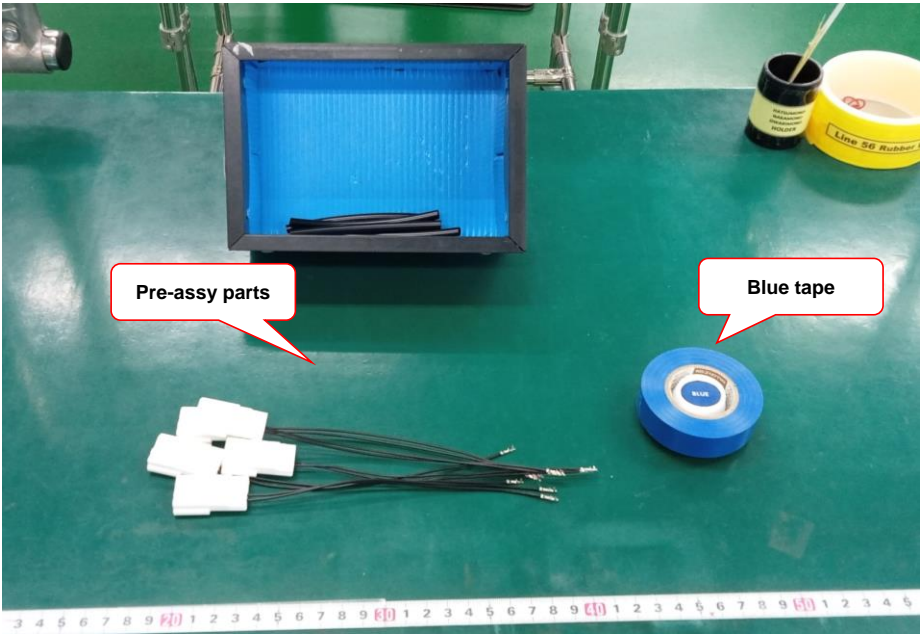
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS						Effectivity Date: April 11, 2025	
	Process Name/Title:						Validity Date: n/a	
	Model code/Part number: 310D / 7N0245-7020			Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1230	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.: 1 Page No.: 1 of 4	

PARTS: 1. Assy Parts 2. Black SV tube (Vinyl) $\phi 5$ L=93 \pm 3mm 3. Blue tape		JIG: n/a	
NO. 1	PROCESS NAME P1 Table Lay out	WORK PROCEDURE/ ILLUSTRATION <div style="text-align: center;">  </div>	
		TOOLS/PPE <div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	QUALITY POINTERS 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		Checked by		Reviewed by		Approved by	
04/11/25	1	Change pre-launch to masspro						A. Buban	J. Loterte	C. Villanueva	A. Arañes				
03/29/25	0	Initial issue						A. Buban	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Checked	Reviewed	Approved	Est. Date:	March 17, 2025		

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.	<div style="border: 2px solid green; padding: 5px; text-align: center;"> NBC (Philippines) MASTER COPY </div>	
	<div style="text-align: right;">DCC Stamp</div>	



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 11, 2025

Process Name/Title:

Model code/Part number:

310D / 7N0245-7020

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH




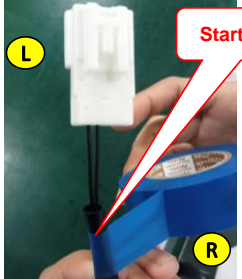
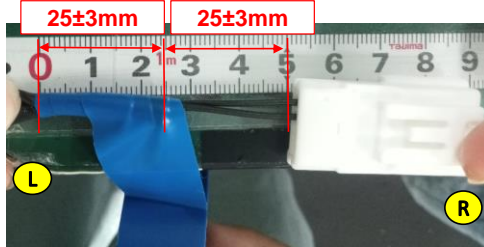
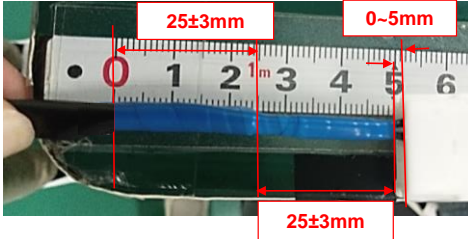
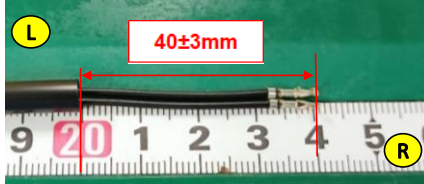

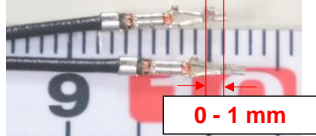
MASSPRO

Revision No.:

1

Page No.:

