



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0122-7020A

Customer:

TRMX

Document No.:

WI-ENG-PDE-559A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 13

PARTS:

1. Assy parts: Connector 7188-0996 (W); AVSSf 0.3 wires Y-OR L=384±2mm; AVSSf 0.3 wires B/W-G L=384±2mm; Black twisted tube Ø5 L=212±4mm; Black tape

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ILLUSTRATION

TOOLS/PPE

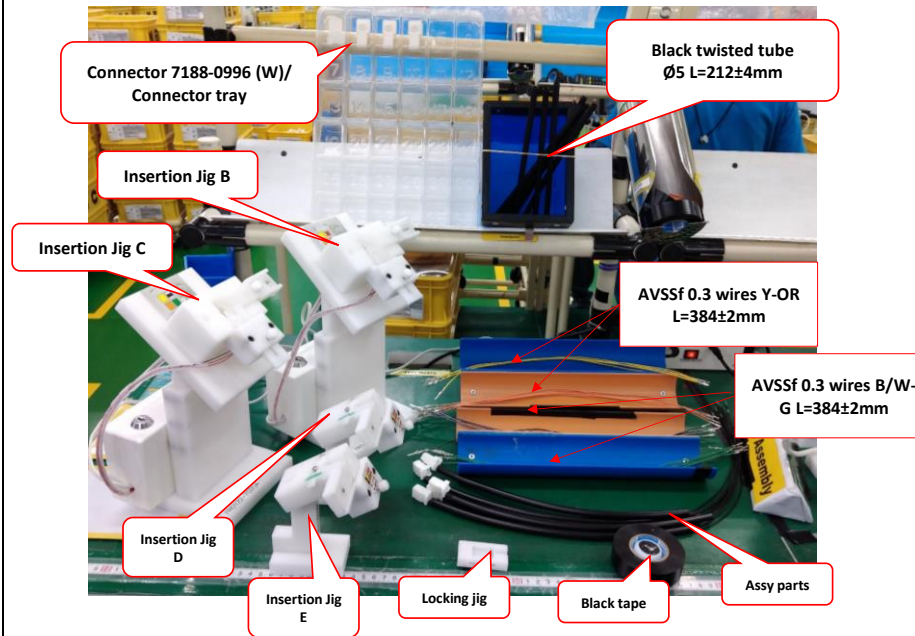
1 QUALITY POINTERS

1

P1

Table Lay-out

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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

12/06/22 1 Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process.

M. Catapang J. Loterte C. Villanueva A. Arañes

07/12/22 0 Initial issue.

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

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

July 12, 2022

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TAPING ASSEMBLY PROCESS

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Revision No.:	1	Page No.:	2 of 13

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **920B / 7R0122-7020A** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 7188-0996 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>1</div> P1 Connector setting to insertion jig 7188-0996 (W)	<div>Insertion jig</div> <div>Visual reference</div> <div>Slider lock</div> <div>Button</div> <div>Guide</div> <div>7R0122-7020A</div> <div>Insertion jig (Back view)</div> <div>Reset</div> <div>Adjustable</div> <div>Slide</div> <div>Slide the slide lock using right thumb.</div> <div>Connector Orientation</div> <div>2. Insert the connector 7188-0996 (W) into jig using left hand and release the side lock.</div> <div>Release</div> <div>3. Push the guide using left hand. The slot for Yellow wire will be opened.</div> <div>Hole</div>		n/a	<div>Important reminders/Note/s:</div> <div>1. Cannot insert the inverted connector.</div> <div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div>

