



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1141B

Revision No.:

1

Page No.:

1 of 5

PARTS: 1. Assy parts; Black tape

JIG:

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

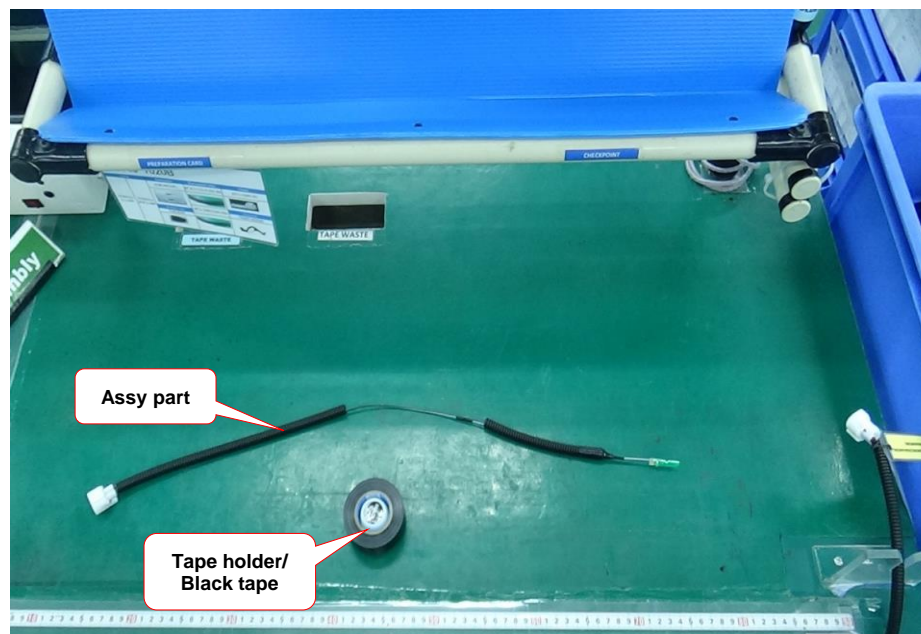
QUALITY POINTERS

1

P2

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear prescribed 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/tools.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/22/24 1 Change pre-launch to mass pro

A.Hernandez C.Villanueva A. Arañes n/a

10/17/24 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 17, 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

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Document No.:

WI-ENG-PDE-1141B

Purpose:

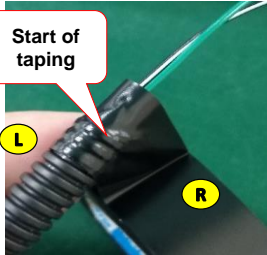
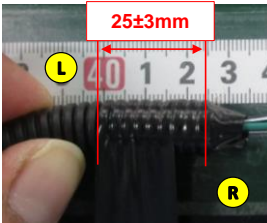
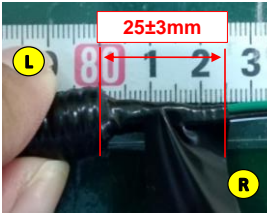

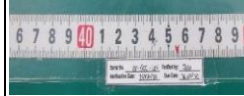
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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 Black COT (no slit) to wire near Taping 1 and PCB	 <p>Start of taping</p>  <p>25±3mm</p>  <p>25±3mm</p>  <p>25±3mm 25±3mm</p> <p>1. Hold the assy parts using left hand, get Black tape then conduct pre-taping using both hands.</p> <p>2. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p> <p>2. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p> <p>6. After taping, check the measurement and taping condition.</p>		 <p>Measuring tape</p>	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <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</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

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1141B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

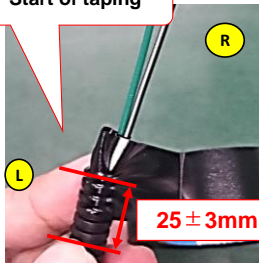
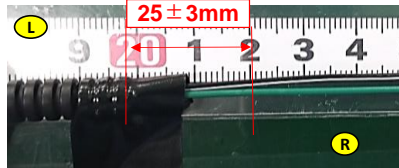
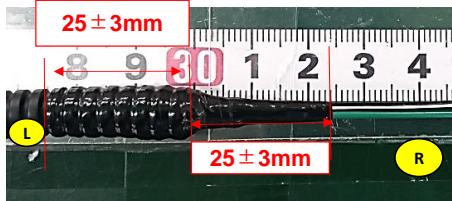


