



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1141A

Revision No.:

1

Page No.:

1 of 7

## PARTS:

1. Connector 6189-0451 (W); MRSW CP TVSSf 0.3 Wires G L=607±3mm; B/W L=607±3mm; Black Corrugated tube Ø7, L= 248±2mm (no slit); Black Corrugated tube Ø7, L= 131±3mm (no slit); Black tape

JIG:

1. Insertion jig with switch cover
2. Locking jig
3. Terminal Cover Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

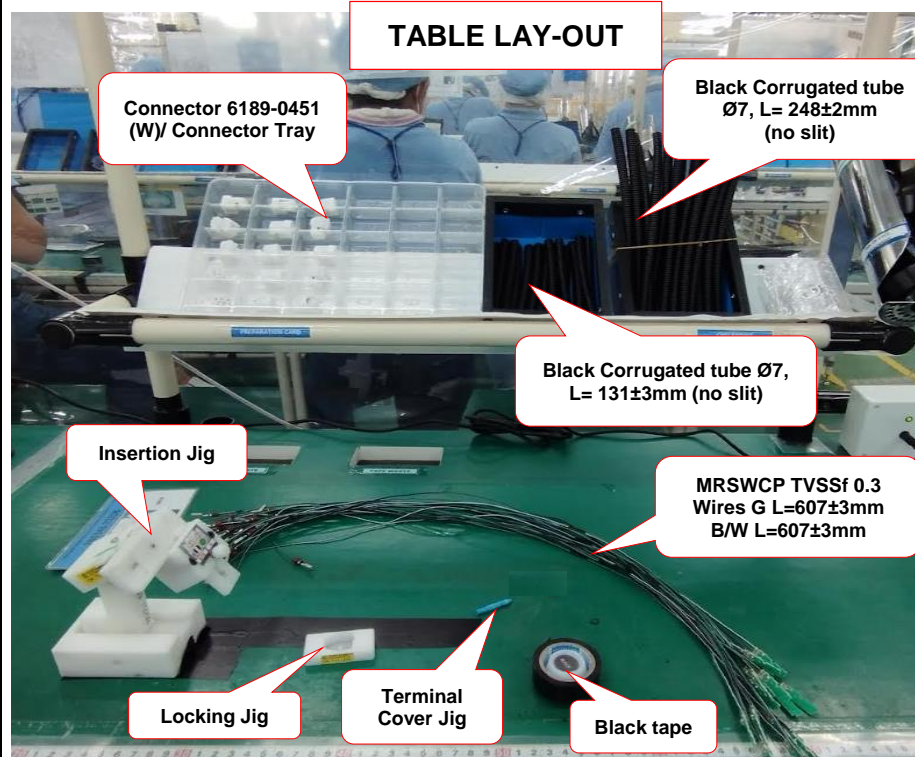
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed 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.

**Document reference/s:**

1. Refer to **WI-PRO-CNC-017** for Wire and Strip length Tolerance.
2. Refer to **WI-PRO-KIT-005** for Wire taping without Vinyl Tube

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

## Revision History

Revision History							Prepared by	Reviewed by	Approved by	Noted by
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
10/22/24	1	Change pre-launch to mass pro.				A.Hernandez	C.Villanueva	A. Arañes	n/a	
10/17/24	0	Initial issue.				A.Hernandez	C.Villanueva	A. Arañes	n/a	
							A.Hernandez	C.Villanueva	A. Arañes	N/A

**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 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Document No.:

WI-ENG-PDE-1141A

Purpose:






☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7

<b>PARTS:</b>		1. Assy parts 2. Black Corrugated tube $\varnothing 7$ L=131 $\pm$ 3mm (No slit)	3. Black corrugated tube $\varnothing 7$ L=248 $\pm$ 2mm	JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	<p>Wire insertion to Black Corrugated tube <math>\varnothing 7</math> L=131<math>\pm</math>3mm and Black corrugated tube <math>\varnothing 7</math> L=248<math>\pm</math>2mm</p> <div><p>1. Get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</p><p>2. Get the corrugated tube <math>\varnothing 7</math> L=131<math>\pm</math>3mm using right hand then insert the G-B/W wires using left hand.</p><p>3. Get the corrugated tube <math>\varnothing 7</math> L=248<math>\pm</math>2mm using right hand then insert the G-B/W wires using left hand.</p><p>4. After insertion, remove the cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal

**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:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Document No.:

