

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

January 28, 2022

Model Code/Part number:

**780B / 7R0106-7021**

Customer:

**TRMX**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-381B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

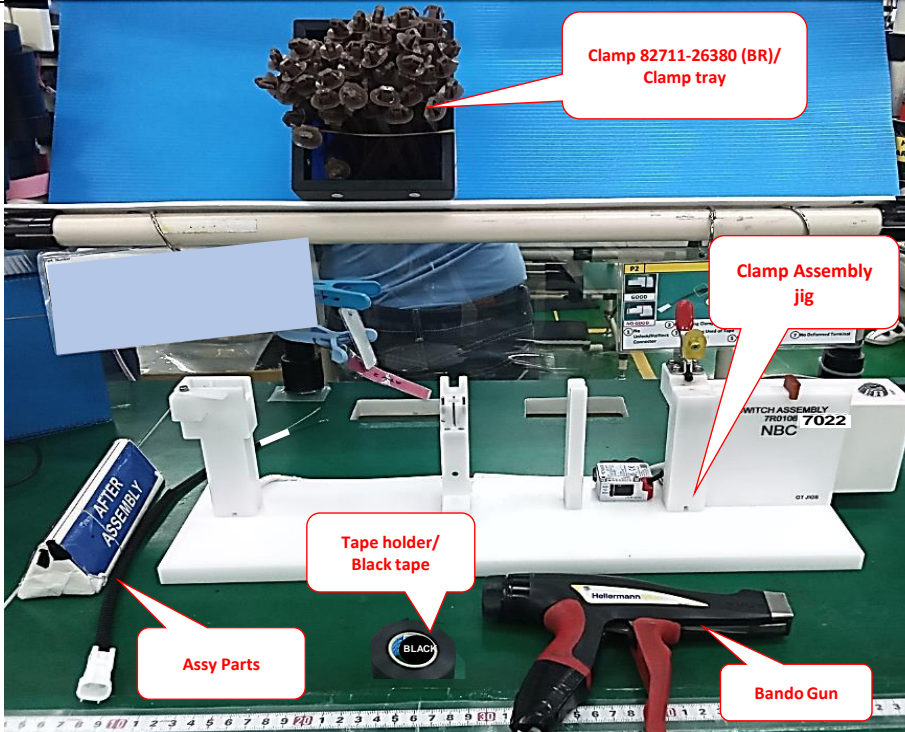
1 of 4

**PARTS:**


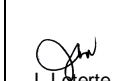


1. Assy parts; Clamp 82711-26380 (BR); Black tape

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	 <p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date	Prepared by:	Reviewed by:	Approved by:	Noted by:
01/28/22	0	Initial Issue. Change PCB from 2 chips (61C619-0002) to 1 chip (7N0994-7060). Change Wire color from Gray (GR) to Green (G).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		 M. Ariola	 J. Loterte	 C. Villanueva	 A. Arañes
01/28/22	0	Initial Issue. Change PCB from 2 chips (61C619-0002) to 1 chip (7N0994-7060). Change Wire color from Gray (GR) to Green (G).	M. Ariola	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

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

January 28, 2022

Model Code/Part number:

780B / 7R0106-7021

Customer:

TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

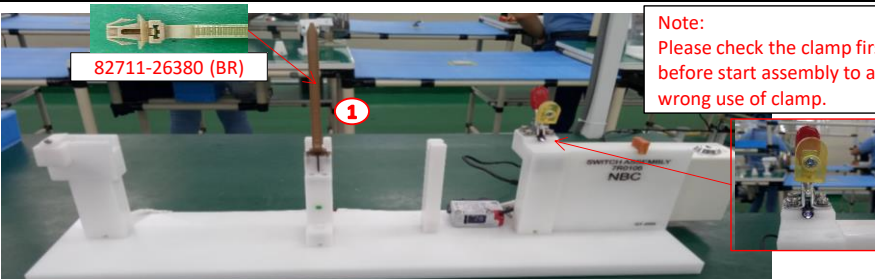
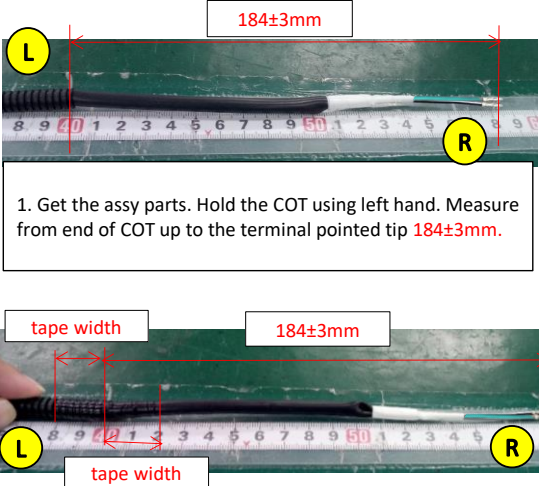
☒ MASSPRO

