

	WORK INSTRUCTION						Effectivity Date:		December 21, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 011B / 7M0364-7021		Customer: TRJ		Document No.: WI-ENG-PDE-420B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.: 1 of 7

PARTS:	1. Assy parts: Clamp 82711-52090 (W); Black sunprene tube ø9 L=120±3mm; Black tape [3pcs.]; Blue tape [1pc.]						JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	QUALITY POINTERS
1	P2	<div style="text-align: center;"> Table Lay-out </div>						<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
12/21/22	1	Improve quality pointers: Reminders/notes, references and by two's inspection. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
02/21/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: February 21, 2022					

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.	<div style="border: 2px solid green; padding: 5px; display: inline-block;"> NBC (Philippines) MASTER COPY </div>	DCC Stamp
--	---	-----------



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 21, 2022

Process Name/Title:

Model Code/Part Number: 011B / 7M0364-7021

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-420B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7

PARTS:

1. Clamp 82711-52090 (W)
2. Black tape

3. Blue tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

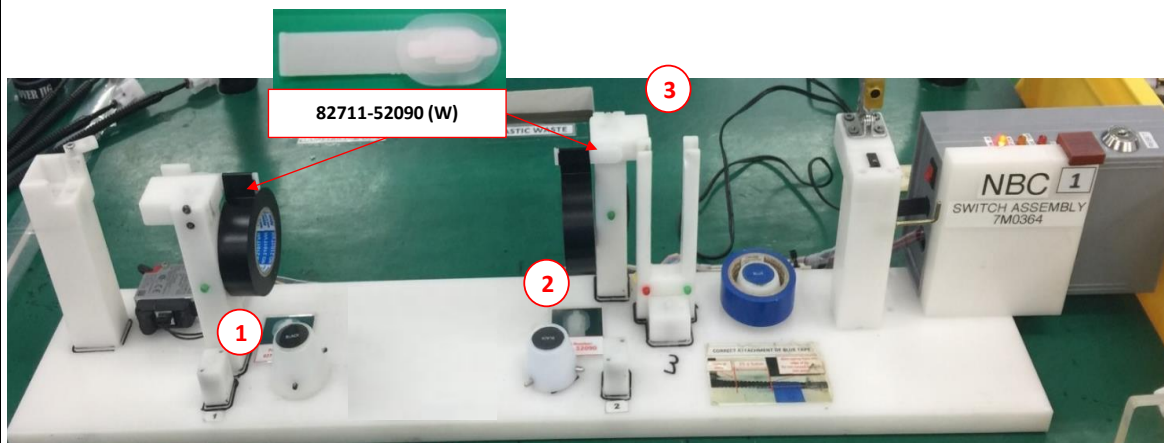
TOOLS/PPE

1 QUALITY POINTERS

2

P2

Clamp Setting



1. Get **2pcs.** of clamp **82711-52090 (W)** using both hands then set to location **1** and **2** using both hands.

2. Initially attach **Black tape** on clamp location **1** and **2** using both hands.

STANDARD TAPING FOR CLAMP

One side tape under clamp



Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

CLAMP ILLUSTRATION



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:

December 21, 2022

Model Code/Part Number:

011B / 7M0364-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-420B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:

1. Black tape
2. Assy parts

3. Black Sunprene tube $\varnothing 9$ L=120 \pm 3mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

3

Wire insertion to
Black Sunprene tube
 $\varnothing 9$ L=120 \pm 3mm



1. Hold the sunprene tube $\varnothing 9$ L=120 \pm 3mm using right hand then insert the G-B/W wires using left hand.

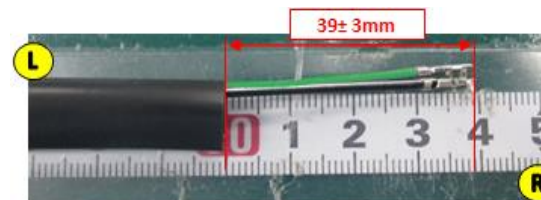
n/a

1. No wrong use of parts
2. No damaged terminal

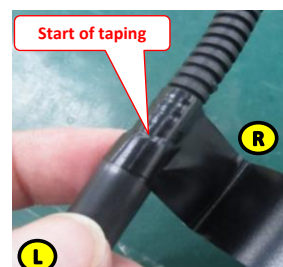
4

P2

Taping 1
Black corrugated tube to
Black sunprene tube



1. Measure from end of sunprene tube up to terminal tip 39 \pm 3mm using both hands.



2. Hold the sunprene tube using left hand and then start taping process using both hands.

MEASURING TAPE



Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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



