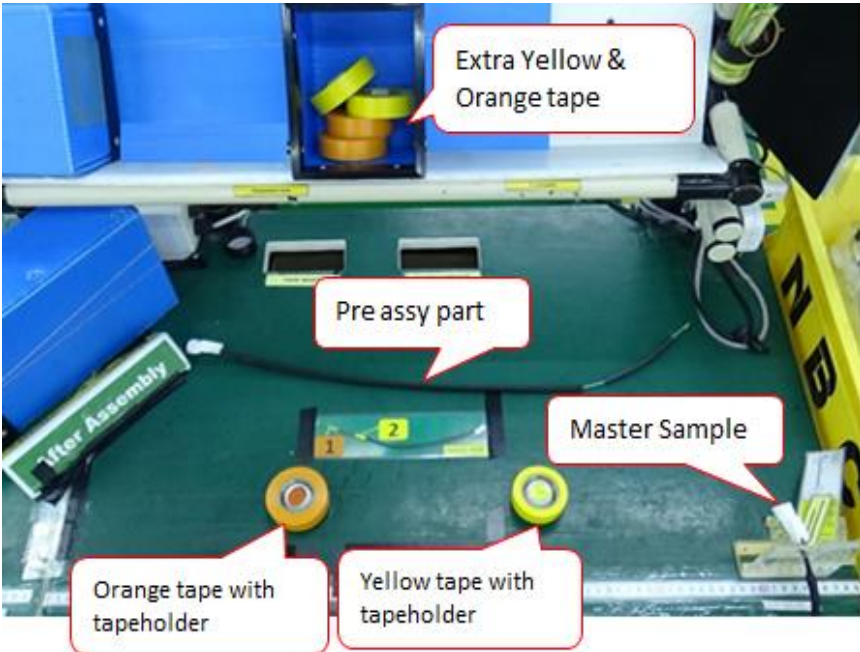

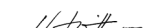

	WORK INSTRUCTION				Effectivity Date:	October 15, 2024			
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number:	Customer:	Car Model:	Document No.:	WI-ENG-PDE-1096B		
	102D / 7L0121-7024A		TRQSS	TOYOTA-RAV4					
Purpose:					<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	1 of 5

PARTS:		1. Assy parts: Yellow tape [1pc.]; Orange tape [1pc.]			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P2	<div>Table Lay-out</div> 			<div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
10/15/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
10/14/24	0	Initial issue	A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	October 14, 2024	

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

102D / 7L0121-7024A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 15, 2024

Validity Date:

n/a

Document No.:

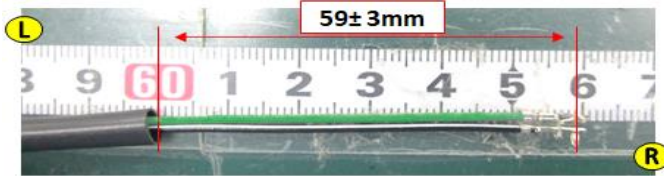
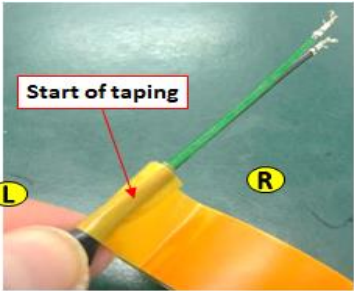
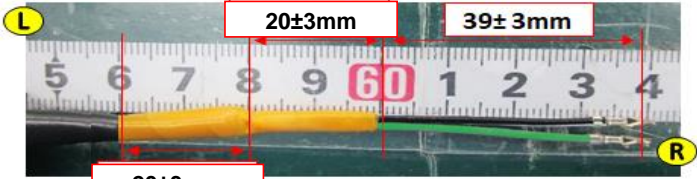

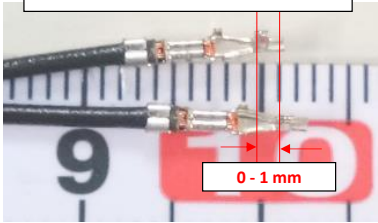
WI-ENG-PDE-1096B

Revision No.:

1

Page No.:

2 of 5

PARTS:		1. Assy parts 2. Orange tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black VM tube (Sunprene) to wire near terminal	<div><p>59±3mm</p><p>1. Measure from end of VM tube (Sunprene) up to end of the terminal pointed tip 59mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the VM tube (Sunprene) using left hand, get the Orange tape then start taping process using both hands.</p></div> <div><p>20±3mm 39±3mm 20±3mm</p><p>3. After taping, check the taping condition, measurement and wire alignment.</p></div>		<div><p>MEASURING TAPE</p></div>	<div><p>Wire alignment tolerance</p><p>0 - 1 mm</p><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p><p>Important reminders/Note/s:</p><p>1. Use ORANGE TAPE only. 2. 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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

102D / 7L0121-7024A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1096B

Purpose:

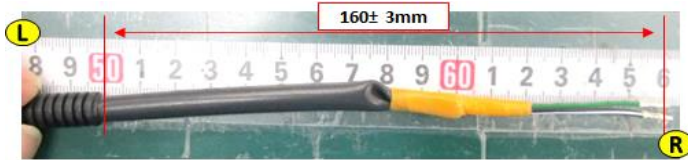

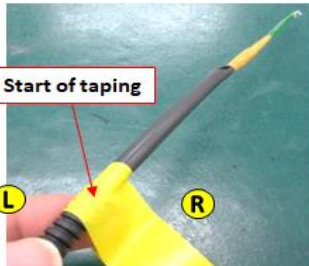
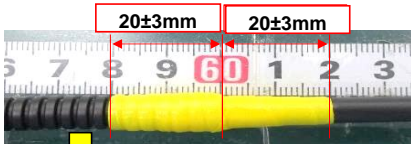

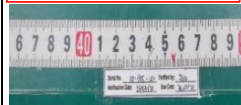
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Yellow tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 Black corrugated tube to Black VM tube (Sunprene) near terminal	<div><p>160± 3mm</p></div> <div><p>1. Measure from end of corrugated tube up to terminal pointed tip 160mm using both hands.</p></div> <div><p>Must be no gap</p><p>Start of taping</p></div> <div><p>2. Fix the corrugated tube and sunprene tube using both hands.</p></div> <div><p>3. Hold the corrugated tube and VM tube (Sunprene) using left hand, get the Yellow tape then start taping process using both hands.</p></div> <div><p>20±3mm 20±3mm</p></div> <div><p>4. After taping, check the measurement and taping condition.</p></div> <div><p>160± 3mm</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE only2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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:

October 15, 2024

Model code/Part number:

102D / 7L0121-7024A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:


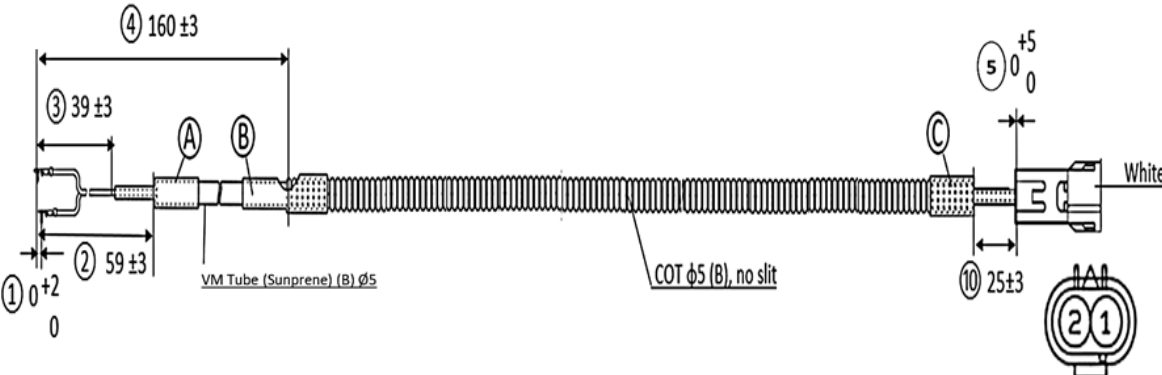
WI-ENG-PDE-1096B

Revision No.:

1

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Yellow tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement	<div><div>MEASURING TAPE</div></div> 		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</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:

October 15, 2024

Validity Date:

n/a

Model code/Part number:

102D / 7L0121-7024A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1096B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P2****7L0121-7024A****1 No Wrong Used of tape (YELLOW and ORANGE)****2 No Missing 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