

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 10, 2022

Model Code/Part Number: **101D / 7N0097-7020A**

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-534C

Revision No.:

1

Page No.:

1 of 7

PARTS:

1. Assy parts; Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Clamp 82711-33380 (B); Black tape [6pcs.]; Violet tape

JIG:

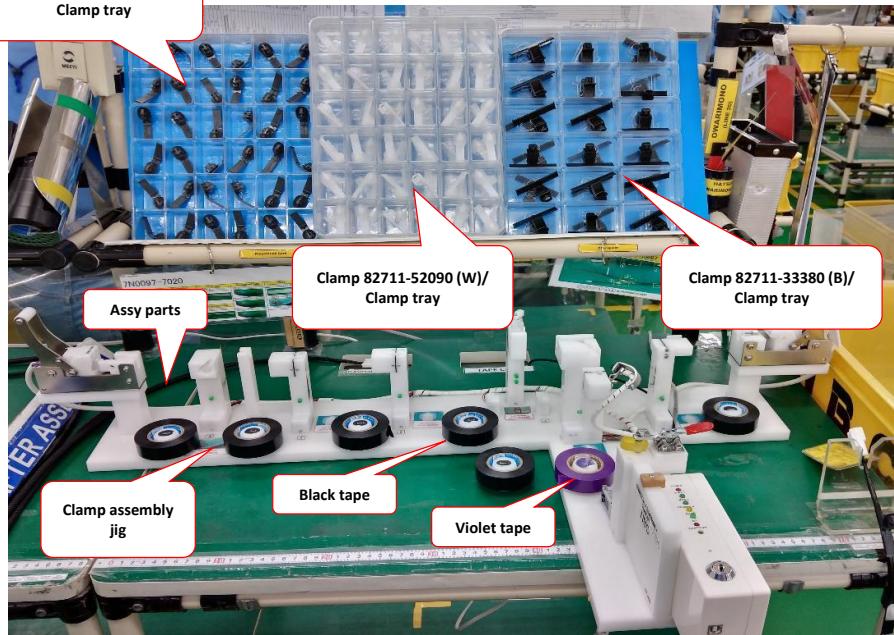
1. Clamp assembly jig

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

1

P3

Table Lay-out

Clamp 82711-48070 (GR)/
Clamp tray**Table Lay-out****Safety Instruction**

Be sure to wear required 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

6/10/2022 1 Change purpose from Pre-launch to Masspro.

K. Doria J. Loterte C. Villanueva A. Arañes

6/2/2022 0 Initial Issue.

K. Doria J. Loterte C. Villanueva A. Arañes

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Prepared by

Reviewed by

Approved by

Noted by

K. Doria

J. Loterte

C. Villanueva

A. Arañes

Est. Date:

June 2, 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.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 10, 2022

Process Name/Title:

Model Code/Part Number: **101D****/ 7N0097-7020A**

Customer:

TRJ

Document No.:

