
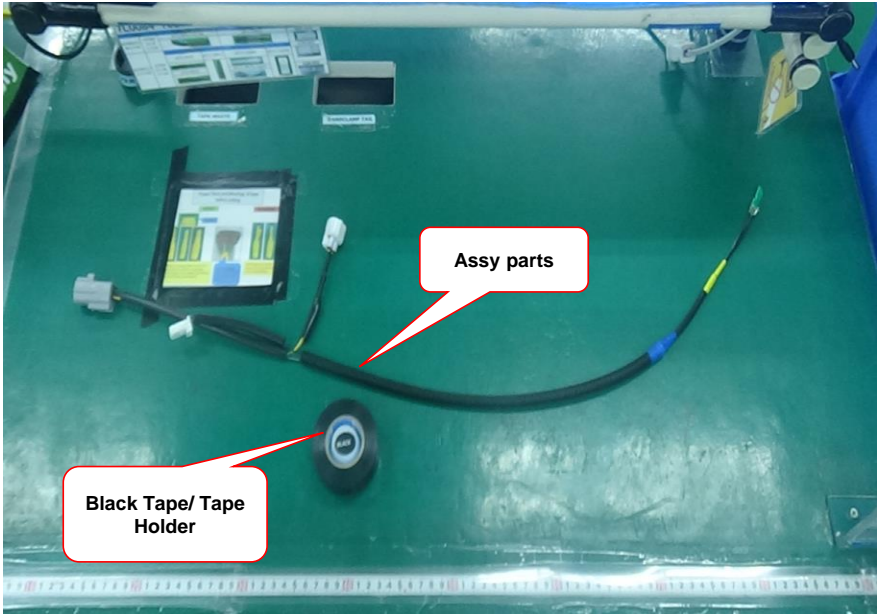
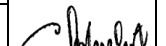




| | | | | | | | | | | |
|---|--------------------------------|--|--|--|------------------------|---------------------------------|-----------|---------------|-------------------------|--|
|  | WORK INSTRUCTION | | | | Effectivity Date: | October 1, 2024 | | | | |
| | TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | | | |
| | Process Name/Title: | | Model code/Part number: 500B / 7L0084-7023A | | Customer: TRQSS | Car Model: TOYOTA-SIENNA | | Document No.: | WI-ENG-PDE-1073C | |
| | Purpose: | | <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | Revision No.: | 1 | Page No.: | 1 of 7 | | |

| PARTS: | 1. Assy parts; Black Tape | | | | JIG: | n/a | |
|--------|---------------------------|------------------------------|---|--|-----------|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS | |
| 1 | P3 | Table Lay-out | <div>TABLE LAY-OUT</div>  <div>Assy parts</div> <div>Black Tape/ Tape Holder</div> | | | <div>Safety Instruction</div> <div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping</div> <div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level</div> <div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> | 1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools |

| Revision History | | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
|------------------|---------|--|-----------|---------------|-----------|-------|--|--|--|----------|
| 10/01/24 | 1 | Change purpose from Pre-launch to Masspro. | M. Ariola | C. Villanueva | A. Arañes | n/a |  M. Ariola |  C. Villanueva |  A. Arañes | n/a |
| 09/26/24 | 0 | Initial Issue. Separate Clamp assembly to Clamp assembly process. Transfer COT to VM tube (Sunprene) taping to P2. Transfer SV tube (Vinyl) to wire near connector and Y-taping from P2 to P3 due to process improvement. Inclusion of car model "TOYOTA-SIENNA" Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints. | M. Ariola | C. Villanueva | A. Arañes | n/a | | | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | September 26, 2024 | | |



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 1, 2024

Process Name/Title:

Model code/Part number:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1073C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

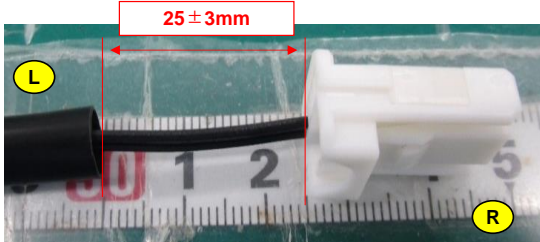
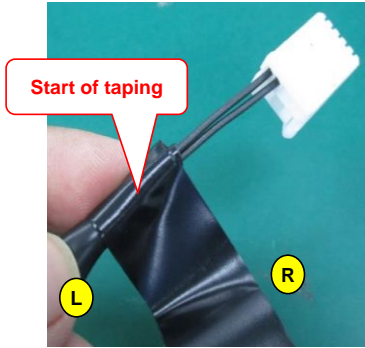
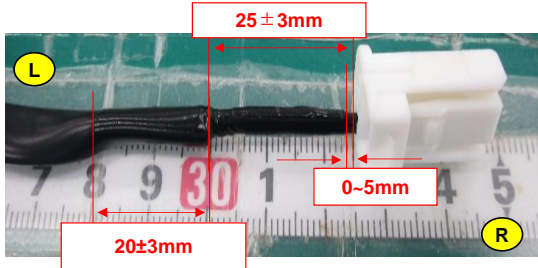

