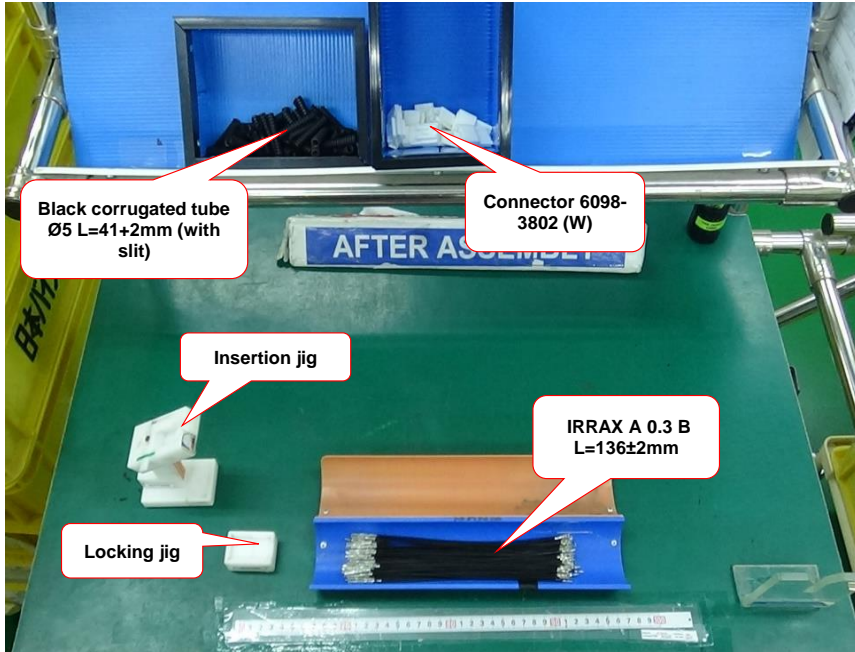
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 17, 2024</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>164B / 7M0545-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-AURIS</b>	Document No.:	<b>WI-ENG-PDE-079</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 7

<b>PARTS:</b>		1. Connector 6098-3802 (W); Black corrugated tube Ø5 L=41+2mm (with slit); IRRAX A 0.3 B L=136±2mm		JIG:	1. Insertion jig 2. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>3</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	Offline Table Lay-out	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 		<div style="border: 1px solid red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px solid red; padding: 5px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the work place is prohibited. Keep it in your locker.         </div> <div style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>            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


  

