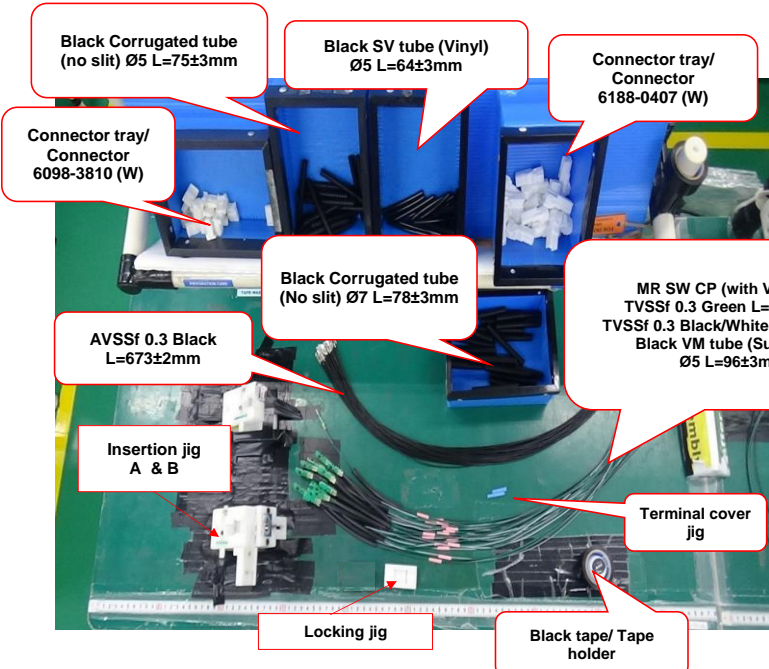
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>September 13, 2024</b>		
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>922B / 7L0124-7022A</b>		Customer: <b>TRQSS</b>	Car Model: <b>LEXUS NX</b>	Document No.: <b>WI-ENG-PDE-1044A</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.: 1 of 9

<b>PARTS:</b>	1. All parts: Connector 6098-3810(W); Connector 6188-0407(W); MR SW CP(G,B/W L=614±2 with VM tube (Sunprene) L=96±3mm); Black Sv tube (Vinyl) Ø5 L=64±3mm; Black Corrugated tube (no slit) Ø5 L=75±3mm; Black Corrugated tube (no slit) Ø7 L=78±3mm; AVSSf 0.3 Black L=673±2mm; Black tape	JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig
---------------	--	------	---


NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div> <div>TABLE LAY-OUT</div>  </div>	<div> <p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-071 Wire and Strip Length Tolerance.</b></p> <p>1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/13/24	1	Change from Pre-launch to Masspro.	D.Castillo	C.Villanueva	A. Arañes	n/a			
09/10/24	0	Initial issue.	D.Castillo	C.Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024	

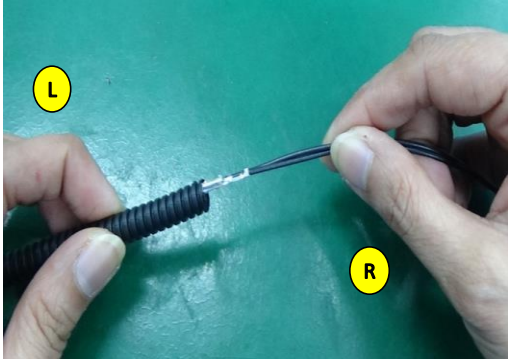
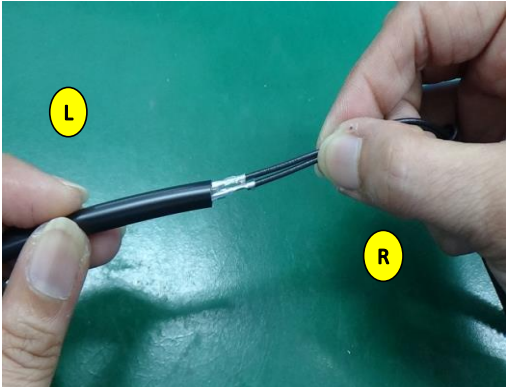
**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>September 13, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>922B / 7L0124-7022A</b>		Customer: <b>TRQSS</b>	Car Model: <b>LEXUS NX</b>	Document No.:	<b>WI-ENG-PDE-1044A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 9

