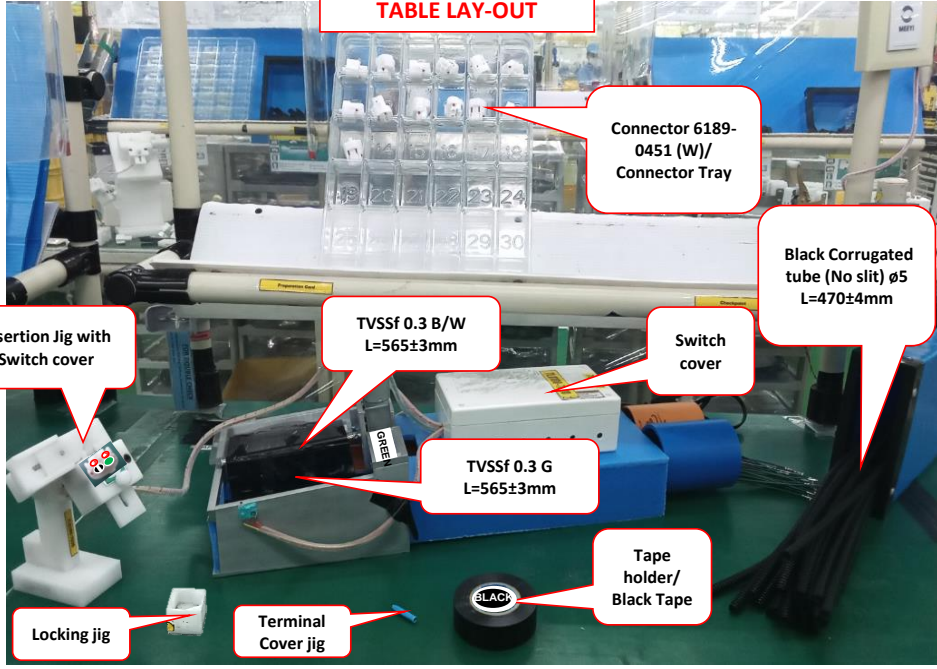



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		May 10, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/ Part Number: 890B / 7L0100-7021		Customer: TRQSS		Document No.:		WI-ENG-PDE-405A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 7

PARTS:		1. Connector 6189-0451 (W); TVSSf 0.3 G-B/W L=565±3mm; Black Corrugated tube (No slit) ø5 L=470±4mm; Black tape		JIG:		1. Insertion jig with switch cover 2. Locking Jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P1	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 Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance			

Revision History						Prepared by:	Reviewed by:	Approved by:	Noted by:	
05/10/23	3	Inclusion of quality checkpoints	J. Loterte	J. Loterte	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a
10/27/22	2	Correction of measurement on process no. 6-Taping 1 COT to wire near terminal from 25±3mm to tape width.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/23/22	1	Change of tolerance from 34+/-3mm to 34(+3/-1mm) as countermeasure of encountered NG dimension from end of tape up to terminal tip. Improve: Work procedure/Illustration on process no. 3, 4, 5 and 6; Quality pointers and notes on Pg. no. 1,2,3,4,6	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/11/22	0	Initial Issue. PCB 2 chips (61C619-0002) to 1 chip (7N09947060) Wire color of Gray (GR) to Green (G)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Established Date:	February 11, 2022	

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Process Name/Title:

Model Code/ Part Number: **890B / 7L0100-7021**

Customer: **TRQSS**

Validity date:

n/a

Document No.:

WI-ENG-PDE-405A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

2 of 7

PARTS:

1. Connector 6189-0451 (W)

JIG

1. Insertion jig with switch cover
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

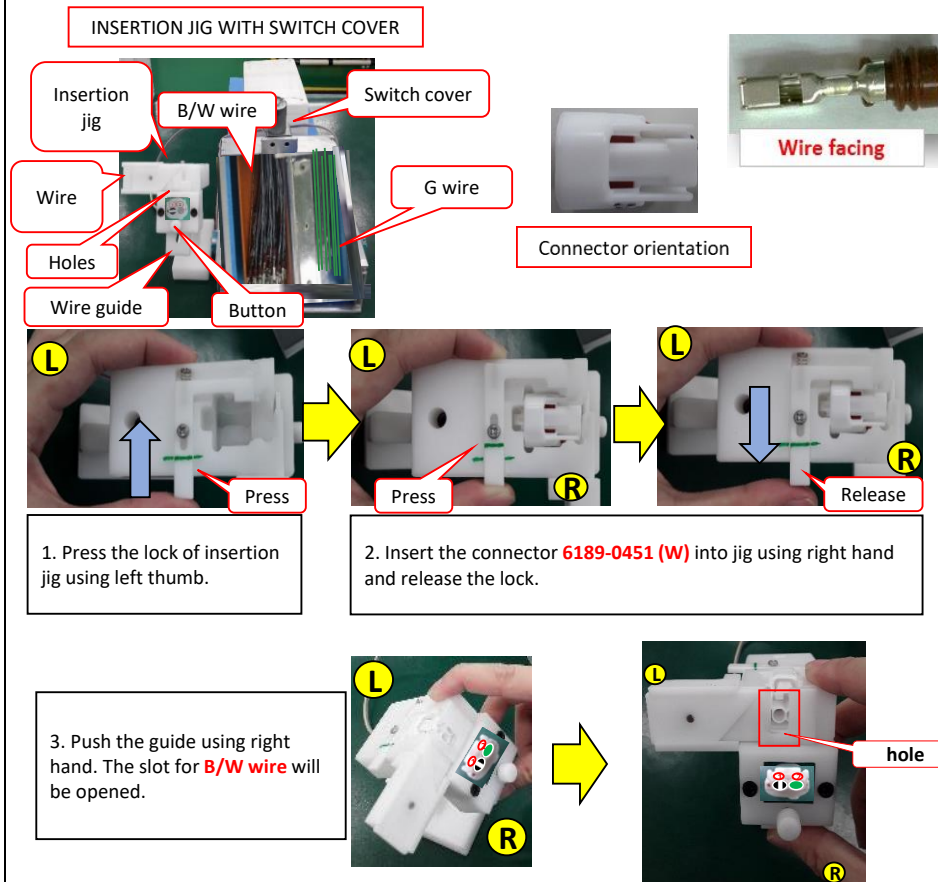
TOOLS/PPE

QUALITY POINTERS

2

P1

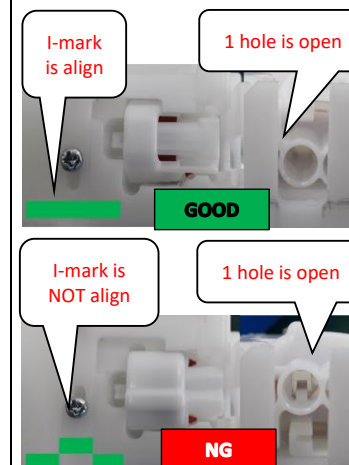
Connector setting to
insertion jig
6189-0451 (W)



n/a

1. Use the provided jig per model
2. No wrong orientation of connector

Connector Orientation Illustration



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TAPING ASSEMBLY PROCESS

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Customer: **TRQSS**

Validity date:

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Document No.:

WI-ENG-PDE-405A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

3 of 7

PARTS:

1. TVSSf 0.3 G-B/W L=565±3mm

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

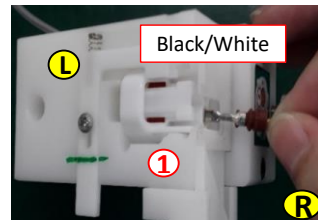
TOOLS/PPE

QUALITY POINTERS

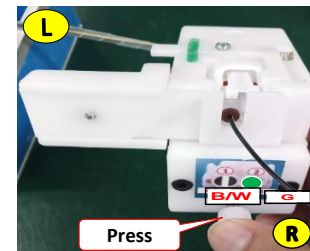
3

P1

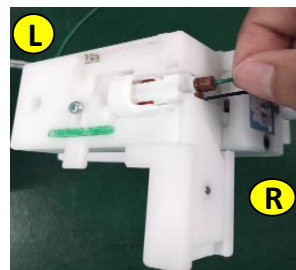
Wire insertion to
connector
6189-0451 (W)



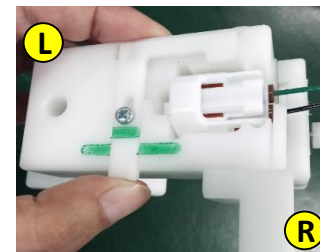
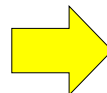
1. Get the **B/W wire** then insert to terminal slot ① using right hand.



2. After insertion of **B/W wire** press the button using right hand. The slot for **G wire** will be open.



3. Get the **G wire** then insert to terminal slot ② using right hand.



4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal

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.

