



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Product Number: 740B / 7H0425W7020

Customer: NBS

Document No.:

WI-ENG-PDE-526A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 8

## PARTS:

1. All parts: Connector 6098-2220 (W); AVSSf 0.3 Y-OR wires L=353±2mm Black vinyl tube Ø5 L=254±3mm; Black vinyl tube Ø5 L=30±3mm; Connector 6098-3802 (W); Black corrugated tube (no slit) Ø5 L=432±3mm; AVSSf 0.3 B wires L=555±3mm; Black tape [1pc.]

JIG

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS					
1	P1	Table Lay-out	<div>1</div> <div>Table Lay-out</div> <div>Connector 6098-2220 (W)/ Connector tray</div> <div>Black vinyl tube Ø5 L=254±3mm</div> <div>Black vinyl tube Ø5 L=30±3mm</div> <div>Connector 6098-3802 (W)/ Connector box</div> <div>AVSSf 0.3 Y-OR wires L=353±2mm</div> <div>Insertion jig A</div> <div>Insertion jig B</div> <div>AVSSf 0.3 B wires L=555±3mm</div> <div>Terminal cover jig</div> <div>Black corrugated tube (no slit) Ø5 L=432±3mm</div> <div>Black tape/tape holder</div> <div><div><div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div>	<div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>						
Revision History				Prepared by	Reviewed by	Approved by	Noted by			
05/17/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A.Arañes	<div>M. Catapang</div>	<div>J. Loterte</div>	<div>C. Villanueva</div>	<div>A. Arañes</div>
05/13/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A.Arañes				
Eff.Date	Rev.No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 13, 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

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Model Code/Product Number: **740B / 7H0425W7020**

Customer:

**NBS**

Validity Date:

n/a

Document No.:

**WI-ENG-PDE-526A**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

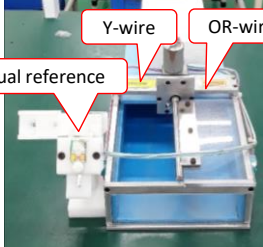
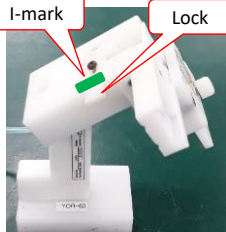

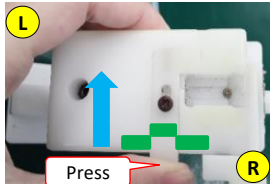
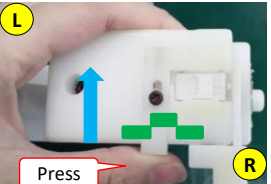
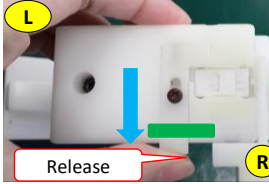
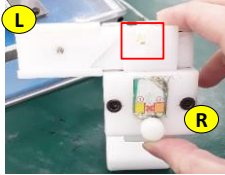
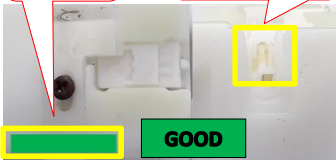
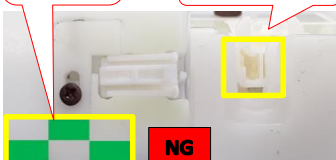
☒ MASSPRO

Revision No.:

1

Page No.:

2 of 8

PARTS:		1. Connector 6098-2220 (W)		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to Insertion jig 6098-2220 (W)	<div><div><p>Visual reference</p><p>Y-wire</p><p>OR-wire</p></div><div><p>I-mark</p><p>Lock</p><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div></div> <div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div></div> <div><div><p>Step 3</p></div><div><p>1. Press the lock of the insertion jig using left hand.</p></div><div><p>2. Get the connector <b>6098-2220 (W)</b> using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p></div><div><p>3. Push the lower wire guide upward using right hand. Slot for <b>Yellow wire</b> will be opened.</p></div></div>	n/a	<div><p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></p><div><p>I-mark is align</p><p>1 hole is open</p><p><b>GOOD</b></p></div><div><p>I-mark is not align</p><p>1 hole is open</p><p><b>NG</b></p></div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p></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:

May 17, 2022

Model Code/Product Number: **740B / 7H0425W7020**

Customer:

**NBS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:


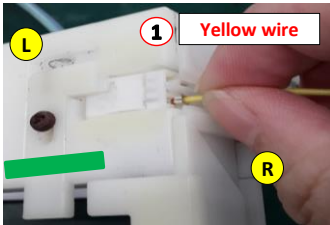
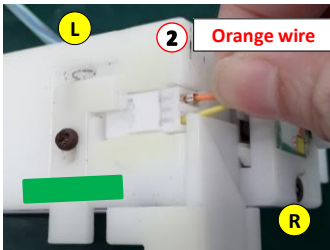
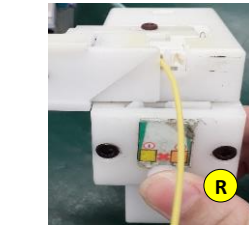
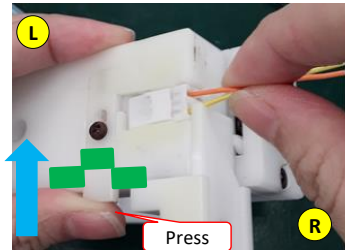
**WI-ENG-PDE-526A**

Revision No.:

1

Page No.:

3 of 8

PARTS:		1. AVSSf 0.3 Y-OR wires L=353±2mm			JIG	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	P1	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>Orange wire</b> will be opened.</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><i>Note: Please hold the wire near terminal during insertion.</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 <b>Pull-Push-Pull-Push</b> 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

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Model Code/Product Number: **740B / 7H0425W7020**

Customer:

**NBS**

Validity Date:

n/a

Document No.:

**WI-ENG-PDE-526A**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


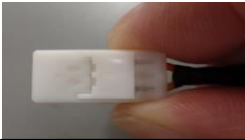
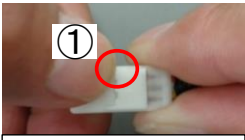
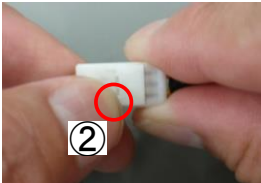
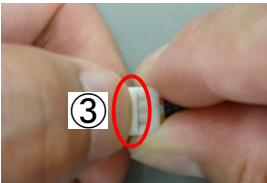
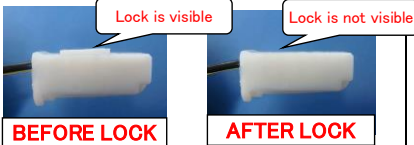
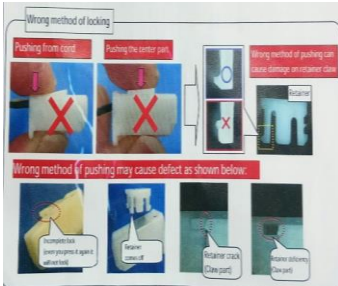
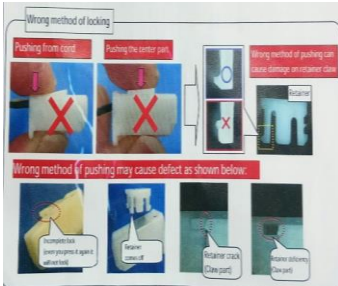


☒ MASSPRO

Revision No.:

1

Page No.:

4 of 8

PARTS:		1. Assy parts 2. Black vinyl tube Ø5 L=254±3mm		3. Black vinyl tube Ø5 L=30±3mm		JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><div><p><b>Sequence of Pressing the Double Lock:</b> ① - ② - ③ <b>Method:</b> Press one by one using one thumb</p></div><div><p>1. Hold the 6098-2220 connector using right hand</p></div><div><p>2. Press the right side of the connector lock using your left thumb</p></div><div><p>3. Press the left side of the connector lock using your left thumb</p></div><div><p>4. Press the terminal insertion side with your left thumb</p></div><div><p>5. Check the locking condition</p></div></div> <div>n/a</div> <td><div><div><p><b>Wrong Locking Method</b></p></div><div><p>1. No unlocked/half-locked connector 2. No one time pressing of double lock 3. Make sure not to hit the portion ③ (bottom side) when pressing ① &amp; ②</p></div></div></td>			<div><div><p><b>Wrong Locking Method</b></p></div><div><p>1. No unlocked/half-locked connector 2. No one time pressing of double lock 3. Make sure not to hit the portion ③ (bottom side) when pressing ① &amp; ②</p></div></div>	
5		Wire insertion to Black vinyl tube Ø5 L=254±3mm (1ST) Ø5 L=30±3mm (2ND)	<div><p>1. Get the Black vinyl tube Ø5 L=254±3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>2. Get the Black vinyl tube Ø5 L=30±3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div>n/a</div> <td><div><p>1. No wrong use of parts 2. No deformed terminal</p></div></td>			<div><p>1. No wrong use of parts 2. No deformed terminal</p></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:

May 17, 2022

Model Code/Product Number: **740B / 7H0425W7020**

Customer:

**NBS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

**WI-ENG-PDE-526A**

Revision No.:

1

Page No.:


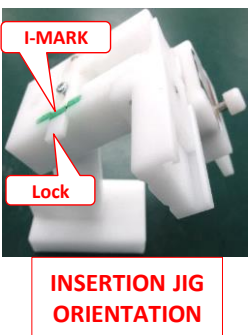
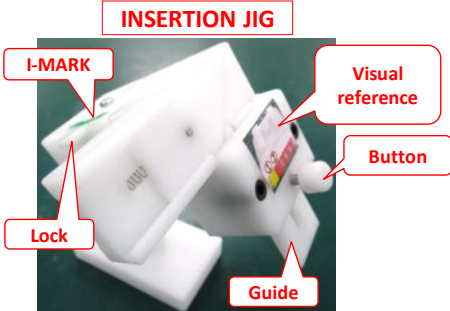
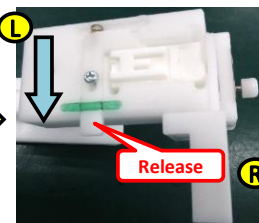
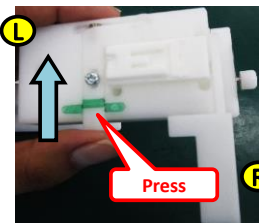
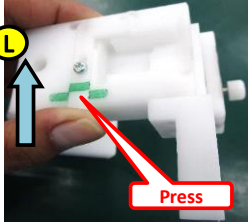
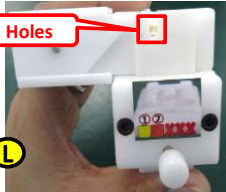
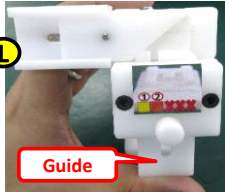
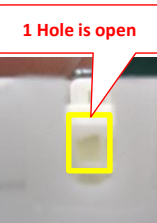

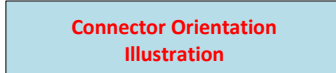


5 of 8

### PARTS:

1. Connector 6098-3802 (W)

### JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Connector setting to insertion jig 6098-3802 (W)	<div></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector <b>6098-3802 (W)</b> into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p><div></div><p>3. Push the guide using left hand. The slot for <b>Y wire</b> will be opened.</p></div>	n/a	<div></div> <div></div> <div><p><b>GOOD</b></p><p><b>NG</b></p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</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

Effectivity Date:

May 17, 2022

Model Code/Product Number: 740B / 7H0425W7020

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-526A

Purpose:



PROTOTYPE



PRE-LAUNCH



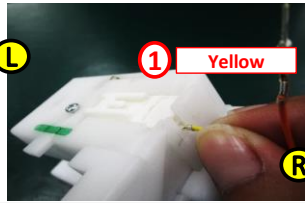

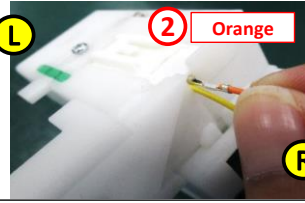
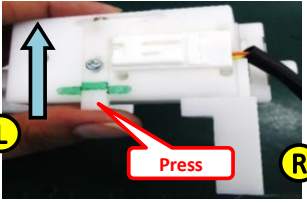
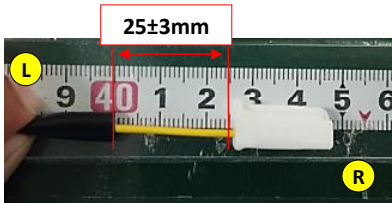

MASSPRO

Revision No.:

1

Page No.:

6 of 8

PARTS:	1. Assy parts 2. Black tape			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to connector 6098-3802 (W)  P1	<div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>Orange wire</b> will be opened.</p></div> <div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> 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 <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>
8	Taping 1 Black vinyl tube to wire near connector	<div><p>1. Measure from end of vinyl tube up to edge of connector <b>25±3mm</b> using both hands.</p></div>		<p><b>MEASURING TAPE</b></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><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</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