<b>PARTS:</b>	1. Black SV tube (Vinyl) Ø5 L=64±3mm 2. Black Corrugated tube Ø5 L=75±3mm (no slit) 3. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire Insertion to Black Corrugated tube Ø5 L=75±3mm (no slit)	 <div> <p>1. Get 2pcs of Black wire using right hand and get corrugated tube Ø5, L=75±3mm (no slit) using left then insert.</p> </div>		n/a	1. No wrong usage of parts
3	Wire Insertion to Black SV tube (Vinyl) Ø5 L=64±3mm	 <div> <p>2. Hold the assy part using right hand then get the SV tube (Vinyl) ø5 L= 64±3mm using left hand and insert the Black wires.</p> </div>			

<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: 5px; text-align: center;"> <b>NBC (Philippines)</b>  <b>MASTER COPY</b> </div>	<div style="text-align: right;">DCC Stamp</div>
--	--	---

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**September 13, 2024**

Model code/Part number:

**922B / 7L0124-7022A**

Customer:

**TRQSS**

Car Model:

**LEXUS NX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

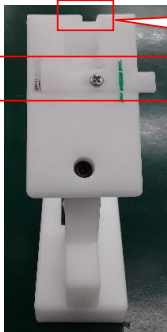
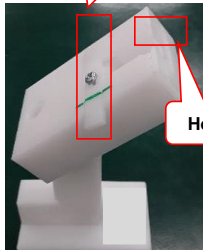


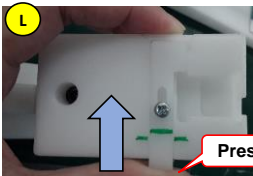
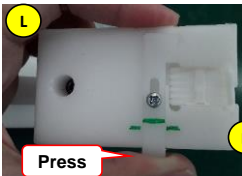
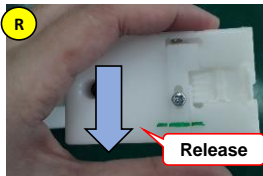

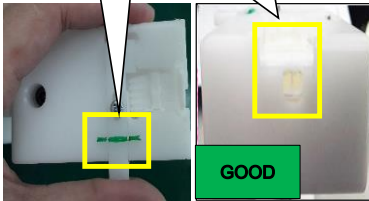
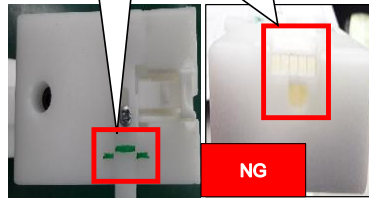
**WI-ENG-PDE-1044A**

Revision No.:

1

Page No.:

3 of 9

PARTS:	1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1  Connector setting to insertion jig (6098-3810)	<div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div></div> <div><div></div><div>3. Check the holes/terminal slot for <b>B-B wires</b>.</div></div>	n/a	<div>1. Use the provide jig per model 2. No wrong orientation of connector</div> <div><div>Connector Orientation Illustration</div><div><div>I-mark was align</div><div>2 holes were only open</div><div></div><div>GOOD</div></div><div><div>I-mark was not align</div><div>All holes were open</div><div></div><div>NG</div></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:

September 13, 2024

Validity Date:

n/a

Model code/Part number:

922B / 7L0124-7022A

Customer:

TRQSS

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-1044A

Purpose:


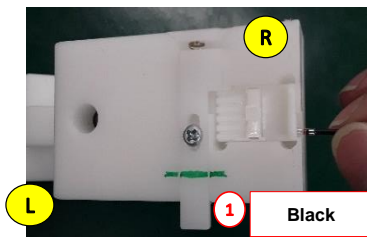
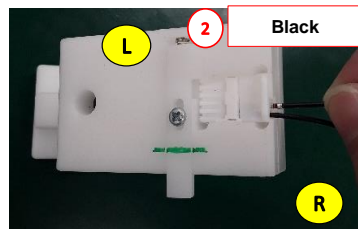
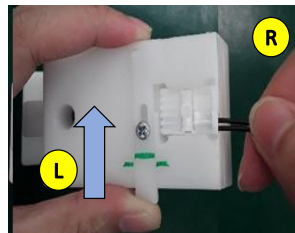
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


4 of 9


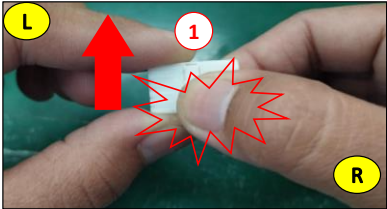
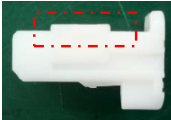


