



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1040

Revision No.:

1

Page No.:

1 of 9

PARTS:

1. Connector 6189-0451 (W); TVSSf 0.3 G-B/W L=565±3mm; Black Corrugated tube (No slit) ø5 L=470±4mm

JIG:

1. Insertion jig with switch cover
2. Locking jig
3. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

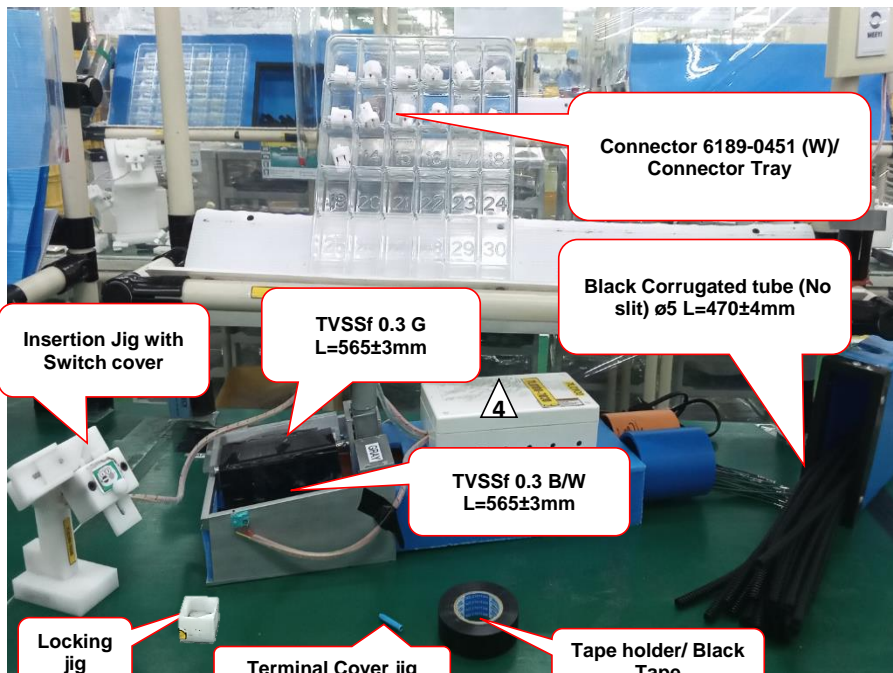
QUALITY POINTERS

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

Prepared by

Reviewed by

Approved by

Noted by

09/12/24 1 Change from Pre-launch to Masspro.

A.
HernandezC.
Villanueva

A. Arañes

n/a

09/09/24 0 Initial Issue

A.
Hernandez

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 09, 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

Process Name/Title:

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Document No.:

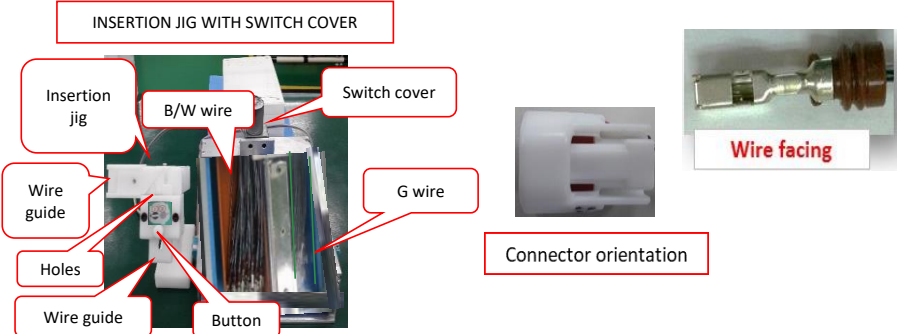
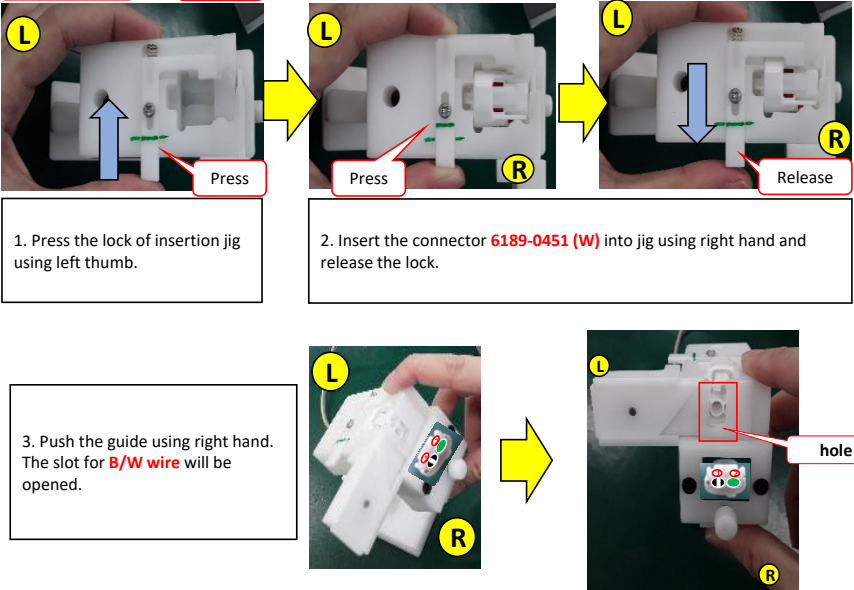
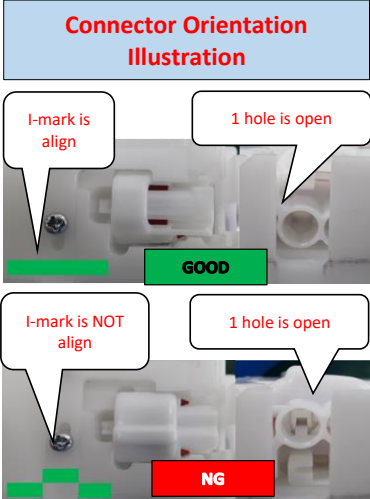
WI-ENG-PDE-1040