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7

| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
|--------|--|---|--|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P3 Taping 4 Black corrugated tube to Black VM tube (Sunprene) | <div><p>25 ± 3mm</p><p>1. Measure from end of SV tube up to edge of connector 25±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>25 ± 3mm</p><p>0~5mm</p><p>20 ± 3mm</p><p>3. After taping, check the measurement and taping condition.</p></div> | |  | <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s:</p> <p>1. Use BLUE TAPE only</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 1, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Document No.:

WI-ENG-PDE-1073C

Purpose:

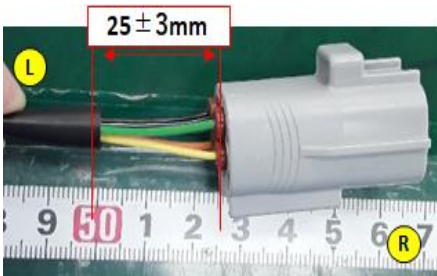
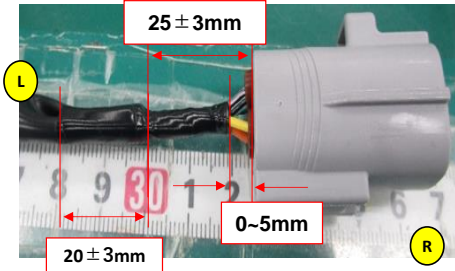
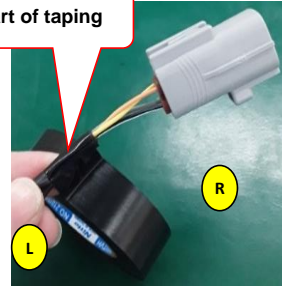

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
|--------|--------------|--|--|--|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | P3 | <div><div><p>25 ± 3mm</p></div><div><p>1. Measure from end of the SV tube (Vinyl) up to connector 25±3mm using both hands.</p></div><div><p>25 ± 3mm</p><p>20 ± 3mm</p><p>0~5mm</p></div></div> <div><div><p>Start of taping</p></div><div><p>2. Get the Black tape then start taping process using both hands.</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div> | | <div><p>MEASURING TAPE</p></div> | <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <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> |

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:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 1, 2024

Validity Date:

n/a

Document No.:

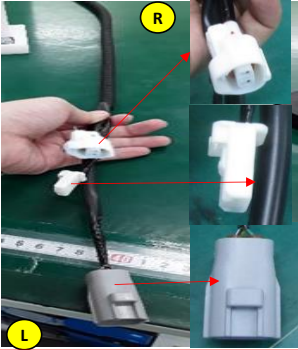
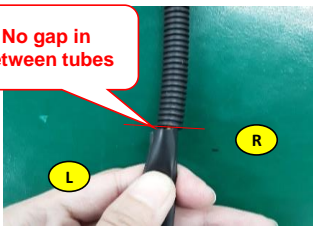



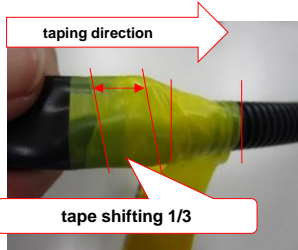



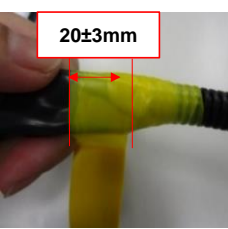
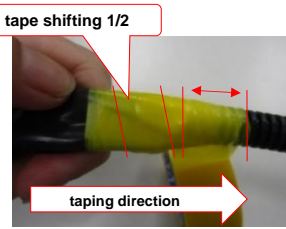
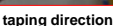
WI-ENG-PDE-1073C

Revision No.:

1

Page No.:

4 of 7

| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
|--------|----------------|---|--|-----------|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P3 Y-Taping | <div><p>Connector and Y-taping facing</p></div> <div><p>No gap in between tubes</p></div> <div><p>Top of tube</p></div> <div><p>taping direction</p></div> <div><p>tape shifting 1/2</p></div> <div><p>taping direction</p></div> <div><p>tape shifting 1/3</p></div> <div><p>tape shifting 1/2</p></div> <div><p>taping direction</p></div> <div><p>20±3mm</p></div> <div><p>tape shifting 1/2</p></div> <div><p>taping direction</p></div> <div><p>1. Fix the two (3) SV tubes (Vinyl) and COT using both hands.</p><p><i>Note: Connector facing and position of two (2) SV tube (Vinyl) must be same with the illustration.</i></p></div> <div><p>2. Start taping at the middle of combined tubes, attach the tape on the top of tube. Then make pre-tape 2 windings. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm.</p><p><i>Note: Do not exert excessive force during pulling & winding of tape.</i></p></div> <div><p>3. Winding the tape 1/3 shifting going to the right side until reach the other side of tube. Make 2 windings, width must be 20±3mm.</p></div> <div><p>4. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm.</p></div> <div><p>5. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></div> | | | <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</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



