



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 17, 2024

Process Name/Title:

Validity Date:

-

Model code/Part number:

177D/ 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA- COROLLA

Document No.:

WI-ENG-PDE-1059

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

1 of 6

PARTS:

1. Connector 6188-0066 (GR); AVSSf 0.3 wires Y-OR L=364±2mm; Black Corrugated tube (no slit) Ø7 L=25±3mm; Black Corrugated tube Ø5 L=286±3mm (no slit)

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

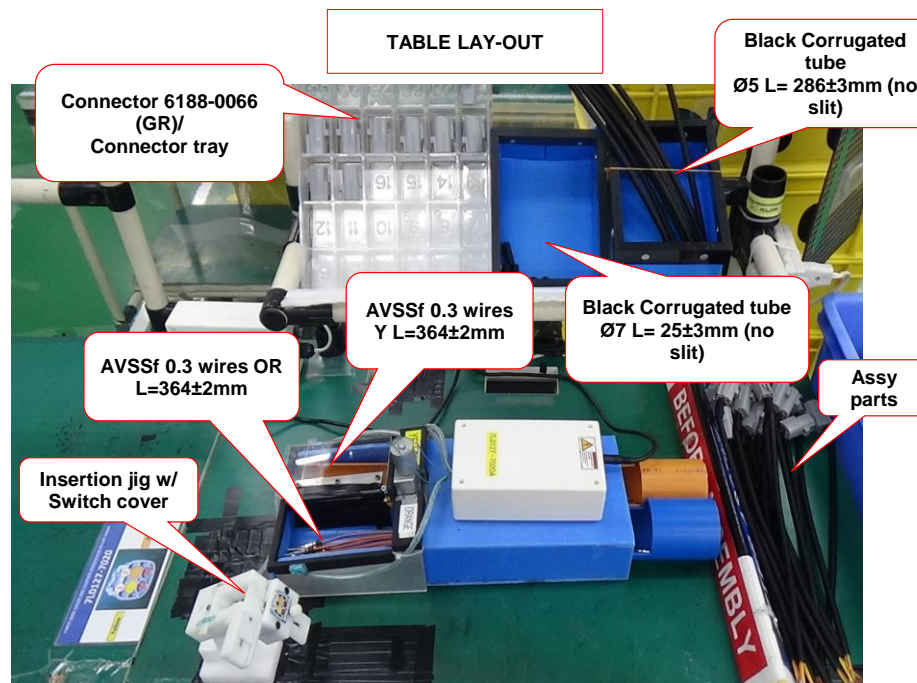
TOOLS/PPE

QUALITY POINTERS

1

n/a

Table Lay-out

**Safety Instruction**

Be sure to wear required 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.

1. No missing parts/tools
2. No excess parts/tools

Document references:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/17/24 1 Change purpose from Pre-launch to Masspro.

M. Ariola C. Villanueva A. Arañes n/a

09/16/24 0 Initial issue.

M. Ariola C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date: September 16, 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

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 17, 2024

Process Name/Title:

Model code/Part number:

177D/ 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA- COROLLA

Validity Date:

-

Document No.:

WI-ENG-PDE-1059

Purpose:



PROTOTYPE



PRE-LAUNCH



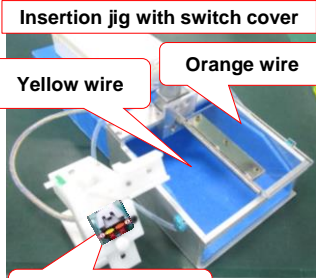
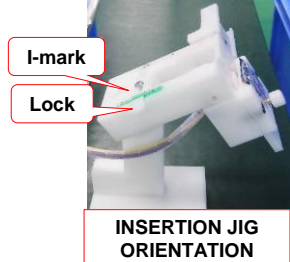

