



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 05, 2024

Model code/Part number:

310B / 7M0524-7020C

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

8

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

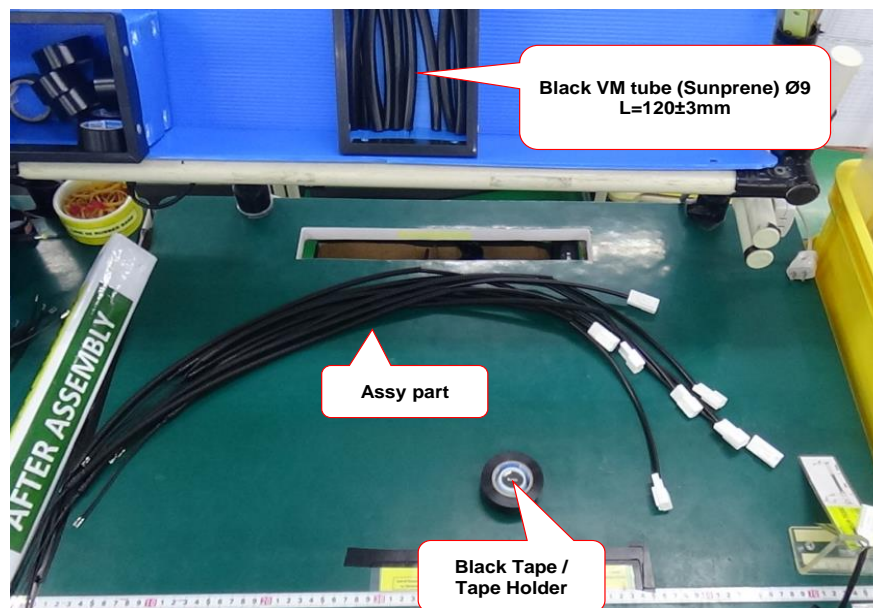
QUALITY POINTERS

1

P2

Table lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tool


Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/05/24	8	Transfer Taping 2 COT to SV tube taping from P1. Update Table lay-out and Visual inspection/ Quality checkpoint. Additional Quality pointers "No insufficient tape" and add document references (Page 2-3) as countermeasure to customer claim. Inclusion of Measurement.	D.Castillo	C.Villanueva	A. Arañes	n/a				n/a
07/28/23	7	Update template; Inclusion of CAR MODEL "TOYOTA-RAV4". Update Table lay-out illustration; Transfer process no.2 and 3 from P1 to P2; Transfer process of Taping from COT to SV tube (Vinyl) to from P2 to P1; Transfer process of P3 to CLAMP ASSEMBLY PROCESS due to new process distribution. Standardized tube description: VM tube (Sunprene). (Please refer to ENGDRR-126 for Document revision request)	M Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/28/23	6	Inclusion of Quality checkpoints.	J. Loterte	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 30, 2022		


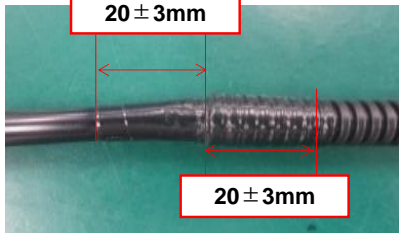


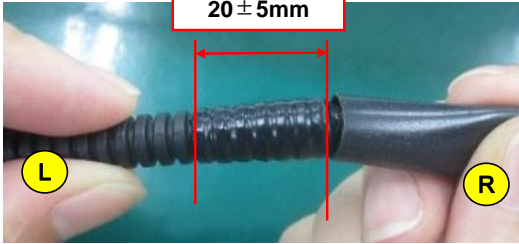
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY


DCC Stamp

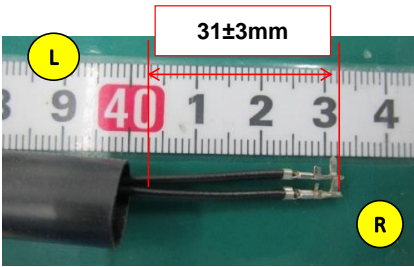


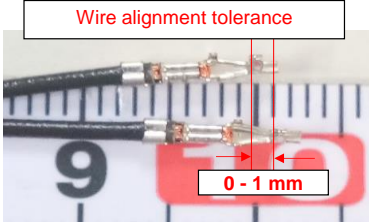
	WORK INSTRUCTION			Effectivity Date:	December 05, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	310B / 7M0524-7020C	Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-163B	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	8	Page No.: 2 of 5



PARTS: 1. Assy parts 2. Black VM tube ø9 L=120±3mm 3. Black tape	JIG:	n/a
--	------	-----