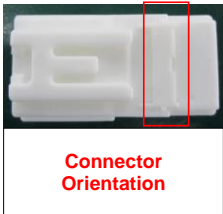
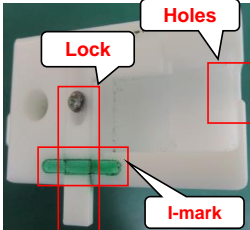
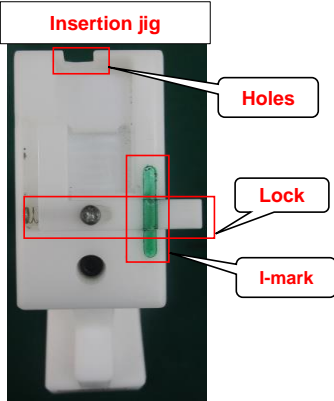
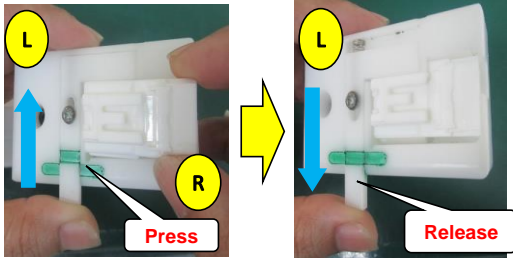
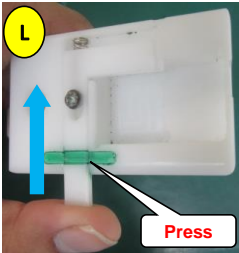
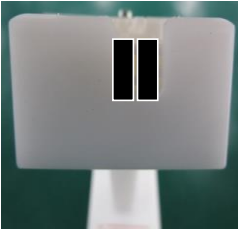
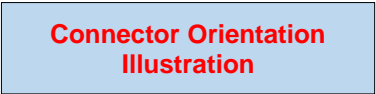
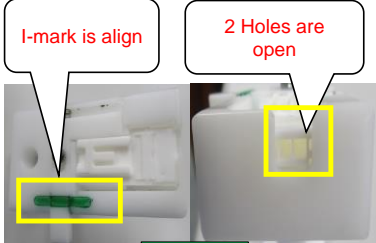
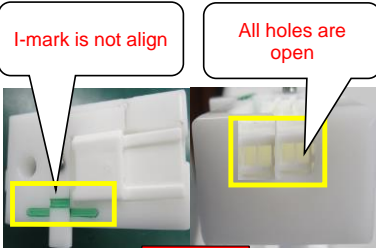
Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/17/24	3	Transfer to new format. Change from Kitting to Offline assembly process; Transfer Process 3 from Taping assembly process. Inclusion of Table lay-out, Measurement and Visual inspection. Update Work procedure of Connector lock process. Update Quality pointers. Important reminders /Note/s. Inclusion of car model "TOYOTA-AURIS".				D.Castillo	C.Villanueva	A. Arañes	n/a	
02/20/21	2	Remove cycle time; Change connector colors in accordance with color standardization for plastic parts (Refer to GL-COM-003); Change 2x pulling to Pull-Push-Pull-Push on wire insertion quality pointers				J.Loterte	C.Villanueva	A. Shimamura	A. Arañes	
08/28/20	1	Updated Cycle time, changed effective and validity date				J.Loterte	R. Peñaloza	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	

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		Est. Date: February 27, 2020

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>May 17, 2024</b>		
	<b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-079		
	Model code/Part number: <b>164B / 7M0545-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-AURIS</b>	Revision No.: 3    Page No.:    2 of 7		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	Offline Connector setting to insertion jig 6098-3802 (W)	<div><p>Connector Orientation</p></div> <div><p>2. Insert the connector <b>6098-3802</b> into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for <b>B-B wires</b>.</p></div>		n/a	<div><p>Connector Orientation Illustration</p><div><p>GOOD</p></div><div><p>NG</p></div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>	

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**TOYOTA-AURIS**

Document No.:

**WI-ENG-PDE-079**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**3**

Page No.:

**3 of 7****PARTS:**

1. IRRAX A 0.3 B L= 136mm [2pcs]
2. Black corrugated tube Ø5 L=41+2mm (with slit)

JIG:

**n/a****NO.****PROCESS NAME****3****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****3**

Offline

Wire insertion to  
corrugated tube  
Ø5 L=41+2mm  
(with slit)



1. Get black corrugated tube **Ø5 L=41+2mm** (with slit) using left hand and insert **IRRAX A 0.3 B L=136mm** using right hand.

**n/a**

1. No wrong usage of parts
2. No deformed terminal

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Customer:

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Car Model:

**TOYOTA-AURIS**

Document No.:

**WI-ENG-PDE-079**

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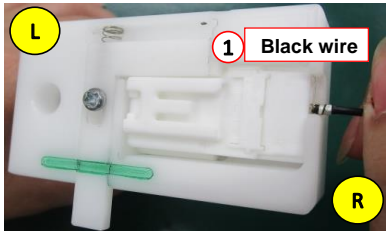
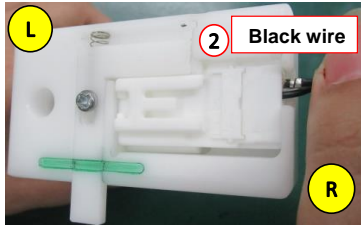
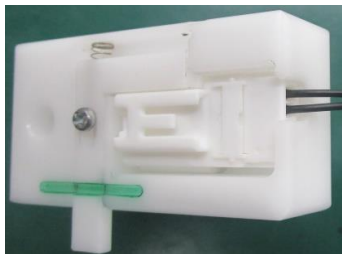
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Revision No.:

3

Page No.:

4 of 7

PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline  Wire insertion to connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div><div>1. Get <b>Black wire</b> then insert to terminal slot ① using right hand. <i>Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</i></div></div><div><div>2. Get <b>Black wire</b> then insert to terminal slot ② using right hand.</div></div></div> <div><div><div>3. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div></div>	n/a	<div>3</div> <div><b>Important reminders/Note/s:</b> <b>1. Insertion of wire must be from left to right.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>

n/a

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Customer:

**TRJ**

Car Model:

**TOYOTA-AURIS**

Document No.:

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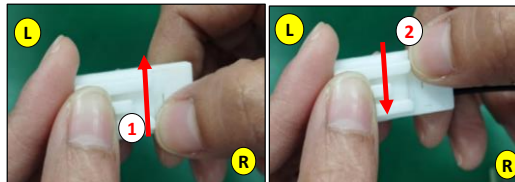


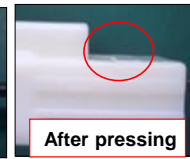
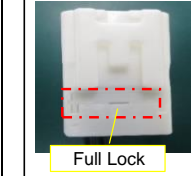
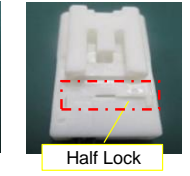
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Revision No.:

3

Page No.:

5 of 7


PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div><div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>	<div>LOCKING JIG</div> <div></div>	<div>3</div> <div><b>Important reminders /Note/s;</b> 1. <b>MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b></div> <div><b>Document reference/s;</b> 1. Please refer to <b>GL-PRO-ASS-017</b> for the verification of connector lock.</div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div> <div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div>

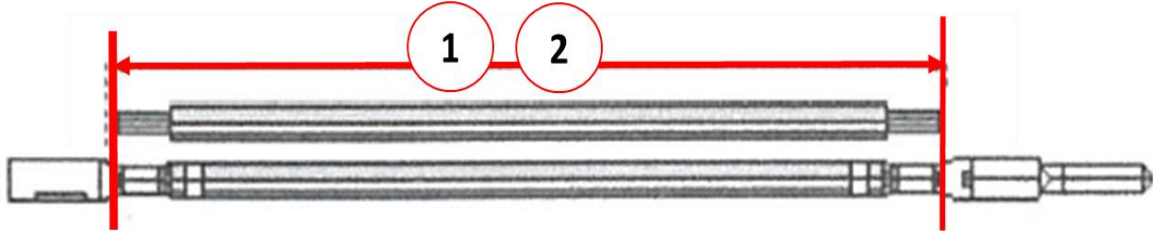

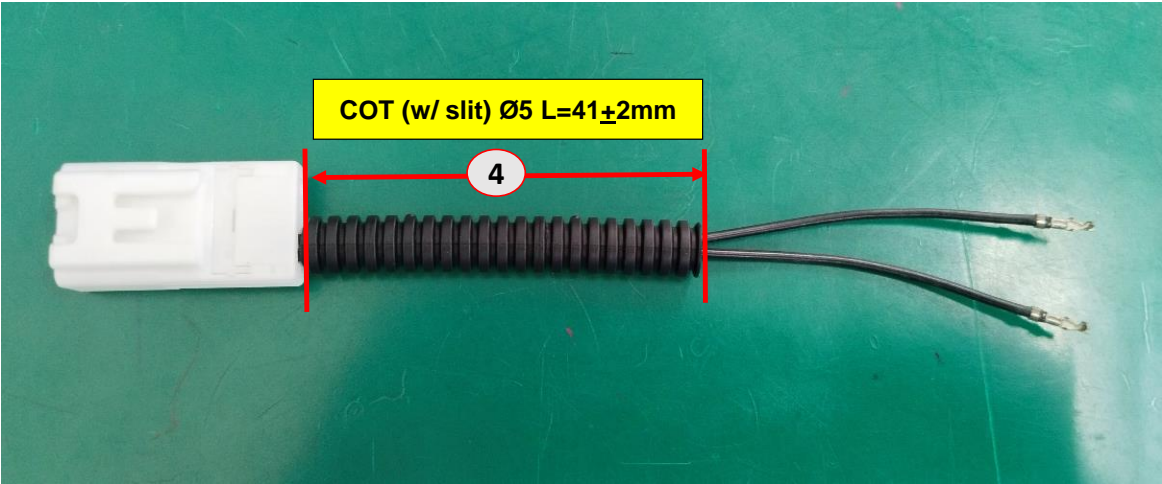

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	Process Name/Title:		Model code/Part number: <b>164B / 7M0545-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-AURIS</b>	Document No.:	<b>WI-ENG-PDE-079</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	3	Page No.:	6 of 7	

