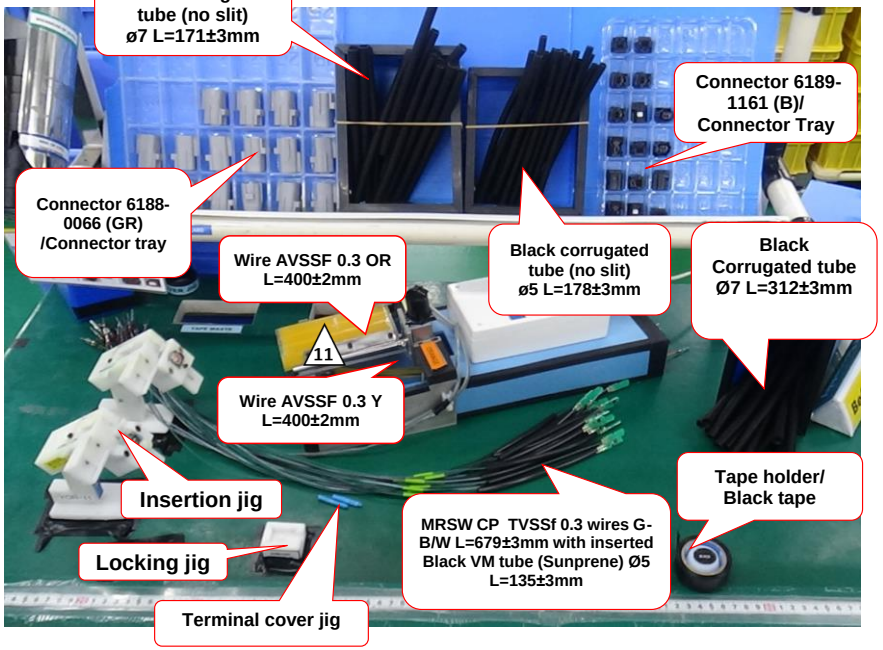
	WORK INSTRUCTION			Effectivity Date:	July 10, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	010B / 7L0033-7024	Customer: TRQSS / Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	11	Page No.:	1 of 10

PARTS:	1. Connector 6189-1161 (B);Connector 6188-0066 (GR); Black corrugated tube (no slit) ø5 L=178±3mm;Black corrugated tube (no slit) ø7 L=171±3mm; Black Corrugated tube Ø7 L=312±3mm; MRSW CP TVSSf 0.3 wires G-B/W L=679±3mm with inserted Black sunprene tube Ø5 L=135±3mm; Black tape;Wire AVSSF 0.3 ORANGE / YELLOW L-400mm	JIG:	1. Insertion jig with flip cover 2. Locking jig 3. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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.	***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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
07/10/24	11	Transfer wire insertion to assy parts from P1 and transfer COT to VM tube (Sunprene) Taping to P3 due to process improvement. Inclusion of car model "TOYOTA-CAMRY". Aligned switch cover to insertion jig. Update table lay-out, and Visual inspection.	D.Castillo	C.Villanueva	A. Arañes	n/a
04/24/23	10	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a
06/01/22	9	Remove and Transfer Process no.2 and 3 to Offline Assembly Process (WI-ENG-PDE-533). Transfer process no.2 from P2 due to process Improvement. Change Table Lay-out.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes

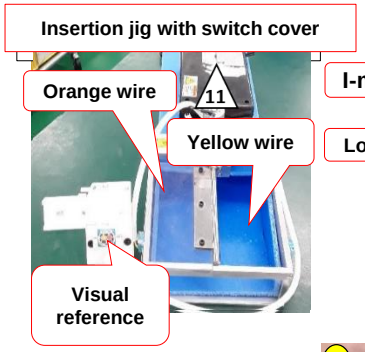
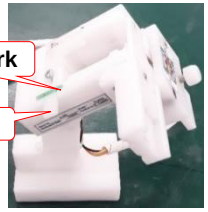
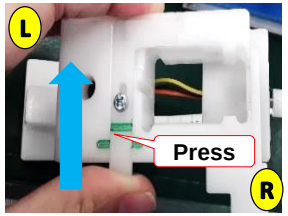
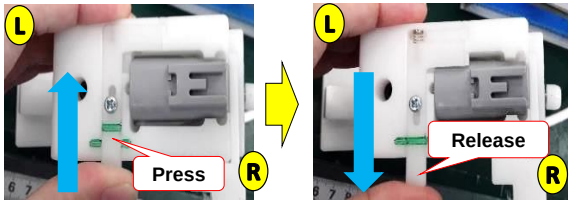
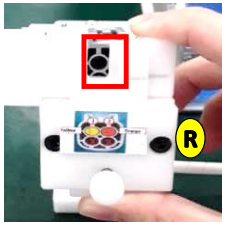
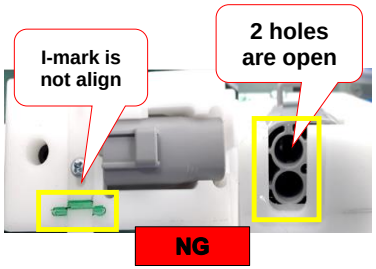
Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C.Villanueva	A. Arañes	n/a
Est. Date:	September 24, 2018		