WI-ENG-PDE-534C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7**PARTS:**

1. Clamp 82711-48070 (GR)
2. Clamp 82711-52090 (W) [4pcs.]
3. Clamp 82711-33380 (B)

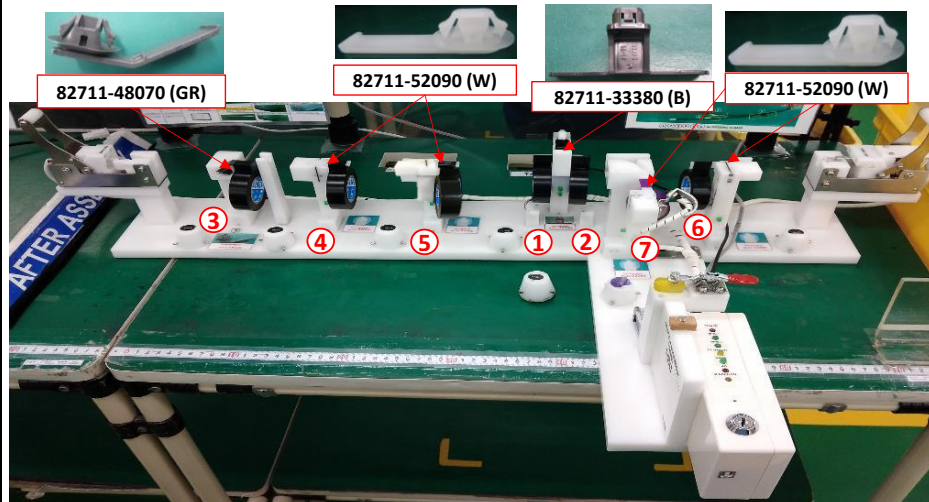
4. Black tape [6pcs.]
5. Violet tape

JIG

1. Clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2****P3**

Clamp setting

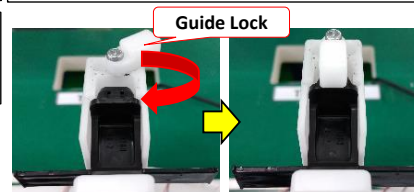


1. Get 1pc. of clamp **82711-48070 (GR)** using right hand then set to clamp location **3** using both hands.

2. Get 4pcs. of clamp **82711-52090 (W)** using both hands then set to clamp location **4, 5, 6 and 7** using both hands.

4. Initially attach **Black tape** on clamp location **1, 2, 3, 4, 5** and **6** using both hands.

3. Get 1pc. of clamp **82711-33380 (B)** using right hand then set to clamp location **1 and 2** using both hands then lock.



5. Initially attach **Violet tape** on clamp location **7** using both hands.

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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

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:

June 10, 2022

Model Code/Part Number: 101D

/ 7N0097-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-534C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

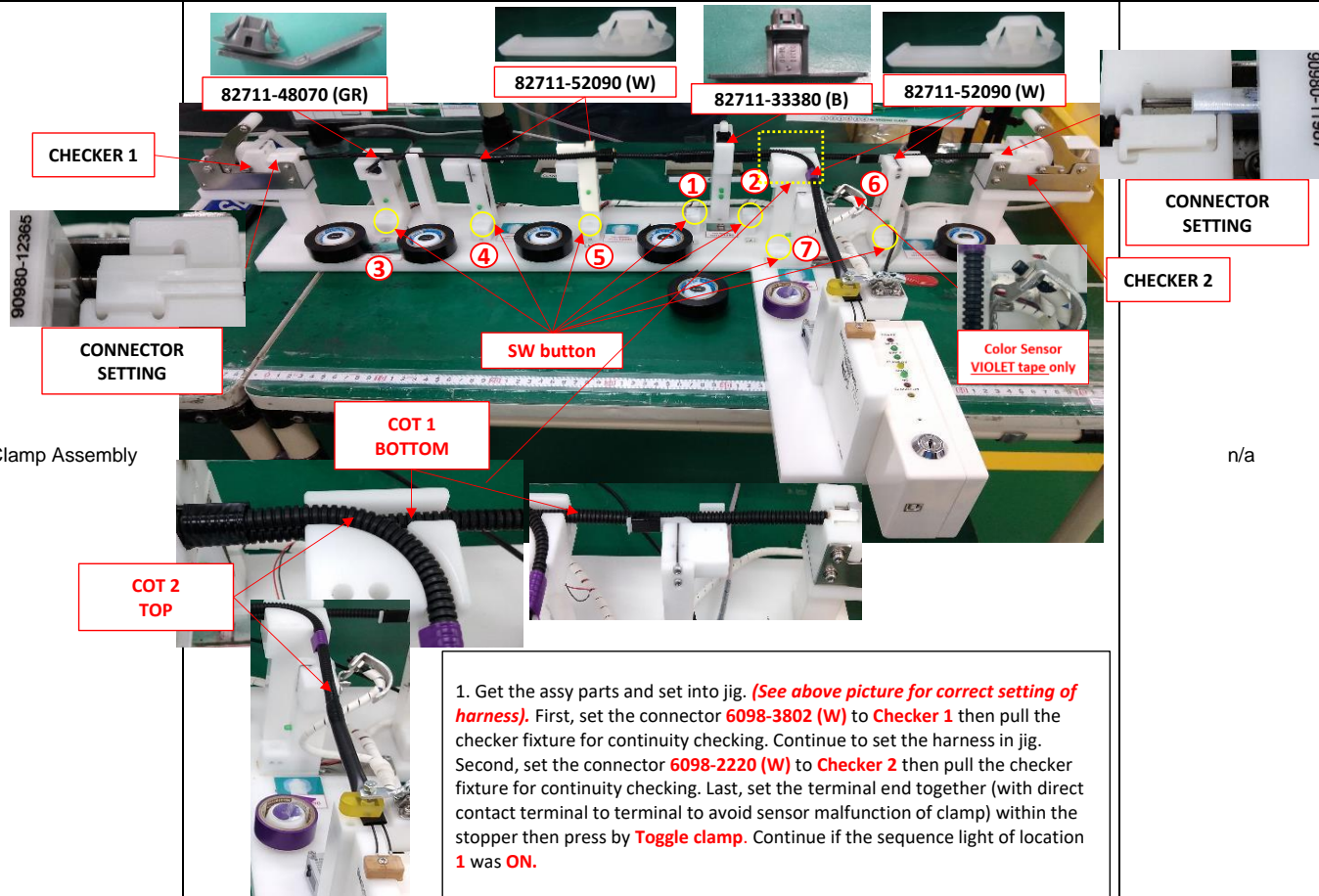
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly



