

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 13, 2022

Model Code/Product Number:

816W / 7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

WI-ENG-PDE-494B

Revision No.:

1

Page No.:

1 of 3

PARTS:

1. Assy parts: Black Corrugated tube Ø5 L=203±2mm (no slit); Black tape

JIG

1. Terminal cover jig

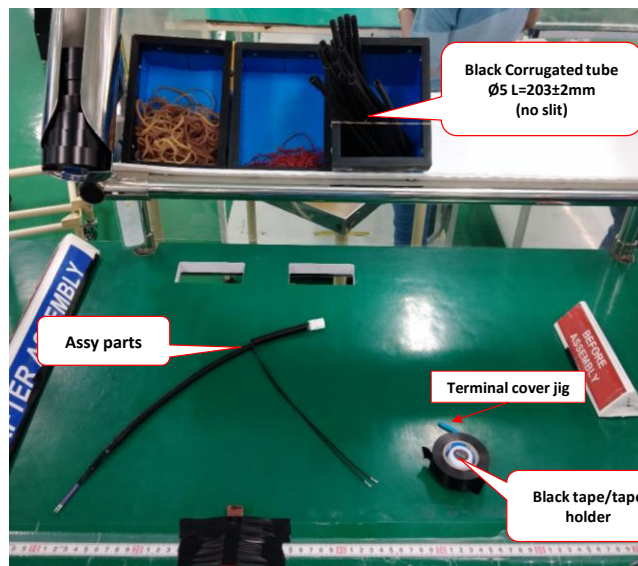
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

Table Lay-out

1

Table Lay-out**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

Revision History

| Eff.Date | Rev.No | Details of Change | Revised | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|----------|--------|--|-------------|------------|---------------|-----------|-------------|-------------|---------------|-----------|
| 05/13/22 | 1 | Change document purpose from pre-launch to masspro. Additional table layout. | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | M. Catapang | J. Loterte | C. Villanueva | A. Arañes |
| 04/29/22 | 0 | Initial issue | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | M. Catapang | J. Loterte | C. Villanueva | A. Arañes |

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:

May 13, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/aModel Code/Product Number: **816W / 7H0402W7020A**Customer: **NBS**

Document No.:

WI-ENG-PDE-494B

Purpose:




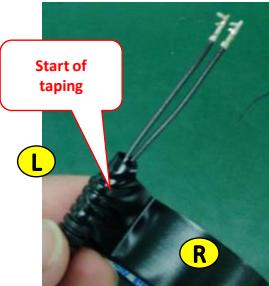
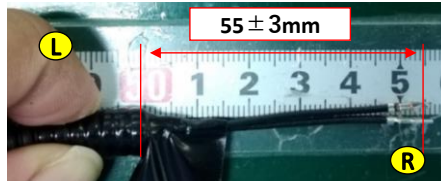
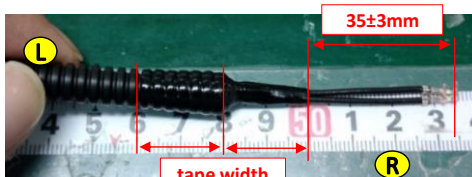

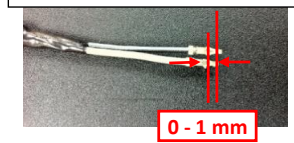
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 3

| PARTS: | | 1. Assy parts 2. Black Corrugated tube Ø5 L=203±2mm 3. Black tape | JIG | 1. Terminal cover jig |
|--------|---|--|---|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 2 | Wire Insertion to Black Corrugated tube Ø5 L=203±2mm |    <p>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</p> <p>2. Get the Black COT Ø5 L=203±2mm (No Slit) using right hand and insert B-B wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> | n/a | 1. No wrong use of parts 2. No deformed terminal |
| 3 | P2 Taping 1 Black vinyl tube to wire near terminal (B-B wires) |    <p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping at the middle of COT and wires using both hands.</p> <p>2. Measure from end of COT up to terminal pointed tip L=55±3mm then continue the taping process using both hands. Note: Please refer to WI-PRO-ASY-001 for taping procedure</p> <p>3. After taping, check the measurement, terminal appearance and taping condition.</p> |  |  <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p> <p>Note: 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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 13, 2022

Process Name/Title:

Model Code/Product Number: 816W / 7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

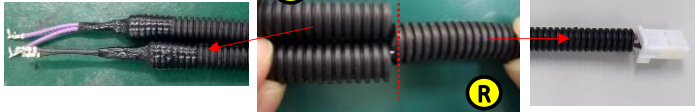
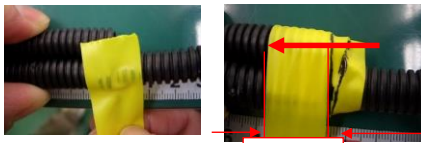
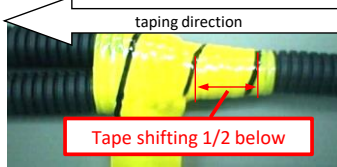
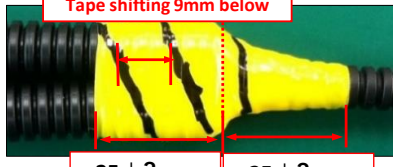
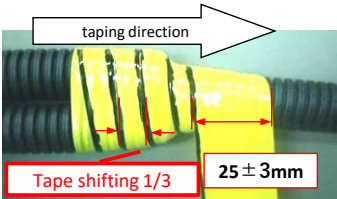

3 of 3

PARTS:

1. Assy part
2. Black tape

JIG

n/a

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|--|--------------|------------------------------|-----------|------------------|
| 4 | P2 | Y-taping | | |
| <div><div>No wide interval</div><div></div><div>1. Fix the corrugated tube.</div><div><div>Note: Do not exert excessive force during pulling & winding of tape</div><div></div><div>25 ± 3mm</div><div>2. Hold the 2 COT using left hand and fix to other COT. Make 1 winding for pre-tape before shifting then wind the tape down to COT until 25±3mm.</div><div></div><div>taping direction</div><div>Tape shifting 1/2 below</div><div>4. Wind the tape backward 1/2</div><div></div><div>Tape shifting 9mm below</div><div>25 ± 3mm</div><div>25 ± 3mm</div><div>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div><div></div><div>taping direction</div><div>Tape shifting 1/3</div><div>25 ± 3mm</div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</div><div></div><div>MEASURING TAPE</div></div></div> | | | | |
| <div><div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div><div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</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