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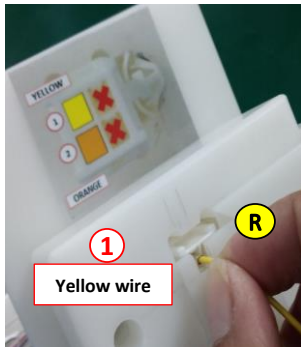
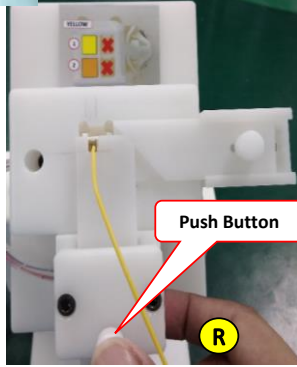
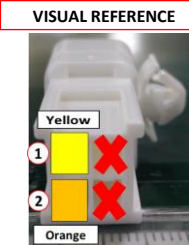
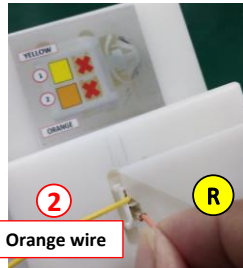
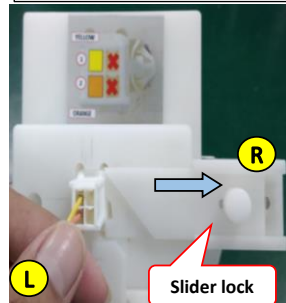
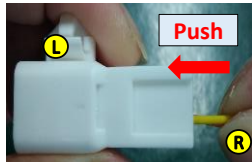
WI-ENG-PDE-559A

Revision No.:

1

Page No.:

3 of 13

PARTS:		1. AVSSf 0.3 wires Y-OR L=384±2mm		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P1 Wire insertion to connector 7188-0996 (W)	<div><div><p>Wire facing</p></div><div><p>1 Yellow wire</p></div><div><p>Push Button</p></div><div><p>2 Orange wire</p></div><div><p>2 Orange wire</p></div><div><p>Slider lock</p></div><div><p>Push</p></div><div><p>1. Get the Yellow wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion.</p><p>2. Press the button using left hand. The slot for Orange wire will be opened.</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. GO sound will be heard.</p><p>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</p><p>5. After removing the connector from jig, conduct Pushing (1x) of Y wire using right hand to confirm that wire is fully inserted. Repeat the process for OR wire.</p></div></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</p> <p>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</p> <p>5. Conduct Pushing of wires after removing the connector from jig.</p> <p>6. Pushing of wires will be done one by one of every inserted wires</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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TAPING ASSEMBLY PROCESS

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Revision No.:	1	Page No.:	4 of 13

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 7189-0995 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
4	P1 <div>1</div> Connector setting to insertion jig 7188-0996 (W)	<div><div>Insertion jig</div><div>Visual reference</div><div>Slider lock</div><div>Button</div><div>Guide</div><div>7R0122-7020A</div></div> <div><div>Insertion jig (Back view)</div><div>Reset</div><div>Adjustable</div></div> <div><div>Slide</div><div>L</div><div>R</div><div>L</div><div>R</div></div> <div><div>1. Slide the slide lock using right thumb.</div></div> <div><div>Connector Orientation</div></div> <div><div>L</div><div>R</div><div>L</div><div>R</div><div>Release</div></div> <div><div>2. Insert the connector 7188-0996 (W) into jig using left hand and release the side lock.</div></div> <div><div>Hole</div><div>L</div><div>R</div></div> <div><div>3. Push the guide using left hand. The slot for B/W wire will be opened.</div></div>		n/a	<div>Important reminders/Note/s:</div> <div>1. Cannot insert the inverted connector.</div> <div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div>

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Customer:

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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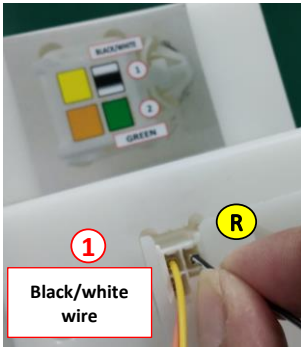
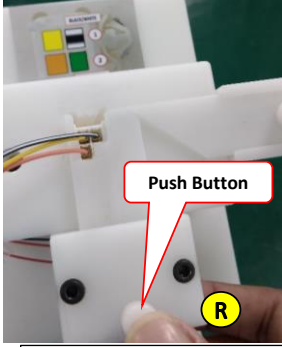
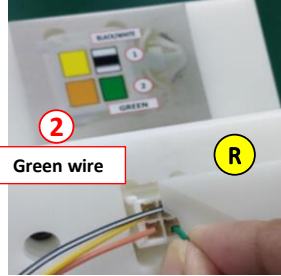
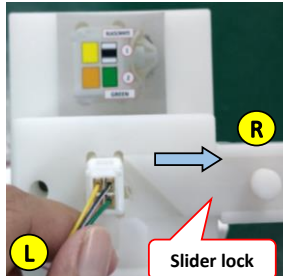
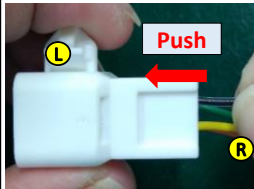
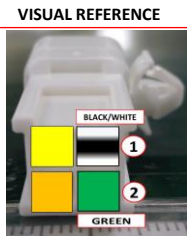
WI-ENG-PDE-559A

Revision No.:

1

Page No.:

5 of 13

PARTS:		1. AVSSf 0.3 wires B/W-G L=384±2mm		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	P1 Wire insertion to connector 7188-0996 (W)	<div><p>Wire facing</p></div> <div><p>1 Black/white wire</p><p>1. Get the Black/white wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion.</p></div> <div><p>Push Button</p><p>2. Press the button using left hand. The slot for Green wire will be opened.</p></div> <div><p>2 Green wire</p><p>3. Get the Green wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. GO sound will be heard.</p></div> <div><p>Slider lock</p><p>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</p></div> <div><p>Push</p><p>5. After removing the connector from jig, conduct Pushing (1x) of B/W wire using right hand to confirm that wire is fully inserted. Repeat the process for G wire.</p></div> <div><p>VISUAL REFERENCE</p><p>BLACK/WHITE 1 GREEN 2</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</p> <p>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</p> <p>5. Conduct Pushing of wires after removing the connector from jig.</p> <p>6. Pushing of wires will be done one by one of every inserted wires</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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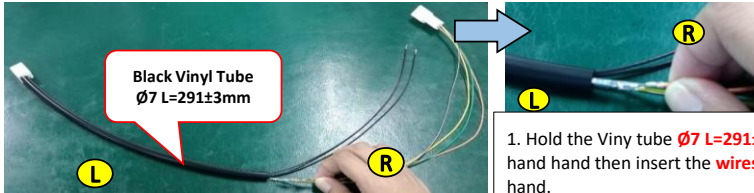
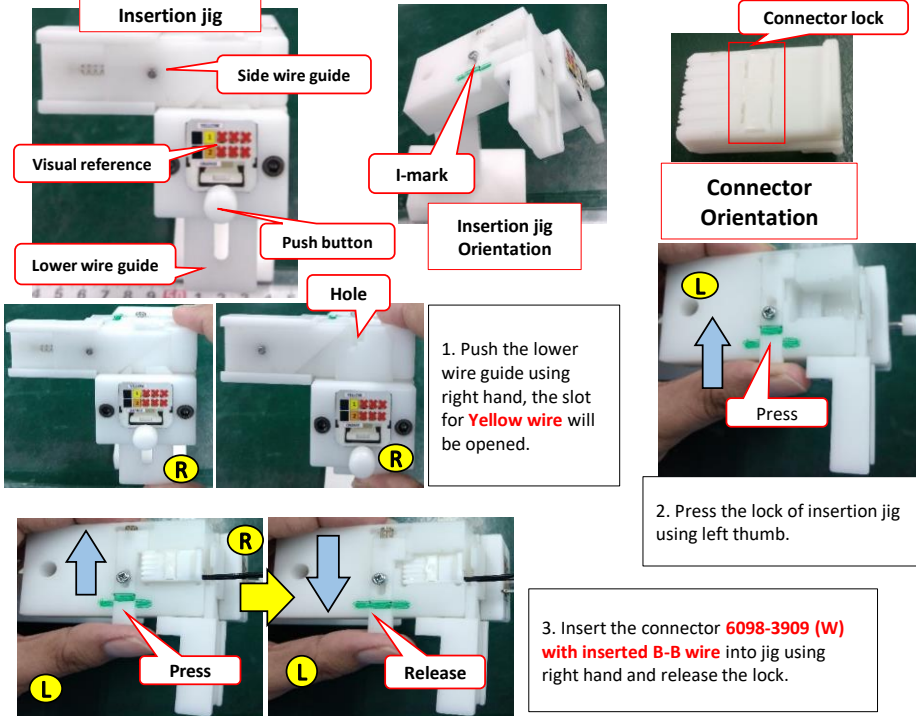
WI-ENG-PDE-559A