2 of 4

PARTS:		1. Black SV tube (Vinyl) $\phi 5$ L=93 \pm 3mm 2. Assy parts 3. Blue tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire Insertion to Black SV tube (Vinyl) $\phi 5$ L=93 \pm 3mm	 <div>1. Get the Black SV tube (Vinyl) $\phi 5$ L=93\pm3mm using right hand then insert the B-B wires.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal
3	P1 Taping 1 Corrugated tube to wire near Connector	 <div>Start taping</div>  <div>25\pm3mm 25\pm3mm</div> <div>1. Get the Blue tape using right hand then start taping process using both hands.</div> <div>2. Hold the COT using left hand and measure from end of COT up to connector 25\pm3mm.</div>  <div>25\pm3mm 0~5mm 25\pm3mm</div>  <div>40\pm3mm</div> <div>3. After taping, check the measurement, taping condition an wire alignment.</div>		 <div>Measuring tape</div>	 <div>Wire alignment tolerance 0 - 1 mm</div> <div>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</div> <div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping</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:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 11, 2025

Validity Date:

n/a

Model code/Part number:

310D / 7N0245-7020

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1230

Purpose:



PROTOTYPE



PRE-LAUNCH



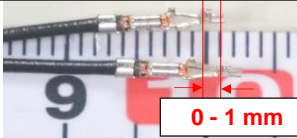
MASSPRO

Revision No.:

1

Page No.:

3 of 4

PARTS:	1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	n/a	<div>1. No wrong usage of parts 2. No deformed terminal</div> <div><div>Wire alignment tolerance</div><div></div></div> <div>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</div> <div><div>Important reminders/note/s:</div><div>1.Please use calibrated/verified measuring tape when getting the measurement.</div><div>Document reference/s:</div><div>1.Refer to WI-PRO-ASY-001 for taping</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**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 11, 2025

Validity Date:

n/a

Model code/Part number:

310D / 7N0245-7020Customer: **TRJ**

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1230

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

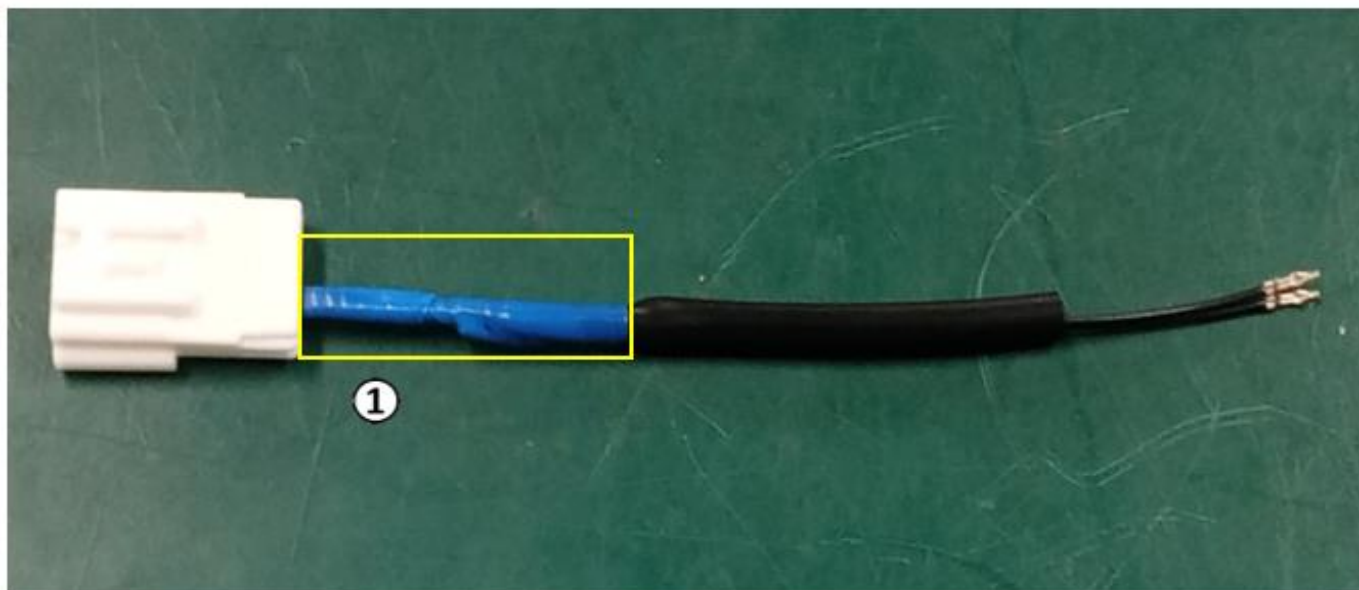
4 of 4

PARTS:

1. Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING P-1****7N0245-7020**

① **No Missing and No Wrong
used 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