



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 17, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code: 922B / 7L0123-7021

Customer: TRQSS

Document No.:

WI-ENG-PDE-265C

Purpose:

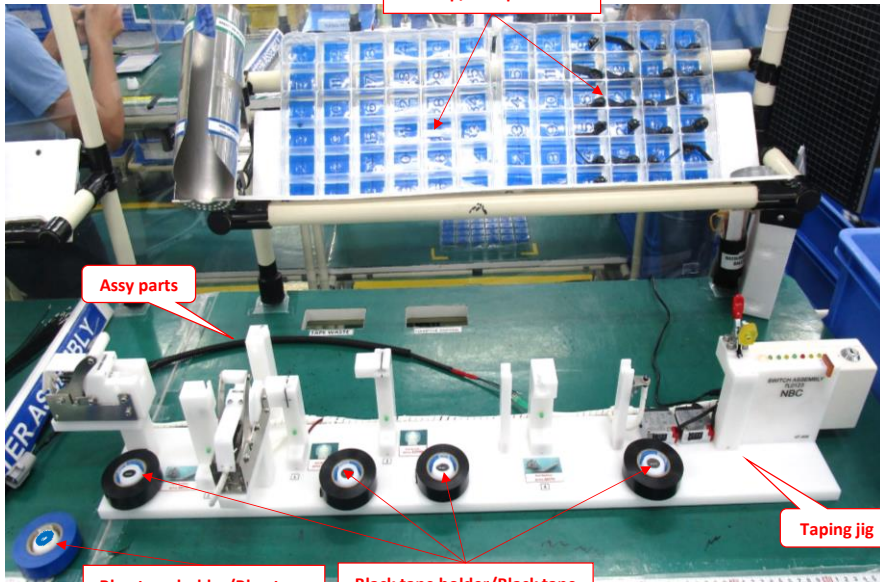
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS:		1. Assy parts 2. Clamp 82711-52090 (W) 3. Clamp 82711-48070 (GR)		1. Black tape [4pcs.] 2. Blue tape [1pc.]		JIG:		1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1		P3 Table Lay-out		<div><div>TABLE LAY-OUT</div><div>Clamp/Clamp Holder</div><div>Assy parts</div><div>Blue tape holder/Blue tape</div><div>Black tape holder/Black tape</div><div>Taping jig</div></div>		<div><div>Safety Instruction</div><div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in</div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools	
Revision History									
						Prepared by		Reviewed by	
09/17/21		1		Revise due to apply some improvements; Change pre-launch to masspro.		M. Catapang		C. Villanueva	
06/04/21		0		Initial issue		M. Catapang		C. Villanueva	
Eff. Date		Rev. No		Details of Change		Prepared		Checked	
						Checked		Approved	
						Est. Date:		June 04, 2021	
								Reviewed by	
								Noted by	
								A. Aranes	

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:

September 17, 2021

Validity Date:

n/a

Product Name/Code:

922B / 7L0123-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-265C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

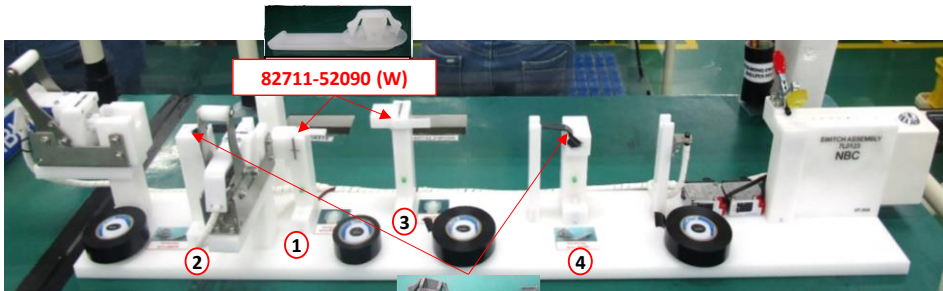
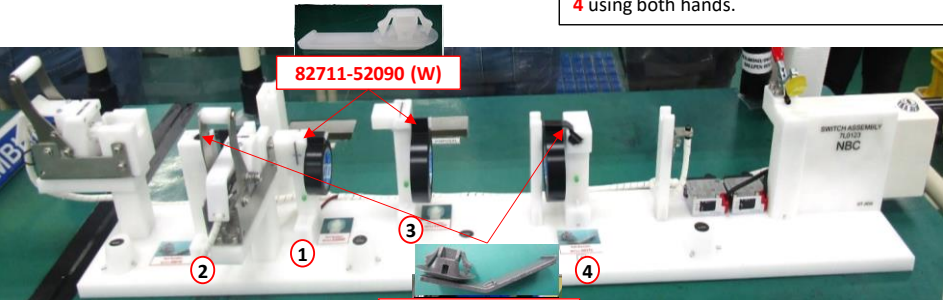
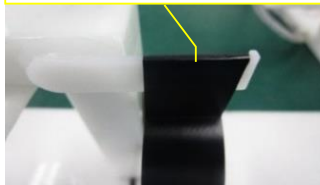
☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7

