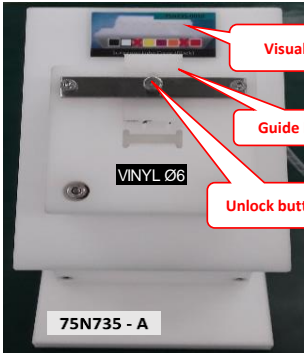
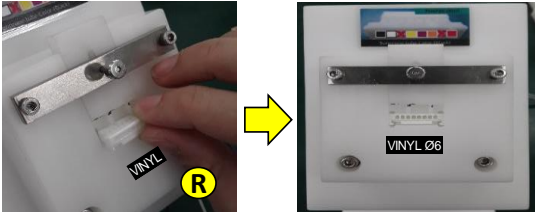
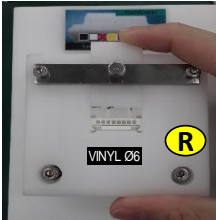





	WORK INSTRUCTION		Effectivity Date:	September 23, 2022	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 435B / 75N735-0011	Customer: TRJ	Document No.:	WI-ENG-PDE-042A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	5	Page No.:

PARTS:	1. Connector PBVP-08V-S (W)		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)	<div> <div> INSERTION JIG  </div> <div> CONNECTOR ORIENTATION  <p>1. Get the connector PBVP-08V-S (W) and set to insertion jig using right hand. Note: Follow the connector orientation</p> </div> </div> <div> <div> BEFORE PRESSING  </div> <div> AFTER PRESSING  <p>2. Press the guide lock using right index finger. You will notice the hole that needs to be inserted are only open.</p> </div> </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 workplace 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>	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	Reviewed by	Approved by	Noted by
09/23/22	5	Remove Connector lock process and additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance and conenctor illustration for 1746872-1 (B).	D.Castillo	J.Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	
06/11/21	4	Apply some improvements: In insertion process, additional quality pointers and note.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					
02/09/21	3	Change connector colors in accordance with standardization for plastic parts; Removal of cycle time; Change 2x pulling to Pull-Push-Pull-Push in wire insertion quality pointers; Put assy parts on pg.3~7 in parts section. Conduct semi-annual review of documents	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
10/28/19	0	Initial issue									
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	October 28, 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: **435B / 75N735-0011**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 23, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-042A

Revision No.:

5

Page No.:

2 of 7

PARTS:

1. AVSSf 0.3 B L=197±2mm; W L=195±2mm; Y L=191±2mm; V L=189±2mm; OR L=187±2mm; R L=183±2mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

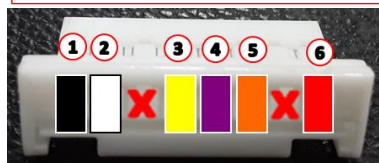
QUALITY POINTERS

2

P1

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

WIRE INSERTION SEQUENCE

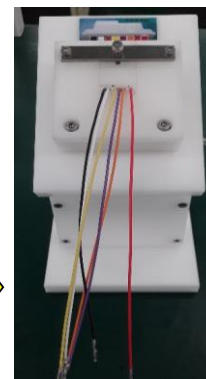
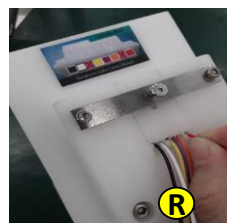


WIRE FACING



WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8
B	W	X	Y	V	OR	X	R
197	195		191	189	187		183



1. Get the **B** wire and insert to terminal **slot 1** using right hand. Repeat the process for **W-Y-V-OR-R**.

Note: Follow the insertion sequence based on the illustration.

STEERING
NAVIGATION

CONTROLLER



1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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 GL-PRO-ASY-028 for Pull-Push procedure.
3. 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

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 23, 2022

Process Name/Title:

Model code/Part number: 435B / 75N735-0011

Customer: TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-042A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


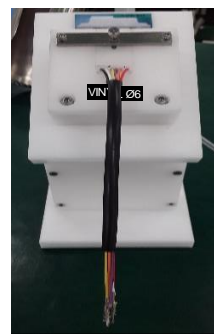

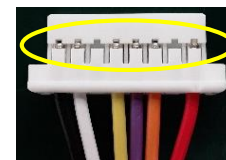
☒ MASSPRO

Revision No.:

5

Page No.:

3 of 7

PARTS:		1. Assy parts 2. Black Sunprene tube Ø6 L=125±3mm	JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	<p>Wire Insertion to Black Sunprene tube Ø6 L=125±3mm</p>  <p>1. Get the Black Sunprene tube $\text{Ø6 L=125} \pm 3\text{mm}$ using right hand then insert the wires using left hand.</p>   <p>2. Press the unlock button using left thumb to release the lock then gently pull out the connector from jig then check the terminal tip condition.</p>	n/a	<p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p> <p>Document References:</p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</p>  <p>Terminal tip must be visible</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: **435B / 75N735-0011**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 23, 2022

Validity Date:

n/a

Document No.:

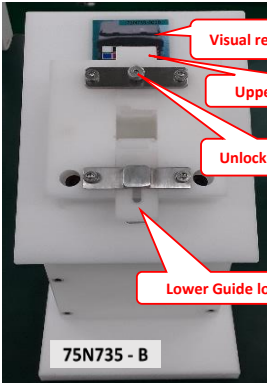
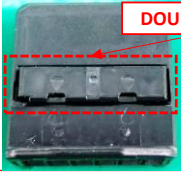

