



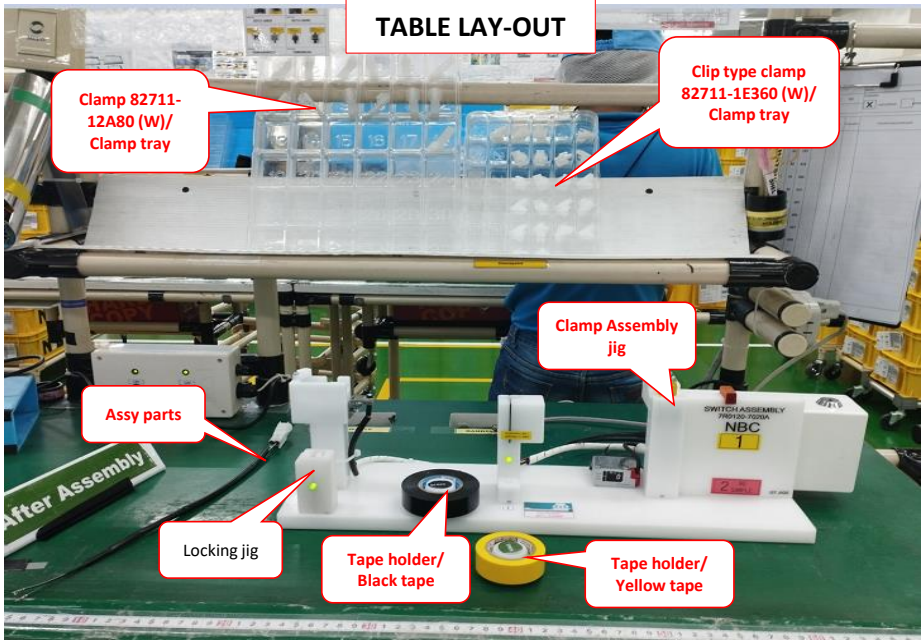
# WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**  
Model Code/Part Number: **920B / 7R0120-7020** Customer: **TRMX**  
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date: **December 03, 2022**  
Validity Date: **n/a**  
Document No.: **WI-ENG-PDE-547B**  
Revision No.: **1** Page No.: **1 of 8**

**PARTS:** 1. Assy parts; Clamp 82711-12A80 (W); Clip type clamp 82711-1E360 (W); Yellow tape; Black tape

**JIG:** 1. Clamp Assembly jig  
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 1 Table Lay-out		<p><b>Safety Instruction</b> Be sure to wear required 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 workplace 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>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <p><b>Important reminders/Note/s:</b> ⚠️ 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p><b>CLIP CLAMP ILLUSTRATION</b> ⚠️ GOOD: 82711-1E360 (W) NG: 82711-12B10 (W)</p> <p><b>CLAMP ILLUSTRATION</b> ⚠️ GOOD: 82711-52090 (W) NG: 82711-12A80 (W)</p>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
12/03/22	1	Change document purpose from Pre-Launch to Masspro. Additional Table lay-out. Improve Quality pointers; Reminders/notes and references on pages no.1 to 7. Improve Work procedure/illustration on process no.7-Visual/ by two's inspection. Integrate connector lock to clamp assembly jig. Inclusion of Quality Checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A.Arañes					
06/16/22	0	Initial issue.	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: **920B / 7R0120-7020**

Customer:

**TRMX**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**December 03, 2022**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-547B**

Revision No.:

**1**

Page No.:

**2 of 8****PARTS:**

1. Clamp 82711-12A80 (W)
2. Black tape

**JIG**

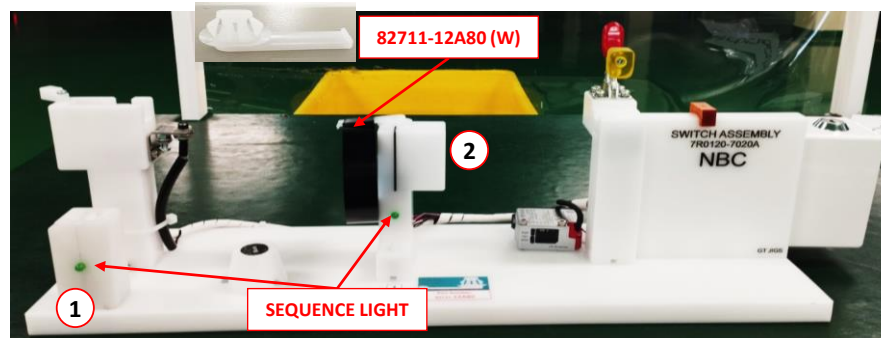
1. Clamp Assembly jig
2. Locking jig

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

2

P2

Clamp setting



1. Get 1pc. of clamp **82711-12A80 (W)** using right hand and set to clamp location **1** using both hands.

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

n/a

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

**Important reminders/Note/s:**

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

**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

## TAPING ASSEMBLY PROCESS

Effectivity Date:

December 03, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number:

920B / 7R0120-7020

Customer:

TRMX

Document No.:

WI-ENG-PDE-547B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 8

## PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

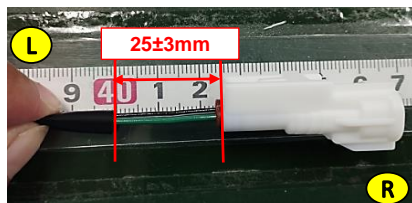
TOOLS/PPE

QUALITY POINTERS

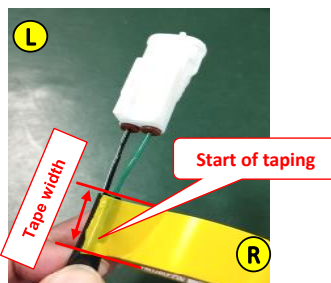
3

P2

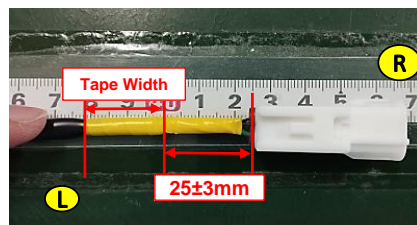
Taping 3  
Black Vinyl tube to Wire  
near connector



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

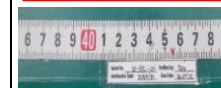


2. Hold the assy parts using left hand. Get **Yellow tape** using right hand and start pre-taping.



3. After taping, check the measurement and taping condition.

## MEASURING TAPE



Important reminders/Note/s:

1. Use **YELLOW TAPE** only.
2. Please use calibrated/verified measuring tape when getting the measurement.

**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:

December 03, 2022

Process Name/Title:

Model Code/Part Number:

920B

/

7R0120-7020

Customer:

TRMX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-547B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 8

### PARTS:

1. Assy part
2. Clip type clamp 82711-1E360 (W)

### JIG

1. Clamp Assembly jig
2. Locking jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

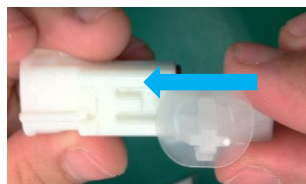
TOOLS/PPE

QUALITY POINTERS

4

Clip type clamp 82711-1E360 (W)

P2



1. Hold the connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. *Note: Sound will be heard if properly inserted.*

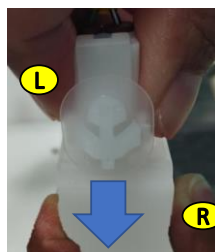
n/a

1. Must be fully inserted.

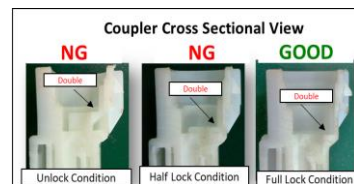
5

1

Connector Lock



1. Put the connector into locking jig using right hand then press 2x to lock.



Before lock

After lock

LOCKING JIG



1

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

**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:	December 03, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-547B		
Revision No.:	1	Page No.:	5 of 8

Process Name/Title:	920B / 7R0120-7020		
Model Code/Product Number:	920B / 7R0120-7020	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. Assy parts 2. Black tape		JIG	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P2 Clamp Assembly	<div><p>1. Put the assy into jig. <i>(See above picture for the correct setting).</i> First, set the connector 6098-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Last, set the Black/White and Green wires together within stopper then press by toggle clamp. Continue the process if sequence light of Location 1 was ON.</p><p>2. Check if all LED light for POWER ON, WIRE 1 and CLAMP ON was ON. if encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p><p>3. Hold the tape on clamp location 1, and start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. GO sound will be heard.</p><p>4. Conduct POINT CHECKING before removing the harness from jig.</p></div>		<p>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</p> <p>1 Important reminders/Note/s:</p> <p>1. Make sure no gap between the terminals and stopper jig</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

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Product Number:

920B / 7R0120-7020

Customer:

TRMX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 03, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-547B

Revision No.:

1

Page No.:

6 of 8

PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P2

Visual/ By two's inspection

ACTUAL PRODUCTS



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



2. Check the **connector lock, terminal, insertion** and Clip type clamp attachment.



4. Check **presence of clamp Attachment and taping condition.**



5. Check **the presence and taping condition of Vinyl to sunprene tube.**



3. Check the **Taping condition and color of tape (Yellow tape only)**



6. Check **presence of Clip type clamp attachment.**

MASTER SAMPLE



1. No skip checking during inspection.

CLIP CLAMP ILLUSTRATION

GOOD



82711-1E360 (W)

NG



82711-12B10 (W)

CLAMP ILLUSTRATION

GOOD



82711-52090 (W)



82711-12A80 (W)

**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:

**December 03, 2022**

Process Name/Title:

Validity Date:

**n/a**

Model Code/Product Number:

**920B / 7R0120-7020**

Customer:

**TRMX**

Document No.:

**WI-ENG-PDE-547B**

Purpose:


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**7 of 8**

<b>PARTS:</b>	n/a			<b>JIG</b>	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
8	P2 Measurement		MEASURING TAPE	<div>1. No wrong dimension.</div> <div><b>Important reminders/Note/s:</b></div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono and Owarimono.</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

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**December 03, 2022**

Model Code/Product Number:

**920B / 7R0120-7020**

Customer:

**TRMX**

Validity Date:

**n/a**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-547B**

Revision No.:

**1**

Page No.:

**8 of 8****PARTS:**

n/a

**JIG**

n/a

**QUALITY POINTERS****P2****7R0120-7020****GOOD****NO GOOD****1 No Unlock/Halflocked Connector****2 No Missing Clip type clamp****4 No Missing Clamp****3 No Missing/Wrong Used of Tape****5 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