PARTS:		1. Assy parts 2. Clamp 82711-52090 (W) [2pcs.] 3. Clamp 82711-48070 (GR) [2pcs.]			4. Black tape [4pcs.] 5. Blue tape [1pc.]		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
2	P3	Clamp setting	<div></div> <div><p>1. Get 2pcs. of clamp 82711-52090 (W) using right hand then set to clamp location 1 and 3 using both hands.</p><p>2. Get 1pc. of clamp 82711-48070 (GR) using right hand then set to clamp location 2 using both hands.</p><p>3. Get 1pc. of clamp 82711-48070 (GR) using right hand then set to clamp location 4 using both hands.</p></div> <div></div> <div><p>4. Initially attach Black tape to clamp location 1, 2, 3 and 4 using both hands.</p></div>			n/a		<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div>  <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</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

Effectivity Date:

September 17, 2021

Validity Date:

n/a

Product Name/Code:

922B / 7L0123-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-265C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

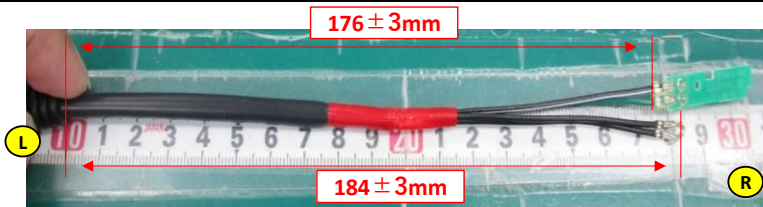
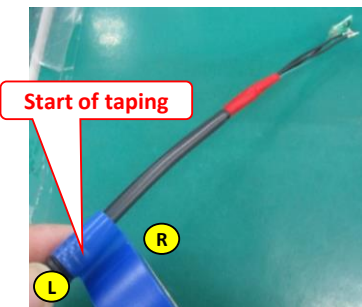
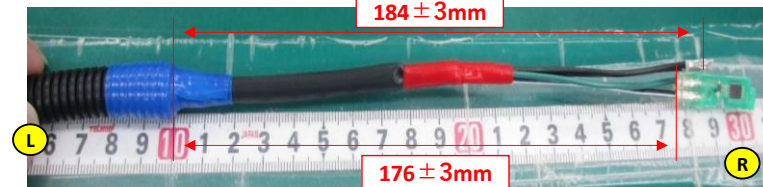

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:		1. Assy parts 2. Blue tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 Taping 1 Black corrugated tube to Black sunprene tube	 <p>1. Measure from end of sunprene tube up to edge of hotmelted wire 176±3mm and up to terminal pointed tip 184±3mm using both hands.</p>  <p>2. Get the Blue tape using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>NOTE: USE BLUE TAPE only.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 17, 2021

Product Name/Code:

922B / 7L0123-7021

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

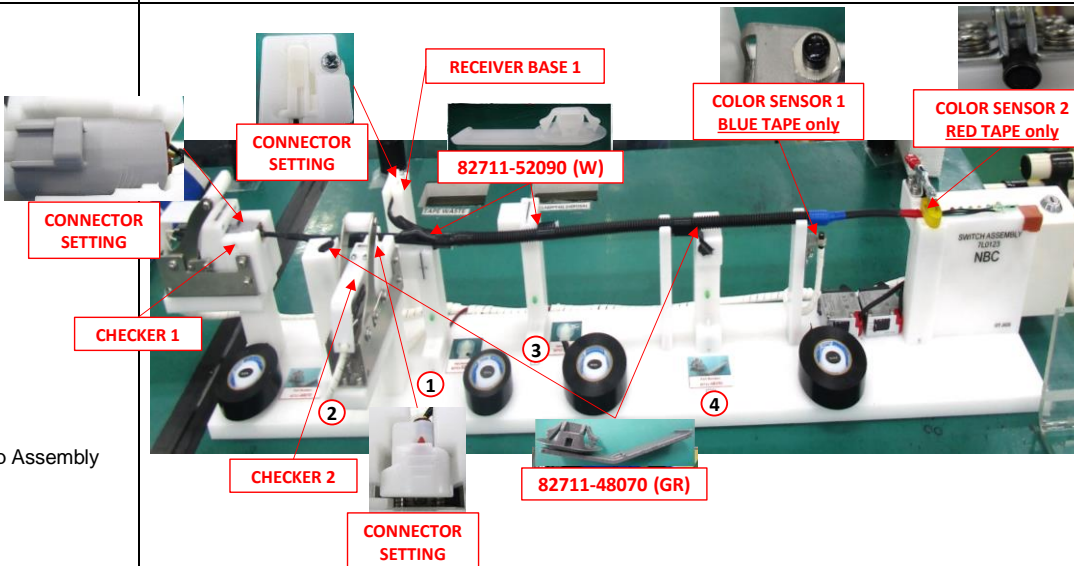
☒ MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Clamp Assembly	 <p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Third, set the connector 6098-3810 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor 1 will beep/buzz if sensor detects Blue tape. Color sensor 2 will beep/buzz if sensor detects Red tape. Last, set the hotmelted wires and terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p>	n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp 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