Revision No.:

1

Page No.:

6 of 13

PARTS:		1. Assy parts 2. Connector 6098-3909 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
6	Wire insertion to assy parts	<div><p>Black Vinyl Tube Ø7 L=291±3mm</p><p>1. Hold the Viny tube Ø7 L=291±3mm using left hand hand then insert the wires using right hand.</p></div>		n/a	1. No wrong use of parts 2. No deformed terminal
7	P1 Connector setting to insertion jig 6098-3909 (W)	<div><div><p>Insertion jig</p><p>Side wire guide</p><p>Visual reference</p><p>Lower wire guide</p><p>Push button</p><p>Hole</p><p>I-mark</p><p>Insertion jig Orientation</p><p>Connector lock</p><p>Connector Orientation</p><p>Press</p><p>Release</p><p>1. Push the lower wire guide using right hand, the slot for Yellow wire will be opened.</p><p>2. Press the lock of insertion jig using left thumb.</p><p>3. Insert the connector 6098-3909 (W) with inserted B-B wire into jig using right hand and release the lock.</p></div></div>		n/a	Important reminders/Note/s: 1. Follow the connector orientation 2. Cannot insert the inverted connector. 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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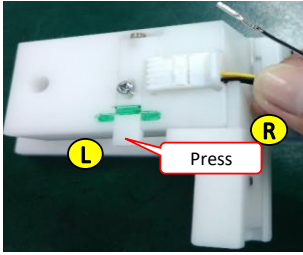
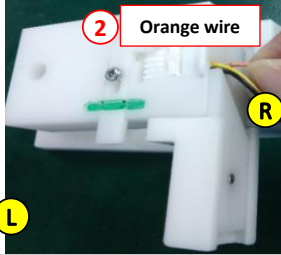
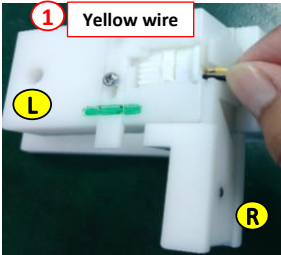
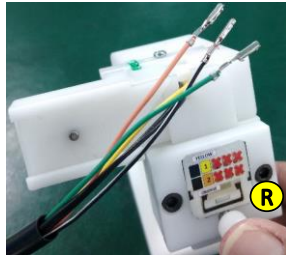

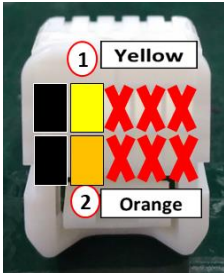
WI-ENG-PDE-559A

Revision No.:

1

Page No.:

7 of 13

PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
8	P1 Wire insertion to Connector 6098-3909 (W)	<div><p>VISUAL REFERENCE</p></div> <p>1. Get the Yellow wire using right hand then insert to terminal slot 1 using right hand.</p> <p>2. Press the button using left hand, the slot for Orange wire will be opened.</p> <p>1. Get the Orange wire using right hand then insert to terminal slot 2 using right hand.</p> <p>4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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WI-ENG-PDE-559A

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1

Page No.:

8 of 13

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

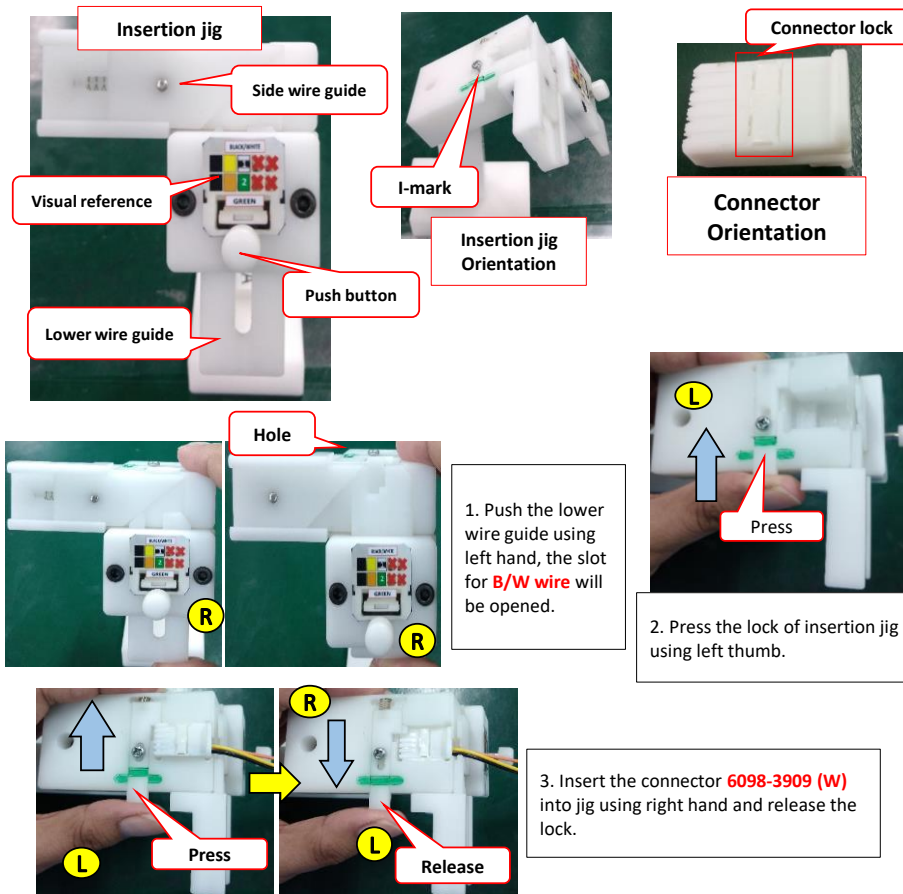
TOOLS/PPE

1 QUALITY POINTERS

9

P1

Connector setting to
insertion jig
6098-3909 (W)



n/a

Important reminders/Note/s:

1. Follow the connector orientation
2. Cannot insert the inverted connector.

1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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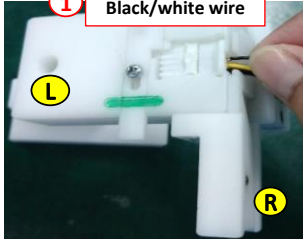
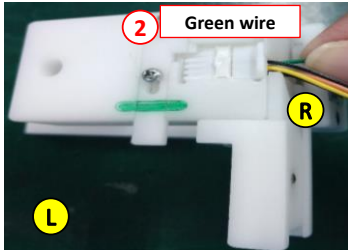
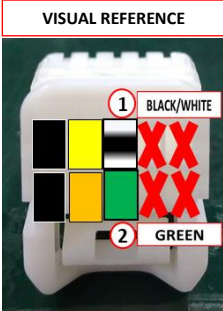

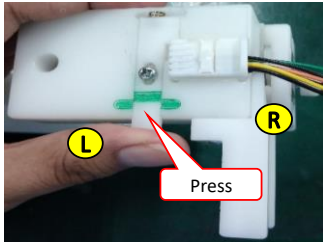
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Revision No.:

1

Page No.:

9 of 13

PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
10	P1 Wire insertion to Connector 6098-3909 (W)	<div><div>1 Black/white wire</div><div>1. Get the Black/white wire using right hand then insert to terminal slot 1 using right hand.</div></div> <div><div>2 Green wire</div><div>1. Get the Green wire using right hand then insert to terminal slot 2 using right hand.</div></div> <div><div>VISUAL REFERENCE</div><div>1 BLACK/WHITE 2 GREEN</div></div> <div><div>Wire facing</div><div>2. Press the button using left hand, the slot for Green wire will be opened.</div></div> <div><div>Press</div><div>4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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☐ PRE-LAUNCH

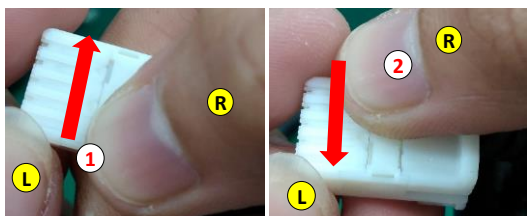




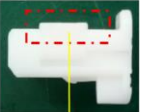
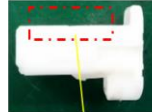
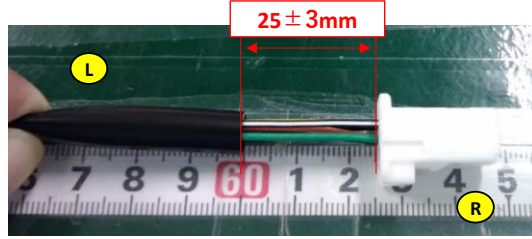
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Revision No.:

1

Page No.:

10 of 13

PARTS:		1. Assy parts 2. Black tape		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	Connector Lock	<div></div> <div>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked. Note: WI-PRO-KIT-001 Proper locking and checking of connector lock</div> <div></div> <div>Before PressingAfter Pressing</div>		<div></div> <div>LOCKING JIG</div>	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <div><div>CONNECTOR LOCK CONDITION</div><div></div><div>Fully LockedUnLocked</div></div>
12	Taping 1 Black Vinyl tube to wire near connector	<div></div> <div>1. Measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</div>		n/a	<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>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2022

Process Name/Title:

Model Code/Part Number: 920B / 7R0122-7020A

Customer: TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-559A

Revision No.:

1

Page No.:

11 of 13

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

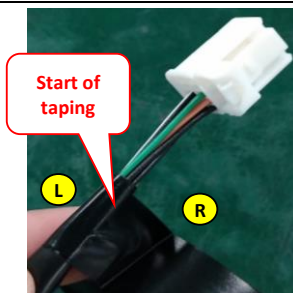
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

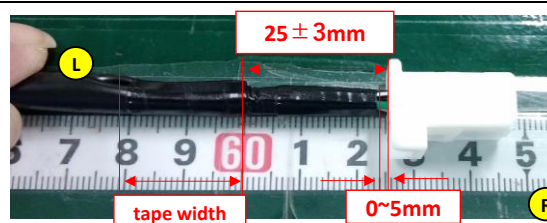
1 QUALITY POINTERS

12

Taping 1
Black Vinyl tube to wire
near connector



2. Get the **Black tape** using right hand then start taping process using both hands.



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

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

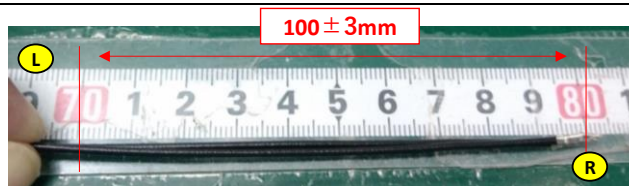
Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

1

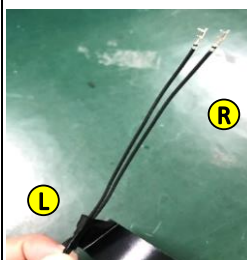
13

P1

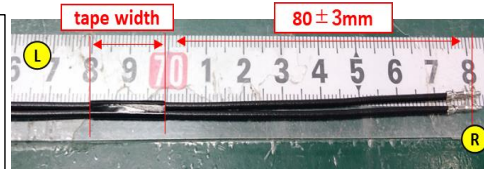
Spot taping 1



1. Hold the wires using left hand and measure from wire up to terminal pointed tip **100±3mm**.



2. Get the **Black tape** and start taping on the Black wires. Conduct **2 windings** of tape before cutting using both hands.



