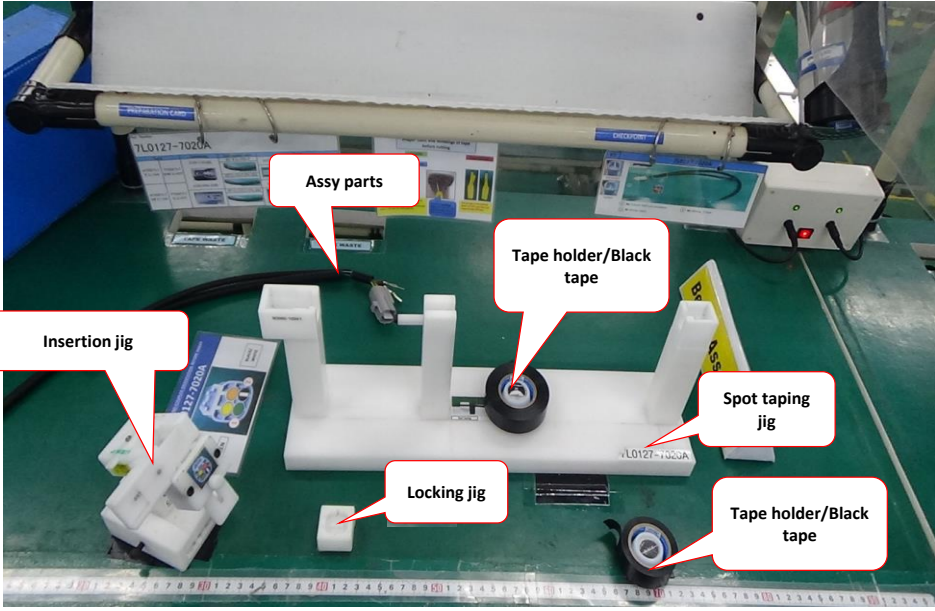
	WORK INSTRUCTION		Effectivity Date:	May 10, 2023	
	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Process Name/Title:		Document No.:	WI-ENG-PDE-351B	
	Model Code/Part Number: 177D / 7L0127-7020A	Customer: TRQSS	Revision No.:	4	Page No.:
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					

PARTS:		1. Assy parts 2. Black tape [2pcs]		JIG:	1. Insertion jig 2. Locking jig 3. Spot taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<p style="text-align: center;">Table Lay-out</p> 		<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level 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>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
05/10/23	4	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	
08/31/22	3	Remove Process no.2 and transfer to P1 due to process improvement. Improve work procedure/Illustration, quality pointers and notes. Change table lay-out	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
01/19/22	2	Revise due to inclusion of spot taping jig tools and spot taping process.	K. Doria	J. Loterte	C. Villanueva	A. Arañes	
01/17/22	1	Change from Pre-launch to Masspro. Additional Table Lay-out; Change part number from 7L0127-7020 to 7L0127-7020A due to change in COT length from $\phi 7 L=537\pm 2\text{mm}$ to $\phi 7 L=532\pm 2\text{mm}$ due to removal of tolerance from COT to MR SW.	K. Doria	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
							October 13, 2021

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

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROPCESS

Effectivity Date:

May 10, 2023

Model Code/Part Number:

177D / 7L0127-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-351B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

3 of 8

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

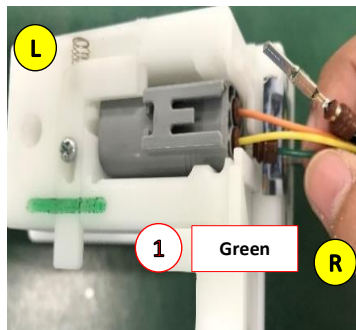
TOOLS/PPE

QUALITY POINTERS

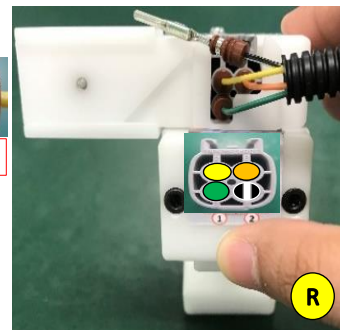
3

P2

Wire insertion to connector
6188-0066 (GR)
(Assy parts)

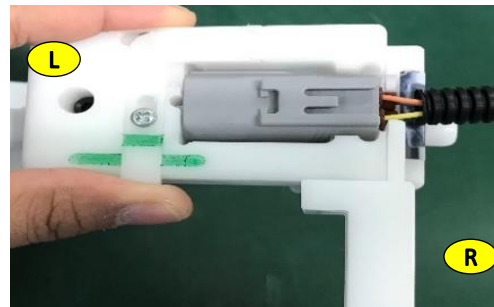
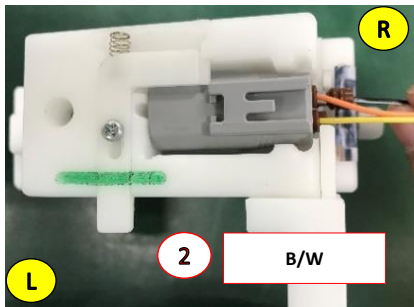