n/a

Note: Make sure no gap between stopper jig and terminals.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-3802 (W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the connector 6098-2220 (W) to Checker 2 then pull the checker fixture for continuity checking. Last, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.

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:

June 10, 2022

Model Code/Part Number: 101D

/ 7N0097-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-534C

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

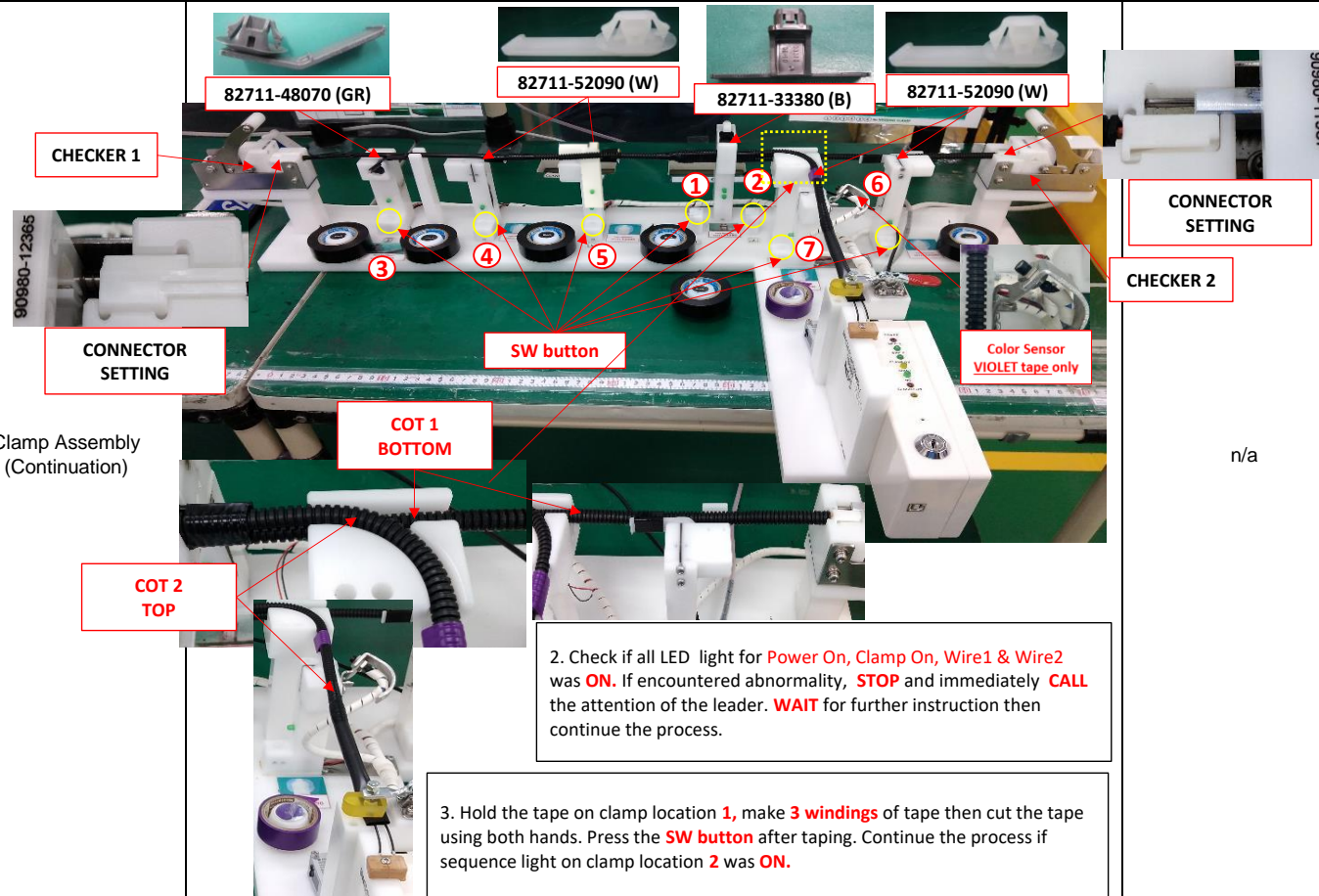
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly
(Continuation)CONNECTOR
SETTING

