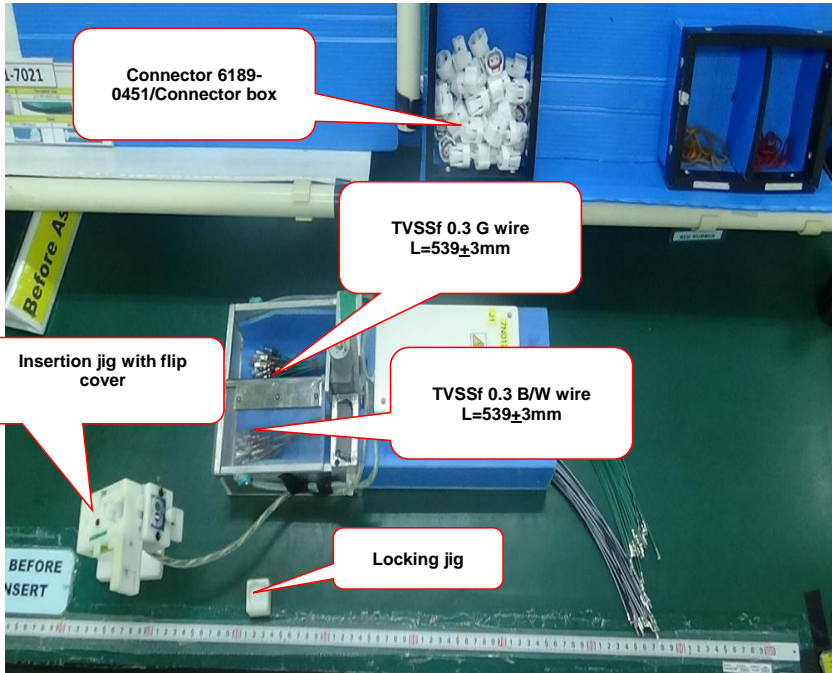
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>August 15, 2024</b>		
	<b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>		
	Process Name/Title:	<b>178D / 7N0127-7021</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-925</b>	
	Model code/Part number:				Revision No.:	<b>0</b>	Page No.: <b>1 of 6</b>
Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			

PARTS:	1. Connector 6189-0451 (W); TVSSf 0.3 G-B/W L=539mm±3mm; Black corrugated tube ø7 L= 469±3mm (no slit)			JIG:	1. Insertion jig with flip cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	Table Lay-out	<div>TABLE LAY-OUT</div> 	<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document references:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools</p>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
08/15/24	0	Initial issue. Separate Connector setting, Wire insertion to connector and connector lock process from Taping assembly process. Aligned switch cover to insertion jig.				D.Castillo	C.Villanueva	A. Arañes	N/A	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: August 15, 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**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**August 15, 2024**

Model code/Part number:

**178D / 7N0127-7021**

Customer:

**TRJ**Car Model: **TOYOTA-COROLLA**

Document No.:

**WI-ENG-PDE-925**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


2 of 6

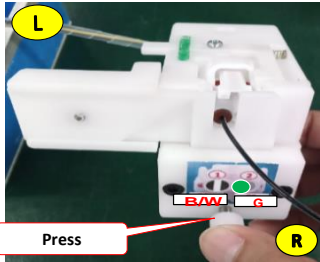

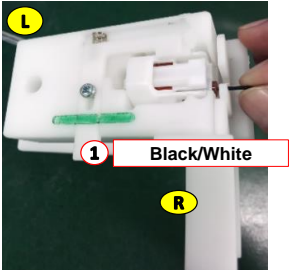
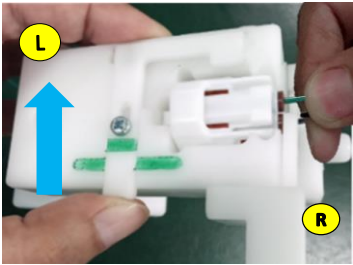
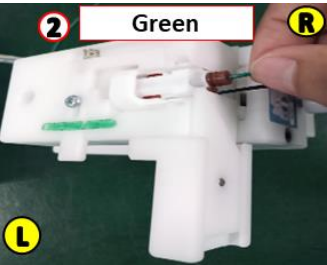
PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig with flip cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Offline	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>Insertion jig</div><div>G-wire</div><div>Switch cover</div><div>Wire guide</div><div>Holes</div><div>Wire guide</div><div>Button</div><div>B/W-wire</div></div><div>Connector Orientation</div></div></div> <div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div></div><div><div>R</div><div>Release</div></div></div> <div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</div><div><div>3. Push the guide using right hand. The slot for B/W wire will be open.</div><div><div>R</div></div></div></div> <td>n/a</td> <td><div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>1 hole is open</div><div>NG</div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></td>			n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>1 hole is open</div><div>NG</div></div></div> <div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>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