Revision No.:

0

Page No.:

2 of 4

PARTS:		1. Clamp 82711-26380 (BR) 2. Black tape	3. Assy parts	JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assembly Setting	 <p>Note: Please check the clamp first before start assembly to avoid wrong use of clamp.</p> <p>Get 1pc of Band clamp 82711-26380 (BR) using right hand and set to clamp location 1.</p>		n/a	1. No wrong use of clamp 2. No damaged clamp
3	P2 Taping COT to Sunprene tube near terminal	 <p>184±3mm</p> <p>1. Get the assy parts. Hold the COT using left hand. Measure from end of COT up to the terminal pointed tip 184±3mm.</p> <p>tape width 184±3mm</p> <p>2. Hold the COT using left hand. Get Black tape using right hand and start taping using both hands. Make sure no gap between COT and Sunprene tube. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>3. After taping, check the measurement and taping condition.</p>		Measuring Tape	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</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 6. No missing tape</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:

January 28, 2022

Model Code/Part number:

**780B / 7R0106-7021**

Customer:

**TRMX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

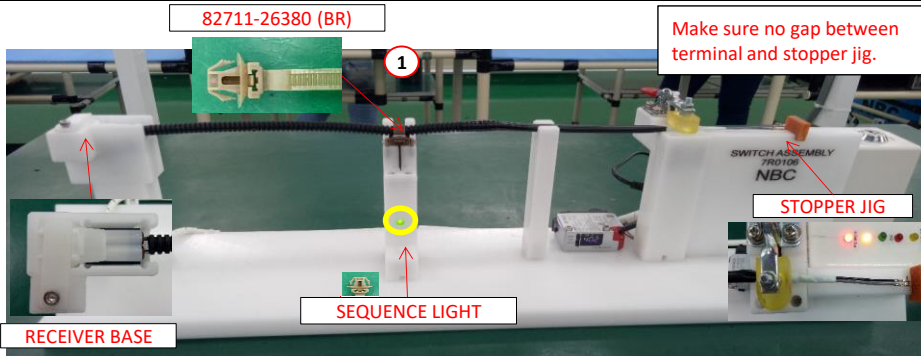
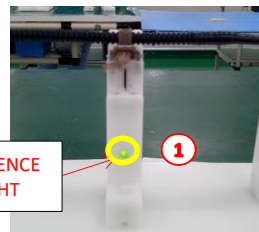
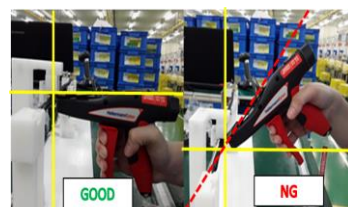
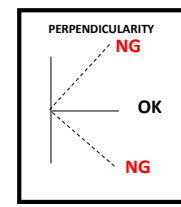
☒ MASSPRO

Revision No.:

0

Page No.:

3 of 4

PARTS:		1. Assy parts		JIG	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly jig	<div><p>1. Get the assy parts using both hands. First, put the connector into receiver base then lock. Second, put the terminal to stopper jig. Color sensor will beep/buzz if detected White tape. Pull down the toggle clamp using right hand. Continue if the sequence light of location 1 was on. <i>Refer to above illustration for the correct setting.</i></p><p>2. Check if LED light for <b>POWER, CLAMP, COLOR SENSOR</b> and <b>SEQUENCE LIGHT</b> is <b>ON</b>. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the Leader and <b>WAIT</b> for instruction.</p><p>3. Initially tighten the clamp on location 1 using both hands.</p><p>4. Get the bando gun and cut the clamp on location 1. Press the switch button after cutting. <b>Go</b> buzzer will be heard.</p><p>5. Conduct <b>POINT CHECKING</b> before removal from jig.</p><div><p>SEQUENCE LIGHT</p></div><div><p>GOOD NG</p></div><div><p>PERPENDICULARITY NG OK NG</p></div></div>	N/A	<p><b>NOTE: YOU WILL HEAR THE NG BUZZER IF THE SENSOR DETECT WRONG USE OF TAPE AND MISSING TAPE.</b></p> <p>1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment</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:

January 28, 2022

Model Code/Part number:

780B / 7R0106-7021

Customer:

TRMX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-381B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

4 of 4

PARTS:		n/a	JIG		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Visual/By two's inspection	<div>1. Check the connector lock.</div> <div>2. Check the presence of clamp attachment.</div> <div>3. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div> <div>4. Check the terminal condition. Make sure no deformed terminal.</div> <div>5. Compare to Master sample. Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</div>			
6	Measurement	<div>0~5mm</div> <div>239±5mm</div> <div>424±5mm</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>			For Hastumono and Owarimono

**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