

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESSModel Code/ Part Number: **101D / 7N0098-7021**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 2, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-434A

Revision No.:

0

Page No.:

1 of 6

PARTS:

All parts; Assy parts; Connector 6188-0407 (W); TVSSf 0.3 wires B/W L=584±3mm; G L=584±3mm; Black Corrugated tube Ø5 L=433±3mm (no slit); Black Sunprene tube Ø9 L=97±3mm; Black tape[1pc]

JIG:

1. Insertion jig with switch cover
2. Locking jig
3. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div>TABLE LAY-OUT</div> <div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance</div> <div>1. No missing parts/ tools 2. No excess parts/ tools.</div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
03/02/22	0	Initial issue	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	March 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

Process Name/Title:

Model Code/ Part Number: **101D / 7N0098-7021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 2, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-434A

Revision No.:

0

Page No.:

2 of 6

PARTS:

1. Connector 6188-0407 (W)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Wire Insertion to
connector
6188-0407 (W)

Insertion jig with switch cover

Insertion jig

Visual reference

Switch cover

Lock

I-mark

Holes

Connector orientation

L **Press**

L **Press** **R**

L **Release** **R**

1. Press the lock of insertion jig using left thumb.

2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock.
Note: Refer to above illustration for correct setting.

3. Check the holes/terminal slot for B/W wire.

n/a

Connector Orientation Illustration

I-mark is align

1 hole is open

GOOD

I-mark is not align

1 hole is open

NG

1. Use the provided jig per model
2. No wrong orientation of connector

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: **101D / 7N0098-7021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 2, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-434A

Revision No.:

0

Page No.:



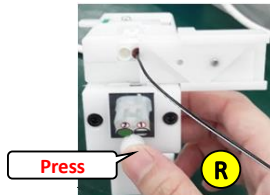
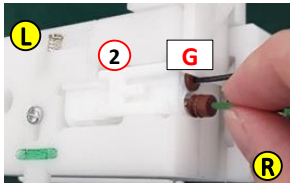

3 of 6

PARTS:

1. TVSSf 0.3 wires B/W L=584±3mm; G L=584±3mm

JIG

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6188-0407 (W)	<div><p>Wire facing</p></div> <div><p>1. Get Black and white wire then insert to terminal slot ① using right hand.</p></div> <div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div> <div><p>3. Get Green wire then insert to terminal slot ② using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <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>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></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**

Effectivity Date:

March 2, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/ Part Number:

101D / 7N0098-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-434A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

4 of 6

PARTS:

1. Assy parts
2. Black Corrugated tube Ø5 L=433±3mm (no slit)

JIG

1. Locking jig
2. Terminal cover jig

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

4

Connector lock

P1



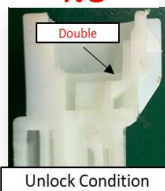
Before lock



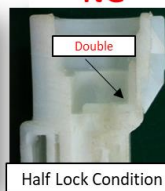
After lock



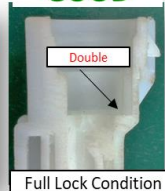
1. Put the connector into locking jig using both hands then press **2x** using both hands. Touch the connector lock to confirm if properly locked.
Refer to GL-PRO-ASY-017 for the verification of lock.

CONNECTOR CROSS SECTIONAL VIEW**NG**

Unlock Condition

NG

Half Lock Condition

GOOD

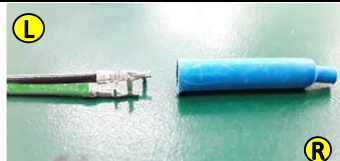
Full Lock Condition

LOCKING JIG

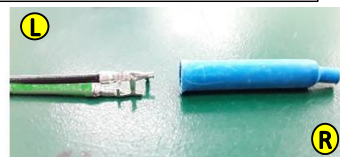
NOTE:
MANUAL LOCKING MAY CAUSE
DAMAGED LOCK

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

5

Wire insertion to
Corrugated tube
Ø5 L=433±3mm
(no slit)