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 1, 2024

Validity Date:

n/a

Model code/Part number:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Document No.:

WI-ENG-PDE-1073C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

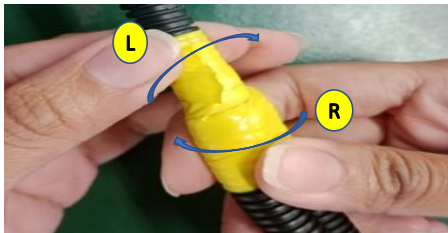
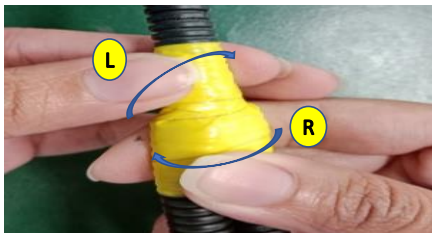
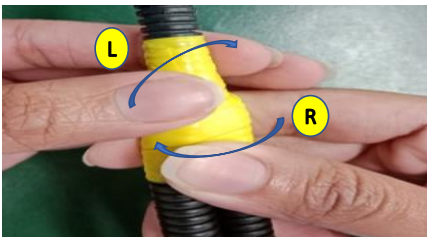
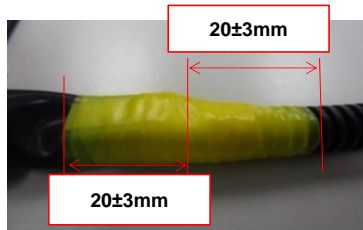
5 of 7

PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|----------------------------------|--|-----------|---|
| 2 | P3 Y-taping (Continuation) | <div><p>6. conduct proper pressing of end tape using left hand (top part)</p></div> <div><p>7. conduct proper pressing of end tape using left hand (Middle part)</p></div> <div><p>8. conduct proper pressing of end tape using left hand (bottom part)</p></div> <div><p>9. Check the Measurement and condition of tape.</p></div> | n/a | <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of 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:

Effectivity Date:

October 1, 2024

Model code/Part number:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

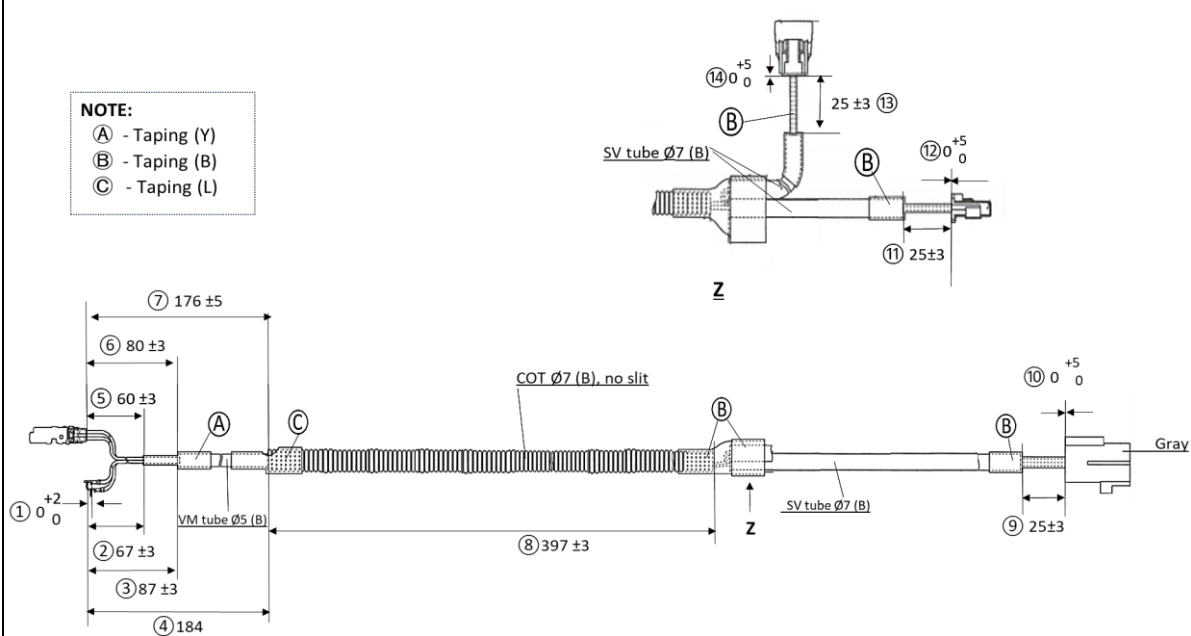

WI-ENG-PDE-1073C

Revision No.:

1

Page No.:

6 of 7

| PARTS: | | 1. Assy parts | | JIG: | n/a |
|--------|--------------|------------------------------|---|-----------|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P3 | Measurement | <div><p>NOTE:</p><ul style="list-style-type: none">(A) - Taping (Y)(B) - Taping (B)(C) - Taping (L)</div>  <div><p>MEASURING TAPE</p></div> | | <p>Important reminders and note/s:</p> <ol style="list-style-type: none">Please use calibrated/verified measuring tape when getting the measurement.For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <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:

October 1, 2024

Validity Date:

n/a

Model code/Part number:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Document No.:

WI-ENG-PDE-1073C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7

PARTS:

1. Assy parts

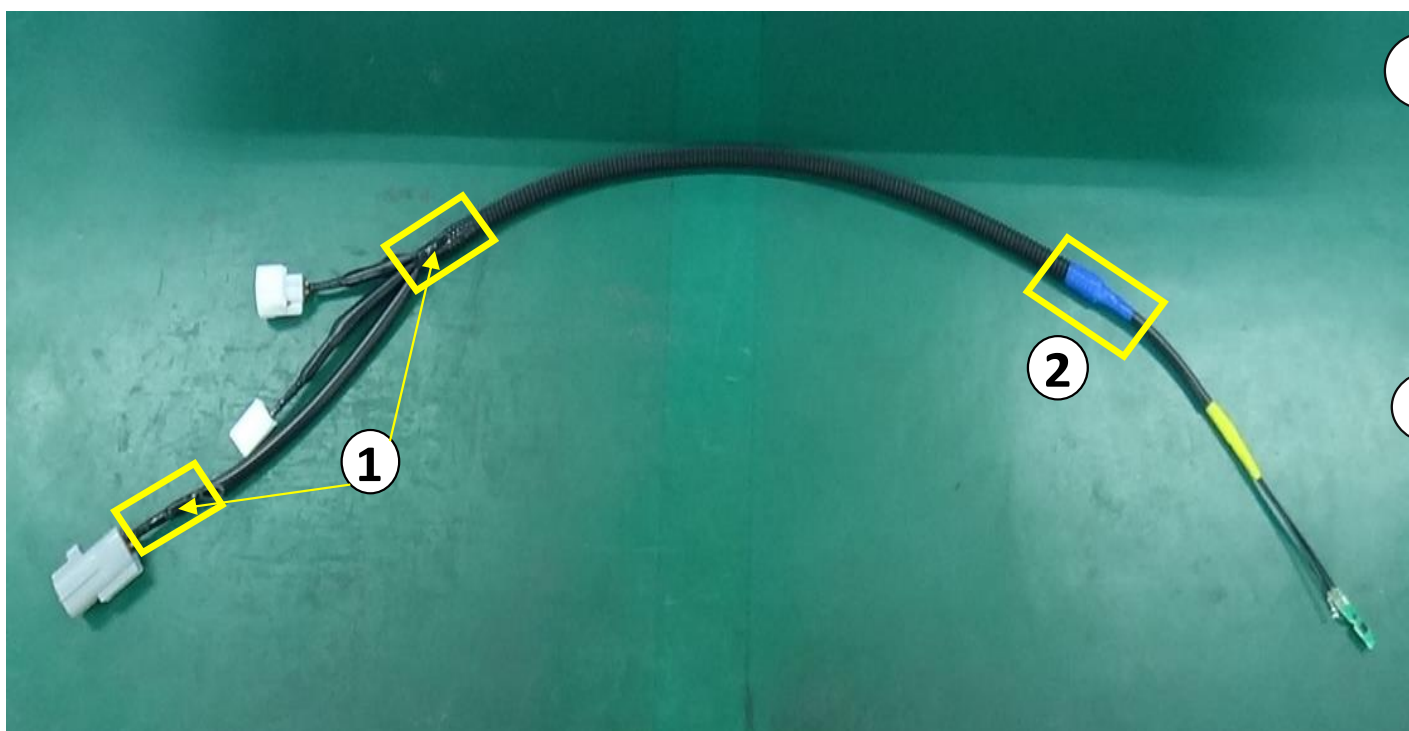
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P3

7L0084-7023A



1

No Missing Tape
No wrong use of tape (Black tape)

2

2

No Missing Tape
No wrong use tape (Blue 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