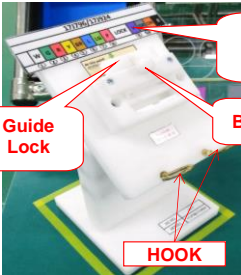
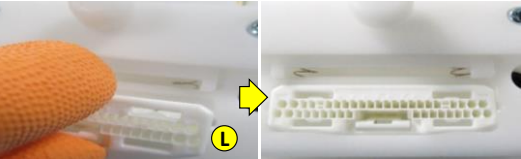





	WORK INSTRUCTION					Effectivity Date:		December 4, 2024	
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Process Name/Title:		Model code/Part number:		Customer:	Car Model:	Document No.:		
	350B/320B/014B/ 360B/150B/		17J796-7051	TRP	TOYOTA-COROLLA/ RAV-4/ HIGHLANDER	WI-ENG-PDE-091A			
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 18 Page No.: 1 of 3	

PARTS:		1. Connector 1827842-1 (W)		JIG:		1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	<div><div>18</div><div>HIGH</div><div>Connector setting to insertion jig 1827842-1 (W)</div></div>	<div><div>INSERTION JIG</div><div></div><div>Visual reference</div><div>Double lock</div><div>CONECTOR ORIENTATION</div><div></div><div>1. Get the connector 1827842-1 (W) using left hand then set to insertion jig.</div><div></div><div>Guide Lock</div><div></div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>2. Press the guide lock using left index finger.</div></div> <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></div> <div><div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 5. No half-locked connector</div><div>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. 3. Follow the connector orientation.</div><div><div>Connector must be no damaged/half-locked/locked</div><div><div>GOOD</div><div>UNLOCK</div></div><div><div>NG</div><div>HALF-LOCKED</div></div></div></div>					

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
12/04/24	18	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Inclusion of Car model "TOYOTA-COROLLA/ RAV-4/ HIGHLANDER"				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
03/02/23	17	Change WIP flow quantity from [1pc] flow to [3pcs] flow due to process improvement.				M. Ariola	J. Loterte	C.Villanueva	A. Arañes				
08/18/22	16	Improve quality pointers; Reminders, notes and references in process no.1, 2 and 3 as document process improvement.				M. Catapang	J. Loterte	C.Villanueva	A. Arañes				
06/10/22	15	Change setting of connector from right hand to left hand - process1, procedure1. Additional: Wire insertion procedure in process2, procedure4. Note for wire and strip length of tolerance.				M. Catapang	J. Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	June 02, 2017		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 4, 2024

Validity Date:

n/a

Model code/Part number:

350B/320B/014B/
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/
RAV-4/ HIGHLANDER

Document No.:

WI-ENG-PDE-091A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

18

Page No.:

2 of 3

PARTS:

1. CIVUS 0.13 W L=183±2mm; G L=186±2mm; R L=184±2mm; Y L=180±2mm; BR L=178±2mm; L L=184±2mm;
LG L=176±2mm; P L=177±2mm; V L=177±2mm; GR L=179±2mm; OR L=181±2mm; B L=181±2mm

JIG:

1. Insertion jig

NO.

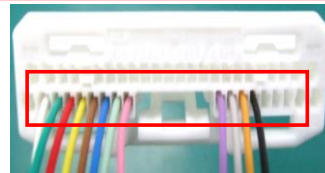
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

WIRE INSERTION ILLUSTRATION



17J796/17J924											
X											
W	G	R	Y	BR	L	LG	P	V	GR	OR	B
183	186	184	180	178	184	176	177	177	179	181	181
1	2	3	4	5	6	7	8	9	10	11	12

Standard hold in wire

5mm

GOOD SHORT
terminalNG LONG
terminal

Terminal facing

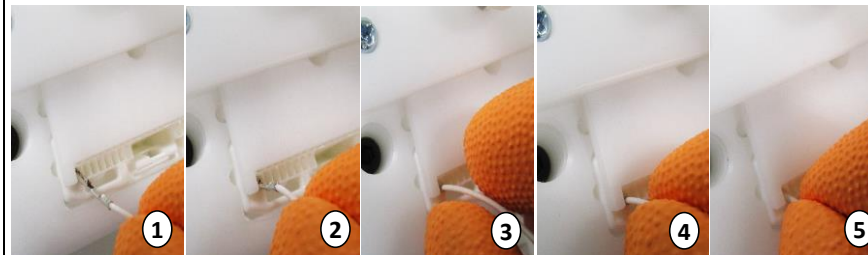
Finger COTS



18

MEDIUM

Wire insertion to connector
(Group 1 wires)
1827842-1 (W)



1. Get the wire and hold it **5mm** away from terminal.
2. Half insert the wire.
3. Release wire to check the color.
4. Conduct point checking in visual
5. Hold again **5mm** away from terminal
6. Fully inserted wires (avoid bending during insertion)

1. No wrong wire insertion
2. No terminal backing out
3. No deformed terminal
4. Make sure wires are properly inserted.
5. Must have slight MOVEMENT after insertion
6. No bend terminal/wires

Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.
2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.
3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
4. Follow the insertion sequence based on the visual reference
5. Hold on wire during insertion must be **5mm** away from terminal end.

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

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	December 4, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-091A		
Revision No.:	18	Page No.:	3 of 3

Process Name/Title:	TAPING ASSEMBLY PROCESS			
Model code/Part number:	350B/320B/014B/ 360B/150B/	17J796-7051	Customer: TRP	Car Model: TOYOTA-COROLLA/ RAV-4/ HIGHLANDER
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			

PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>18</div> <div>MEDIUM</div> <div>Wire insertion to connector (Group 1 wires) 1827842-1 (W) (Continuation)</div> <div>P1</div>	<div><div>Button</div><div>L</div><div>L</div><div>R</div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>7. Press the button using left thumb.</div></div> <div>8. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</div>		<div>Finger COTS</div> <div></div>	<div>1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted. 5. Must have slight MOVEMENT after insertion 6. No bend terminal/wires</div> <div><div>No bend terminal/wires</div><div>GOOD</div><div>NG</div><div>No damaged/whitens</div></div>
3	Pass WIP to P2	<div>3 PIECES FLOW</div> <div></div> <div>1. Pass WIP to WIP Holder. Note: Three pieces flow.</div>		<div>WIP HOLDER</div> <div></div>	<div>1. No WIP overflow</div>

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