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Model Code/ Part Number: **890B / 7L0100-7021**

Customer: **TRQSS**

Validity date:

n/a

Document No.:

WI-ENG-PDE-405A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

4 of 7

PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

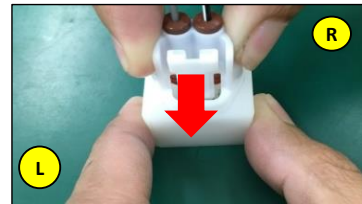
TOOLS/PPE

QUALITY POINTERS

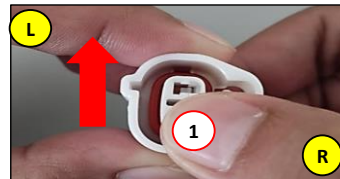
4

P1

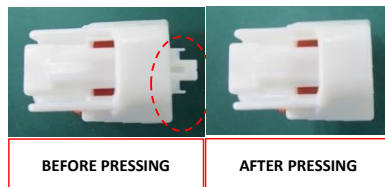
Connector Lock



1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.



Check the double lock deformation

LOCKING JIG



1. No half-locked and unlock
2. No lock deformation
3. Use provided jig tool to lock the connector

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

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Process Name/Title:

Model Code/ Part Number: **890B / 7L0100-7021**

Customer: **TRQSS**

Validity date:

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Document No.:

WI-ENG-PDE-405A

Purpose:

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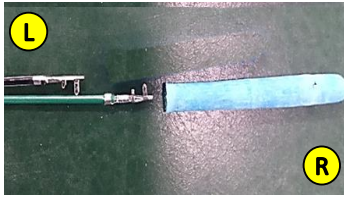

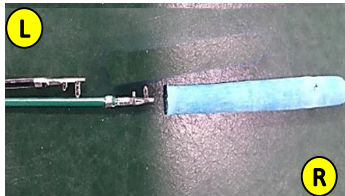



☒ MASSPRO

Revision No.:

3

Page No.:

5 of 7

PARTS:		1. Black Corrugated tube (No slit) $\phi 5$ L=470 \pm 4mm 2. Assy parts 3. Black tape		JIG	1. Terminal Cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div></div> <div>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</div> <div></div> <div>2. Get the Black Corrugated tube $\phi 5$ L=470\pm4mm (no slit) using right hand and insert to G-B/W wires using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal
6		<div></div> <div>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands.</div>		<div>MEASURING TAPE</div> 	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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Document No.:

WI-ENG-PDE-405A

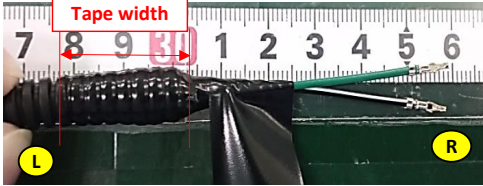
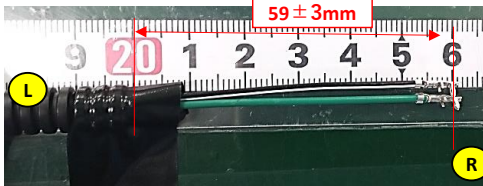
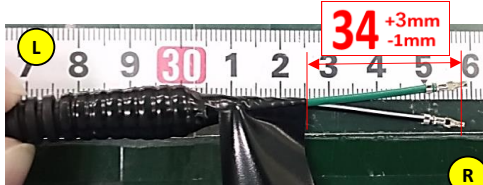
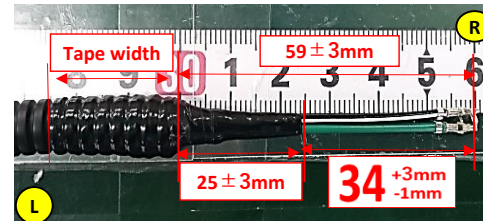

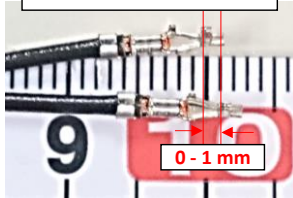
Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

6 of 7

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 COT to wire near terminal (Continuation)	<div><p>2. Confirm measurement from end of tape up to end of COT (must be tape width) then continue the taping process using both hands.</p></div> <div><p>3. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p></div> <div><p>4. Measure from end of tape up to terminal pointed tip 34+3/-1mm then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension 5. No missing tape 6. No wrong use of tape</div> <div>Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div>Wire alignment tolerance</div> 

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Model Code/ Part Number: **890B / 7L0100-7021**Customer: **TRQSS**

Validity date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-405A

Revision No.:

3

Page No.:

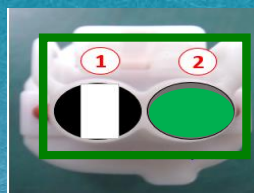
7 of 7

PARTS:

1. Assy parts

JIG

n/a

**QUALITY CHECKPOINTS****P1****7L0100-7021****GOOD****NO GOOD****1** No **Unlocked/ Half Locked Connector****3** No **missing tape****2** No **Wrong Insert/No terminal backing out**

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