PARTS:	1. Assy parts		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1  Wire insertion to connector 6098-3810 (W)	<div><div>Terminal facing</div></div> <div><div>1. Get the first <b>Black wire</b> and insert to <b>Slot 1</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></div></div> <div><div>2. Get the <b>2nd Black wire</b> then insert to connector <b>slot 2</b> using right hand.</div></div> <div><div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><b>Important reminders/note/s:</b>  1. <i>Please hold the wire near terminal during insertion.</i>  2. <i>Insertion of wire must be inserted.</i>  3. <i>Make sure wires are properly inserted.</i>  <i>Conduct <b>Pull-Push-Pull-Push</b> after insertion.</i> <i>Do not exert extra force.</i></div> <div><b>Document reference/s:</b>  1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip lenght Tolerance.  2. <i>Please refer to <b>GL-PRO-ASSY-029</b> for Pull-Push procedure.</i></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				Effectivity Date:	September 13, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 922B / 7L0124-7022A	Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-1044A	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:

PARTS:		1. Assy parts		JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P1	Connector lock				
		<div><div>1. Put the connector into locking jig using right hand then press to lock <b>2x</b>.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div>		<div><div>Before Pressing</div><div>After Pressing</div></div> <div><div>LOCKING JIG</div></div>	<div>1. Use provided jig tools per model 2. No unlock/ half-locked connector.</div> <div><b>Important reminders/note/s:</b> 1. Manual locking may cause damaged connector lock.</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:

September 13, 2024

Model code/Part number:

922B / 7L0124-7022A

Customer:

TRQSS

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-1044A

Purpose:

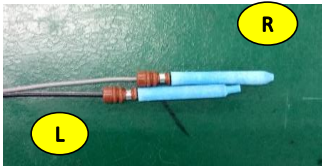

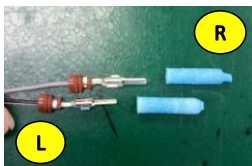

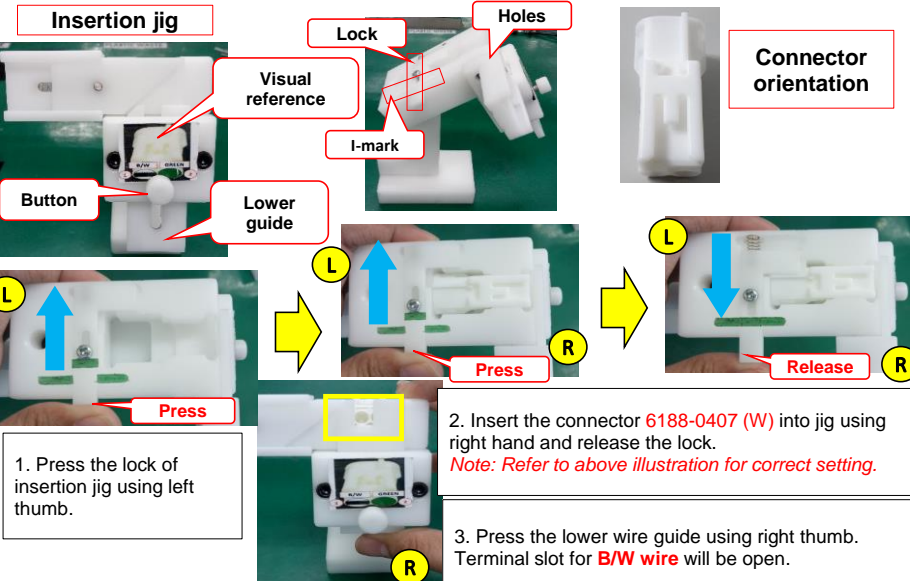
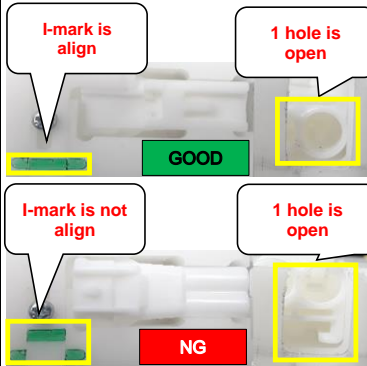
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

6 of 9

PARTS:		1. Black Corrugated tube (No Slit) Ø7 L=78±3mm 2. Connector 6188-0407 (W)		3. MR SW CP(G,B/W L=614±2 with VM tube (Sunprene) L=96±3mm); Black Vinyl tube Ø5 L=64±3mm		JIG:	1. Terminal cover jig 2. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
7	P1	Wire insertion to Black Corrugated tube Ø7 L=78±3mm				<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal 3. No damage rubber seal  <b>Important reminders/Note/s:</b> <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</i>
8		Connector setting to insertion jig 6188-0407 (W)	 <p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p> <p>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be open.</p>			n/a	<div>Connector Orientation Illustration</div>  <p>1. Use the provided jig per model 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

