NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PE QUALITY POINTERS Table Lay-out Safety Instruction Be sure to wear frequind-personal required personal required person				WORK INSTRUCTION						Effectivity Date:		25	
Purpose: PRESIDENT PRESIDENT PRESIDENT PRESIDENT PRESIDENT PRESIDENT PRESIDENT PROCESS NAME 1. Al parts: Connector 6098-3802 (W); Black corrugated tube (no sit) as L-6824emm; AVSSI 0.3 B wires L-8164amm; Black tape 1. Al parts: Connector 6098-3802 (W); Black corrugated tube (no sit) as L-6824emm; AVSSI 0.3 B wires L-8164amm; Black tape 1. Al parts: Connector 6098-3802 (W); Black corrugated tube (no sit) as L-6824emm; AVSSI 0.3 B wires L-8164amm; Black tape 1. Al parts: Connector 6098-3802 (W); Black corrugated tube (no sit) as L-6824emm; AVSSI 0.3 B wires L-8164amm; Black tape 1. Al parts: Connector 6098-3802 (W); Black corrugated tube (no sit) as L-6824emm; AVSSI 0.3 B wires L-8164amm; Black tape (no sit) as L-6824emm; AVSSI 0.3 B wires L-8164amm; Black tape (no sit) as L-6824emm; Black tape (no sit) as L	NE			Process Name/Title:						n/a			
ARTS: 1. Al partir: Connector 6098-3802 (W): Black corrugated tube (no sit) of L=852±6mm; AVSSI 0.3 B wires L=816±5mm; Black tape 1. Al partir: Connector 6098-3802 (W): Black corrugated tube (no sit) of L=852±6mm; AVSSI 0.3 B wires L=816±5mm; Black tape 1. Table Lay-out 1. No messing particlose 5. 2. Perforant Margins on the days of the control of the contr				Model code/Part number:	011B / 7M0367-7020A	Customer: TRJ	Car Model: TOYOTA	A-CAMRY	Document No.:		WI-ENG-PDE-17	4A	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION Table Lay-out Table Lay-out Black corrugated tube (no sitt) of Lessing Jig Black corrugated tube (no sitt) of Lessing Jig Black corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black Corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black Corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Black Corrugated tube (no sitt) of Lessing Jig AVSST 0.3 B wires Lessing Jig Avsst 1. No missing parts/lools 2. No excess parts/lools 1. No missing parts/lools 2. No excess parts/lools 2. No excess parts/lools 2. No excess parts/lools 2. No excess parts/lools 3. Approvisor or Line Leader for immediate corrective action. Avsst 1. Approvisor or Line Leader for immediate corrective action. Avsst 1. Approvisor or Line Leader for immediate corrective action. Avsst 1. Approvisor or Line Leader for immediate corrective action. Avsst 2. Approvisor or Line Leader for immediate corrective action. Avsst 2. Approvisor or Line Leader for immediate corrective action. Avsst 2. Approvisor or Line Leader for immediate corrective action. Avsst 2. Approvisor or Line Leader for immediate corrective action. Avsst 3. Approvisor or Line Leader for immediate corrective action. Avsst 3. Approvisor or Line Leader for immediate corrective action. Avss 4. Avss				Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	10	Page No.:	1 of 6	
Table Lay-out Safety Instruction Be sure to wear required personal protective equipment (gloves, finger cots, etc.)	PARTS:		1. Al p	. Al parts: Connector 6098-3802 (W); Black corrugated tube (no slit) ø5 L=652±6mm; AVSSf 0.3 B wires L= 816±3mm; Black tape									
Black corrugated tube (no slit) Finder P1 Table Lay-out Revision History Revisi	N	0.	F	ROCESS NAME	WORK P	ROCEDURE/ ILLUSTRA	ATION		TOOLS/PPE		QUALITY POIN	TERS	
Housekeeping 1. Maintain and always practice 5s. 2. Personal things on the workplace is prohibited. Keep it in your locker. Alert Level For any trouble, inform the Assembly Assistant Supervisor of Line Leader for immediate corrective action. Revision History Revision by Revision History Revisi					Connector 6098-3802 (W)	Black corrugated	E6mm`		Be sure to wear required persona protective equipm during operatior (gloves, finger col	Docun 1. Refer ent Wire and	to WI-PRO-CNC-	017 for	
Revision History Revision History Revision History Revision History Prepared by Reviewed by Approved by Noted by Approved by Noted by Oz/08/25 10 Additional Quality pointers "No insufficient tape" as countermeasure to customer claim. Improved Visual inspection/Quality Checkpoint. D.Castillo C. Villanueva A. Arañes n/a Transfer Offline process to Taping process assembly and transfer some process to P2 due to process improvement. Update table lay-out and Visual inspection/Quality checkpoints. Separate Clamp setting and Clamp assembly to Clamp assembly process (Wi-ENG-PDE-755) and update process sequence due to process improvement. Update Quality pointers (specify which part has a length of 25 +/- 3 and Tape width) as countermeasure to DCS (DC-0723-133). Inclusion of Car model TOYOTA-CAMRY. D.Castillo J. Loterte C. Villanueva A. Arañes D.C. C. Villanueva D.C. C. Vi	1		P1	Table Lay-out	Insertion	WALL PROPERTY.		Maintain and alw practice 5's. Personal things the workplace is prohibited. Keep it	vays 1. No miss on 2. No exce	1. No missing parts/tools			
Additional Quality pointers "No insufficient tape" as countermeasure to customer claim. Improved Visual inspection/Quality photocolory A. Arañes D. Castillo D. Castillo C. Villanueva A. Arañes D. Castillo C. Villanueva A. Arañes N/a D. Castillo					Locking Jig	J. 5 5 7 7 11 1 4 5			For any trouble, info the Assembly Assis Supervisor or Lin Leader for immedi	itant le ate			
checkpoint. D. Castillo	<u> </u>								Prepared by	Reviewed by	Approved by	Noted by	
table lay-out and Visual inspection/Quality checkpoints. D. Castillo D. Castillo	02/08/25	10			tape" as countermeasure to customer claim. Impro	oved Visual inspection/Quality	D.Castillo C. Villanueva	A. Arañes n	/a				
due to process improvement. Update Quality pointers (specify which part has a length of 25 +/- 3 and Tape width) as countermeasure to DCS (DC-0723-133). Inclusion of Car model TOYOTA-CAMRY. D. Castillo D. Castil)7/02/24	9				process improvement. Update	D.Castillo C. Villanueva	A. Arañes n	/a				
	12/15/23	8	due to pr	e to process improvement. Update Quality pointers (specify which part has a length of 25 +/- 3 and Tape width) as D.Castillo J. Loterte C. Villanueva A. Arañes						A. Aranes	n/a		
	ff. Date	Rev. No			Details of Change		Revised Reviewed	Approved No		November 3, 2017			