1. Get the terminal cover jig using right hand then insert the **G** and **B/W wires**.



2. Get the Corrugated Ø5 L=433±3mm (no slit) using right hand and insert the **G** and **B/W wires**

3. After insertion, remove the terminal cover jig using right hand.

TERMINAL COVER JIG

1. No wrong use of parts
2. 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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/ Part Number: **101D / 7N0098-7021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 2, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-434A

Revision No.:

0

Page No.:

5 of 6

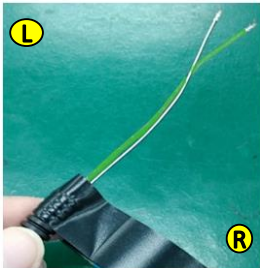
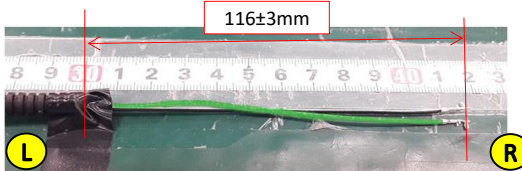
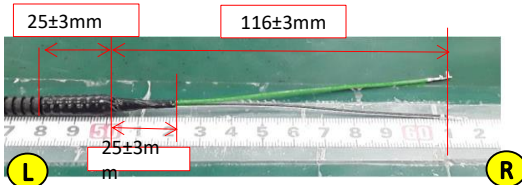

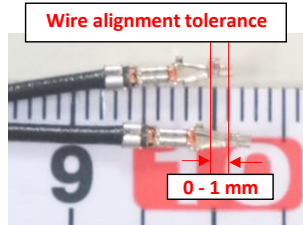

PARTS:

1. Assy parts
2. Black tape

3. Black Sunprene tube $\varnothing 9$ L=97 \pm 3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping COT to wire near terminal	  <p>1. Hold the COT using left hand. Get Black tape using right hand and conduct pre taping.</p> <p>2. Measure the end of COT to terminal tip 116mm and continue taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the dimension, taping condition and wire alignment.</p>	MEASURING TAPE 	 <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape</p> <p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>
7	Wire insertion to sunprene $\varnothing 9$ L=97 \pm 3mm	 <p>1. Get the Black Sunprene tube $\varnothing 9$ L=97\pm3mm using right hand and insert the G and B/W wires</p>	n/a	<p>1. No wrong use of parts 2. No deformed terminal</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/ Part Number: **101D / 7N0098-7021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 2, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-434A

Revision No.:

0

Page No.:

6 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

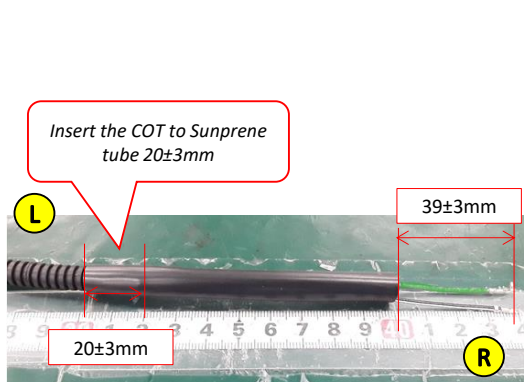
TOOLS/PPE

QUALITY POINTERS

8

P2

Taping COT to Sunprene

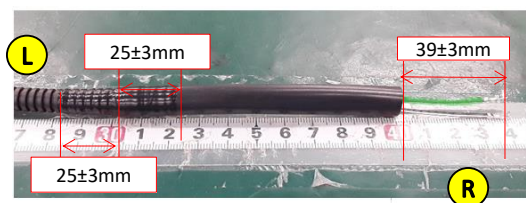


1. Hold the COT using left hand and check the dimension from Sunprene to terminal tip **39mm**.



2. Hold the assy parts, get Black tape and proceed to taping process.

Note: Refer to WI-PRO-ASY-001 for taping procedure.



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

MEASURING TAPE



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

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. 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