Revision No.:

1

Page No.:

2 of 9

PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6189-0451 (W)</p>   <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</p> <p>3. Push the guide using right hand. The slot for B/W wire will be opened.</p>		n/a	<p>Connector Orientation Illustration</p>  <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</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

Process Name/Title:

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Document No.:

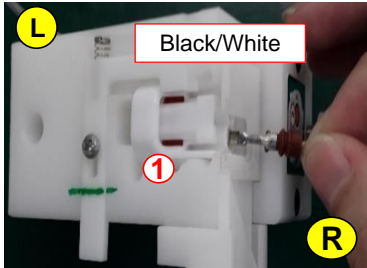
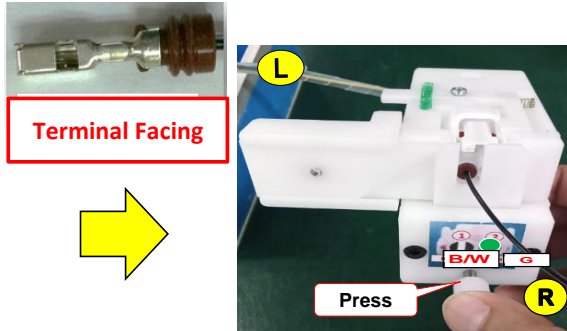
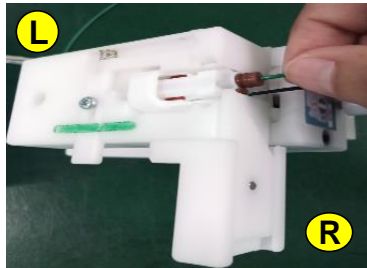
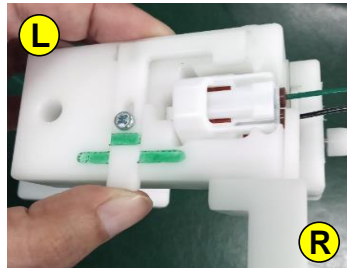
WI-ENG-PDE-1040

Revision No.:

1

Page No.:

3 of 9

PARTS:	1. Assy parts		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div><div><p>1. Get the B/W wire then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of B/W wire press the button using right hand. The slot for G wire will be open.</p></div><div><p>3. Get the G wire then insert to terminal slot ② using right hand.</p></div><div><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></div></div> <div>n/a</div> <div><p>Important reminders/Note/s:</p><p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>2. Please hold the wire near terminal during insertion.</p><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal</p></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

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Process Name/Title:

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1040

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



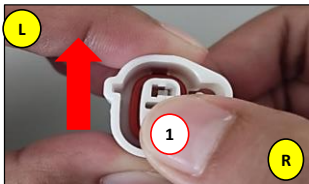
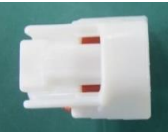




☒ MASSPRO

Revision No.:

1

Page No.:

4 of 9

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><p>1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>BEFORE PRESSING AFTER PRESSING</p></div> <div><p>GOOD NG</p><p>Check the double lock deformation</p></div>	<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. No half-locked and unlock 2. No lock deformation 3. Use provided jig tool to lock the connector</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**

Process Name/Title:

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Document No.:

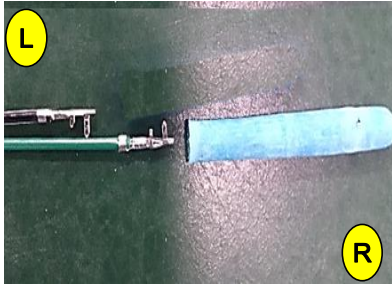
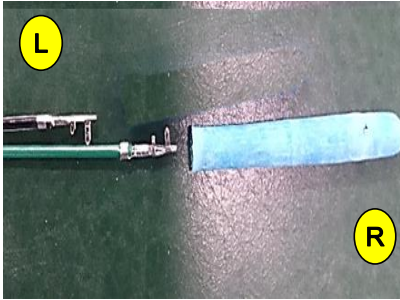

WI-ENG-PDE-1040

Revision No.:

1

Page No.:

5 of 9

PARTS:		1. Black Corrugated tube (No slit) $\phi 5$ L=470 \pm 4mm 2. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div><div></div><div><p>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</p><p>2. Get the Black Corrugated tube $\phi 5$ L=470\pm4mm (no slit) using right hand and insert to G-B/W wires using left hand.</p><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div><div>TERMINAL COVER JIG</div></div>	1. No wrong usage 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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Document No.:


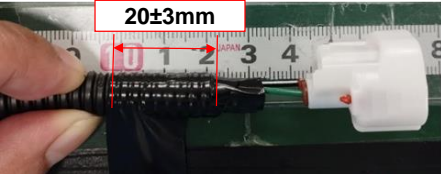

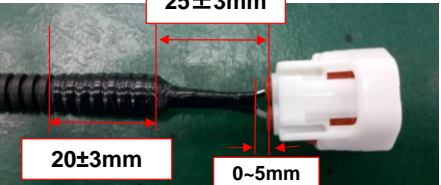

WI-ENG-PDE-1040

Revision No.:

1

Page No.:

6 of 9

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Corrugated tube to wire near connector	 <p>1. Hold the corrugated tube using left hand. Get Black tape using right hand and start pre-taping using both hands.</p>  <p>20±3mm</p> <p>2. Confirm measurement of tape width from end of tape up to end of COT then continue the taping process using both hands.</p>  <p>25±3mm</p> <p>3. Measure the end of the corrugated tube up to the edge of connector 25mm. Then continue taping using right hand.</p>  <p>25±3mm 20±3mm 0-5mm</p> <p>4. After taping, check the measurement and tape condition.</p>		MEASURING TAPE 	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 wrong dimension 5. No wrong use of tape 6. No missing 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

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Document No.:


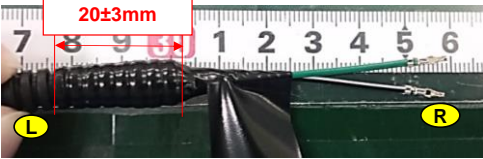
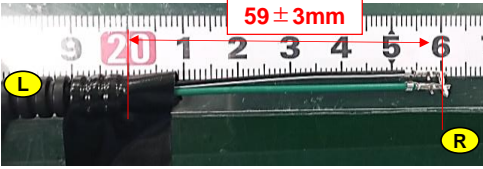

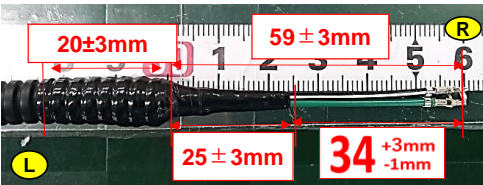

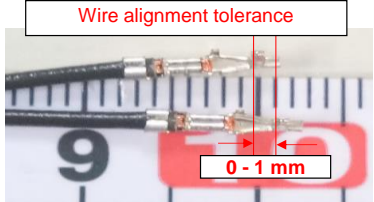
WI-ENG-PDE-1040

Revision No.:

1

Page No.:

7 of 9

PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 2 Corrugated tube to wire near terminal	 <p>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands.</p>  <p>2. Confirm measurement from end of tape up to end of COT (must be tape width) then continue the taping process using both hands.</p>  <p>3. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p>  <p>4. Measure from end of tape up to terminal pointed tip 34+3/-1mm then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, wire alignment and taping condition.</p>		<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>0 - 1 mm</p> <ul style="list-style-type: none">1. No flip-out tape2.No peel-off tape3. No loose tape4. No wrong dimension5. No wrong use of tape6. No missing 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**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Document No.:

WI-ENG-PDE-1040

Purpose:

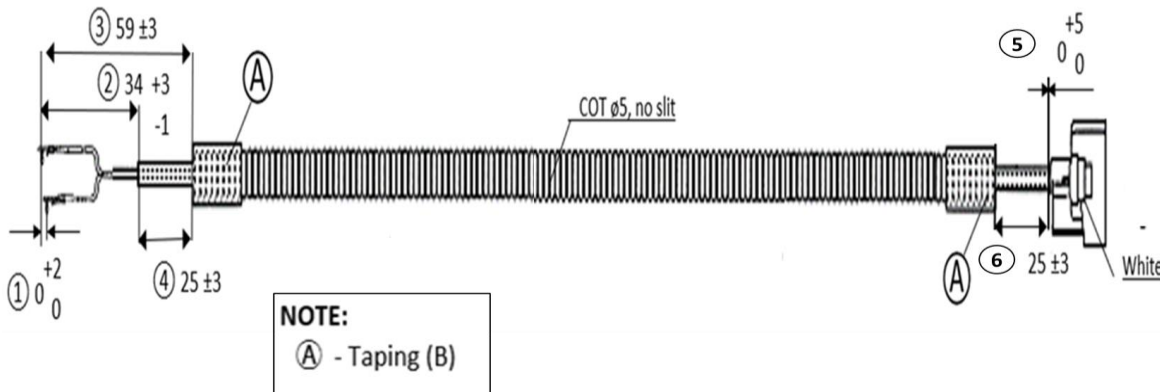

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

8 of 9

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Measurement	 <p>Technical drawing of a threaded rod with dimensions: (1) 0⁺²₀, (2) 34⁺³, (3) 59^{±3}, (4) 25^{±3}, (5) 0⁺⁵₀, (6) 25^{±3}. A note indicates (A) - Taping (B). A photograph of a measuring tape is included.</p> <p>NOTE: (A) - Taping (B)</p>	<p>MEASURING TAPE</p>  <p>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s: 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:

September 12, 2024

Validity Date:

n/a

Model code/Part number:

890B / 7L0100-7021A

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Document No.:

WI-ENG-PDE-1040

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

9 of 9

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

7L0100-7021A

1

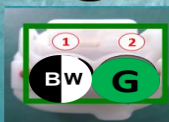


GOOD

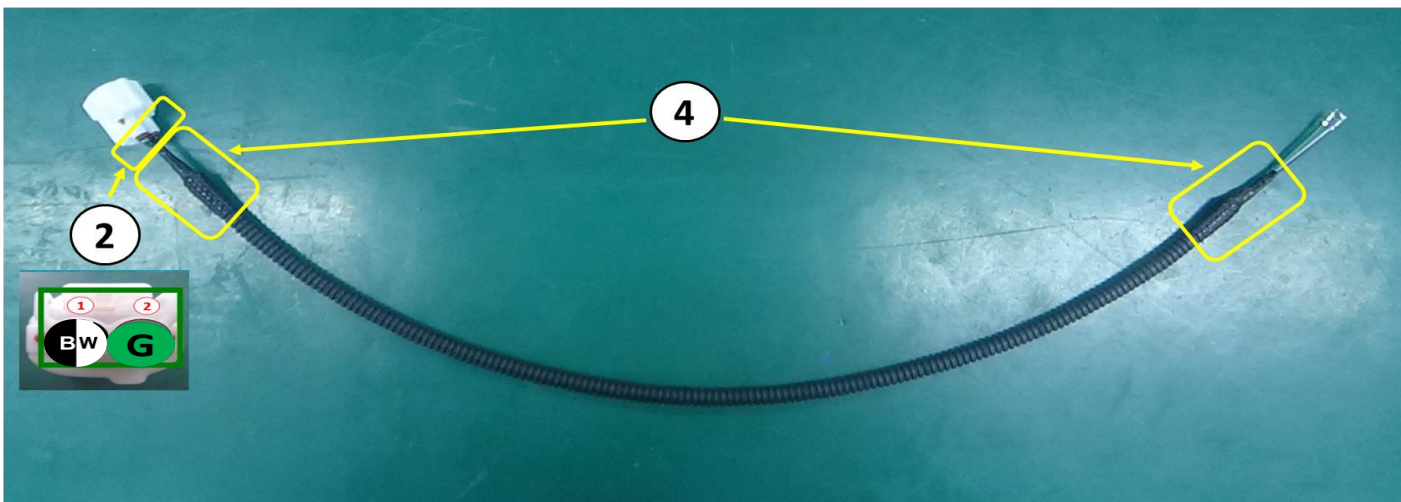


NO GOOD

2



4



3



GOOD



NO GOOD

1

No Unlocked / Halflocked Connector

3

No Terminal Backing Out

2

No Wrong Insert

4

No Missing 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