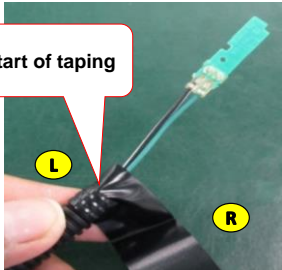
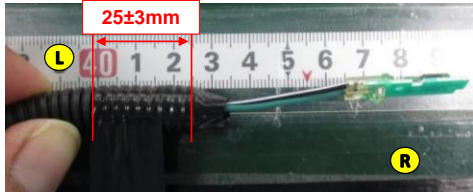
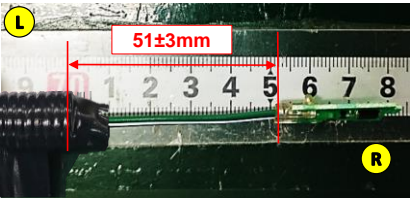
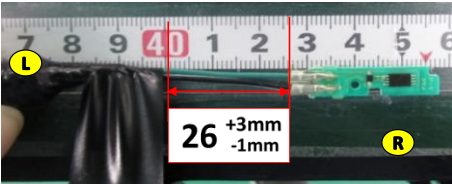
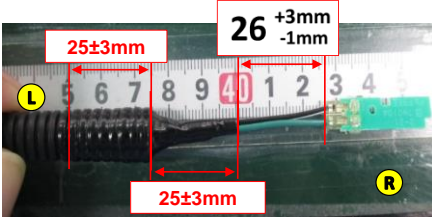

WI-ENG-PDE-1141A

Revision No.:

1

Page No.:

3 of 7

PARTS:		1. MRSW CP TVSSf 0.3 wires G-B/W L=607±3mm 2. Black Corrugated tube Ø7 L=131±3mm (no slit) 3. Black tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Black COT to wire near PCB	<div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>1. Hold the assy parts using left hand, get <b>Black tape</b> then conduct pre-taping using both hands.</p></div> <div><p>51±3mm</p></div> <div><p>2. Confirm measurement of <b>25±3mm</b> from end of tape up to end of COT then continue the taping process using both hands.</p></div> <div><p>26 +3mm -1mm</p></div> <div><p>2. Confirm measurement of <b>51±3mm</b> from COT to hotmelted wire then continue the taping process using both hands.</p></div> <div><p>25±3mm 26 +3mm -1mm 25±3mm</p></div> <div><p>4. Confirm measurement of <b>26+3/-1mm</b> from end of tape up to edge of PCB then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement and taping condition.</p></div>		<div>Measuring tape</div> 	<p><b>Important reminders/note/s:</b></p> <p>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

Effectivity Date:

October 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Document No.:

WI-ENG-PDE-1141A

Purpose:

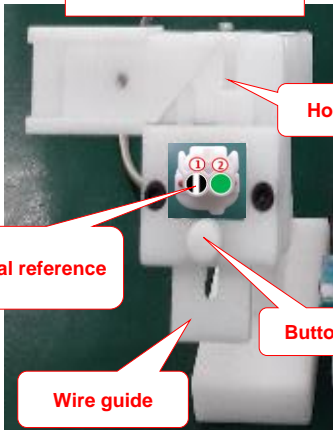
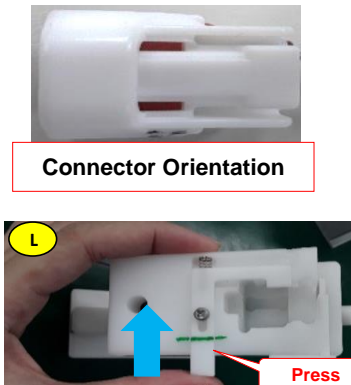
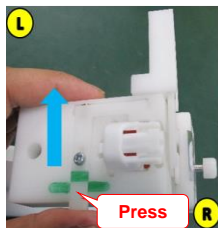
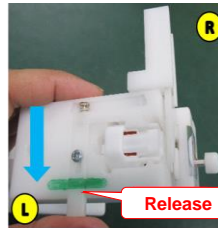
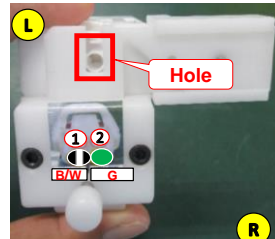
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 7

PARTS:	1. Connector 6189-0451 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1  Connector setting to insertion jig 6189-0451 (W)	<div><div><div>INSERTION JIG</div></div><div><div>Connector Orientation</div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><div><p>Press</p><p>Release</p></div><div><p>Hole</p><p>3. Push the guide using right hand. The slot for B/W wire will be opened.</p></div><div><p>2. Get the connector <b>6189-0451 (W)</b> using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p></div></div></div>	N/A	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT</div><div>1 hole is open</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****TAPING ASSEMBLY PROCESS**

Effectivity Date:

October 22, 2024

Process Name/Title:

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1141A

Purpose:


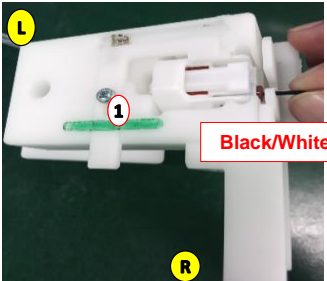
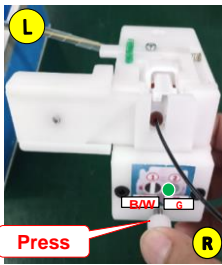
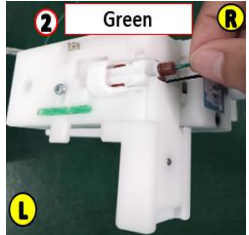
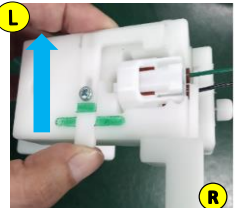
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:	1. Connector 6189-0451 (W)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1  Wire insertion to connector 6189-0451 (W)	<div><p>Wire Terminal Facing</p></div> <div><p>Black/White</p></div> <div><p>Press</p></div> <div><p>Green</p></div> <div></div> <div>1. Get the <b>B/W wire</b> then insert to terminal slot <b>1</b> using right hand.</div> <div>2. After insertion of <b>B/W wire</b> press the button using right hand. The slot for <b>G wire</b> will be open.</div> <div>3. Get the <b>G wire</b> then insert to terminal slot <b>2</b> using right hand.</div> <div>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.</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. Please hold the wire near terminal during insertion. 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div> <div><b>Document reference/s:</b> 1. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</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

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Model code/Part number:

990B / 7N0143-7020D

Customer: TRJ

Car Model: TOYOTA PRIUS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1141A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


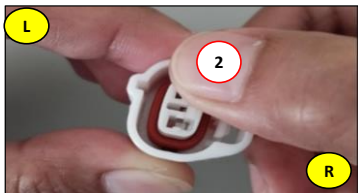
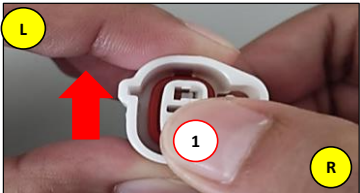





☒ MASSPRO

Revision No.:

1

Page No.:

6 of 7

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Connector Lock	<div><p>1. Put the connector into locking jig using right hand. Then press to lock <b>2x</b> using both hands.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p><p>GOOD</p><p>NG</p><p>Check the double lock deformation</p></div>	<div>LOCKING JIG</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</b></p> <p>1. Must be fully inserted 2. No double lock deformation 3. No Unlock/Half-locked 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:

October 22, 2024

Validity Date:

n/a

Model code/Part number:

**990B / 7N0143-7020D**Customer: **TRJ**Car Model: **TOYOTA PRIUS**

Document No.:

**WI-ENG-PDE-1141A**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

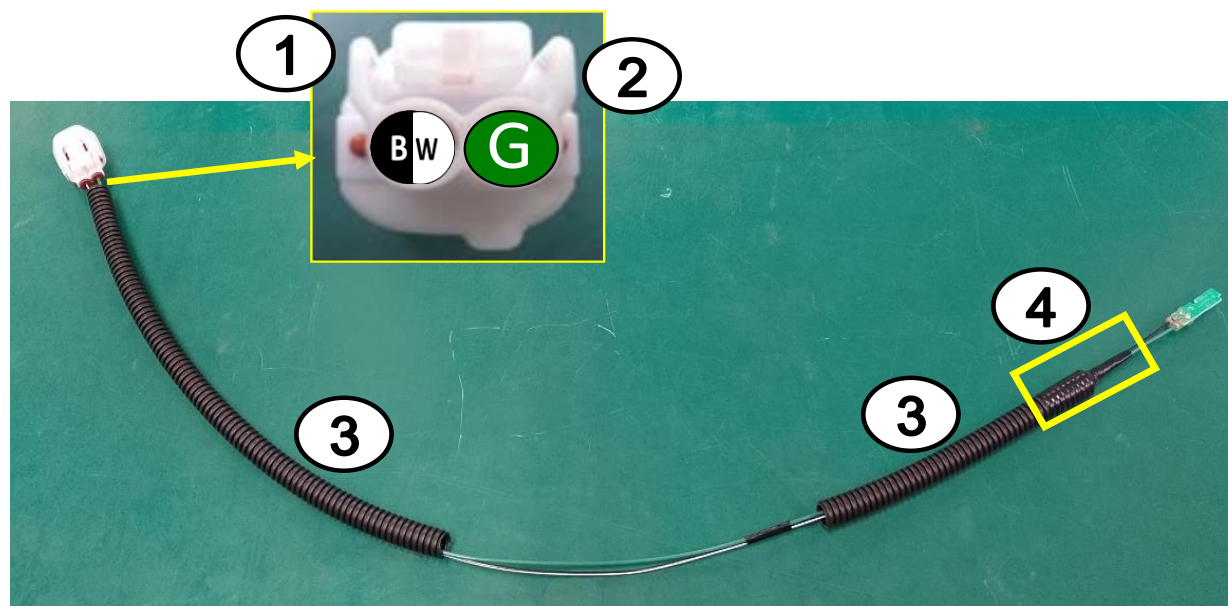
7 of 7

**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7N0143-7020D****① No Unlocked/Half-locked connector****② No Wrong Insert****③ No Missing COT****④ No Missing Tape****⑤ No Terminal Backing Out****⑥ 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