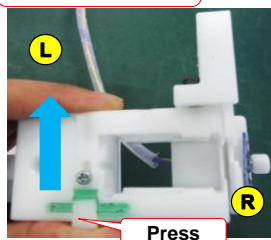
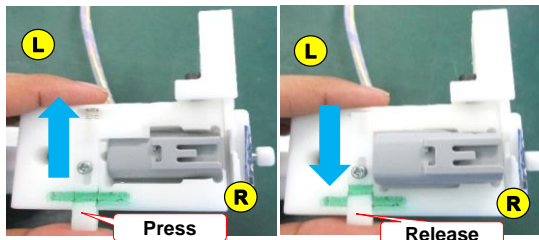
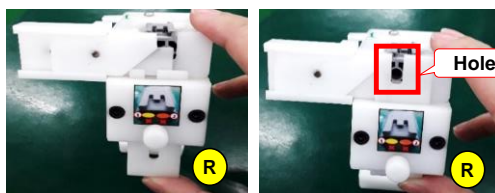
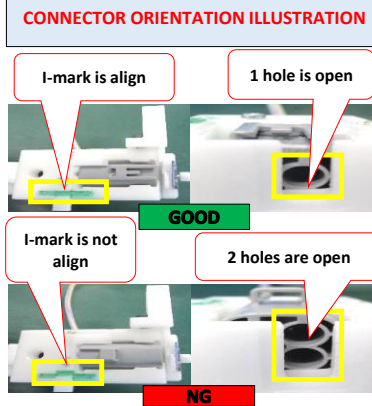
MASSPRO

Revision No.:

1

Page No.:

2 of 6

PARTS:	1. Connector 6188-0066 (GR)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to insertion jig 6188-0066 (GR)	<div><div><p>Insertion jig with switch cover</p><p>Yellow wire</p><p>Orange wire</p><p>Visual reference</p></div><div><p>I-mark</p><p>Lock</p><p>INSERTION JIG ORIENTATION</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>L</p><p>Press</p></div><div><p>L</p><p>R</p><p>Release</p></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion.</p></div><div><p>Hole</p></div><div><p>3. Push the lower wire guide upward using right thumb. Slot for Yellow wire will be opened.</p></div></div>	n/a	<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p><p>I-mark is not align</p><p>2 holes are open</p><p>NG</p></div> <div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div> <p>Document references:</p> <p>1. Follow the connector orientation.</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

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 17, 2024

Process Name/Title:

Model code/Part number:

177D/ 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA- COROLLA

Validity Date:

-

Document No.:

WI-ENG-PDE-1059

Purpose:



PROTOTYPE



PRE-LAUNCH




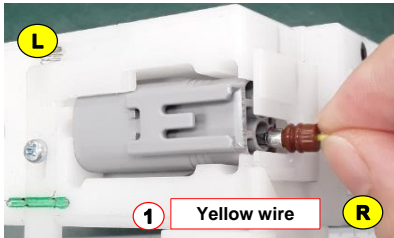
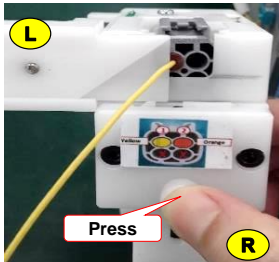
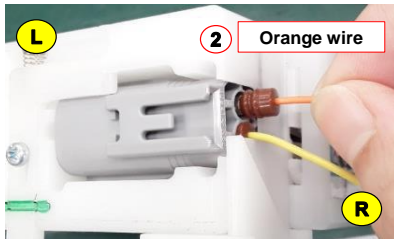
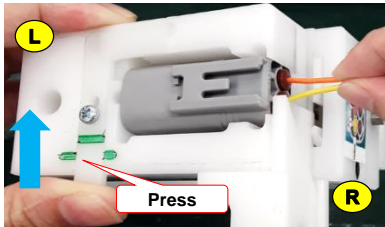
MASSPRO

Revision No.:

1

Page No.:

3 of 6

PARTS:	1. AVSSf 0.3 wires Y L=364±2mm; OR L=364±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div><p>WIRE FACING</p></div><div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div><div><p>3. Get the Orange 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>	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>Important Reminders/Note/s 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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 17, 2024

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

-

Model code/Part number:

177D/ 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA- COROLLA

Document No.:

WI-ENG-PDE-1059

Purpose:



PROTOTYPE



PRE-LAUNCH






MASSPRO

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Black Corrugated tube Ø7 L=25±3mm (no slit) 2. Black Corrugated tube Ø5 L=286±3mm (no slit)		3. Assy parts	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Wire insertion to COT (no slit) Ø7 L=25±3mm (1ST) Ø5 L=286±3mm (2ND)	<div><div></div><div></div><div></div></div> <div><div>1. Hold the wires using left hand. Get the Corrugated tube (no slit) Ø7 L=25±3mm using right hand then insert the Y-OR wires using left hand.</div><div>2. Hold the wires using left hand. Get the Corrugated tube (no slit) Ø5 L=286±3mm using right hand then insert the Y-OR wires using left hand.</div></div>		n/a	1. No wrong use 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****OFFLINE ASSEMBLY PROCESS**

Process Name/Title:

Effectivity Date:

September 17, 2024

Model code/Part number:

177D/ 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA- COROLLA

Validity Date:

-

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

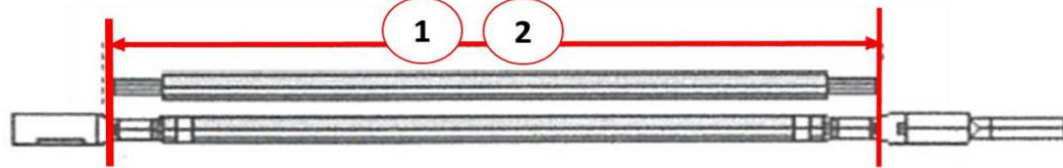

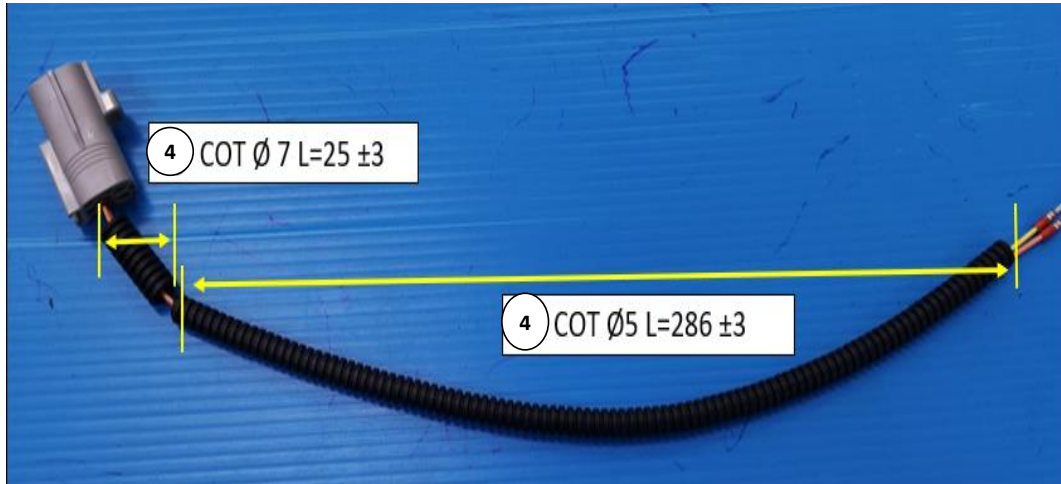
WI-ENG-PDE-1059

Revision No.:

1

Page No.:

5 of 6

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   		<p>1. No wrong dimension</p> <p>Improvement reminders and note/s:</p> <p>1. Please calibrated/Verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono Inspection.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono Inspection.</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:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 17, 2024

Validity Date:

-

Model code/Part number:

177D/ 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA- COROLLA

Document No.:

WI-ENG-PDE-1059

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

6 of 6

PARTS:

n/a

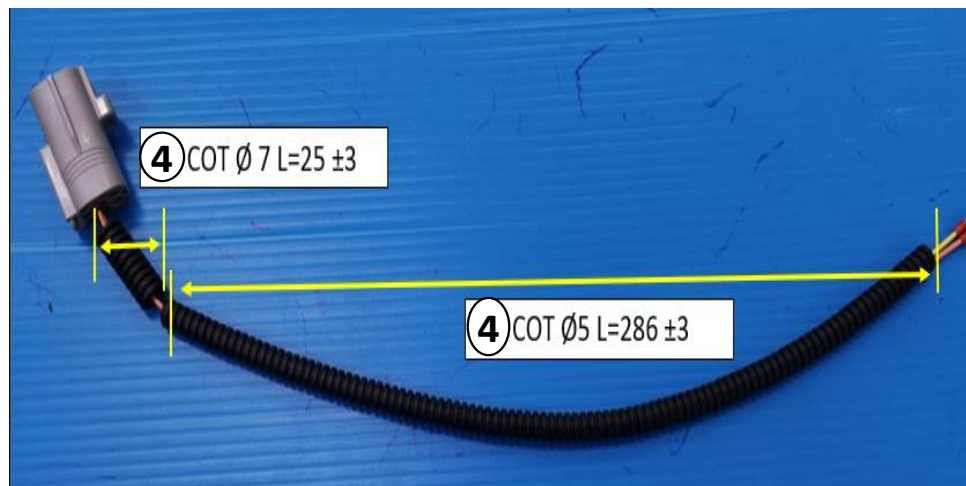
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

OFFLINE ASSEMBLY

7L0127-7020B



① No Wrong Insert

② No Terminal Backing out

③ No Deform Terminal

④ No Missing COT

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