<b>PARTS:</b>	1. 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>	
6	Offline Measurement	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>   	<b>Measuring tape</b> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>	

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**164B/ 7M0545-7020C**Customer: **TRJ**Car Model: **TOYOTA-AURIS**

Document No.:

**WI-ENG-PDE-079**

Purpose:

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Revision No.:

3

Page No.:

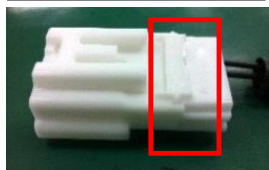
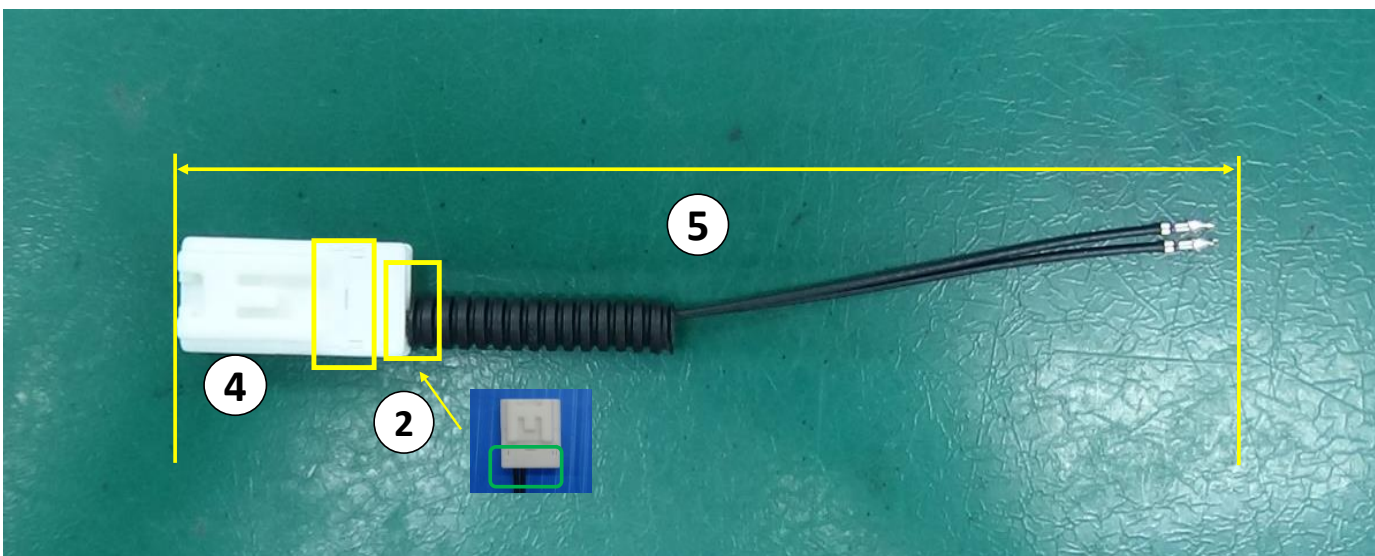
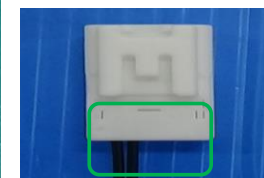
7 of 7

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****OFFLINE INSERTION****7M0545-7020C****1****GOOD****NO GOOD****1** No **Unlock connector****2** No **Wrong insert****5****3** No **Terminal backing out****4** No **Deformed terminal****5** Check the **Alignment****3****GOOD****NO GOOD**

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