CHECKER 2

n/a



Note: Make sure no gap between
stopper jig and terminals.

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

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 10, 2022

Process Name/Title:

Model Code/Part Number: 101D

/ 7N0097-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-534C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:

1. Assy parts
2. Black tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

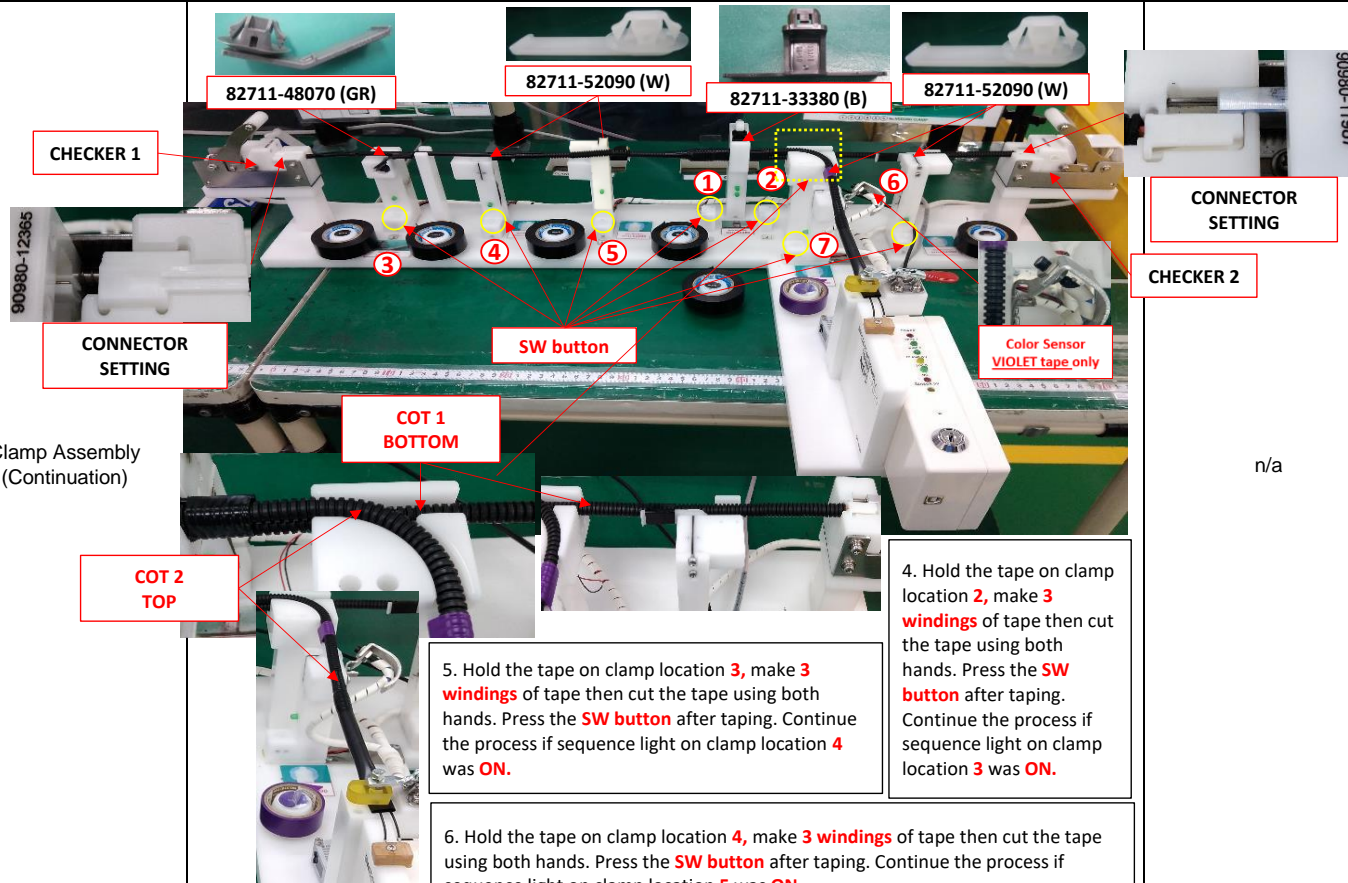
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly
(Continuation)