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Validity Date:

n/a

Model code/Part number:

922B / 7L0124-7022A

Customer:

TRQSS

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-1044A

Purpose:

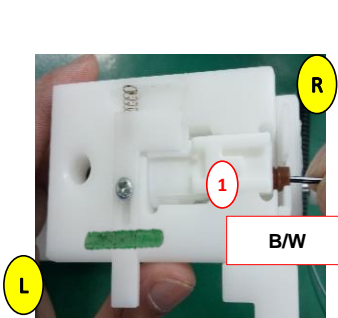
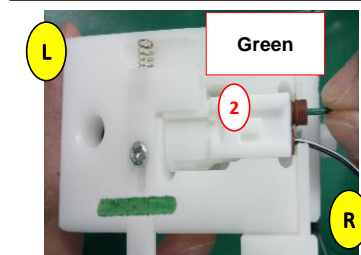
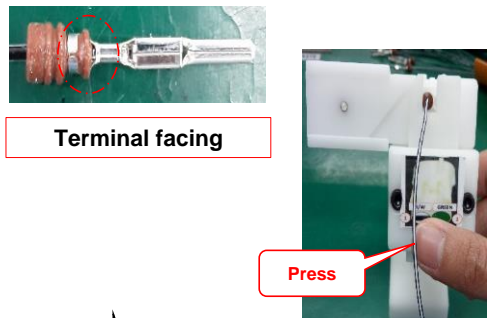
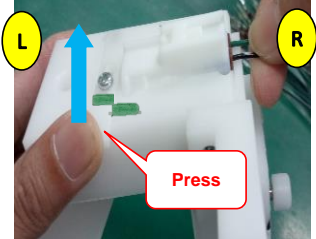
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


7 of 9


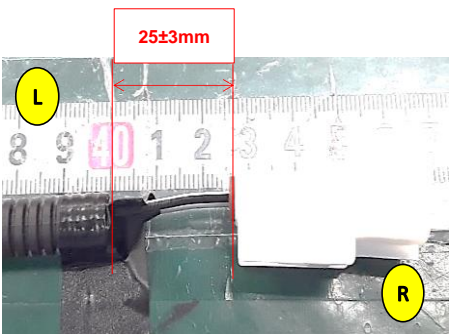
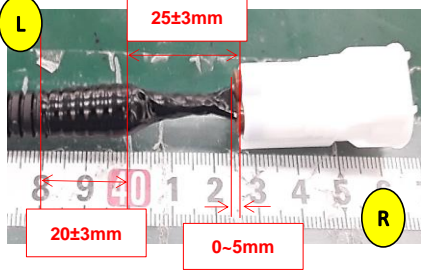

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire Insertion to connector 6188-0407 (W)	<div><p>1. Get <b>Black/White wire</b> then insert to terminal <b>slot 1</b> using right hand.</p></div> <div><p>3. Get <b>Green wire</b> then insert to terminal <b>slot 2</b> using right hand.</p></div> <div><p>2. Push the button after insertion. Hole for Green wire will be open.</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>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Insertion of wire must be inserted.</p> <p>3. Make sure wires are properly inserted.</p> <p>Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip length Tolerance.</p> <p>2. Please refer to <b>GL-PRO-ASSY-029</b> for Pull-Push procedure.</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

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>September 13, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>922B / 7L0124-7022A</b>		Customer: <b>TRQSS</b>	Car Model: <b>LEXUS NX</b>	Document No.:	<b>WI-ENG-PDE-1044A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	8 of 9

<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>	<b>QUALITY POINTERS</b>	
10	P1 Taping 1 Corrugated tube to wire near connector	<div><div><p>Start of taping</p></div><div><p>1. Hold the COT using left hand. Get <b>Black tape</b> using right hand and conduct pre taping.</p></div><div><p>25±3mm</p></div><div><p>25±3mm 20±3mm 0~5mm</p></div><div><p>2. Measure the end of COT to connector <b>25±3mm</b> and continue taping process.</p></div><div><p>3. After taping, check the dimension and taping condition.</p></div></div> <div><p><b>Measuring tape</b></p></div>		<p><b>Important reminders/note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Please refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p> <p>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</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