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>August 15, 2024</b>				
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: <b>178D / 7N0127-7021</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>		Document No.:	<b>WI-ENG-PDE-925</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:


<b>PARTS:</b>		1. TVSSf 0.3 Wires G L=539±3mm; B/W L=539±3mm		JIG:	1. Insertion jig with flip cover	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	Offline  Wire insertion to Connector 6189-0451 (W)	<div><p>1. Get the <b>B/W</b> wire then insert to terminal slot ① using right hand.</p><p>2. After insertion of <b>B/W</b> wire press the button using right hand. The slot for <b>G</b> wire will be open.</p></div> <div><p>3. Get the <b>G</b> wire then insert to terminal slot ② using right hand.</p><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>		n/a	<p><b>Important reminder/ Note/s:</b></p> <p>1. <b>Make sure wires are properly inserted.</b> 2. <b>Conduct Pull-Push-Pull-Push after insertion.</b> 3. <b>Do not exert extra force.</b></p> <p><b>Document references:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for <b>Wire and Strip Length Tolerance</b> 2. Refer to <b>GL-PRO-ASY-029</b> for <b>Pull-Push procedure.</b></p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>	

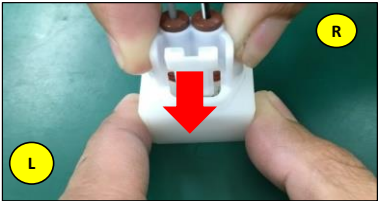

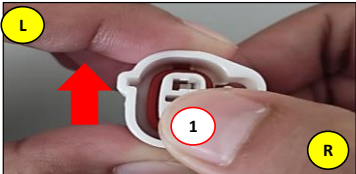
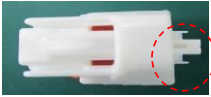




**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**

**MASTER COPY**

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	August 15, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 178D / 7N0127-7021		Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-925	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 6


PARTS:	1. Assy parts			JIG:	1. Locking jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
4	Offline	Connector lock	<div><div>1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div><div><div>GOOD</div><div>NG</div></div><div>Check the double lock deformation</div></div>			<div>LOCKING JIG</div> 	<p><b>Document references:</b></p> <p>1. Manual locking may cause damaged connector lock</p> <p>1. No wrong usage of parts 2. No deformed terminal</p>	

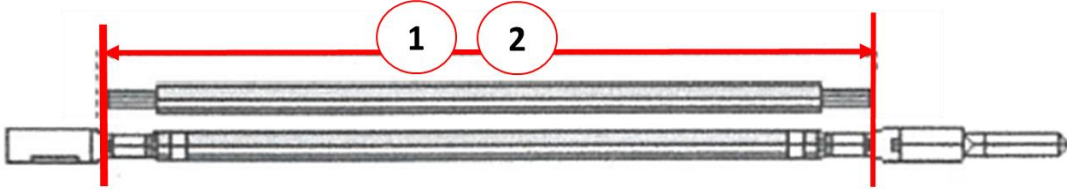
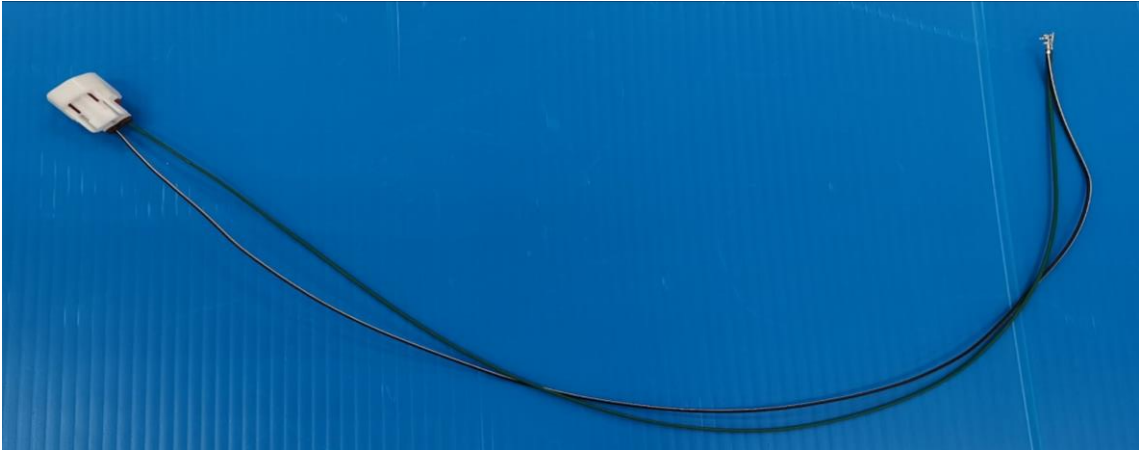