3. After taping, check measurement and taping condition.

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:

December 21, 2022

Model Code/Part Number:

011B / 7M0364-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-420B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:

1. Assy parts
2. Black tape

3. Blue tape

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

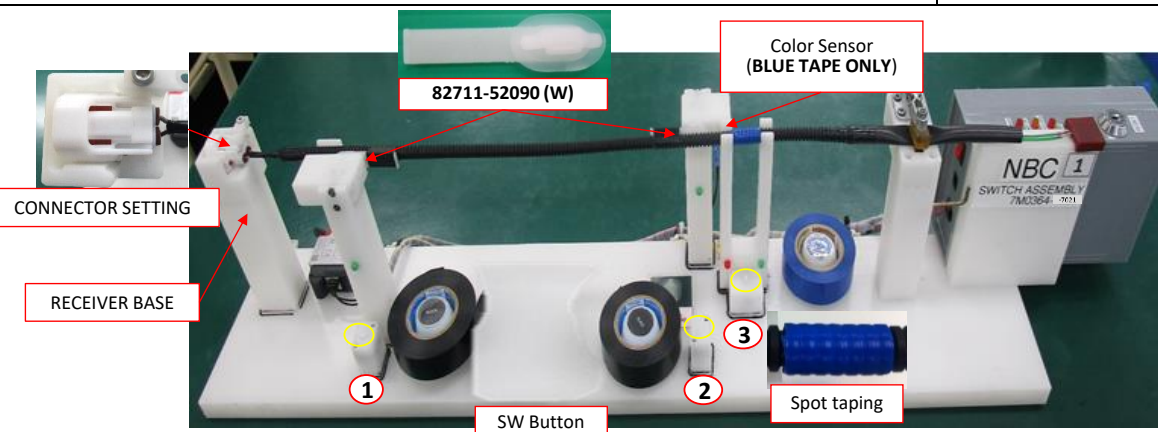
TOOLS/PPE

1 QUALITY POINTERS

5

P2

Clamp Assembly



1. Get the assy parts and set into jig. (See above picture for the correct setting). First, set the connector 6189-0451 (W) to Receiver base 1 and then pull the checker fixture for continuity checking. Last, set the G-B/W wires together within the stopper then press by toggle clamp. Continue the process if sequence light in location 1 was ON.

3. Hold the tape on clamp location 1 and start taping using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 2 was ON.

4. Hold the tape on clamp location 2 and start taping using both hands. Make 3 windings then cut the tape. Press the SW button after taping. Continue the process if sequence light on location 3 was ON.

2. Check if LED light for POWER ON, CLAMP ON was ON. Check also if clamp location 1 sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light of location 1 was ON.

5. Get Blue tape and conduct spot taping on location 3 using both hands. Go sound will be heard if the color sensor detected the Blue tape.

6. Conduct POINT CHECKING before removing of harness from jig.



Important reminders/Note/s:
1. Make sure no gap between stopper and terminals

1. No loose attachment of clamp
2. No damage clamp
3. No missed tape
4. No missing parts
5. 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**

Effectivity Date:

December 21, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

011B / 7M0364-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-420B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1