WIRE FACING



1 Hold the **G wire** then insert to terminal slot **1** using right hand.

2. Press the button using right thumb. The slot for **B/W wire** will be opened.



3. Hold the **B/W wire** then insert to terminal slot **2** using right hand.

4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Important reminders/Note/s:

1. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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 PROPCESS

Effectivity Date:

May 10, 2023

Model Code/Part Number:

177D / 7L0127-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-351B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

4 of 8

PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

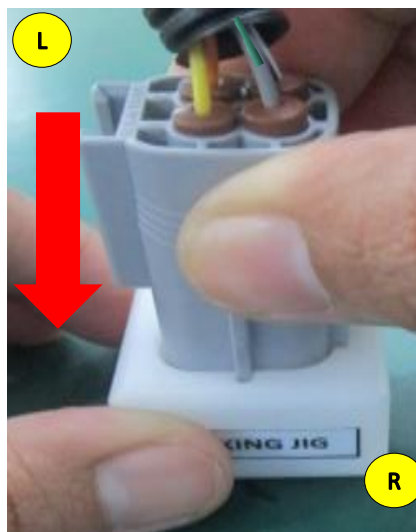
TOOLS/PPE

QUALITY POINTERS

4

P2

Connector Lock



1. Put the connector into locking jig using both hands and then conduct **2x** pressing. Check the connector if properly locked.



Before pressing



After pressing

LOCKING JIG



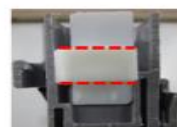
1. Use the provided locking jig per model
2. No unlock/half-locked connector
3. No damaged lock

Important reminders/Note/s:

1. manual locking may cause damaged connector lock.

Coupler Cross Sectional View

NG



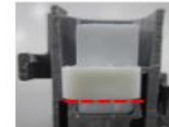
Unlock

NG



Half Lock Condition

GOOD



Full Lock 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 PROPCESS

Effectivity Date:

May 10, 2023

Validity Date:

n/a

Model Code/Part Number:

177D / 7L0127-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-351B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

5 of 8

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

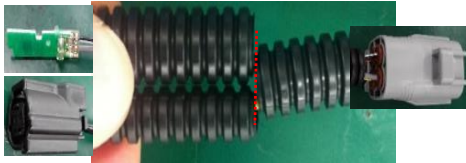
QUALITY POINTERS

5

P2

Y-taping

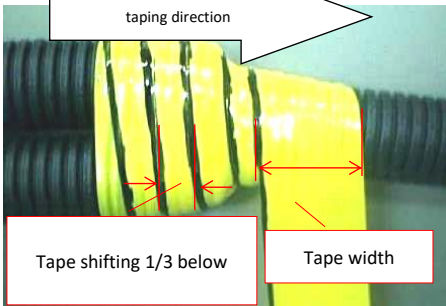
NO GAP BETWEEN CORRUGATED TUBES



1. Fix the corrugated tube .

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)

taping direction



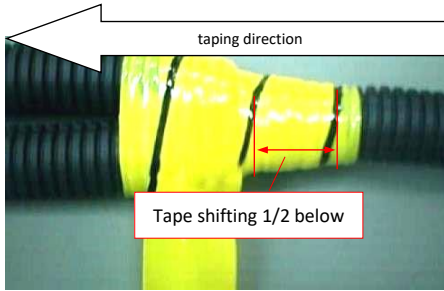
Tape shifting 1/3 below

Tape width

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

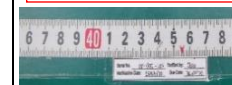
4. Wind the tape backward 1/2 shifting

Tape width



Tape shifting 1/2 below

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. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be black tape.

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

3. Do not exert excessive force during pulling & winding of tape

4. Must be no gap between Corrugated tubes

Y-TAPING ORIENTATION



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 PROPCESS

Effectivity Date:

May 10, 2023

Validity Date:

n/a

Model Code/Part Number:

177D / 7L0127-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-351B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

6 of 8

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

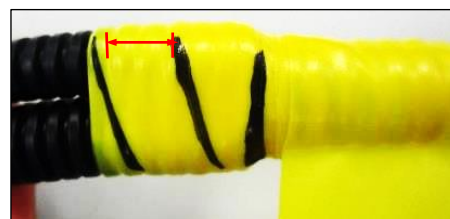
TOOLS/PPE

QUALITY POINTERS

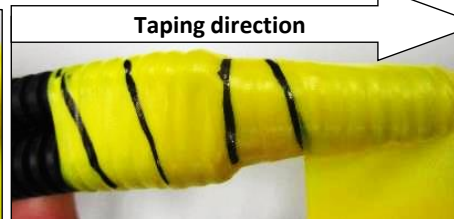
5

P2

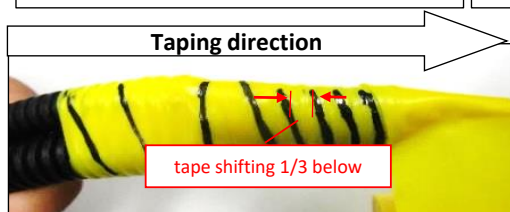
Y-taping
(continuation)