			WORK INS	Effectivity Date:	February 8, 2025					
		Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
		Model code/Part number:	011B / 7M0367-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-PDE-17	4A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	10	Page No.:	2 of 6	
PARTS:	1. Coni	nector 6098-3802 (W)				JIG:	1. Insertion jig			
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUSTF	RATION	TOOLS/PPE	(QUALITY POIN	ΓERS	
2	P1	Connector Setting to Insertion jig 6098-3802 (W)	INSERTION JIG Lock I-mark 1. Press the lock of insertion jig using left thumb.	Lock R Press 2. Insert the connector	CONNECTOR ORIENTATION I-mark Release or 6098-3802) (W) into jig using et he lock using left hand. 3. Check the holes/terminal slot for B-B wires.	N/A	I-mari al 1. Use the 2. No wron 3. No wron	Connector Orientillustration mark is align GOOD k is not All	holes are open bodel nnector	



			Effectivity Date:	February 8, 2025						
		Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number:	011B / 7M0367-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-PDE-17	′4A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	10	Page No.:	3 of 6	
PARTS:	1. Blac 2. AVS	k corrugated tube (no slit) a Sf 0.3 B/B wires L= 816±3r	⊅5 L=652±6mm nm [2pcs.]	JIG:	1. Insertio	1. Insertion jig				
NO.	F	PROCESS NAME	WORK F	PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE		QUALITY POIN	TERS	
3		Wire insertion to Black corrugated tube (no slit) ø5 L=652±6mm	1. Get the corrugated tube (no slit) Ø5 L=652±6mm using left hand and insert two (2) Black wires using right hand.		R	N/A	No wrong usage of parts No deformed terminal			
4	P1	Wire insertion to connector 6098-3802 (W)	1. Get the 1st B wire then insert to connector using right hand. Note: Insertion of wire must be from left to right.	2. Get the 2nd Eusing right hand R 3. After insertic thumb then ho	R B wire then insert to connector i. on, push the lock using left old the wires and gently pull out 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 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing			

