			WORK INSTRUCTION		Effectivity Date:	July 02, 2024
		Process Name/Title:	TAPING ASSEMBLY PROC		Validity Date:	n/a
		Model code/Part number:	096D / 7L0119-7021A Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-393B
		Purpose:	PROTOTYPE PRE-LAUNCH	MASSPRO	Revision No.:	4 Page No.: 1 of 8
PARTS:		Assy parts; Black tape [1pc.]			JIG:	n/a
N	0.	PROCESS NAME	WORK PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	QUALITY POINTERS
1		P2 Table Lay-out	Assy parts Assy parts	Black tape/Tape holder	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.	No missing parts/tools No excess parts/tools
			Revision History	Prepared by	Reviewed by Approved by Noted by	
07/02/24	4		ENG-PDE-393A due to process improvement. Update table lay-out. Improved parate clamp seeting and clamp assembly process to Clamp assembly process.	D.Castillo C.Villanueva A. Arañes	n/a	
07/26/23	3	· · ·	Sunprene); SV tube (Vinyl) page no.3,10,11 and 13.	+ + + + + +	Arañes	Alas I
04/06/23		Align procedure no.4 in process no.5 in a process in jig	ctual due to elimination the resetting of alarm from time-to-time by the leader and the	ivi. Catapang J. Loterte C. Villanueva A. /	/	C.Villanueva A. Aranes n/a
Eff. Date	Rev. No		Details of Change	Revised Reviewed Approved N	loted Est. Date: Febr	uary 03, 2022



			WORK INS			Effectivity Date:		July 02, 2024	
		Process Name/Title:	TAPIN	G ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	096D / 7L0119-7021A	Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:		WI-ENG-PDE-39	3B
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	2 of 8
PARTS:	1. Assy 2. Black					JIG:	n/a		
NO.	F	PROCESS NAME	WORK F	PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(QUALITY POIN	TERS
2	P2	Taping 2 Black SV tube (vinyl) to wire near connector	25±3mm	start taping prod	1. Measure from end of SV tube (vinyl) up to end of connector 25±3mm using both hands. Stape using right hand then less using both hands. 3. After taping, check the measurement and taping condition.	6789 123456789	1. Please measure measure Doc. 1. Refer taping p 1. No flip-c 2. No peel 3. No loos 4. No miss 5. No wron	ument reference to WI-PRO-ASY-corocedure. but tape -off tape e tape	erified ting the ee/s:



			WORK INS	STRUCTION		Effectivity Date:		July 02, 2024	
		Process Name/Title:		IG ASSEMBLY PROC	ESS	Validity Date:		n/a	
		Model code/Part number:	096D / 7L0119-7021A		Car Model: TOYOTA-HIGHLANDER	Document No.:		WI-ENG-PDE-39	93B
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	3 of 8
PARTS:	1. Assy 2. Blac	parts k tape				JIG:	n/a		
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR/	ATION	TOOLS/PPE	(QUALITY POIN	TERS
3	P2	Taping 3 Black Cot to Black SV tube (vinyl) near connector		Start of tag 2. Get the Blar process using 20±3mm 20±3mm 20±3mm 40 1 2 3 4 the measurement and taping	ck tape and start taping both hands.		3. No loo 4. No mis 5. No wro 6. No wro 1.Pleas measur measur 1. Refe	el-off tape se tape ssing tape ong use of tape ong dimension ant reminders, e use calibrate ring tape when	ed/verified getting the ace/s:



			WORK INS	TRUCTION				Effectivity Date:	T	July 02, 2024	ļ
		Process Name/Title:	TAPIN	IG ASSEMBI	LY PROC	ESS		Validity Date:		n/a	
		Model code/Part number:	096D / 7L0119-7021A	Customer:	TRQSS	Car Model: TOYOTA-HIGH	HLANDER	Document No.:		WI-ENG-PDE-39	93B
		Purpose:	PROTOTYPE	PRE-LAUNCH		MASSPRO		Revision No.:	4	Page No.:	4 of 8
PARTS:	1. Assy 2. Blac	k tape						JIG:	n/a		
NO.	F	PROCESS NAME	WORK I	PROCEDURE/	ILLUSTRA	ATION		TOOLS/PPE	(QUALITY POIN	TERS
4	P2	Taping 4 Black Corrugated tube to Black VM tube (sunprene) near terminal	2. Fix the corrugated tube and St tube (vinyl) using both hands.	4 5 6 7 8	gated tube upoth hands. Start of the liprocess us	o to end of terminal of taping R Black tape and start taping ing both hands.	R	6 7 8 9 10 1 2 3 4 5 6 7 8 9 1	1. Pleas measur measur Doc 1. Refer taping p 1. No flip-c 2. No peel 3. No loos 4. No miss 5. No wror	ument reference to WI-PRO-ASY- procedure. but tape -off tape e tape	d/verified getting the ce/s:

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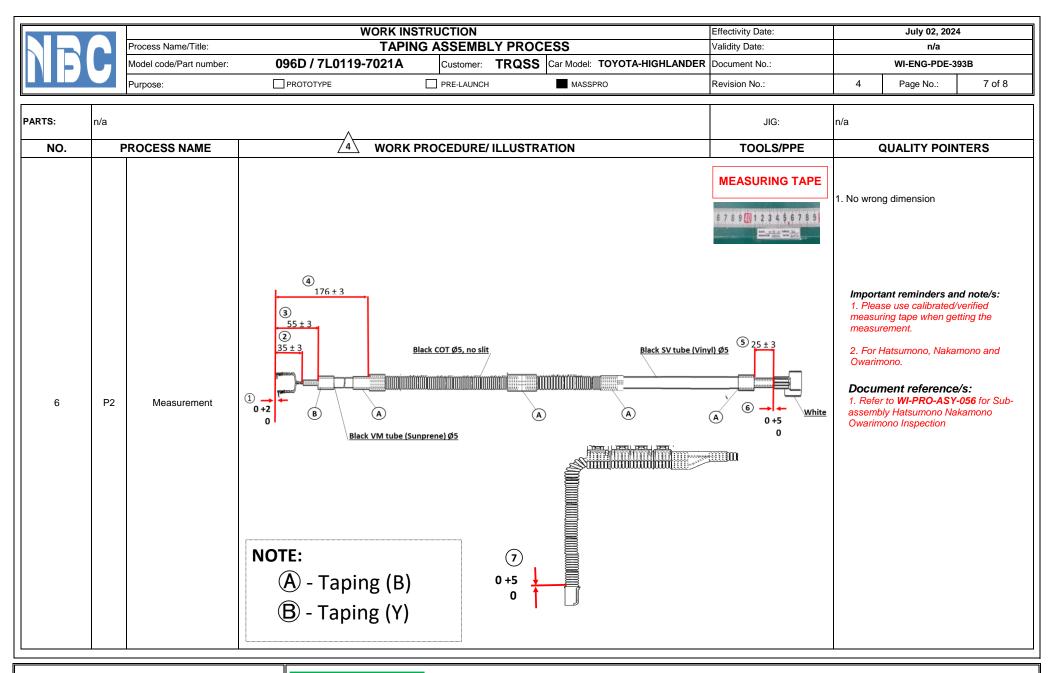
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		Effectivity Date:		July 02, 2024					
		Process Name/Title:	TAPIN	Validity Date:					
		Model code/Part number:	096D / 7L0119-7021A	Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:		WI-ENG-PDE-39	3B
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	5 of 8
PARTS:	1. Assy 2. Blac					JIG:	n/a		
NO.	F	PROCESS NAME	TOOLS/PPE	(QUALITY POIN	TERS			
5	P2	Y-Taping	L taping direction tape shifting 1/3 below	R left sic (20±3)	nd the tape 1/3 shifting until it reach her side of corrugated tube (must be		Importante of the second of th	-off tape e tape	asy es,but actual e/s:

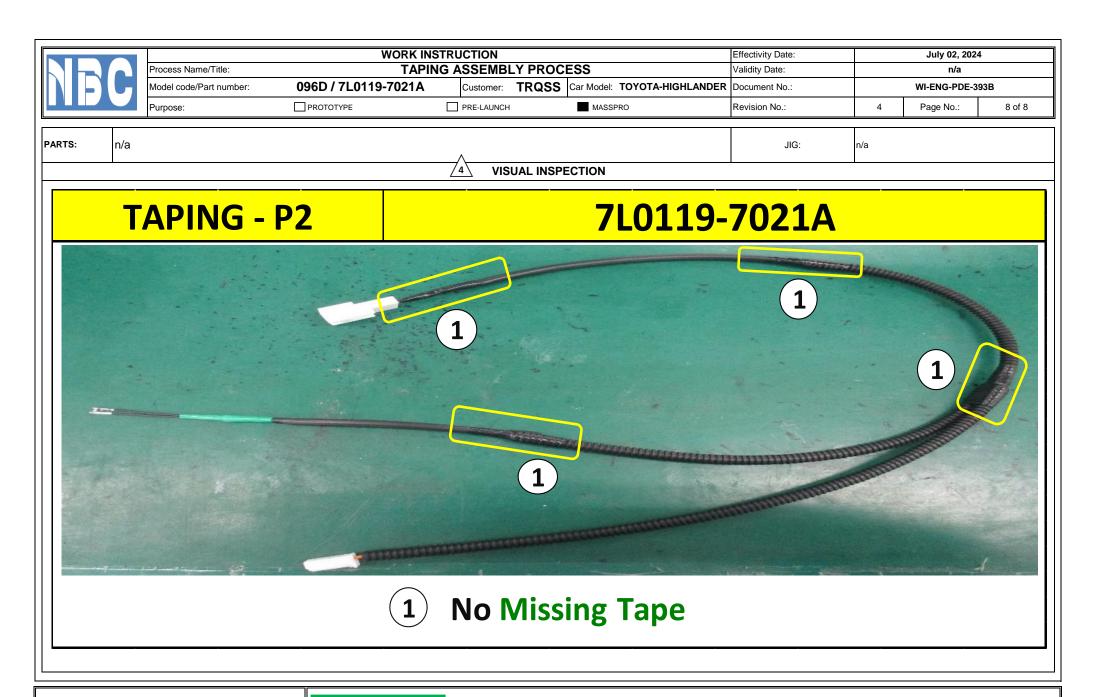


PARTS: 1. Assy parts 2. Black tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. No flip-out tape 2. No peel-off age 3. No loose tape 4. Wind the tape backward 1/2 shifting 6. No wrong use of tape 6. No wrong use of tape 6. No wrong dimension Tape shifting 9mm below Tape shifting 9mm below S. Wind the tape 1/2 shifting going to the state of the part of				WORK INST			Effectivity Date:		July 02, 2024	
PARTS: 1. Assy parts 2. Black tape NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE QUALITY POINTERS 4. Wind the tape backward 1/2 shifting 5. No lose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Important reminders/Note 1. Lege shifting 9mm below Tape shifting 9mm below S. Wind the tape 1/2 shifting going to shirten does do not not be the ACR LAPE. 2. Please use calibrated/verting the measurement.			Process Name/Title:	TAPING	ASSEMBLY PROC	ESS	Validity Date:		n/a	
PARTS: 1. Assy parts 2. Black tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. No flip-out tape 2. No peel-off tape 2. No peel-off tape 3. No loose tape 4. No missing tape 4. No missing tape 6. No wrong dimension MEASURING TAPE Tape shifting 9mm below Tape shifting 9mm below S. Wind the tape 1/2 shifting going to the steep 1/2 shifting going to the steep 4 the steep the part of th			Model code/Part number:	096D / 7L0119-7021A	Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:		WI-ENG-PDE-39)3B
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 4. Wind the tape backward 1/2 shifting tape shifting 1/2 below Tape shifting 9mm below Tape shifting 9mm below Tape shifting 9mm below S. Wind the tape 1/2 shifting going to be the size of corrected the base of the period to be sub-size of the period to			Purpose:	PROTOTYPE [PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	6 of 8
taping direction 4. Wind the tape backward 1/2 shifting 1. No flip-out tape 2. No peel off tape 3. No loose tape 4. No missing tape 4. No missing tape 6. No wrong dimension Tape shifting 9mm below Tape shifting 9mm below Tape shifting 9mm below S. Wind the tape 1/2 shifting going to other side of our pelled the beautiful to the pelled of the pelled the pe	PARTS:	1. Assy	/ parts k tape				JIG:	n/a		
4. Wind the tape backward 1/2 shifting 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Tape shifting 9mm below Tape shifting 9mm below 5. Wind the tape 1/2 shifting going to other side of corrupted the ban out the other side of corrupted the side of corr	NO.	ı	PROCESS NAME	WORK PR	OCEDURE/ ILLUSTRA	ATION	TOOLS/PPE	(QUALITY POIN	TERS
tape. After taping, check the condition of tape. 20±3mm 20±3mm Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.			Y-Taping	taping direction tape shifting 1/2 b Tape shifting 9mm below	A. Wind other si tape. Al tape.	d the tape backward 1/2 shifting I the tape 1/2 shifting going to de of corrugated tube then cut the	MEASURING TAPE	1. No flip-c 2. No peel 3. No loose 4. No miss 5. No wron 6. No wron 1. Use YE visualizat should b 2. Please measuren Doo 1. Refe	out tape -off tape e tape ing tape ig use of tape ig dimension rtant reminders LLOW TAPE for etion of shifting line e BLACK TAPE. use calibrated/ve. ig tape when gettiment. cument referencer to WI-PRO-ASY	s/Note/s: easy ees,but actual rified ing the









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