



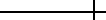



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	March 3, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-100		
Revision No.:	6	Page No.:	1 of 16

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number	D01L / 75N350-0011	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Connector PBVP-08V-S (W) [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig PBVP-08V-S (W)	<p>1. Get the 2pcs of <b>PBVP-08V-S</b> connector using right hand transfer the 1 connector tooo left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p> <p>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p>		<p><b>Safety Instruction</b> Be sure to wear prescribed 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>	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

Revision History								Prepared by:	Checked by:	Approved by:	Noted by:
03/03/23	6	Improved the insertion jig and procedure. Improved work process/illustration. Change term sunprene tube to VM tube (Sunprene). Inclusion of Quality checkpoints (Page 16).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	
10/21/22	5	Improve Quality pointers; Reminders/notes and references on page no. 2,3,5,4,6,7,8,9,10,12 and 13. Improve work procedure/illustration on process no. 14- Visual/ by two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
08/02/22	4	Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Include WI-ENG-PDE-431 for Steering Electrical Test after assembly.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Established Date:		October 9, 2019		

**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: **D01L / 75N350-0011**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**2 of 16**

**PARTS:**



1. AVSS 0.3 BR L=292±2mm; GR/B L=161±2mm; GR L=161±2mm; W/G L=161±2mm; Y L=161±2mm; OR L=161±2mm; R/L L=292±2mm
2. Blue VM tube (Sunprene) Ø6.5 L=119±3mm

**JIG**

1. Insertion jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

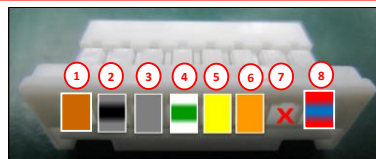
**QUALITY POINTERS**

2

P1

Wire insertion to  
Connector  
PBVP-04V-S (W)

**INSERTION SEQUENCE FROM LEFT TO RIGHT**



**WIRE INSERTION ILLUSTRATION**

1	2	3	4	5	6	7	8
BR	GR/B	GR	W/G	Y	OR	X	R/L
292	161	161	161	161	161		292



1. Get the **BR wire** using left hand and transfer to right hand then insert to connector. Repeat the process for **GR/B-GR-W/G-Y-OR-R/L wires**. Check the wire after insertion.  
*Note: Follow the insertion sequence based on the illustration.*

**STEERING  
NAVIGATION**



**CONTROLLER**



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

**Important reminders/Note/s:**

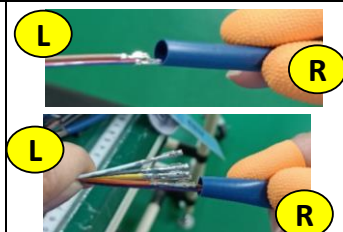
1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

**Document References:**

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

3

Wire insertion to  
Blue VM tube  
(Sunprene)  
Ø6.5 L=119±3mm



1. Get the **Blue VM tube (Sunprene)** Ø6.5 L=119±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.

N/A

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

**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:

**D01L / 75N350-0011**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**3 of 16****PARTS:**

1. AVSS 0.3 wires R L=161±2mm; R/W L=161±2mm; G L=161±2mm; LG L=161±2mm; B L=161±2mm

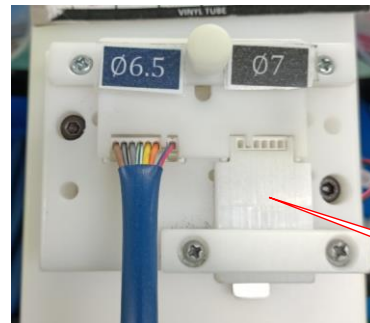
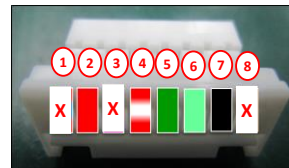
**JIG**

1. Insertion jig

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

4

P1

Wire insertion to  
Connector  
PBVP-08V-S (W)**INSERTION SEQUENCE FROM LEFT TO RIGHT**

Lower guide

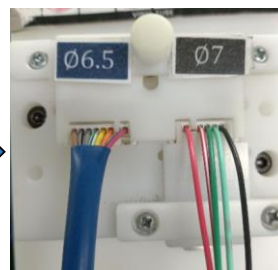
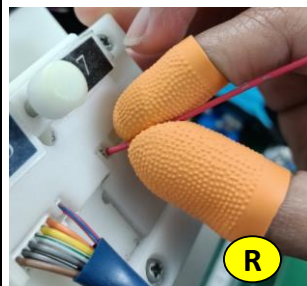
**WIRE INSERTION ILLUSTRATION**

1	2	3	4	5	6	7	8
X	R	X	R/W	G	LG	B	X
	161		161	161	161	161	



Wire facing

Note: Holes that need to be insert are only open.