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			WORK II		Effectivity Date:		February 8, 20	025	
		Process Name/Title:	TAP	Validity Date:	n/a				
		Model code/Part number:	011B / 7M0367-7020A	Customer: TR	J Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-PDE-1	74A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	10	Page No.:	4 of 6
PARTS:	1. Ass	/ parts				JIG:	1. Locking	jig	
NO.	ı	PROCESS NAME	WOR	K PROCEDURE/ ILLU	USTRATION	TOOLS/PPE	(QUALITY POIN	ITERS
5	P1	Connector Lock	1. Load the connector into the jig h both side of the connector, tip first. Right thumb-Lower Left thumb-middle 3. Press the lower parts of connector right hand while left hand holding the left thumb-middle Left thumb-middle 5. Lift then press the connector in the middle using left and right hand.	or using he middle. 4. Preshand with the following the middle of the following has been seen as the following the	Press the lower part of connector to fully ert into the locking jig. Right thumb-upper Left thumb-middle ses the upper part of connector using right while left hand holding the middle. Representation of the sequence illustrated.	LOCKING JIG	1. Use the 2. No unlo Import 1. MANU DAMAG 2. Use pavoid de Docum 1. Pleas the veri	provided locking ck/half-locked cordinate reminders DAL LOCKING MACED LOCK provided jig tool peamaged lock. The presence of the presence of the pressing of t	jig per model nnector s/note/s: AY CAUSED eer model to

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			WORK INS	Effectivity Date:	February 8, 2025					
		Process Name/Title:	TAPIN	NG ASSEMBLY PRO	CESS	Validity Date:		n/a		
		Model code/Part number:	011B / 7M0367-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-PDE-17	′4A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	10	Page No.:	5 of 6	
		parts k tape				JIG:	n/a	n/a		
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUST	RATION	TOOLS/PPE		QUALITY POIN	TERS	
6	P1	Taping 1 COT to wire near connector	1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping between COT to wire using both hands.	2. Measure form end of CO	131 ± 3mm 5 6 7 8 9 60 1 2 3 R OT up to terminal pointed tip he taping process using both hands	MEASURING TAPE	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 wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape			
			±31	mm neasurement, terminal alignm			Wire alignment tole	erance -1 mm		



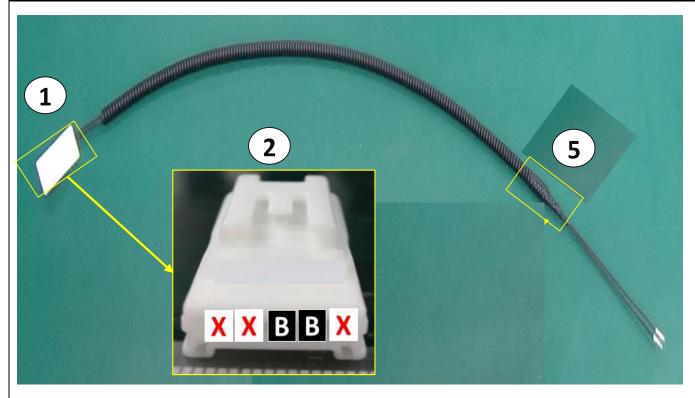
WORK INSTRUCTION				Effectivity Date:	February 8, 2025		
Process Name/Title:	TAPIN	Validity Date:	n/a				
Model code/Part number:	011B / 7M0367-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-PDE-1	74A
Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	10	Page No.:	6 of 6

PARTS: 1. Assy parts JIG: n/a

 $^{
u}$ visual inspection/ quality checkpoints

TAPING - P1

7M0367-7020A



- 1 No Unlocked/ Half-locked connector
- 2 No Wrong Insert
- 3 No Deformed terminal
- 4 No Terminal backing out
- 5 No Missing Tape

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