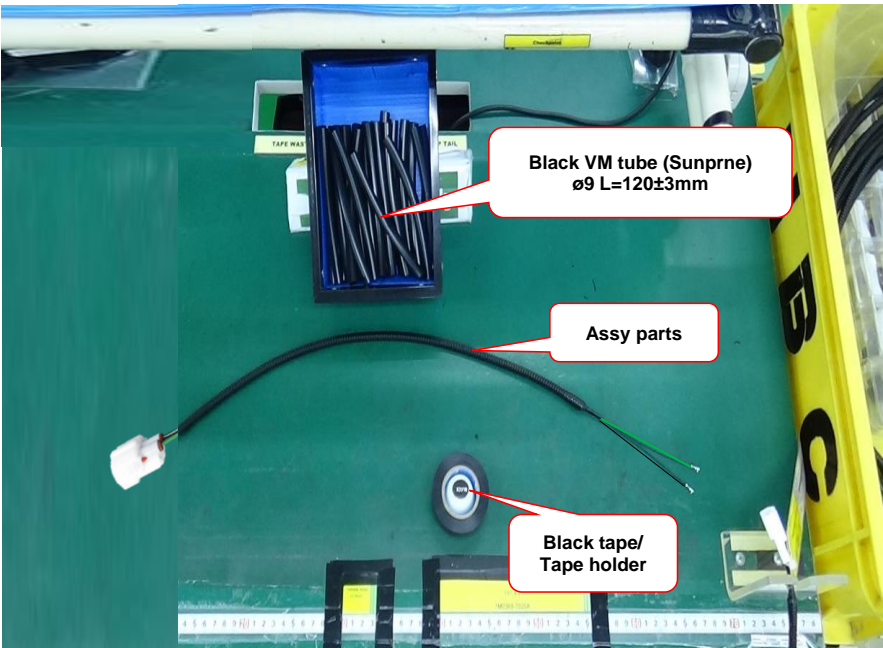

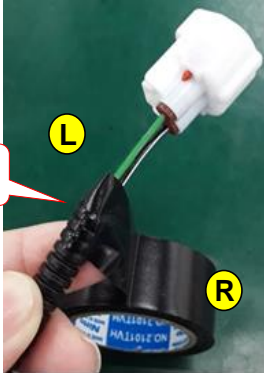
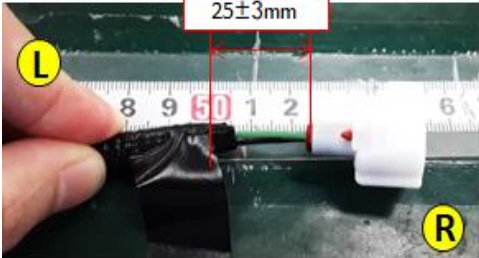
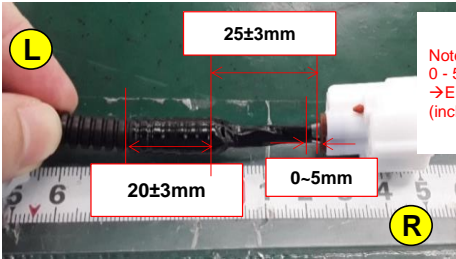

	WORK INSTRUCTION				Effectivity Date:		October 30, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 011B / 7M0364-7021B		Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-PDE-1144B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 5

PARTS:		1. Assy parts; Black VM tube (Sunprene) ø9 L=120±3mm; Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2	<div style="border: 1px solid red; padding: 5px; text-align: center;">Table Lay-out</div> 		<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by		
10/30/24	1	Change from Pre-launch to Masspro.						D.Castillo	C.Villanueva	A. Arañes	N/A					
10/22/24	0	Initial issue. Separate Clamp setting and Clamp assembly to Clamp assembly process and transfer COT to wire near connector taping from P1 due to process improvement. Inclusion of Car model "TOYOTA-CAMRY". Update Table lay-out, Measurement and Visual inspection/Quality checkpoints. Standardize term of VM tube (Sunprene).						D.Castillo	C.Villanueva	A. Arañes	N/A					
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		October 22, 2024		

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.	<div style="border: 2px solid green; padding: 10px; display: inline-block;"> NBC (Philippines) MASTER COPY </div>	DCC Stamp


	WORK INSTRUCTION				Effectivity Date:	October 30, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 011B / 7M0364-7021B		Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-1144B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 5


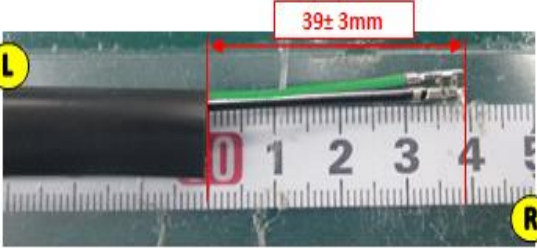



PARTS:	1. Assy parts 2. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 2 COT to wire near connector	<div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm 20±3mm 0~5mm</p><p>Note: 0 - 5mm → End tape up to connector (includes rubber seal)</p></div>	<div><p>MEASURING TAPE</p></div>	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of 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

