

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 26, 2021

Product Name/Code:

310B / 7M0557-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-162B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO


Revision No.:

3

Page No.:

1 of 4

PARTS:	<div>1. Clamp 82711-52090 (W) [2pcs] 2. Black tape</div>	<div>3. Light Green tape</div>	<div>1. Clamp Assembly jig</div>
---------------	--	--------------------------------	----------------------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Clamp Assembly setting	<div><div>1. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 1 and 2 using both hands.</div><div>2. Get BLACK TAPE using right hand and conduct pre-taping on clamp location 1.</div><div>3. Get LIGHT GREEN TAPE using right hand and conduct pre-taping on clamp location 2.</div></div> <div>STANDARD TAPING FOR CLAMP One side tape under clamp</div> 	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
02/26/21	3	Change clamp colours in accordance with color standardization for plastic parts; Remove cycle time; Put assy parts on Pg.2 and 3 parts section; Put measuring tape illustration and instruction on measurement process.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
08/19/20	2	Transferred process owner from Production (WI-PRO-ASY-117B) to Engineering; Changed sunprene tube from Dia. 11 to Dia. 9; apply some improvements and added cycle time.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
10/11/19	1	Remove Marking/ Include Refer Guidelines for By Two's Inspection	A. Roxas	A. Morcozo	O. Merin	n/a	J. Loterte	C. Villanueva	Shimamura	A. Arañes
Est. Date:							October 11, 2018			

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**Product Name/Code: **310B / 7M0557-7020B**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 26, 2021

Validity Date:

-

Document No.:

WI-ENG-PDE-162B

Revision No.:


3

Page No.:

2 of 4





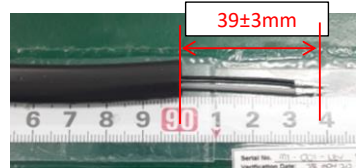



PARTS:

1. Black Sunprene tube $\varnothing 9$ L=97 \pm 3mm
2. Black tape

 3. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	 Wire insertion to Sunprene tube $\varnothing 9$ L=97 \pm 3mm	  <ol style="list-style-type: none">1. Get the Sunprene tube $\varnothing 9$ L=97\pm3mm using right hand then insert the Gray and Black/White wire2. Insert the Sunprene to COT 20mm (Tape width) using bot hands.	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal.
3	P2  Taping COT to Sunprene tube	   <ol style="list-style-type: none">1. Hold the COT using left hand and measure the sunprene tube up to terminal tip 39mm.2. Hold the COT using left hand and begin taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i>3. After taping, check the dimension, terminal appearance and taping condition.	MEASURING TAPE 	<i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong dimension

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:

February 26, 2021

Process Name/Title:

Product Name/Code:

310B / 7M0557-7020B

Customer:

TRJ

Validity Date:

Document No.:

WI-ENG-PDE-162B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

3 of 4

PARTS: 3 1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly



1. Get the assy parts and set to jig using both hands. First, put the connector into connector receiver base and lock. Second, put the terminal into stopper jig and pull down the toggle clamp.
Refer to above illustration for the correct setting.

2. Check if LED light for **POWER**, **CLAMP** and **SEQUENCE** light was **ON**. If encountered abnormality **STOP** the process, **CALL** the attention of the leaders and **WAIT** for instructions.

3. Hold the clamp on **location 1** and begin taping using right hand. Make **3 winds** and cut the tape. Press the SW button after taping.
TAPE COLOR MUST BE BLACK.

4. Hold the clamp on **location 2** and begin taping using right hand. Make **3 winds** and cut the tape. Press the SW button after taping. Go sound will be heard.
TAPE COLOR MUST BE LIGHT GREEN.

5. Conduct **POINT CHECKING** before removing from jig.

n/a

*Note:
Make sure no clearance between terminal and stopper jig*



1. No missing tape
2. No missing parts
3. No wrong use of tape

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:

February 26, 2021

Product Name/Code: **310B / 7M0557-7020B**Customer: **TRJ**

Validity Date:

-

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

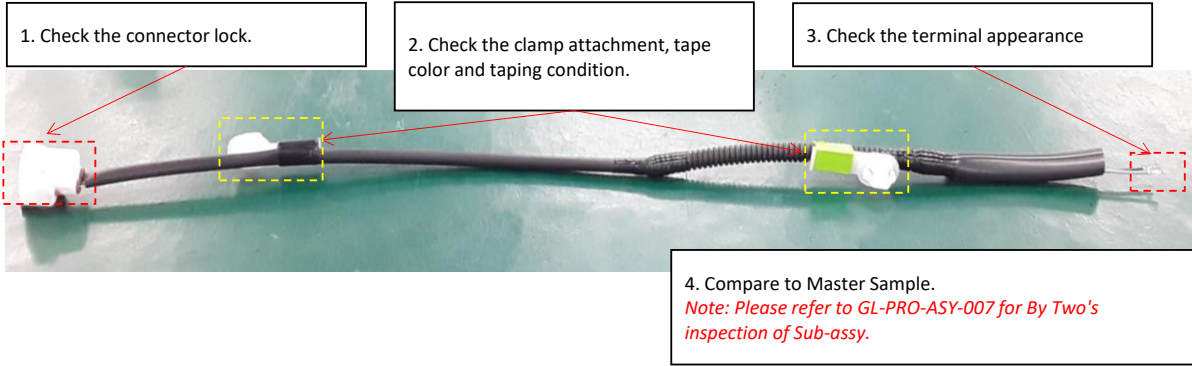

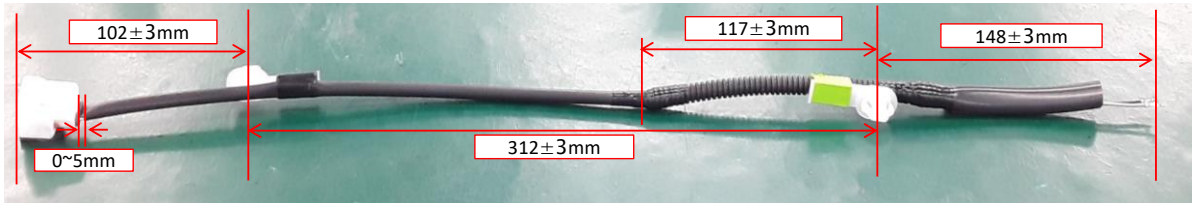
WI-ENG-PDE-162B

Revision No.:

3

Page No.:

4 of 4

PARTS:	n/a		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	<div>3</div> <div>Visual/By two's Inspection</div> <div>3</div>	<div>1. Check the connector lock.</div> <div>2. Check the clamp attachment, tape color and taping condition.</div> <div>3. Check the terminal appearance</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	P2 Measurement	<div>3</div> <div><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</div> 	<div><i>Note:</i> For 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