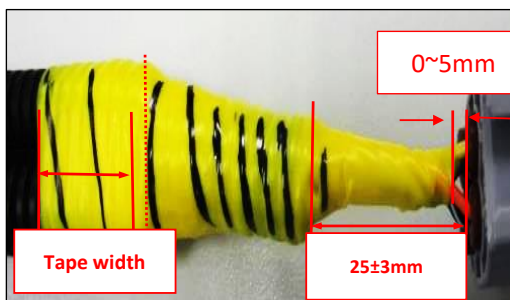
5. Wind the tape $\frac{1}{2}$ shifting going to other side of corrugated tube.



6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.



7. Wind the tape $\frac{1}{3}$ shifting until it reach the wire , make 3 winds to wires then cut.



8. 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. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be black tape.
2. Please use calibrated/ verified measuring tape when getting the measurement.
3. 0-5mm end or tape up to connector (Includes rubber seal).

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 PROPCESS

Effectivity Date:

May 10, 2023

Validity Date:

n/a

Model Code/Part Number:

177D / 7L0127-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-351B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

7 of 8

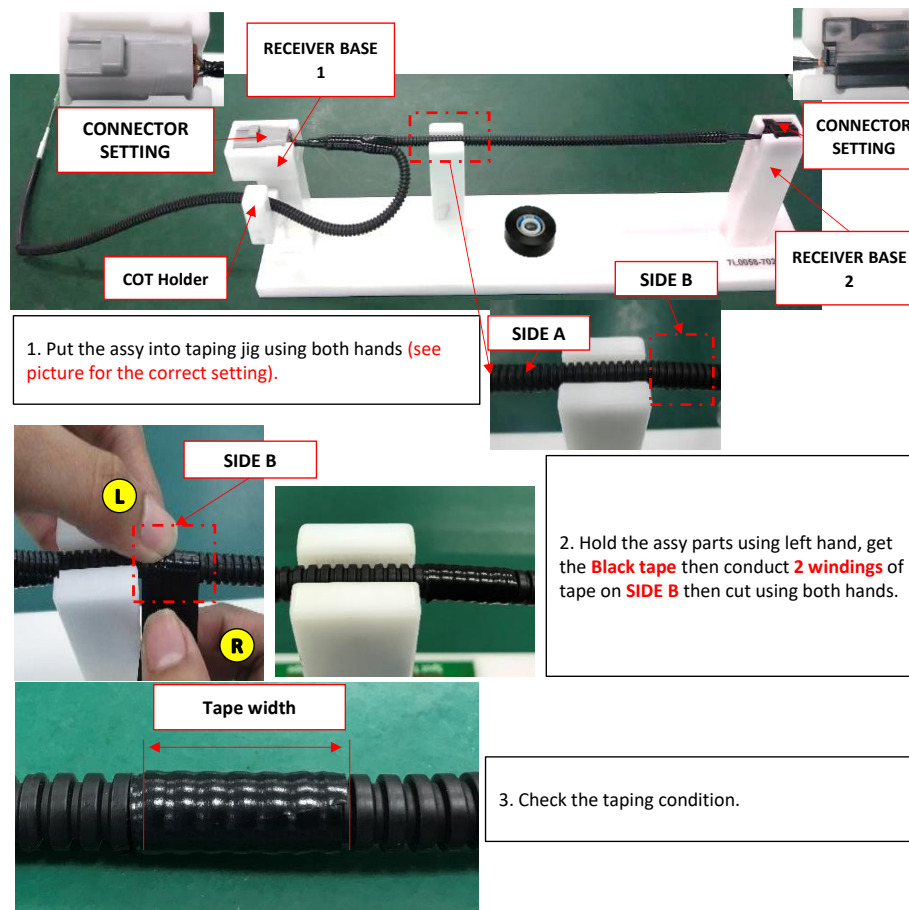
PARTS:

1. Assy parts
2. Black tape

JIG

1. Spot taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Spot taping	n/a	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. 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 PROPOCESS

Effectivity Date:

May 10, 2023

Validity Date:

n/a

Model Code/Part Number:

177D

/

7L0127-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-351B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

8 of 8

PARTS:

1. Assy parts

JIG

1. Spot taping jig



QUALITY CHECKPOINTS

P2

7L0127-7020A



NO GOOD



GOOD



1

No **WRONG INSERT**

No **Unlocked / halflocked connector**

No **TBO**

2

No **MISSING 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