					WORK INST	DUCTION				Γ#22	tivity Date:			February 28, 2	000
			Process Name/Title:			E ASSEMBLY PROC	ECC				ity Date:			n/a	023
				T140 /							,				205
		7	Model Code/Part Number:		7L0117-7020A	Customer:	TRQSS			Docu	ment No.:			WI-ENG-PDE-	365
			Purpose:	☐ PROTOTYPE	[PRE-LAUNCH	MASSF	PRO		Revis	sion No.:		3	Page No.:	1 of 7
													1		
PARTS:			art: Connector 7186-8847 (W 0.3 Y wire L=290±2mm); Jointed wire B-V-P-W	7L0117-2000; AVSSf 0.	.3 V wires L=451±2mm; AVSSf	B wires L=4	141±2mm; A	VSSf 0.3 OF	R wires L=4	62±2mm;	JIG:	1. Insertion	jig	
N	0.		PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/P	PE	QUALITY POINTERS			
	1	n/a	Table Lay-out	Insertion jig A	L:	VSSf B wires =441±2mm Jointed wire B-V-P-W 7L0117-2000	7LG117-7020A	wires L=	ires	p du	Be sure to we prescribed per rotective equiring operation finger cots, expenses and the sure of the su	rear rsonal ipment (gloves, etc.) ping always s. s on the hibited. locker. inform ssistant e Leader	Refer to Strip Lengt 1. No missir	reference/s: WI-PRO-CNC-017 j h Tolerance ng parts/tools s parts/tools	ior Wire and
					Revision History					•	Prepared by	y R	eviewed by	Approved by	Noted by
02/28/23	3		quality pointers and notes in proof insertion jig. Addition of " Mus				M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
10/11/22	2	illustratio		, , , , , , , , , , , , , , , , , , ,			M. Ariola	J. Loterte	C. Villanueva	A. Arañes) A i .	~ !		
09/01/22	1		and 3 as document improvement.			ality pointers and notes in process untermeasure for encountered	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	4º (J. Loterte	South form	A.Arabes
Eff. Date	Rev. No			Details of Ch	ange	-	Revised	Reviewed	Approved	Noted	Est. Date:	Octob	er 15, 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

			Effectivity Date:		February 28, 2023						
		Process Name/Title:	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
		Model Code/Part Number:	TM3 / 7L0117-7020	A Customer:	TRQSS	Document No.:		WI-ENG	-PDE-365		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3 Page No.:	2 of 7		
PARTS:	1. Con	nector 7186-8847 (W)					JIG	1. Insertion jig			
NO.		PROCESS NAME	WORK PRO	WORK PROCEDURE/ ILLUSTRATION			PPE	QUALITY POINTERS			
			Insertion jig	Insertion jig (Back view)	Insertion jig Orientation				(81-1 (
			Visual reference	Reset				Important remind 1. Cannot insert th connector.			
			Slider lock					 Use provided jig No wrong usage No wrong orienta 	of parts		

Adjustable

Connector GOOD Orientation Slide lock Release 2. Insert the connector 7186-8847 (W) into jig using left hand and release the slide lock.

Button

Guide

1. Slide the slide lock using right thumb..



3. Push the guide using left thumb. The slot for B Jointed wire will be opened.

n/a

CONNECTOR ILLUSTRATION

4. No damaged connector



7186-8847 (W)

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.

Connector setting to

insertion jig

7186-8847 (W)

2

n/a

NBC (Philippines) **MASTER COPY**

			WORK INSTRU		Effectivity Date:		February 28, 2023			
		Process Name/Title: OFFLINE ASSEMBLY PROCESS Validity Date:						n/a		
		Model Code/Part Number:	TM3 / 7L0117-7020/	Customer:	TRQSS	Document No.:		WI-ENG-PDE-365		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3 Page No.: 3 of 7		
		parts ed wire B-V-P-W 7L0117-20	JIG	1.	1. Insertion jig					
NO.	Р	ROCESS NAME	WORK PRO	TOOLS/PPE		QUALITY POINTERS				
3	n/a	Wire insertion to connector 7186-8847 (W)	1. Get B Jointed wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion. Slider lock 3. After insertion, slide the slider lock using right the jointed wire and gently pull out the connection.	2. Press the button using left heard.	thumb. GO sound will be 4. After removing the connector from jig, conduct Pushing (1x) of wires using right hand to confirm that wire is fully inserted.		2. 3. 4. 5. 6. ins	No loose insertion No wrong insertion One by one insertion No deformed terminal No wrong wire facing Must have slightly movement after sertion. 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. 3. Conduct Pushing of wires after removing the connector from jig. 4. Pushing of wires will be done one by one of every inserted wires 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