QUALITY POINTERS

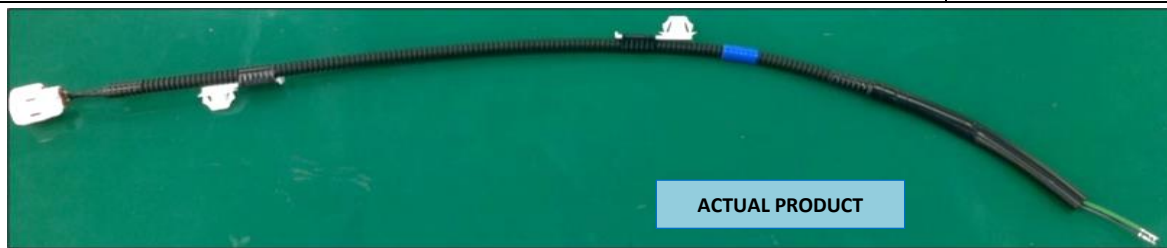
6

P2

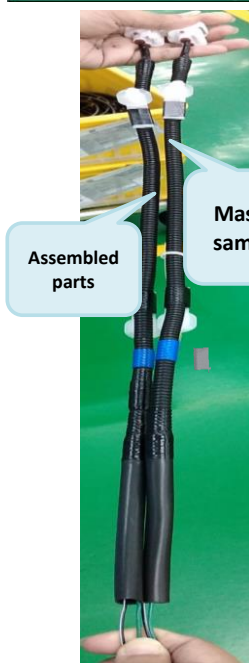
Visual/By Two's Inspection

1


ACTUAL PRODUCT



Assembled parts



Master sample



1. Conduct **alignment of harness (Master sample vs. assembled parts)** using both hands.

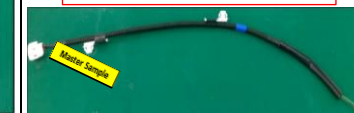
2. Check the **connector lock, terminal, insertion and taping condition.**

3. Check the **presence of all clamp attachment, taping condition and presence of undertape.**

4. Check the presence of **spot tape color** and taping condition.

5. Conduct **bending of COT and tube and taping condition.**

6. Check the **terminal appearance.** Must be **no deformed terminal.**

MASTER SAMPLE

1. No skip checking during inspection

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**

Effectivity Date:

December 21, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

011B / 7M0364-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-420B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

