



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-977

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=341±2mm;

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

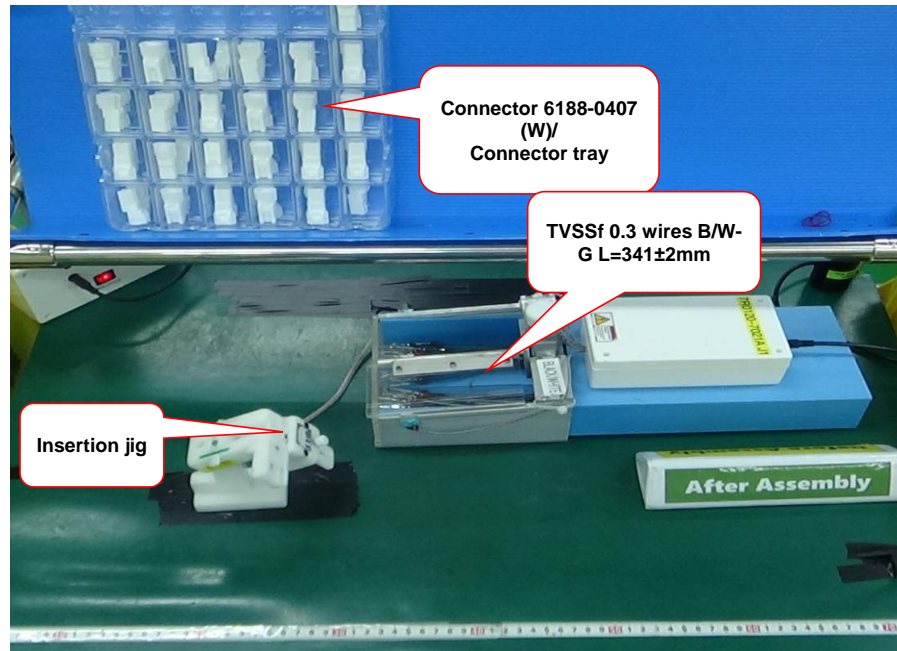
QUALITY POINTERS

1

n/a

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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
08/15/24	1	Change Pre-launch to Mass Production.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
08/08/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 08, 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.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Process Name/Title:

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Validity Date:

n/a

Document No.:

WI-ENG-PDE-977

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

PARTS:	1. Connector 6188-0407 (W)		JIG:	1.Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to Insertion jig 6188-0407 (W)	<div><div>INSERTION JIG WITH FLIP COVER</div><div><div><div>Visual reference</div><div>GREEN</div><div>BLACKWHITE</div><div>Insertion jig</div><div>Switch cover</div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div></div><div><div><div>L</div><div>↑</div><div>Press</div></div><div>1. Press the lock of insertion jig using left thumb.</div><div><div><div>1</div><div>2</div><div>B/W</div><div>G</div></div></div></div><div><div><div>L</div><div>↑</div><div>Press</div><div>R</div></div><div>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock.</div><div>Note: Refer to above illustration for correct setting.</div></div><div><div><div>L</div><div>↓</div><div>Release</div><div>R</div></div><div>3. Check the holes/terminal slot for B/W wire.</div></div></div>	n/a	<div>Connector Orientation Illustration</div> <div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div><div>I-mark is not align</div><div>1 hole is open</div><div>NG</div></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged 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

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Process Name/Title:

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

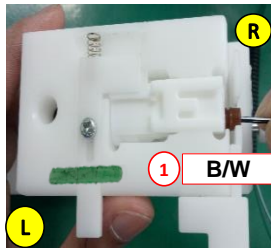
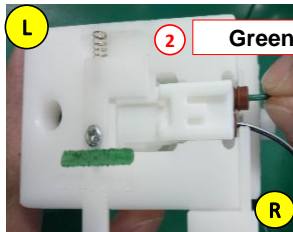
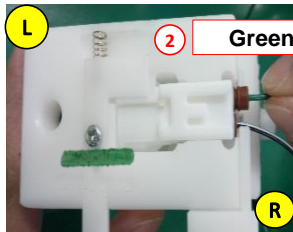
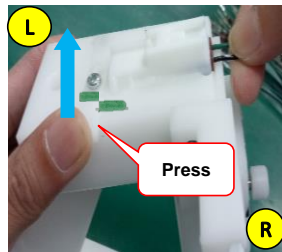

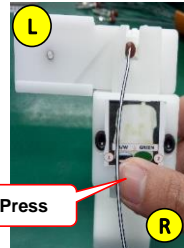
WI-ENG-PDE-977

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. TVSSf 0.3 wires G-B/W L=341±2mm		JIG:	1. Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div><div><p>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button using right hand. The slot for Green wire will be opened.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div><div><div><p>Wire facing</p></div><div><p>Press</p></div></div></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</p> <p>Do not exert extra force.</p> <p>3. Insertion of wires must be from left to right</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deformed terminal</p> <p>5. No wrong wire facing</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:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-977

Purpose:

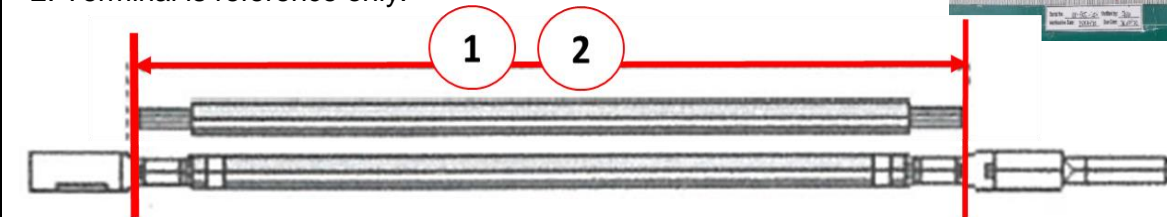
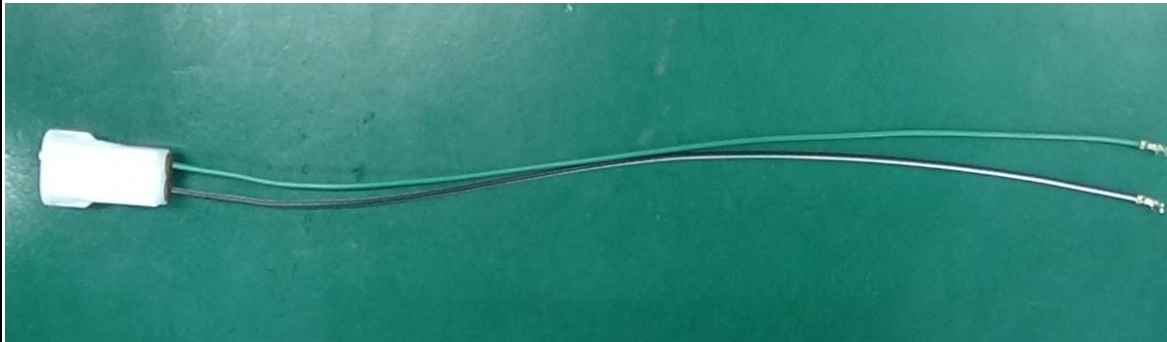
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 5

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   <p>Measuring tape</p>	<p>Important reminders and note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.	<ol style="list-style-type: none">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:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-977

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5

PARTS:

n/a

JIG:

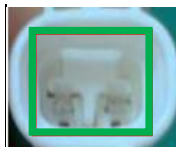
n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION

7R0120-7022

1



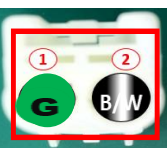
GOOD



GOOD

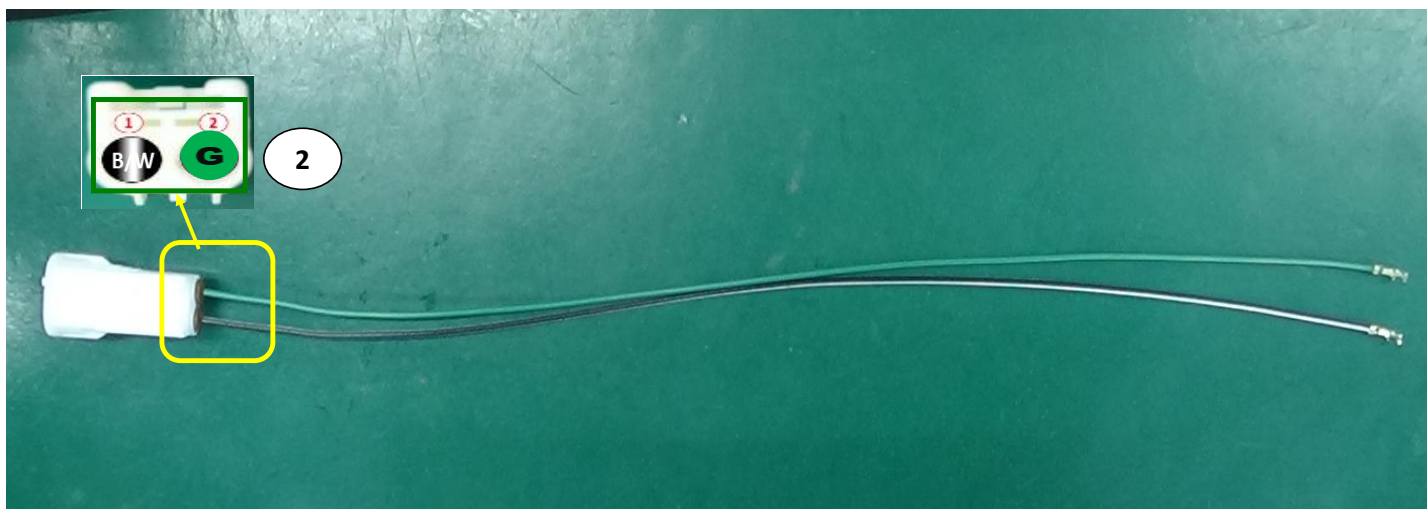


NO GOOD



NO GOOD

2



3

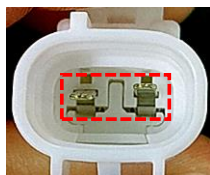


GOOD

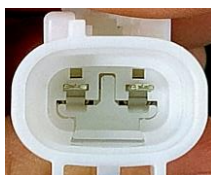


NO GOOD

4



NO GOOD



GOOD

1

No Locked Connector

2

No Wrong Insert

3

No Terminal Backing Out

4

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.

NBC (Philippines)
MASTER COPY

DCC Stamp