1. Get the **R wire** using right hand and insert to connector. Repeat the process for **R/W-G-LG-B wires**. Check the wire after insertion.

Note: Follow the insertion sequence based on the above illustration.

**STEERING NAVIGATION****CONTROLLER**

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

**Important reminders/Note/s:**

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

**Document References:**

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 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 PROCESS**

Model Code/Part Number: **D01L / 75N350-0011**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:



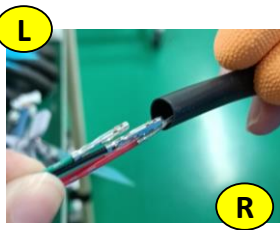
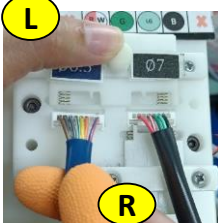
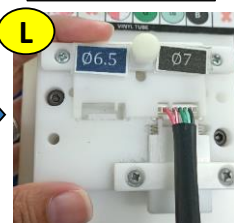
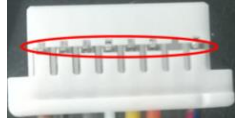


**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**4 of 16**

PARTS: 		1. Black VM tube (Sunprene) Ø7 L=119±3mm		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	 Wire insertion to Black VM tube (Sunprene) Ø7 L=119±3mm	 <p>1. Get the <b>Black VM tube (Sunprene) Ø7 L=119±3mm</b> using right hand. Hold the wire using left hand then insert the wires.</p>   <p>2. Press the Upper button using left hand.</p> <p>3. Remove the 1st connector with inserted wires and <b>Blue VM tube (Sunprene)</b> using right hand then press the upper guide using left hand. Check the wire insertion condition.</p> <p>Note: Second connector with inserted wire and Black Sunprene tube will stay in the jig.</p>		N/A	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires  <p><b>Terminal tip must be visible</b></p> <p><b>Document References:</b> 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p>
6	Wire insertion to assy parts	 <p>1. Hold the <b>Black VM tube (Sunprene)</b> using left hand and insert the wires from <b>Blue VM tube (Sunprene)</b> using right hand.</p> 		N/A	1. No wrong use of parts 2. No deformed terminal 3. No tangled wires

**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:

March 3, 2023

Model Code/Part Number:

D01L / 75N350-0011

Customer:

TRJ

Document No.:

WI-ENG-PDE-100

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

5 of 16

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

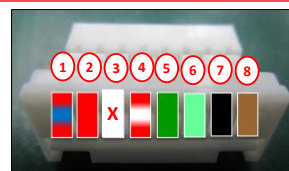
QUALITY POINTERS

7

P1

Wire insertion to  
Connector  
PBVP-08V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT



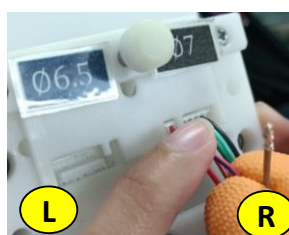
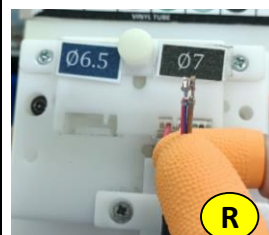
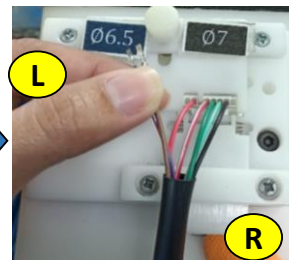
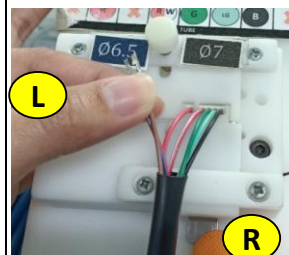
WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8
R/L	R	X	R/W	G	LG	B	BR
292	161		161	161	161	161	292



Wire facing

1. Press the Lower button using right hand. Holes that need to be insert are only open.



2. Hold the **R/L wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **BR wire**. Check the wire after insertion  
*Note: Follow the insertion sequence based on the above illustration.*

STEERING  
NAVIGATION

CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

#### Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

#### Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 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 PROCESS**

Model Code/Part Number: **D01L / 75N350-0011**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**6 of 16**

