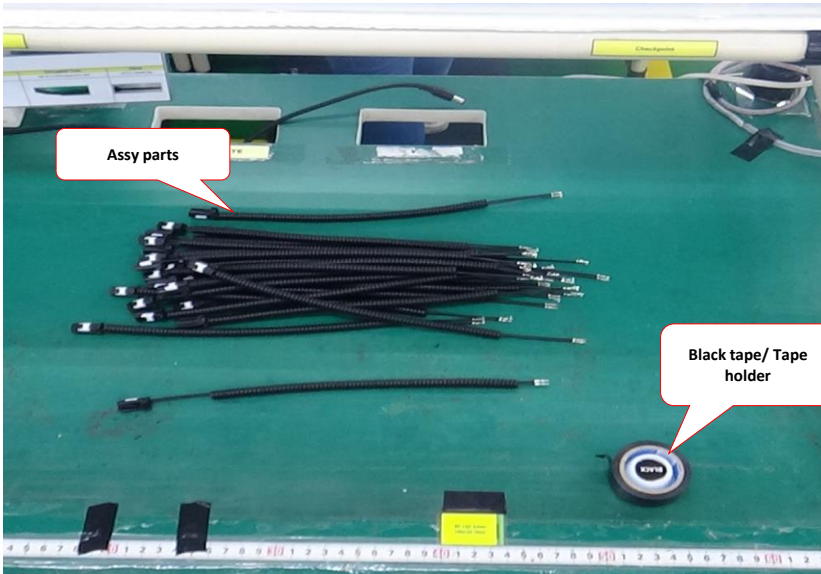





	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date: December 21, 2023	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: <b>200D/220D /7R0125-7022</b>		Customer: <b>TRMX</b>		Car Model: <b>TOYOTA-SEQUOIA</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-578</b>		Revision No.: 4	
Page No.:		4		1 of 3		

<b>PARTS:</b> 1. Assy parts 2. Black tape [1pc]		JIG: n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	P1  Table Layout	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;"> <b>Table Lay-out</b> </div> 	<div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <b>MEASURING TAPE</b>   </div>
		<b>Document references:</b> 1. Refer to WI-ENG-PDE-744 for Offline Assembly process  1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
12/21/23	4	Separate Connector setting, Wire insertion to connector, Connector lock and Wire insertion to COT process to Offline Assembly process (WI-ENG-PDE-744). Separate Clamp setting and Clamp assembly process to Clamp Assembly process (WI-ENG-PDE-754) due to process improvement. Update Table lay-out and Quality checkpoints.				D. Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
03/31/23	3	Work instruction improvement: Remove offline process. Inclusion of batching. Update table lay-out. Inclusion of Quality Checkpoints (Page 9).				D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
09/23/22	2	Improve quality pointers: References in process no.1 and 3 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 12, 2023		

<b>CONFIDENTIAL:</b> 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: 10px; text-align: center;"> <b>NBC (Philippines)</b>  <b>MASTER COPY</b> </div>	DCC Stamp
--	---	-----------



# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

200D/220D /7R0125-7022

Customer:

TRMX

Car Model:

TOYOTA-SEQUOIA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 21, 2023

Validity Date:

n/a

Document No.:

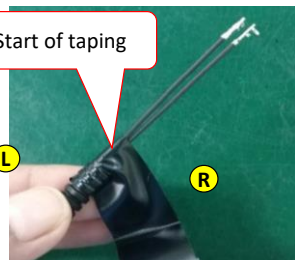
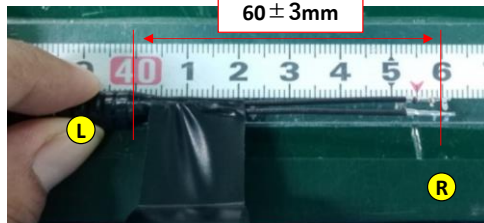
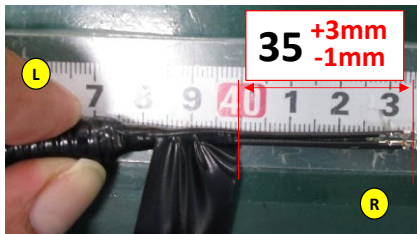
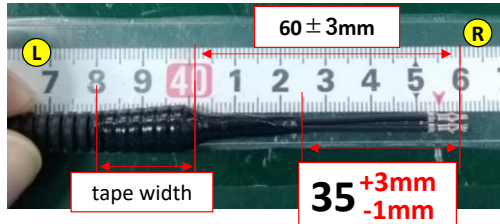

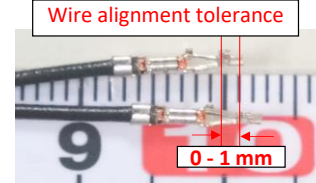
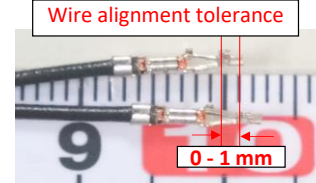
WI-ENG-PDE-578

Revision No.:

4

Page No.:

2 of 3

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1  Taping 1 COT to wire near terminal	<div><div><p>Start of taping</p></div><div><p>60 ± 3mm</p></div><div><p>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p></div><div><p>35 +3mm -1mm</p></div><div><p>60 ± 3mm tape width 35 +3mm -1mm</p></div><div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div><div><p>3. Confirm measurement of 35+3mm/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div><div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div></div> <div><p>MEASURING TAPE</p></div> <td><div><p>Wire alignment tolerance 0 - 1 mm</p></div><div><p>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</p></div><div><p><b>Important reminders/Note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p></div><div><p><b>Document references:</b></p><p>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</p></div></td>		<div><p>Wire alignment tolerance 0 - 1 mm</p></div> <div><p>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</p></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p><b>Document references:</b></p><p>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</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**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

December 21, 2023

Validity Date:

n/a

Model code/Part number:

**200D/220D /7R0125-7022**

Customer:

**TRMX**

Car Model:

**TOYOTA-SEQUOIA**

Document No.:

**WI-ENG-PDE-578**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

3 of 3

PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7R0125-7022****GOOD****NO GOOD****GOOD****NO GOOD****1****No UNLOCK / HALFLOCK  
CONNECTOR****3****No DEFORMED TERMINAL****2****No MISSING TAPE****4****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