			WORK INSTRUC	CTION		Effectivity Date:			February	28, 2023		
		Process Name/Title:	OFFLINE AS	OFFLINE ASSEMBLY PROCESS					n/a			
		Model Code/Part Number:	TM3 / 7L0117-7020A	Customer:	TRQSS	Document No.:			WI-ENG-F	PDE-365		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	4 of 7		
<u> </u>	1							1				
PARTS:	1. Assy	parts			JIG	1. Insertion jig						
NO.	l	PROCESS NAME	WORK PROC	TOOLS/P	QUALITY POINTERS							
4	n/a	Connector setting to insertion jig 7186-8847 (W) (Assy parts)	Insertion jig Visual reference Slider lock Suide lock Release 2. Insert the connector 7186-8847 (W) into jig using left hand and release the side lock.	1. Slide the slider I	Insertion jig Orientation lide R ock using right thumb Hole g left hand. The slot for ened.	n/a		1. Use pi 2. No wro 3. No wro 4. No da	ot insert the or. rovided jig pong usage cong orientatimaged conr	or orientation inverted per model of parts ion 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 COF

MASTER COPY

		WORK INSTRUCTION					Effectivity Date:		February 28, 2023		
		Process Name/Title:		OFFLINE ASSE	EMBLY PROCES	SS	Validity Date:		n/a		
		Model Code/Part Number:	TM3 / 7L	.0117-7020A	Customer:	TRQSS	Document No.:		1	WI-ENG-I	PDE-365
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	5 of 7
<u> </u>	1										
PARTS:	1. Assy parts 2. Y wire L=290±2mm; B wire L=441±2m			2mm					1. Insertion jig		
NO.	F	PROCESS NAME	SS NAME WORK PROCEDURE/ ILLUSTRATION TOO					PE.	QUALITY POINTERS		
5	n/a	Wire insertion to connector 7186-8847 (W) (Assy parts)	1. Get Yellow wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion. Slider lock 4. After insertion, slide the wires and gently pull out to	Black wire will be ope	R R	3. Get Black wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push after insertion. Push 5. After removing the connector from jig, conduct Pushing (1x) of B wires using right hand to confirm that wire is fully inserted. Repeat the process for Y wire.	n/a	<u> </u>	2. No wr 3. One b 4. No de 5. No wr 6. Must I insertion Importa 1. Pleas termina 2. Make inserted Conduc after in Do not 3. Cond removii 4. Push one by Docum 1. Refer Push pi 2. Refer	ant reminde se hold the v al. e sure wires d. st PUII-PUS sertion. exert extra ; luct Pushing ng the conning of wires one of every ent reference r to GL-PRO- rocedure. r to WI-PRO	ers/Note/s: ers/Note/s: ers/Note/s: ers/Note/s: ers rear s are properly ch-Pull-Push force. g of wires after ector from jig. s will be done y inserted 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 COF

MASTER COPY

NBC		D 11 (F)	Effectivity Date:		1	February 28, 2023					
		Process Name/Title:	OFFLINE ASSEMBLY PROCESS			Validity Date:		n/a WI-ENG-PDE-365			
		Model Code/Part Number:			TRQSS	Document No.:		+		6 of 7	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	6 01 7	
ARTS:	1. Assy	y parts					JIG	1. Insert	tion jig		
NO.		PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/I	TOOLS/PPE		QUALITY POINTERS		
			Visual reference Slider lock Button Guide	Rese Adjustable Slider lock	Insertion jig Orientation			1. Follow 2. Canno connect 1. Use p 2. No wr 3. No wr	ont reminders, w the connector ot insert the inter- tor. provided jig per rong usage of rong orientation	er model parts on of connect	

1. Slide the slider lock using right hand.

3. Push the guide using right hand. The slot for

Orange wire will be opened.

Hole

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.

insertion jig

7186-8847 (W) (Assy parts)

6

n/a

NBC (Philippines)

MASTER COPY

2. Insert the connector 7186-8847 (W) into jig using

right hand and release the side lock.

GOOD

Release

Connector Orientation

7186-8847 (W) 7186-8849 (W)

n/a

			W	ORK INSTRUCTION		Effectivity Date:			February 2	8, 2023	
		Process Name/Title:		OFFLINE ASSEMBLY PROCES	S	Validity Date:			n/a		
		Model Code/Part Number:	TM3 / 7L0	117-7020A Customer:	TRQSS	Document No.:		,	WI-ENG-P	DE-365	
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		3 Pa	age No.:	7 of 7	
PARTS:		1. Assy parts 2. OR wire L=462±2mm; V wire L=451±2mm						1. Insertion	1. Insertion jig		
NO.	F	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	N	TOOLS/PPE			QUALITY POINTERS		
7	n/a	Wire insertion to connector 7186-8847 (W) (Assy parts)		Wire facing R 2. Press the button using right hand. The slot for Violet wire will be opened. Lider lock using left thumb and then hold the out the connector from jig using left hand.	3. Get Violet wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push after insertion. Push 5. After removing the connector from jig, flip the connector then conduct Pushing (1x) of OR wire using right hand to confirm that wire is fully inserted. Repeat the process for V wire.	n/a		2. No wron 3. One by c 4. No defor 5. No wron 6. Must have insertion. Importan 1. Please terminal. 2. Make s inserted. Conduct if after insee 3. Conduct if after insee 4. Pushing one by or Documen 1. Refer to Push proce 2. Refer to	nt reminders hold the wings sure wires a Pull-Push ertion. xert extra fo ct Pushing o g the connect g of wires v ne of every at references o GL-PRO-AS edure.	al g novement after s/Note/s: ire near are properly -Pull-Push orce. of wires after ctor from jig. will be done inserted 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