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:	July 10, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 010B / 7L0033-7024	Customer: TRQSS	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	11	Page No.: 2 of 10

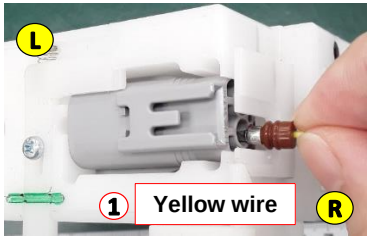
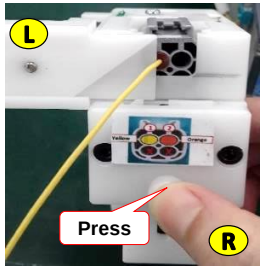
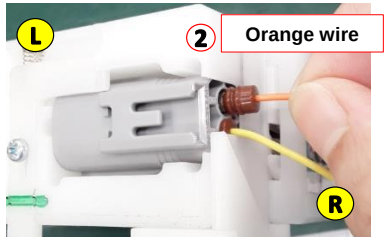
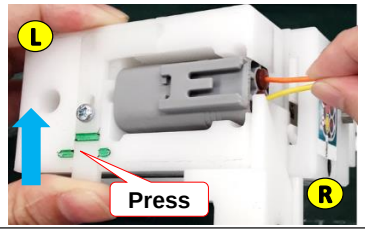
PARTS:	1. Connector 6188-0066 (GR)			JIG:	1. Insertion jig with switch cover
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	P1	Connector setting to insertion jig 6188-0066 (GR)	  INSERTION JG ORIENTATION CONNECTOR ORIENTATION  1. Press the lock using left hand.  2. Get the connector **6188-0066 (GR)** using right hand then insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.***  3. Push the lower wire guide upward using right hand. Slot for **Yellow wire** will be opened.	n/a	CONNECTOR ORIENTATION ILLUSTRATION  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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

PARTS:	1. AVSSf 0.3 Y L=400±2mm; OR L=400±2mm	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire Insertion to connector 6188-0066 (GR)	WIRE FACING  1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot **1** using right hand.  2. Press the button using right thumb. The slot for Orange wire will be opened.  3. Get the Orange wire then insert to terminal slot **2** using right hand.  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.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders /Note/s:*** ***1.Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***Document reference/s:*** ***1.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** ***2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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

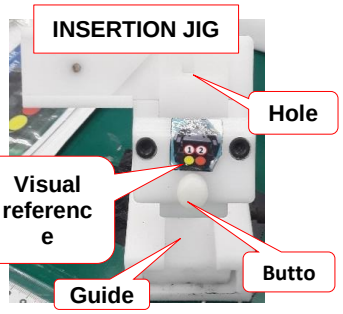
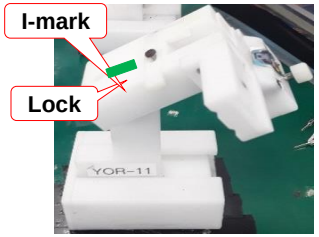
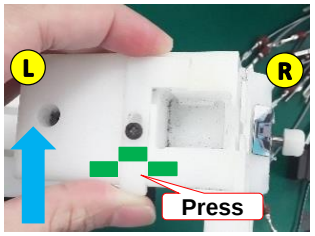
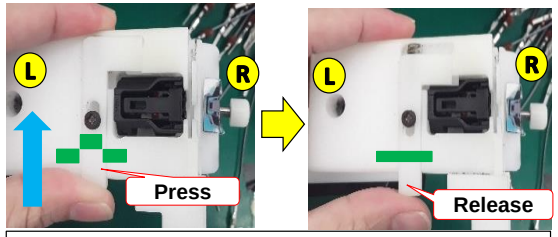
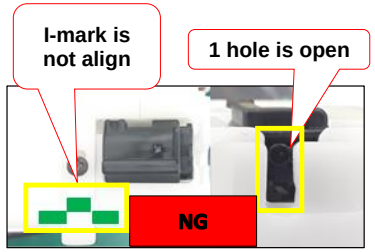
PARTS:	1. Assy parts 2. Black corrugated tube (no slit) Ø7 L=171±3mm 3. Black corrugated tube (no slit) Ø5 L=178±3mm	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	11 Wire Insertion to Corrugated tube (no slit) Ø7 L=171±3mm	 1. Hold the wires using left hand. Get the Corrugated tube (no slit) ø7 L=171±3mm using right hand then insert the Yellow- Orange wires using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Black corrugated tube (no slit) Ø5 L=178±3mm	 1. Hold the wires using left hand. Get the Corrugated tube (no slit) ø5 L=178±3mm using right hand then insert the Y-OR wires using left hand.	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.