### PARTS:

1. Assy parts

**JIG**

1. Insertion jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

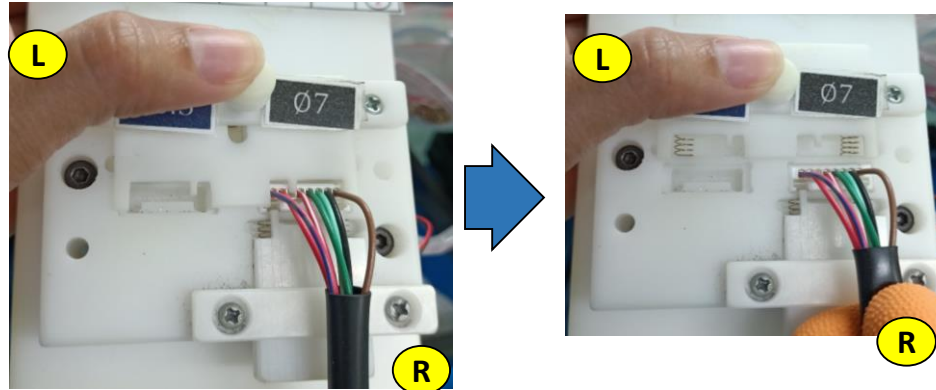
**TOOLS/PPE**

**QUALITY POINTERS**

7

P1

Wire insertion to  
Connector  
PBVP-08V-S (W)  
(Continuation)



3. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.

N/A



**Terminal tip must be visible**

#### Document References:

1. Refer to GL-PRO-ASY-025 for  
Inspection Standard for Coupler  
Insertion.

1. No deformed terminals
2. No tangled wires
3. No wrong facing

**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:

March 3, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: **D01L / 75N350-0011**Customer: **TRJ**

Document No.:

**WI-ENG-PDE-100**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

7 of 16

**PARTS:**

1. Assy parts

**JIG**

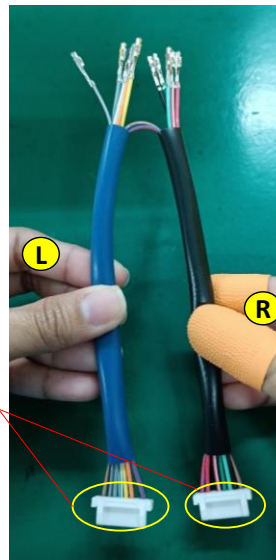
n/a

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

8

P1

Wire arrangement

**BEFORE FOLDING****AFTER FOLDING**Terminal tip is  
not visible

1. Hold the assy parts using both  
hands then conduct wire  
arrangement.

n/a

1. No deformed terminals
2. No tangled wires
3. No wrong facing

**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:

March 3, 2023

Model Code/Part Number:

D01L / 75N350-0011

Customer:

TRJ

Document No.:

WI-ENG-PDE-100

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

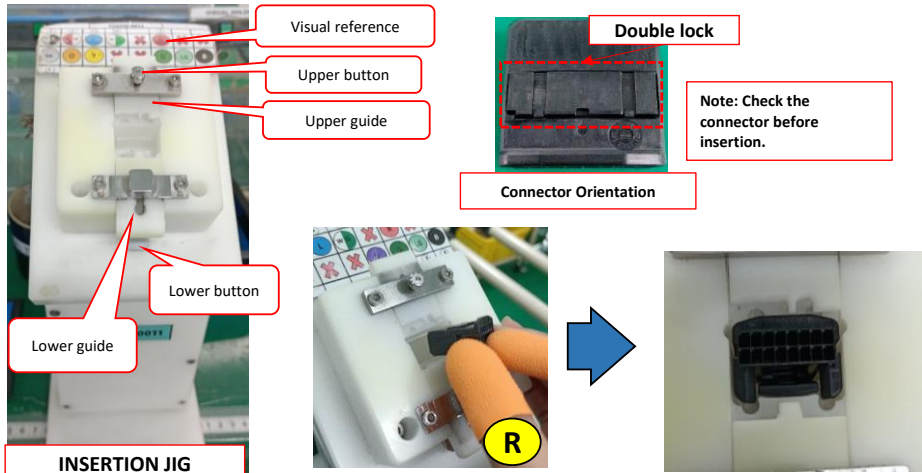
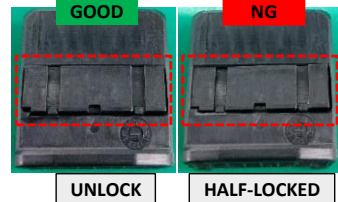
☒ MASSPRO

Revision No.:

6

Page No.:

8 of 16

PARTS:		1. Connector 1318386-2 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<p>Connector setting to insertion jig 1318386-2 (B)</p>  <p>1. Get the connector <b>1318386-2 (B)</b> and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></p> <p>2. Press the upper and lower guide using left hand. Holes that need to be insert are only open.</p>		N/A	<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p> <p><b>Important reminders/Note/s:</b> 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</p> <p><b>CONNECTOR LOCK APPEARANCE CHECK</b></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

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Model Code/Part Number:

**D01L / 75N350-0011**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**9 of 16****PARTS:**

1. Assy parts

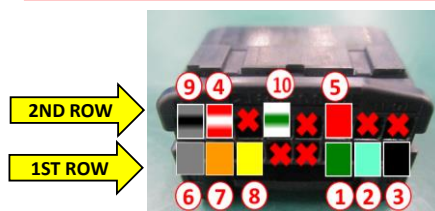
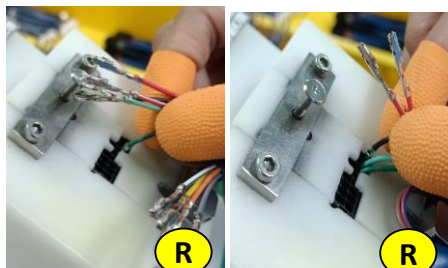
**JIG**

1. Insertion jig

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

10

P1

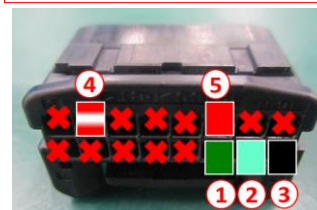
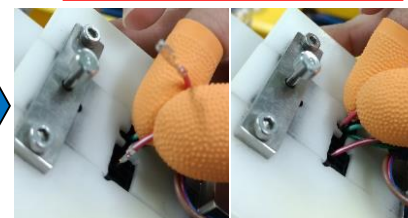
Connector setting to  
insertion jig  
1318386-2 (B)**INSERTION SEQUENCE FROM LEFT TO RIGHT****Wire facing****FIRST ROW (LEFT TO RIGHT)**

1. Insert first the wires from **Black VM tube (Sunprene)**. Hold the **G wire** and insert to terminal slot 1 using right hand. Repeat the process for **G-LG-B wires**.

*Note: Follow the insertion sequence based on the illustration stated above.*

**WIRE INSERTION ILLUSTRATION**

9	4	X	10	X	5			
GR/B	R/W		W/G		R	X	X	
158	161		158		161			
6	7	8			1	2	3	
GR	OR	Y	X	X	G	LG	B	
158	161	161			161	161	161	

**Black VM tube (Sunprene)****SECOND ROW (LEFT TO RIGHT)**

2. Hold the **R/W wire** and insert to terminal slot 4. Repeat the process for **R wire**.

*Note: Follow the insertion sequence based on the illustration stated above.*

N/A

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

**Important reminders/Note/s:**

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

**Document References:**

1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

**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:

March 3, 2023

Model Code/Part Number:

D01L / 75N350-0011

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

10 of 16

PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME		6 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE		QUALITY POINTERS	
10	P1	Wire insertion to Connector 1318386-2 (B) (Continuation)	<p>Blue VM Tube (Sunprene)</p> <p>Wire facing</p> <p>FIRST ROW (LEFT TO RIGHT)</p> <p>3. Hold the <b>GR wire</b> using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for <b>OR-Y wires</b>. <i>Note: Follow the insertion sequence based on the above illustration.</i></p> <p>4. Hold the <b>GR/B wire</b> and insert to terminal slot 8 using right hand. Repeat the process for <b>W/G wire</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p>	n/a		<p>1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1.</b> Please hold the wire near terminal during insertion. <b>2.</b> Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. <i>Do not exert extra force.</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

DCC Stamp



## WORK INSTRUCTION

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Model Code/Part Number:

**D01L****/****75N350-0011**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**12 of 16**

PARTS:		1. Assy parts				JIG	1. Insertion jig																																																	
NO.	PROCESS NAME		6 WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS																																																
12	P1	Wire insertion to Connector 1318386-2 (B) (Continuation)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div>2ND ROW</div> <div>1ST ROW</div> <div>WIRE INSERTION ILLUSTRATION</div> <table><tr><td>9</td><td>4</td><td>11</td><td>10</td><td>X</td><td>5</td><td></td><td></td></tr><tr><td>GR/B</td><td>R/W</td><td>L</td><td>W/G</td><td>X</td><td>R</td><td>X</td><td>X</td></tr><tr><td>158</td><td>161</td><td>129</td><td>158</td><td></td><td>161</td><td></td><td></td></tr><tr><td>6</td><td>7</td><td>8</td><td></td><td></td><td>1</td><td>2</td><td>3</td></tr><tr><td>GR</td><td>OR</td><td>Y</td><td>X</td><td>X</td><td>G</td><td>LG</td><td>B</td></tr><tr><td>158</td><td>161</td><td>161</td><td></td><td></td><td>161</td><td>161</td><td>161</td></tr></table> <div></div> <div>Wire facing</div> <div>FIRST ROW (LEFT TO RIGHT)</div> <div><div>4. Get the <b>L wire</b> using right hand and insert to terminal slot 11 using right hand. <i>Note: Follow the insertion sequence based on the above illustration.</i></div><div><div>5. Press the upper guide and lower guide (same timing) using both hands then remove the assy part using right hand.</div></div><div><div>5. Press the upper guide and lower guide (same timing) using both hands then remove the assy part using right hand.</div></div></div> <td>n/a</td> <td><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. One by one insertion</div><div>4. No wrong insertion</div><div>5. No deformed terminal</div><div>6. No stuck of terminal tip</div><div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b></div></td>				9	4	11	10	X	5			GR/B	R/W	L	W/G	X	R	X	X	158	161	129	158		161			6	7	8			1	2	3	GR	OR	Y	X	X	G	LG	B	158	161	161			161	161	161	n/a	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b></div>
			9	4	11	10	X	5																																																
GR/B	R/W	L	W/G	X	R	X	X																																																	
158	161	129	158		161																																																			
6	7	8			1	2	3																																																	
GR	OR	Y	X	X	G	LG	B																																																	
158	161	161			161	161	161																																																	

**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: **D01L / 75N350-0011**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**13 of 16**

### PARTS:

1. Assy parts

### JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

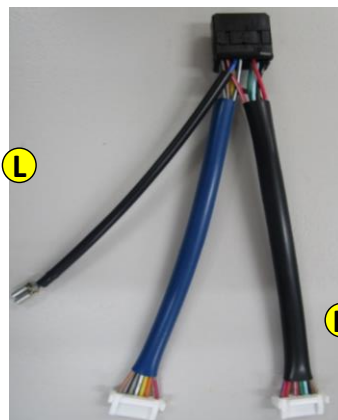
TOOLS/PPE

QUALITY POINTERS

13

P1

Wire arrangement



1. Hold the assy parts using both hands then conduct wire facing arrangement.



n/a

1. No wrong orientation of connector
2. No tangled wires
3. No wrong harness facing

**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: **D01L / 75N350-0011**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**March 3, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-100**

Revision No.:

**6**

Page No.:

**14 of 16****PARTS:**

1. Assembled parts
2. Master sample

JIG:

n/a

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

14

P1

Visual/By Two's Inspection

1. Check the connector lock. Lock of connector is included in Steering electrical test.

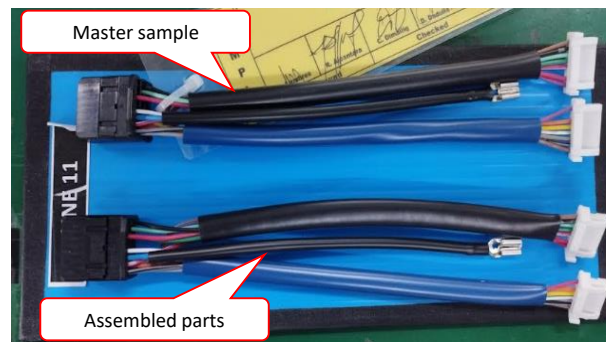
2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

**ACTUAL PRODUCT**

4. Check the orientation of harness.

5. Compare to **Master sample** by tapping..

**Master sample****Assembled parts**

1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

**MASTER SAMPLE****Important reminders/Note/s:**

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

**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:

March 3, 2023

Process Name/Title:

Model Code/Part Number: D01L / 75N350-0011

Customer: TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-100

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

Page No.:

15 of 16

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

15

Measurement

P1



MEASURING TAPE



1.No wrong dimension

**Important reminders/Note/s:**

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

**2. For Hatsumono and Owarimono.**

**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 3, 2023

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

D01L / 75N350-0011

Customer:

TRJ

Document No.:

WI-ENG-PDE-100

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

Page No.:

16 of 16

PARTS:

n/a

JIG

n/a



## QUALITY CHECKPOINTS

### 75N350-0011

1. Check the connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

Black VM Tube (Sunprene)

Black VM Tube (Sunprene)

Blue VM Tube (Sunprene)

3. Check the orientation of harness.

4. Check if no missing parts.

5. Check the terminal if with backing out (no fully inserted) or deformed terminal

6. Compare to master sample.

FOLDED WIRES  
MUST BE IN  
BACK 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