	WORK INSTRUCTION			Effectivity Date:	October 30, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-1144B		
	Model code/Part number: 011B / 7M0364-7021B		Customer: TRJ	Car Model: TOYOTA-CAMRY	Revision No.: 1 Page No.: 3 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) ø9 L=120±3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black VM tube (Sunprene) ø9 L=120±3mm	 <p>1. Hold the VM tube (Sunprene) ø9 L=120±3mm using right hand then insert the G-B/W wires using left hand.</p>		n/a	1. No wrong use of parts 2. No damaged terminal
4	P2 Taping 2 Black corrugated tube to Black VM tube (Sunprene)	 <p>1. Measure from end of VM tube (Sunprene) up to terminal tip 39±3mm using both hands.</p>  <p>2. Hold the VM tube (Sunprene) using left hand and then start taping process using both hands.</p>  <p>3. After taping, check measurement and taping condition.</p>			Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure. 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

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 30, 2024

Model code/Part number:

011B / 7M0364-7021BCustomer: **TRJ**Car Model: **TOYOTA-CAMRY**

Document No.:

WI-ENG-PDE-1144B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 5**PARTS:**

1. Assy parts

JIG:

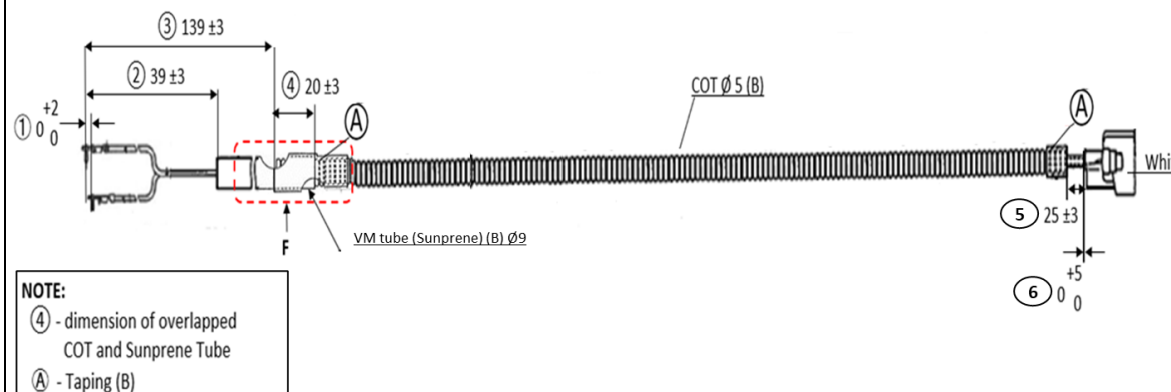
n/a

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

5

P2

Measurement

**MEASURING TAPE****Important reminders and note/s:****1. Please use calibrated/verified measuring tape when getting the measurement.****2. For Hatsumono, Nakamono and Owarimono.****Document reference/s:****1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection****1. 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 30, 2024

Model code/Part number:

011B / 7M0364-7021BCustomer: **TRJ**Car Model: **TOYOTA-CAMRY**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1144B

Revision No.:

1

Page No.:

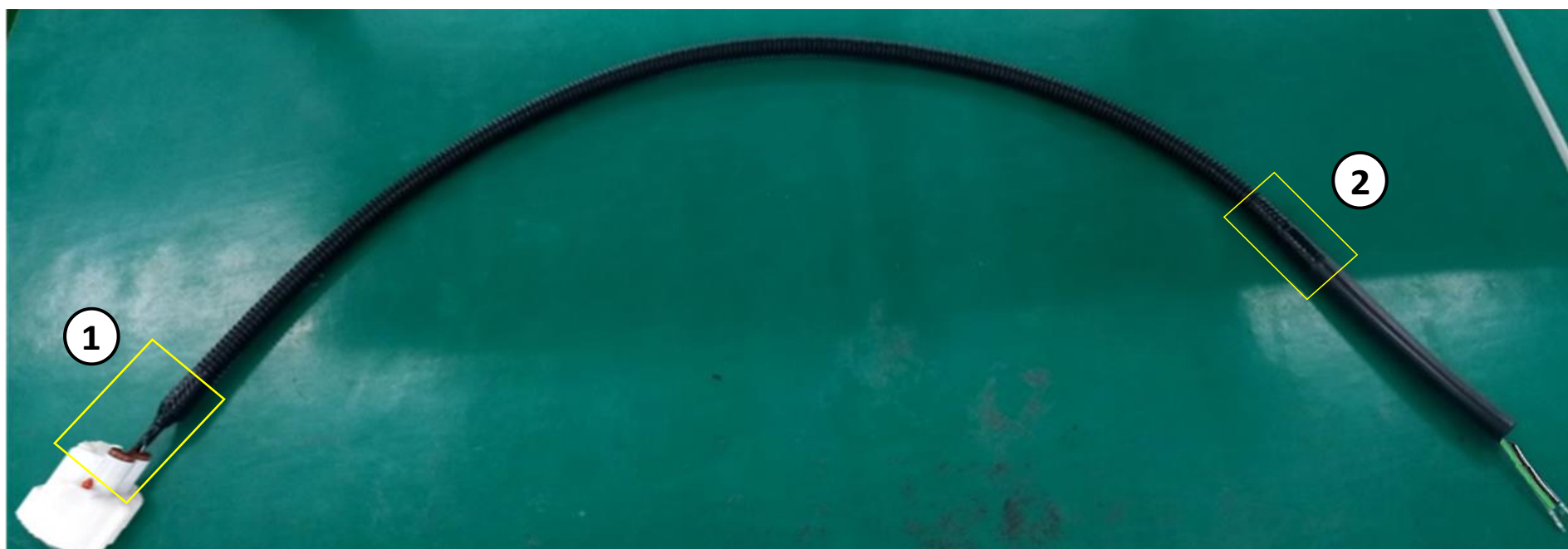
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS**TAPING - P2****7M0364-7021B****1 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