NBC (Philippines)
MASTER COPY

DCC Stamp

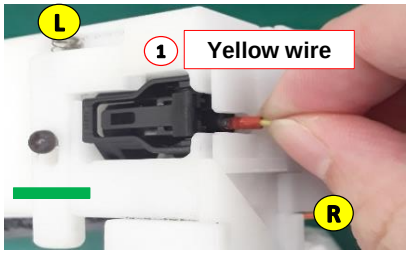
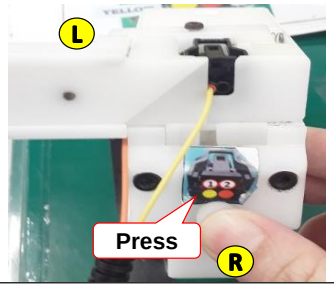
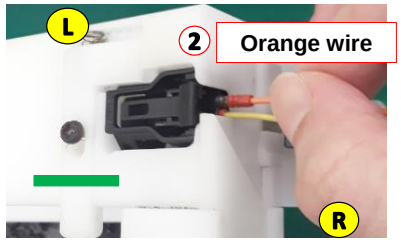
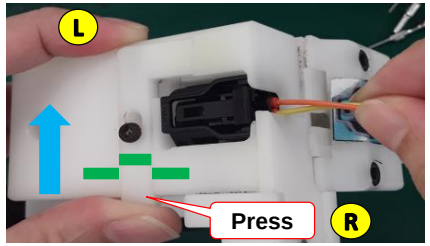
PARTS:	1. Connector 6189-1161 (B)			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
6	P1	Connector setting to insertion jig 6189-1161 (B)	  INSERTION JIG ORIENTATION CONNECTOR ORIENTATTON  1. Press the lock using left thumb.  2. Get the connector **6189-1161 (B)** using right hand then insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.*** 3. Push the lower wire guide upward using right hand. Slot for **Yellow wire** will be opened.	n/a	**CONNECTOR ORIENTATION ILLUSTRATION**  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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

PARTS:	1. Assy parts	JIG:	1. Insertion jig

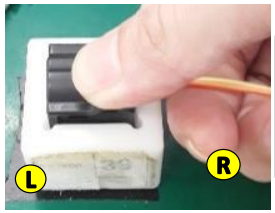
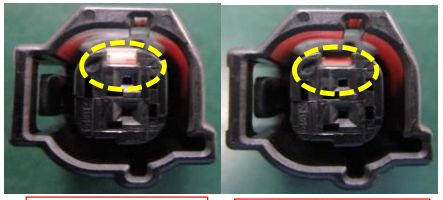
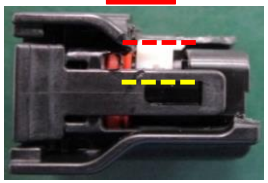
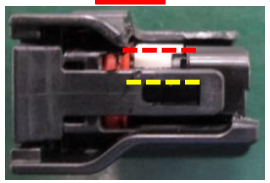
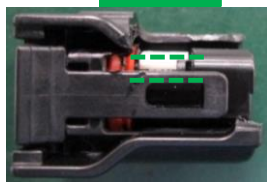
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire insertion to connector 6189-1161 (B)	 WIRE FACING  1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot **1** using right hand.  2. Press the button using right thumb. The slot for Orange wire will be opened.  3. Get the Orange wire then insert to terminal slot **2** using right hand.  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.	n/a	***Important reminders /Note/s:*** ***1.Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***Document reference/s:*** ***1.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** ***2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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

PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Connector lock	 1. Put the connector into locking jig and push down **2x** using both hands. Check the connector lock if properly locked.  BEFORE PRESSING AFTER PRESSING GOOD NO GOOD NG  UNLOCK CONDITION NG  HALF LOCKED CONDITION GOOD  FULLY LOCKED CONDITION	n/a	***Important reminders /Note/s:*** ***1.Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2.Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

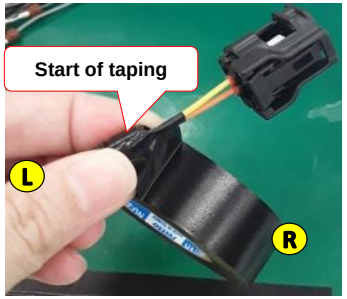
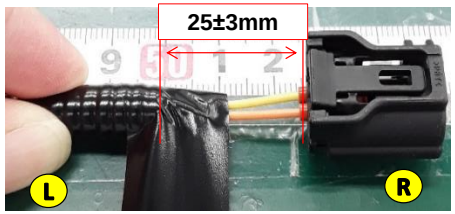
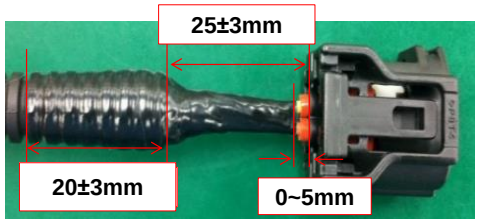
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	July 10, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	010B / 7L0033-7024	Customer: TRQSS / Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	11 / Page No.: 8 of 10

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

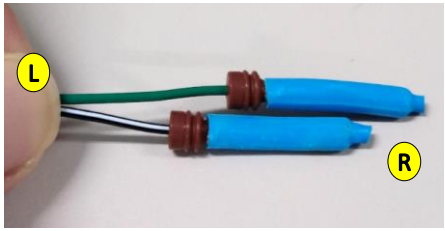
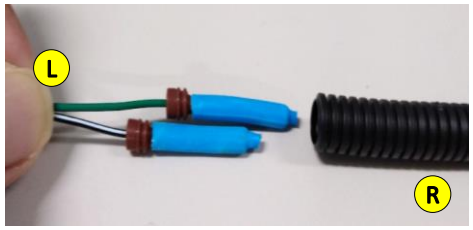
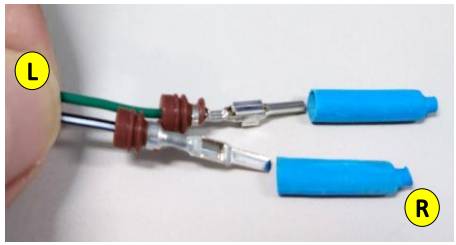
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Taping 1 COT to wire near connector	 1. Hold the assy parts using left hand, get **Black tape** then conduct pre-taping using both hands.  2. Hold the assy parts using left hand and measure from COT to connector **25±3mm** using both hands. Continue taping process using both hands.  3. After taping, check the measurement and taping condition. **NOTE: SET ASIDE THE ASSY PARTS.**	n/a	***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			Effectivity Date:	July 10, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 010B / 7L0033-7024	Customer: TRQSS	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	11	Page No.:	9 of 10

PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) Ø7 L=312±3mm			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
10	P1	Wire insertion to Black Corrugated tube (no slit) Ø7 L=312±3mm	 1. Get the terminal cover jig using right hand then insert to both terminals **(G-B/W wires)** using right hand.  2. Get the corrugated tube **Ø7 L=312±3mm** using right hand then insert the **G-B/W wires** using left hand.  3. After insertion, remove the cover jig using right hand.	**TERMINAL COVER JIG** 	1. No wrong usage of parts 2. No damaged rubber seal

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

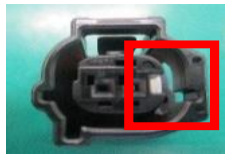
DCC Stamp

PARTS:	1. Assy parts	JIG:	n/a

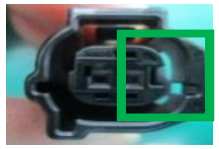
11 VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1	7L0033-7024

②



NO GOOD



GOOD

1. No Wrong insert
2. No Unlocked/Half-locked connector
3. No Missing tape
4. No Missing Parts

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