

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**Model code/Part Number **715W / 7H0420W7020**

Customer:

**NBS**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 05, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-512

Revision No.:

1

Page No.:

1 of 3

**PARTS:**

1. All parts; Pre-assy parts from Offline (Connector 6098-3802 (W); IRRAX A 0.3 B wires L=140±2mm ); Black vinyl tube ø5 L=70±3mm; Yellow tape

**JIG**

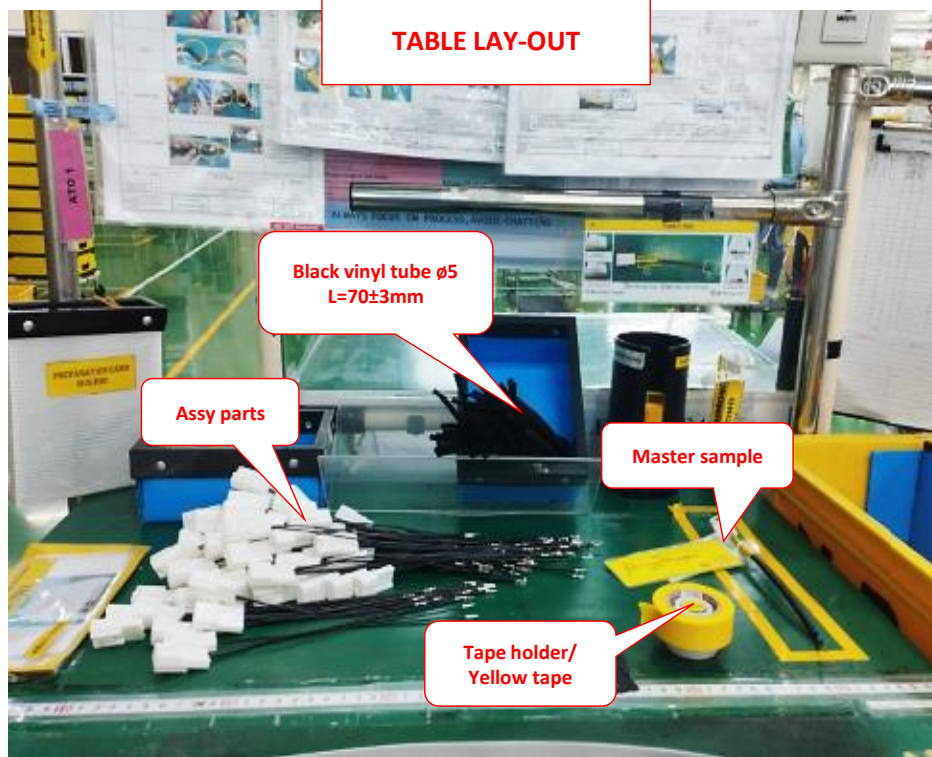
n/a

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

1

n/a

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	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
05/05/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out	M.Ariola	J.Loterte	C. Villanueva	A. Arañes		M. Ariola	J. Loterte	C. Villanueva	A. Arañes
05/02/22	0	Initial issue	M.Ariola	J.Loterte	C. Villanueva	A. Arañes		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

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part Number **715W / 7H0420W7020**

Customer:

**NBS**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 05, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-512

Revision No.:

1

Page No.:

2 of 3

### PARTS:

1. Pre-assy parts from Offline (Connector 6098-3802 (W); IRRAX A 0.3 B wires L=140±2mm )
2. Black Vinyl tube ø5 L=70±3mm
3. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Wire Insertion to  
Black Vinyl tube ø5  
L=70±3mm



1. Get the Vinyl tube **ø5 L= 70±3mm** using right hand then insert the **B-B wires**.

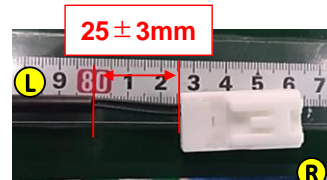
n/a

1. No wrong usage of parts
2. No deformed terminal

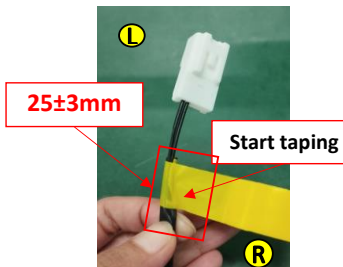
3

n/a

Taping 1  
Black Vinyl tube to Wire  
near connector



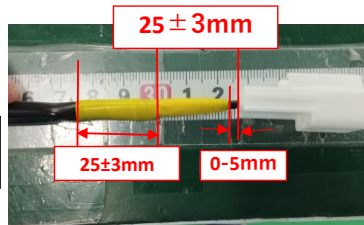
1. Measure from end of Vinyl tube to connector **25±3mm** using both hands.



3. After taping, check the measurement and taping condition

2. Get the **Yellow tape**, hold the Black vinyl tube (**ø5 L=70±3mm**) using left hand then fold the vinyl tube start taping process using both hands.  
**Note: Please refer to WI-PRO-ASY-001 for taping procedure.**

Measuring tape



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. 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

Model code/Part Number **715W / 7H0420W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 05, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-512

Revision No.:

1

Page No.:

3 of 3

PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

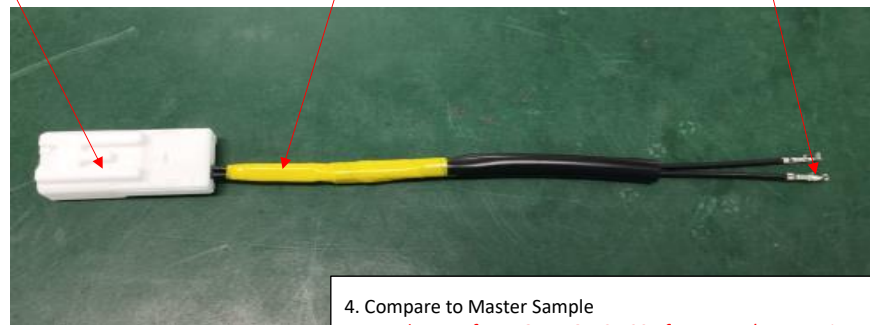
4

Visual/By Two's inspection

1. Check the connector lock.

2. Check the taping condition

3. Check the terminal appearance. Make sure no deformed terminal.



4. Compare to Master Sample

*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-*

MASTER SAMPLE



5

Measurement

MEASURING TAPE



Note:

*Please use calibrated/verified measuring tape when getting the measurement.*



**NOTE: FOR HATSUMONO AND OWARIMONO**

1. 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