☒ MASSPRO

Revision No.:

1

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
3	P2	<div><p>Taping 3 Corrugated tube Ø7 L=248±2mm (no slit) to wire between the other COT</p></div> <div><p>Start of taping</p></div> <div><p>1. Get the Black tape using right hand then start taping process using both hand.</p></div> <div></div> <div><p>2. Measure from end of COT up to wire 25 ± 3mm then continue the taping process using both hands.</p></div> <div></div> <div><p>3. After taping, check the measurement and taping condition.</p></div> <div><p>Note: Proper Taping location</p></div>		<p>Measuring tape</p> 	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <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</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 22, 2024

Model code/Part number:

990B / 7N0143-7020D

Customer:

TRJ

Car Model:

TOYOTA PRIUS

Validity Date:

n/a

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
4	P2	Measurement	<p>Illustration</p> <p>NOTE: A - Taping (B) B - Taping (P) D - Protector (B) for item number ①, Dimension tolerance is different from the master drawing due to Internal change only.</p>	<p>MEASURING TAPE</p>	<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 Owarimono.</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 22, 2024

Validity Date:

n/a

Model code/Part number:

990B / 7N0143-7020DCustomer: **TRJ**Car Model: **TOYOTA PRIUS**

Document No.:

WI-ENG-PDE-1141B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

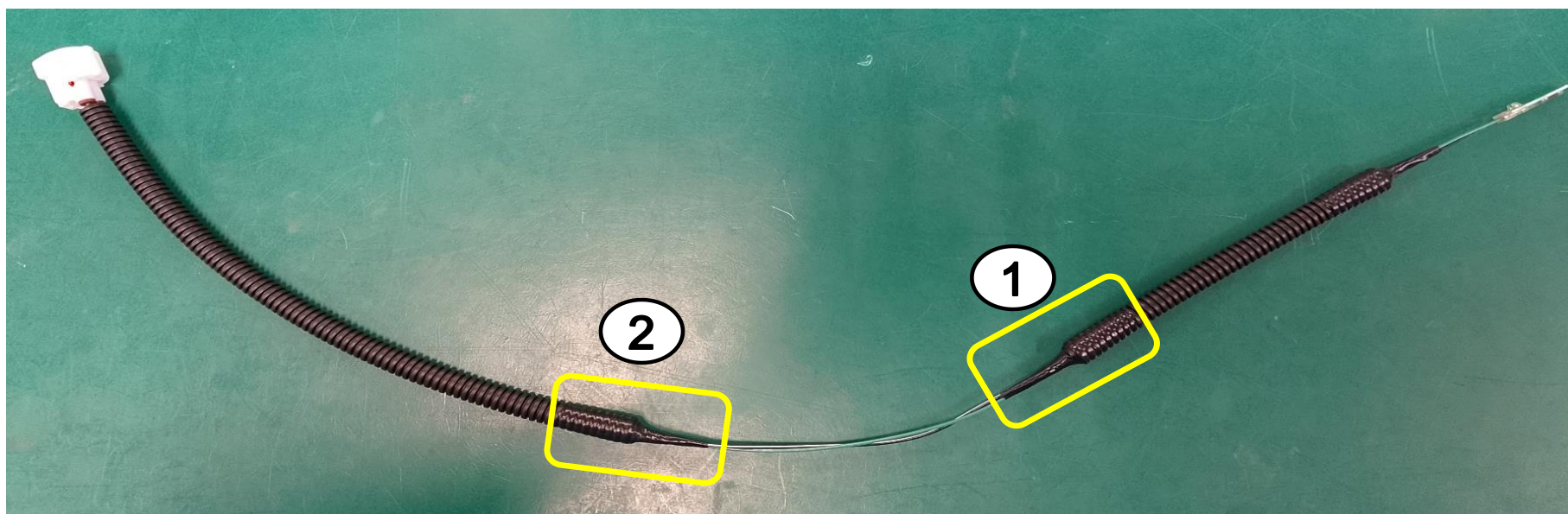
5 of 5

PARTS:

1. Assy parts

JIG:

N/A

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7N0143-7020D**

1 No Missing Tape
COT to wire near Taping1 and PCB

2 No Missing Tape
COT to wire between the other COT

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