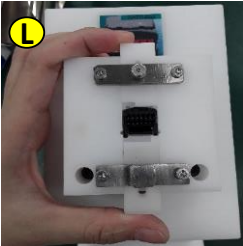
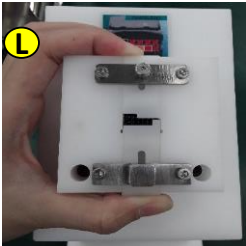

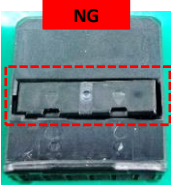
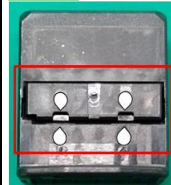

WI-ENG-PDE-042A

Revision No.:

5

Page No.:

4 of 7

PARTS:		1. Connector 1746872-1 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div>INSERTION JIG</div><div>DOUBLE LOCK</div><div>CONNECTOR ORIENTATION</div><div>Note: Check the connector before insertion.</div></div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>1. Get the connector 1746872-1 (B) and set to insertion jig using right hand. Note: Follow the connector orientation</div><div>2. Press the upper and lower guide lock using left index and right thumb (same timing). You will notice the hole that needs to be inserted are only open.</div></div>		n/a	<div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div>CONNECTOR LOCK APPEARANCE CHECK</div> <div><div>GOOD</div><div>NG</div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div></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**Model code/Part number: **435B / 75N735-0011**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 23, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-042A

Revision No.:

5

Page No.:

5 of 7

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

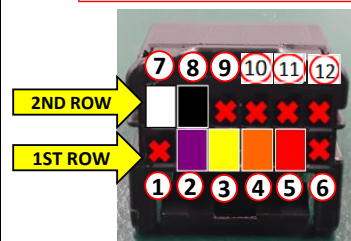
QUALITY POINTERS

5

P1

Wire Insertion to
Connector
1746872-1 (B)

WIRE INSERTION SEQUENCE



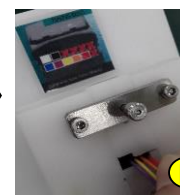
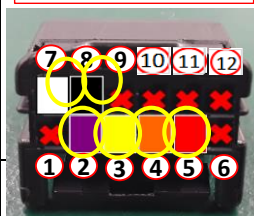
WIRE INSERTION ILLUSTRATION

7	8	9	10	11	12
W	B	X	X	X	X
195	197				
1	2	3	4	5	6
X	V	Y	OR	R	X
	189	191	187	183	

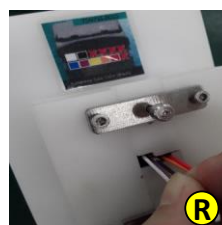
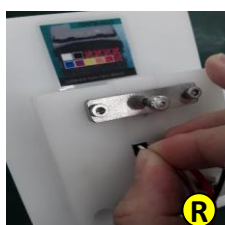
WIRE FACING



Sunprene tube (Black)



1. Begin insertion process in **1ST ROW**. Get **V** wire and insert to terminal slot **2** using right hand. Repeat the process for **Y-OR-R** wires.
Note: Follow wire insertion sequence to avoid wrong insertion.



2. Begin insertion process in **2nd ROW**. Get the **W** wire and insert to terminal slot **7** using right hand and **B** wire to terminal slot **8**.

n/a

1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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 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**

Effectivity Date:

September 23, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number: **435B / 75N735-0011**

Customer:

TRJ

Document No.:

WI-ENG-PDE-042A

Purpose:


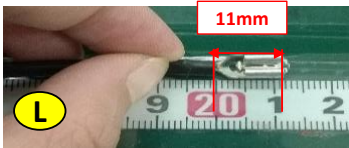


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

6 of 7

PARTS:		1. Black Sunprene tube Ø3 L=140±3mm 2. AVSS 0.5 wire L=154±2mm			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P1	<div><p>1. Get the Blue wire using right hand and insert to Sunprene tube (Black) Ø3 L=140±3mm</p></div> <div><p>2. Measure the Sunprene tube up to the tip of the terminal it should be 11mm.</p></div>			<div>MEASURING TAPE</div> 	<div><p>Peel-off wire should be covered by Sunprene tube (Black)</p></div> <p>Important Reminder/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document References:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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: **435B / 75N735-0011**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 23, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-042A

Revision No.:

5

Page No.:

7 of 7

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

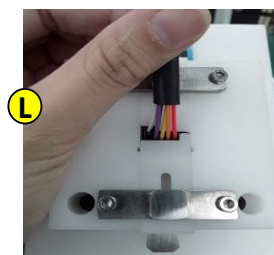
QUALITY POINTERS

7

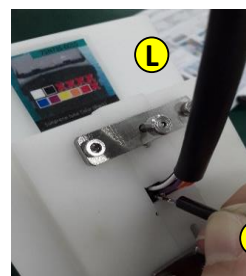
P1

Wire Insertion to
Connector
1746872-1 (B)

WIRE INSERTION SEQUENCE



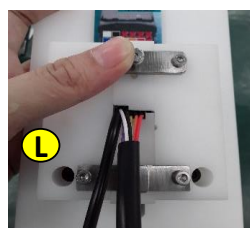
1. Hold the assy parts upward using left hand to make way for insertion process.



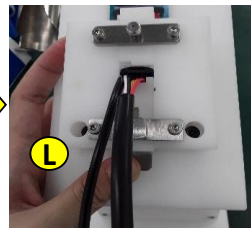
2. Get the L wire with inserted Black Sunprene tube and insert to terminal slot 1 using right hand.

WIRE INSERTION ILLUSTRATION

7	8	9	10	11	12
X	X	X	X	X	X
1	2	3	4	5	6
L	X	X	X	X	X
154					



3. Press the unlock button and lower guide lock using left thumb.



4. Gently pull out the connector from jig using right hand.

n/a

1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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 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