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

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

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

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2022

Process Name/Title:

Model Code/Part Number: **920B / 7R0122-7020A**

Customer: **TRMX**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-559A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


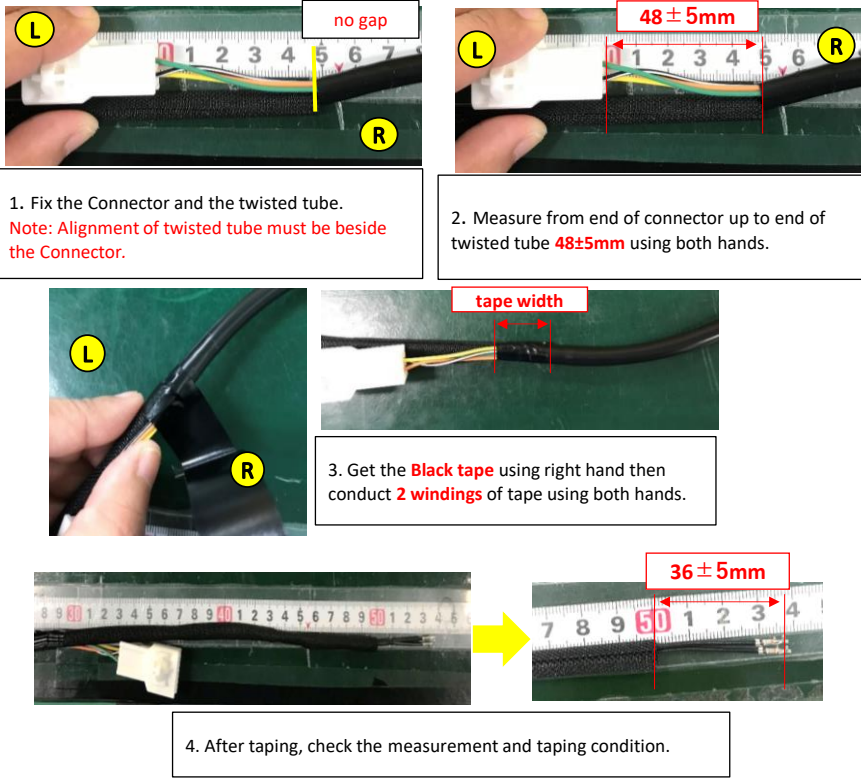

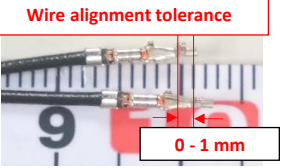
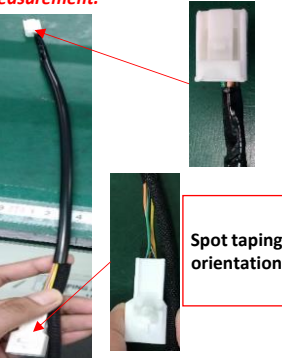
☒ MASSPRO

Revision No.:

1

Page No.:

12 of 13

PARTS:		1. Assy parts 2. Black tape	3. Black twisted tube Ø5 L=212±4mm	JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
14	Wire insertion to Black twisted tube Ø5 L=212±4mm	 <p>1. Get the Viny tube Ø5 L=212±4mm using right hand then insert the B-B wire using left hand.</p>		n/a	1. No wrong use of parts 2. No deformed terminal
15	P1 1 Spot taping 2	 <p>1. Fix the Connector and the twisted tube. Note: Alignment of twisted tube must be beside the Connector.</p> <p>2. Measure from end of connector up to end of twisted tube 48±5mm using both hands.</p> <p>3. Get the Black tape using right hand then conduct 2 windings of tape using both hands.</p> <p>4. After taping, check the measurement and taping condition.</p>		 <p>MEASURING TAPE</p>	 <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>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> 