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**Model Code/Part Number: **101D / 7N0097-7020A**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 10, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-534C

Revision No.:

1

Page No.:

6 of 7

PARTS:

1. Assy parts
2. Black tape
3. Violet tape

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

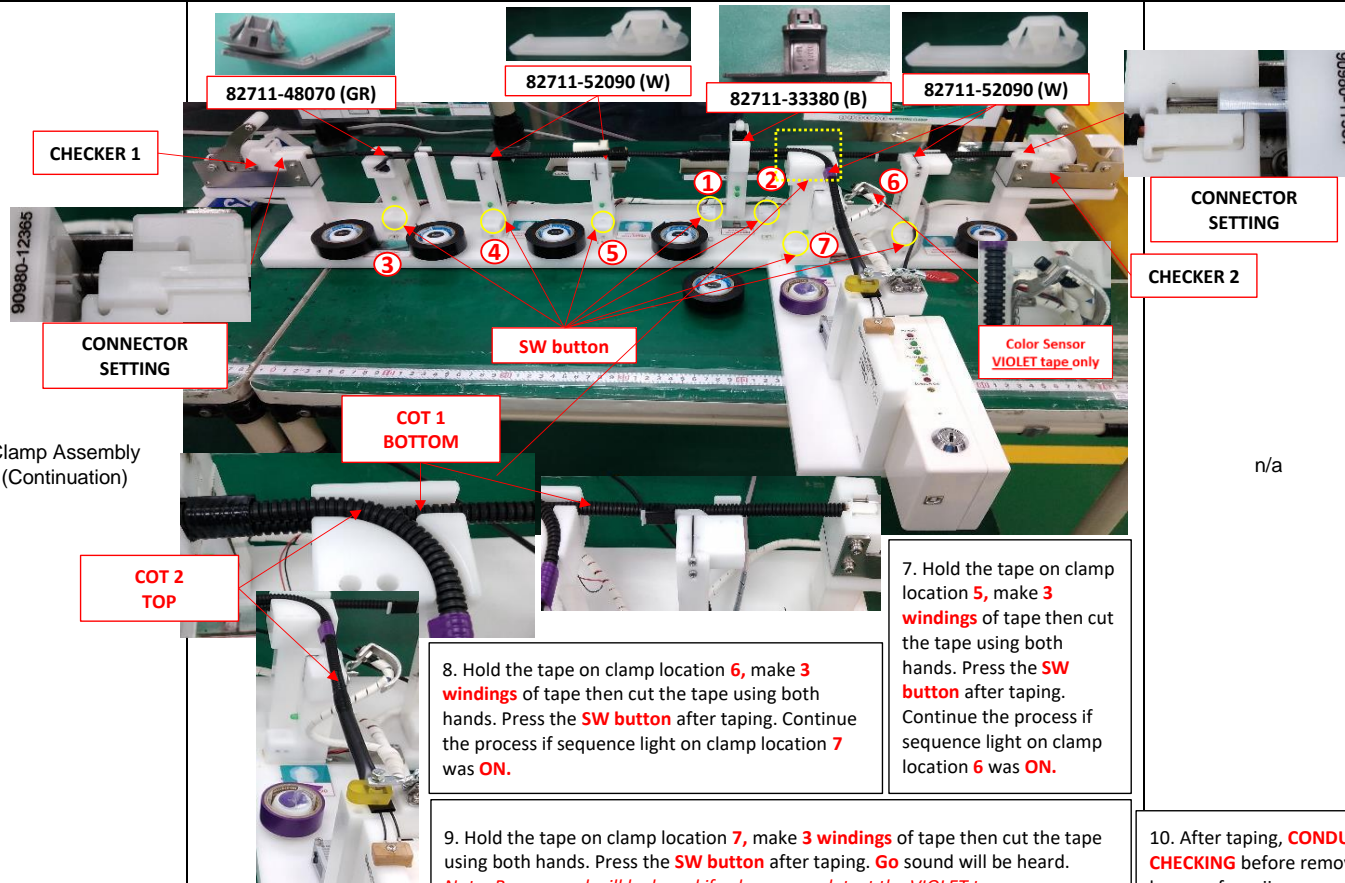
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp Assembly
(Continuation)

n/a



Note: Make sure no gap between stopper jig and terminals.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