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Taping 2 Black Corrugated tube to Black SV tube (Vinyl)	  <p>1. Hold the corrugated tube using left hand, get Black tape and start taping using right hand.</p> <p>2. After taping, Check the measurement and taping condition</p>		Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001A for Taping process 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 7. No insufficient tape
3	Wire insertion to Black VM tube ø9 L=120±3mm	  <p>1. Hold the 2 Black wires using left hand and insert the VM tube (Sunprene) ø9 L=120±3mm using right hand.</p> <p>2. Insert the VM tube (Sunprene) to COT 20mm</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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: 5px; text-align: center;"> NBC (Philippines) MASTER COPY </div>	<div style="text-align: right;">DCC Stamp</div>
--	--	---

	WORK INSTRUCTION			Effectivity Date:	December 05, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310B / 7M0524-7020C		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-163B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	8	Page No.:	3 of 5

PARTS: 1. Assy parts 2. Black tape		JIG:		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Taping 3 Black Corrugated tube to Black VM tube (Sunprene)	<div>  <p>31±3mm</p> <p>Start of taping</p> </div> <div> <p>1. Hold the corrugated tube $\varnothing 5$ L=438±4mm (no slit) using left hand and measure the VM tube (Sunprene) up to terminal tip 31±3mm.</p> </div> <div> <p>2. Hold the COT using left hand and Start taping process using right hand.</p> </div> <div>  <p>20±3mm</p> <p>31±3mm</p> <p>20±3mm</p> <p>3. After taping, check the dimension, terminal appearance and taping condition.</p> </div>	<div> <p>MEASURING TAPE</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 7. No insufficient tape</p> </div> <div> <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p> </div>	<p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references: 1. Refer to WI-PRO-ASY-001A for Taping process</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.	<div>  </div>	<div>  </div>
--	--	--

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 05, 2024

Model code/Part number:

310B / 7M0524-7020CCustomer: **TRJ**Car Model: **TOYOTA-RAV 4**

Document No.:

WI-ENG-PDE-163B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:


8

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	<div>MEASURING TAPE</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 and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>
			<p>NOTE: ④ - overlapping of Sunprene and COT Ⓐ - Taping (B) *Unit of dimension is in millimeter (mm)</p>	

MEASURING 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:

December 05, 2024

Validity Date:

n/a

Model code/Part number:

310B / 7M0524-7020CCustomer: **TRJ**

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-163B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

8

Page No.:

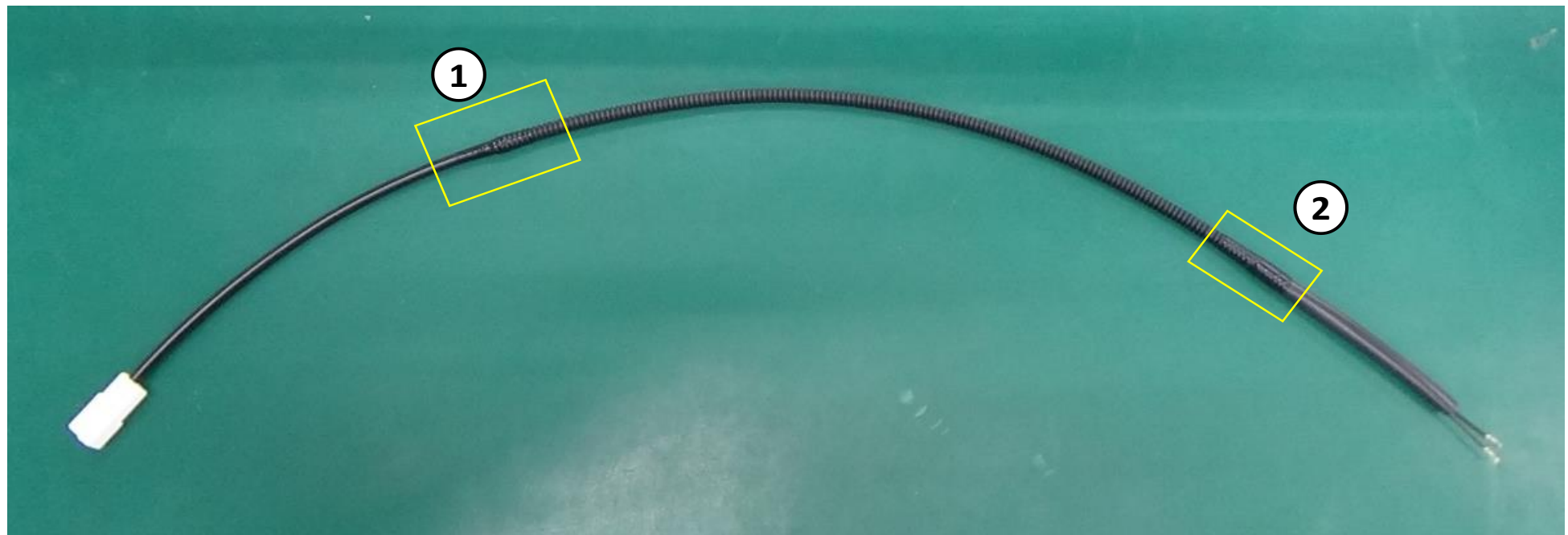
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7M0524-7020C****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