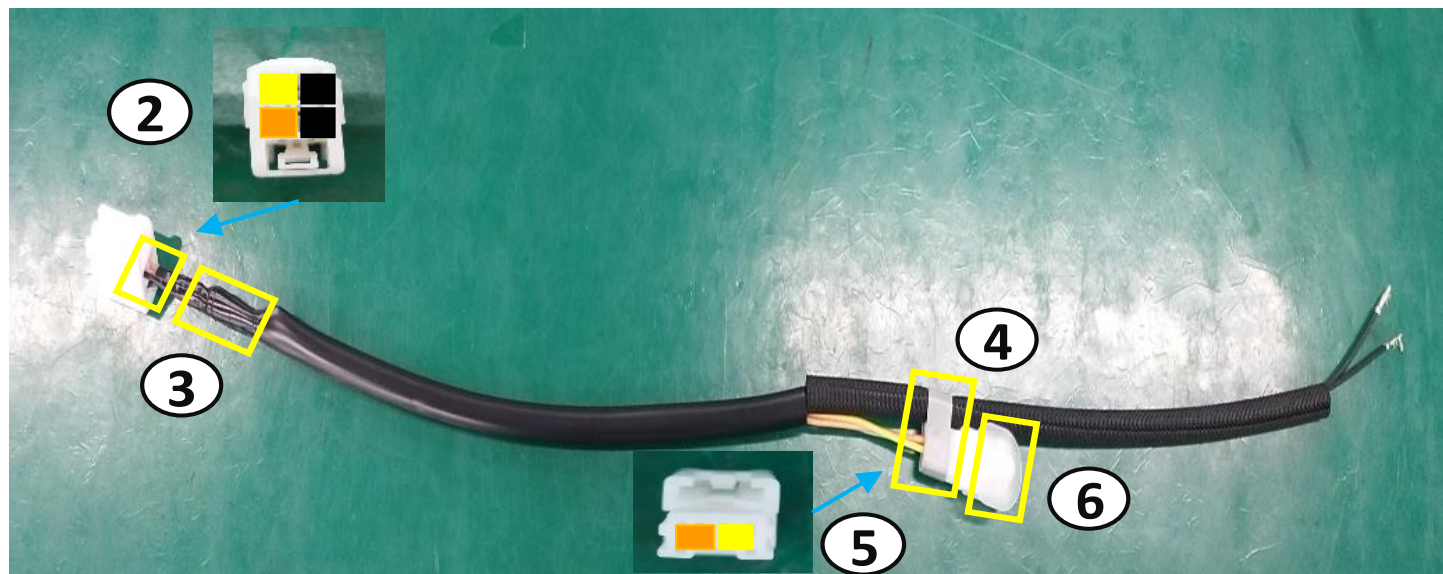
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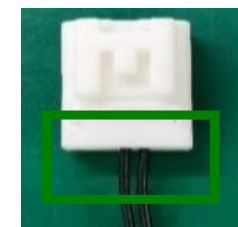
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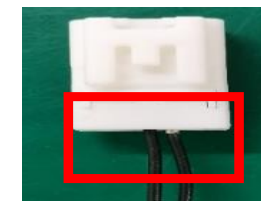
NO GOOD



7



GOOD



NO GOOD

① No Unlock/Halflocked Connector

③④ No Missing tape

②⑤ No Wrong Insert

⑥ No Missing Clip type clamp

⑦ No Terminal Backing Out

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