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2022

Model Code/Product Number:

740B / 7H0425W7020

Customer:

NBS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

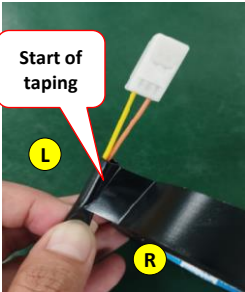
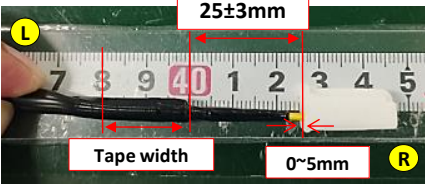


WI-ENG-PDE-526A

Revision No.:

1

Page No.:

7 of 8

PARTS:	1. Assy parts 2. Black tape 3. Black Corrugated tube Ø5 L=432±3mm 4. AVSSf 0.3 B wires L=555±3mm [2pcs.]			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
8	Taping 1 Black vinyl tube to wire near connector (Continuation)  P1	 <p>Start of taping</p> <p>2. Get the <b>Black tape</b> using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>25±3mm</p> <p>Tape width</p> <p>0~5mm</p> <p>3. After taping, check the measurement and taping condition.</p>	<p>MEASURING TAPE</p> 	<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol>	
9	Wire insertion to Black Corrugated tube Ø5 L=432±3mm (no slit)	 <p>1. Get the corrugated tube <b>Ø5 L=432±3mm (no slit)</b> using left hand then insert the <b>B-B wires</b> using right hand.</p>	n/a	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>	

**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:

May 17, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Product Number: 740B / 7H0425W7020

Customer:

NBS

Document No.:

WI-ENG-PDE-526A

Purpose:

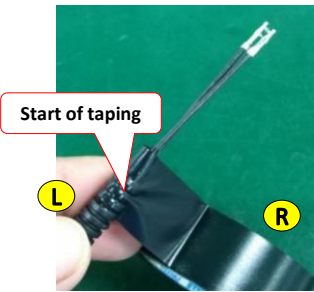
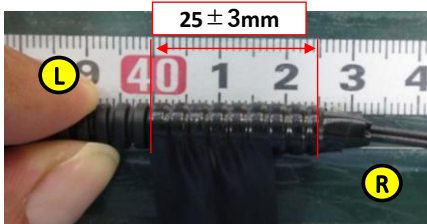
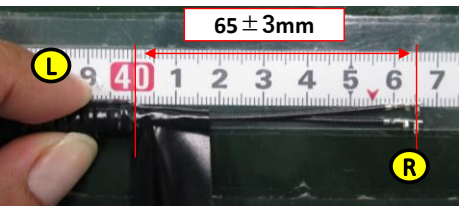
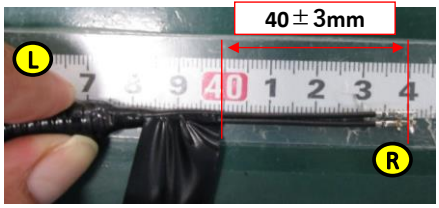
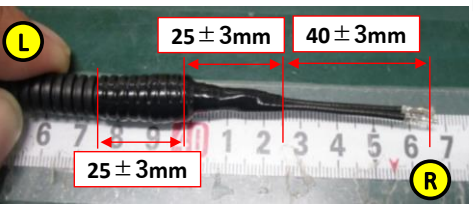

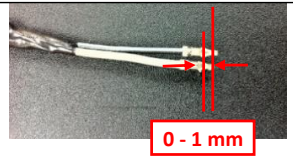
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

8 of 8

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 2 Black corrugated tube to wire near terminal	<div><p>1. Hold the COT using left hand, get the <b>Black tape</b> using right then start pre-taping at the middle of COT and wires using both hands.</p></div> <div><p>2. Confirm measurement of <b>25±3mm</b> from end of tape up to COT then continue the taping process using both hands.</p></div> <div><p>3. Measure from end of COT up to terminal pointed tip <b>L=65±3mm</b> then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement of <b>40±3mm</b> from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, terminal appearance and taping condition.</p></div>	<div></div>	<div><p>0 - 1 mm</p></div> <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><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p></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