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 17, 2021

Product Name/Code:

922B / 7L0123-7021

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-265C

Revision No.:

1

Page No.:

5 of 7

PARTS:		1. Black tape 2. Assy parts		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	<div></div> <div>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 2 was ON.</div> <div>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 3 was ON.</div>		n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp 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



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 17, 2021

Validity Date:

n/a

Product Name/Code:

922B / 7L0123-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-265C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

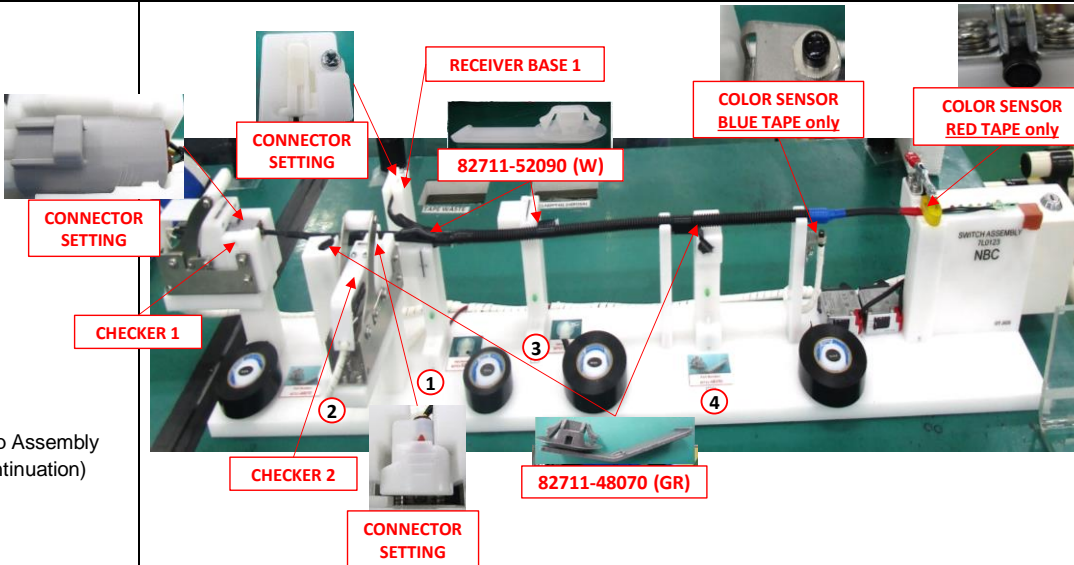
☒ MASSPRO

Revision No.:

1

Page No.:

6 of 7

PARTS:		1. Black tape 2. Assy parts	JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Clamp Assembly (Continuation)	 <p>5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</p> <p>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</p> <p>7. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p>	n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp 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



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 17, 2021

Product Name/Code:

922B / 7L0123-7021

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:



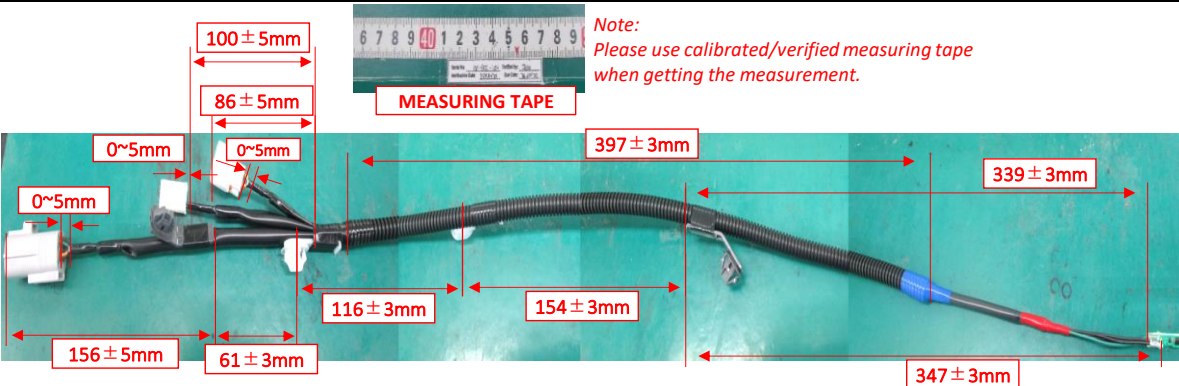
WI-ENG-PDE-265C

Revision No.:

1

Page No.:

7 of 7

PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Visual Inspection/By Two's inspection	<div>1. Check the connector lock.</div> <div>3. Check the clamp attachment and taping condition</div> <div>2. Check the terminal and hotmelted wire appearance. Make sure no deformed terminal.</div> <div>4. Compare to MASTER SAMPLE. <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div> 		<div>MASTER SAMPLE</div> 
6	Measurement	<div>MEASURING TAPE</div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> 		<div>NOTE: HATSUMONO AND OWARIMONO</div> <div>1. No wrong dimension</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