7. Hold the tape on clamp location **5**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **6** was **ON**.

8. Hold the tape on clamp location **6**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **7** was **ON**.

9. Hold the tape on clamp location **7**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard. *Note: Beep sound will be heard if color sensor detect the VIOLET tape.*

10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

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:

June 10, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: 101D / 7N0097-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-534C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7

PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

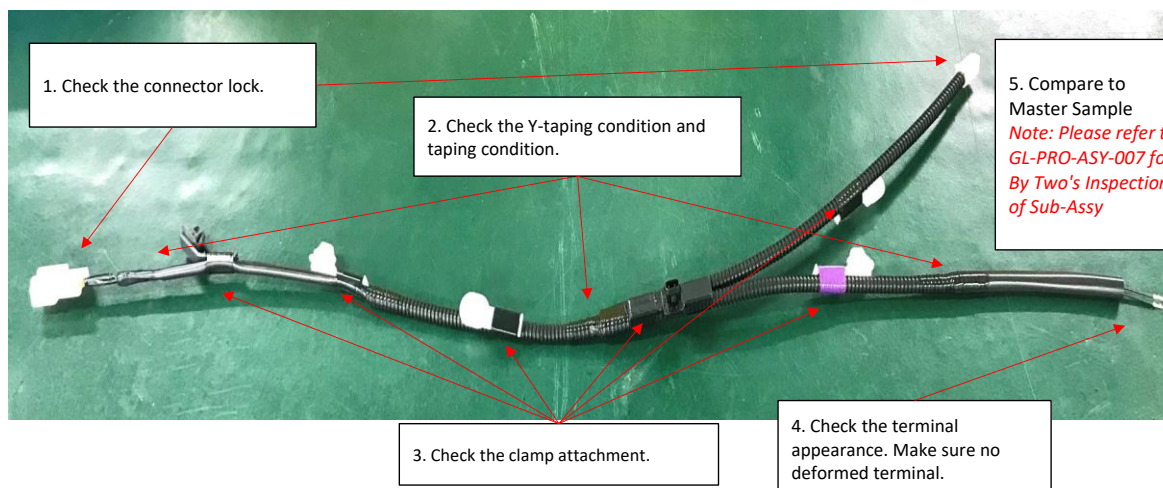
TOOLS/PPE

QUALITY POINTERS

4

Visual/By Two's Inspection

P3

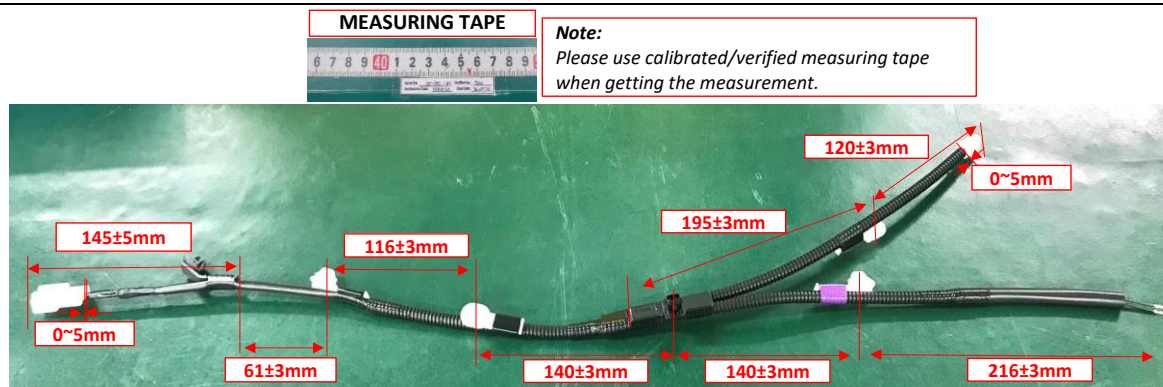


MASTER SAMPLE



5

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