6 of 7

PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

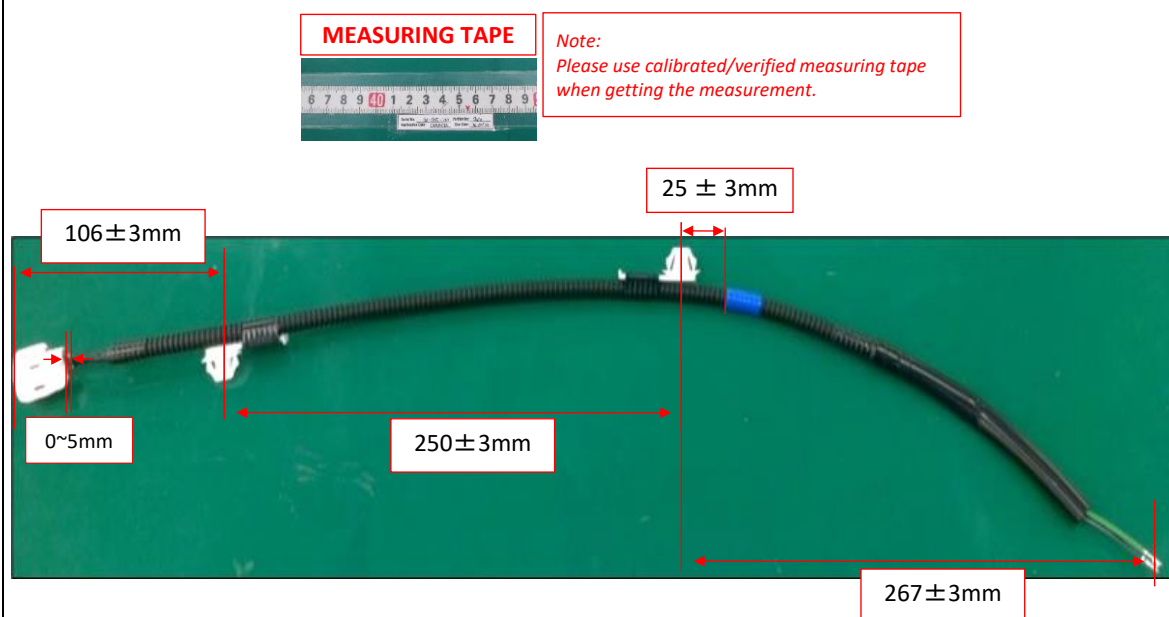
TOOLS/PPE

1 QUALITY POINTERS

7

P2

Measurement

**Important reminders/Note/s:****1. 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



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 21, 2022

Model Code/Part Number:

011B

/

7M0364-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-420B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7

PARTS:

n/a

JIG

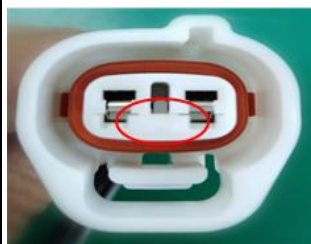
n/a



QUALITY CHECKPOINTS

P2

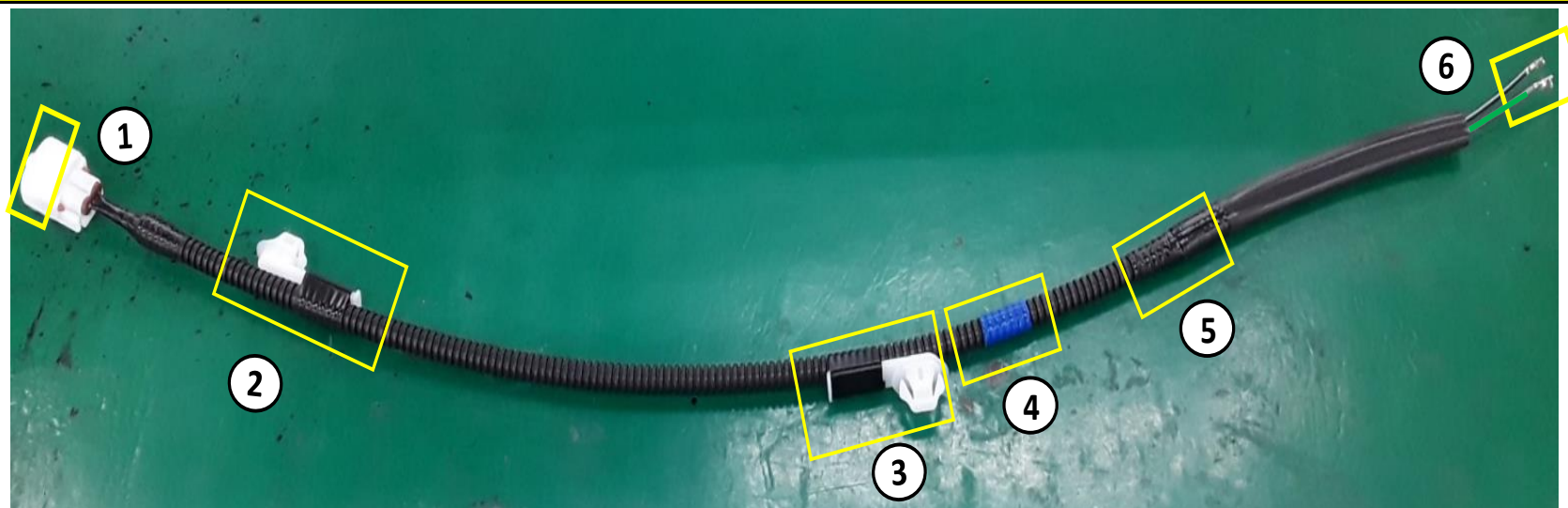
7M0364-7021



GOOD



NO GOOD



① No Unlock/ Half Lock Connector

② ③ No Missing Clamp

④ No Missing Spot Tape(Blue)

⑤ No Missing Tape

⑥ No Deformed Terminal

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