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>August 15, 2024</b>				
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: <b>178D / 7N0127-7021</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>		Document No.:	<b>WI-ENG-PDE-925</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		0	Page No.:

<b>PARTS:</b>		1. Assy parts		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div>	<div><b>MEASURING TAPE</b></div> 	<div><b>Important reminders and note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. For Hatsumono, Nakamono and Owarimono.</b></div> <div><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b></div> <div>1. No wrong dimension</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**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**August 15, 2024**

Validity Date:

n/a

Model code/Part number:

**178D / 7N0127-7021**

Customer:

**TRJ**

Car Model:

**TOYOTA-COROLLA**

Document No.:

**WI-ENG-PDE-925**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

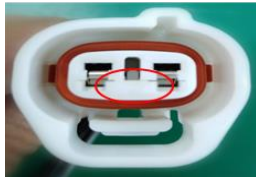
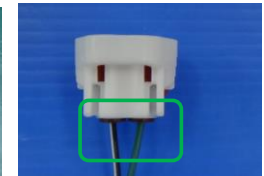
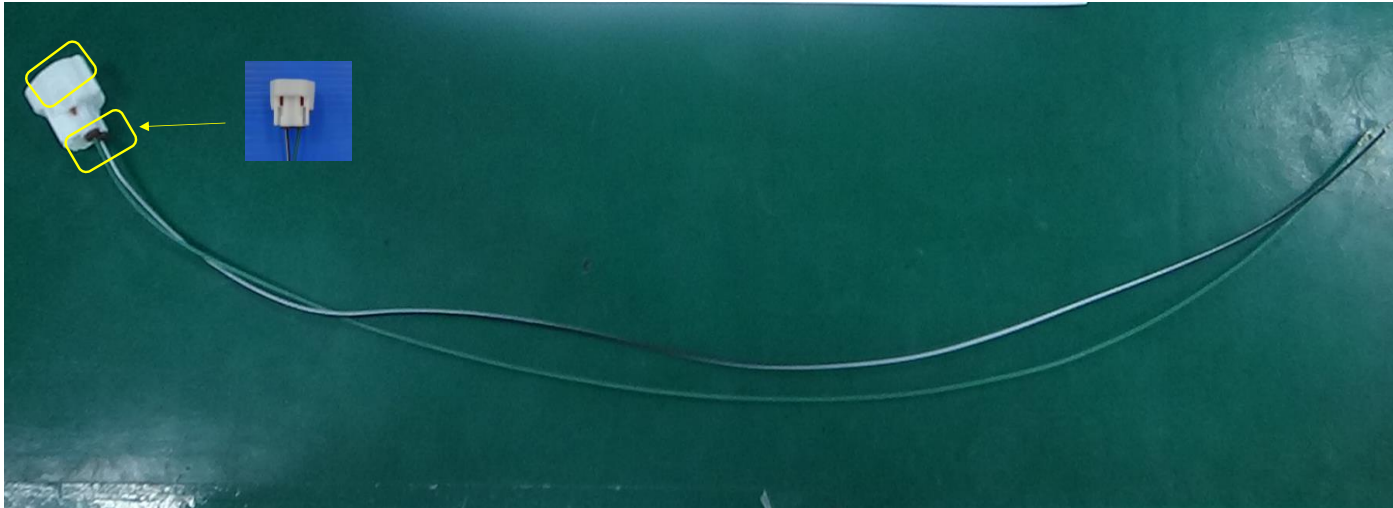
6 of 6

**PARTS:**

1.Assy Parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0127-7021A****GOOD****NO GOOD****GOOD****NO GOOD****1****No Unlocked/Half-locked connector****2****No Wrong insert****3****No Terminal Backing Out**

**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