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number: **920B / 7R0122-7020A**

Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 06, 2022

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n/a

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WI-ENG-PDE-559A

Revision No.:

1

Page No.:

13 of 13

PARTS:

1. Assy parts

JIG

n/a

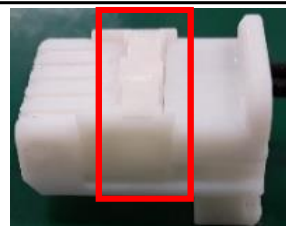
1 QUALITY CHECKPOINTS

P1

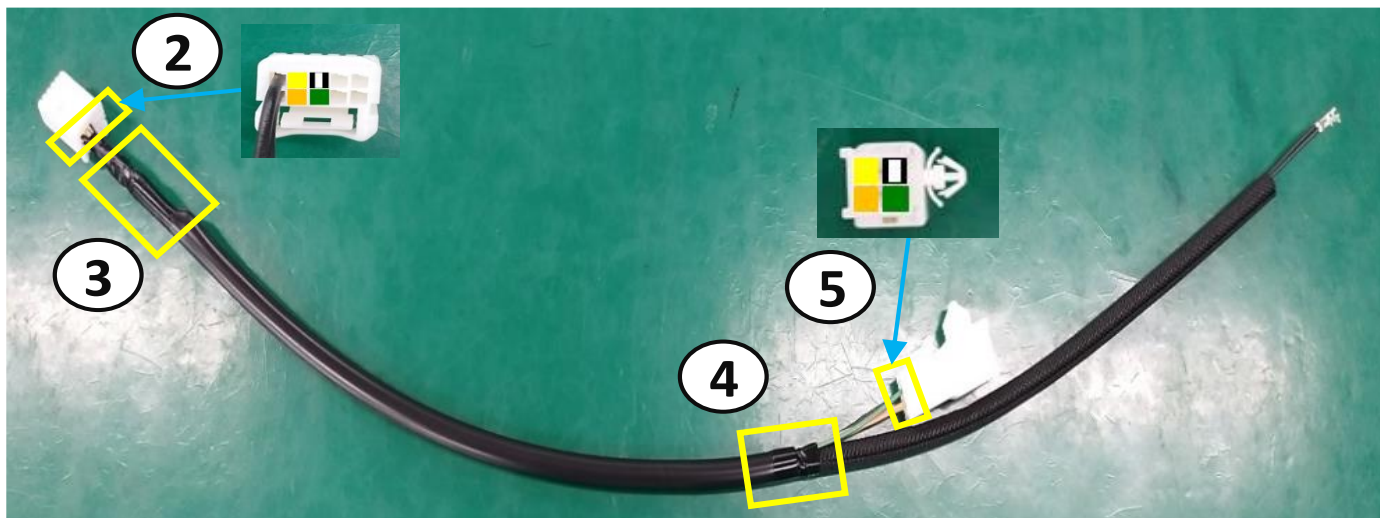
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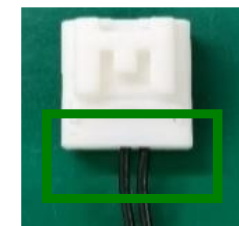
GOOD



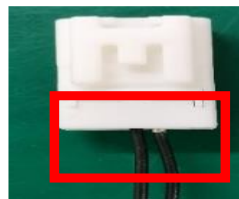
NO GOOD



6



GOOD



NO GOOD

① No Unlock/Halflocked Connector

② ⑤ No Wrong Insert

③ ④ No Missing tape

⑥ No Terminal Backing Out

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