



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 02, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

311D

/

7L0154-7023

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1026A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 5

## PARTS:

1. Assy parts

2. Black Corrugated tube (with slit) Ø5 L=164±3mm

3. Black tape

JIG:

n/a

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

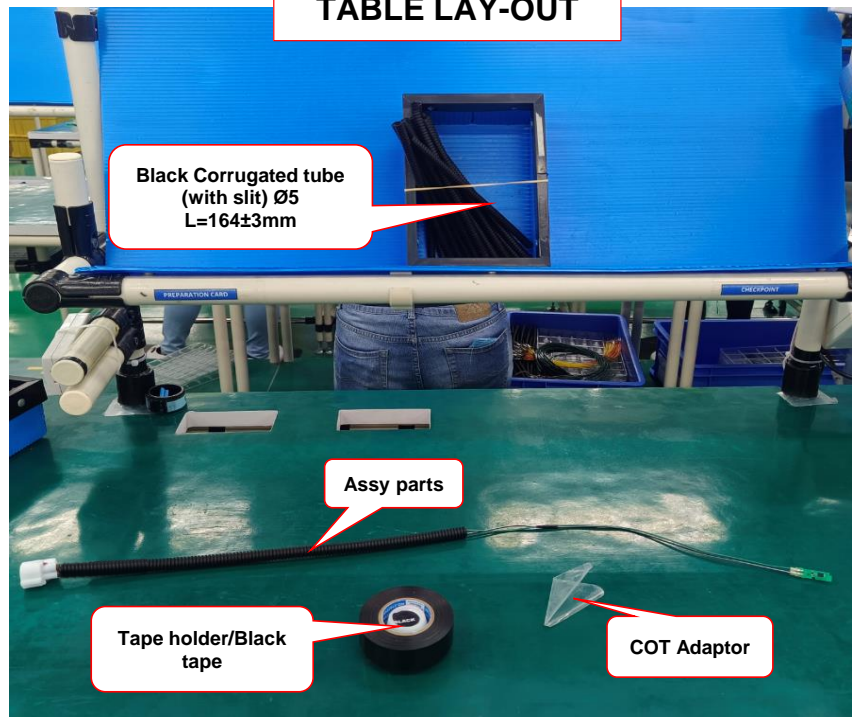
## QUALITY POINTERS

1

P1

Table lay-out

## 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.

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

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/02/24	1	Change Purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a				
09/06/24	0	Initial Issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	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**

Process Name/Title:

Effectivity Date:

October 02, 2024

Model code/Part number:

311D

/

7L0154-7023

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1026A

Purpose:

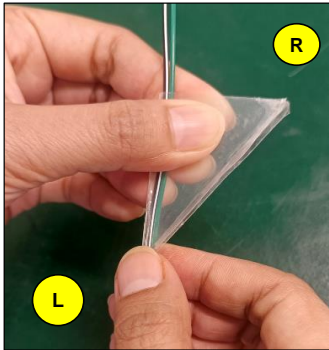
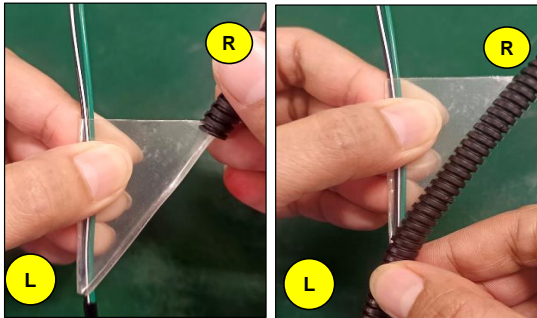

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1  Wire insertion to Black Corrugated tube (with slit) Ø5 L=164±3mm	<div><div>1. Hold the COT Adaptor using left hand. Insert the wires using right hand.</div></div> <div><div>2. Hold the COT Adaptor with wires using left hand , get the <b>Black Corrugated tube (w/ slit) Ø5 L=164±3mm</b> using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</div></div>	<div>COT Adaptor</div> 	<b>Important reminders/Notes</b> <b>1. Please use calibrated/verified measuring tape when fetting the measurement.</b>  1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing 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

Effectivity Date:

October 02, 2024

Process Name/Title:

Model code/Part number:

311D

/

7L0154-7023

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1026A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

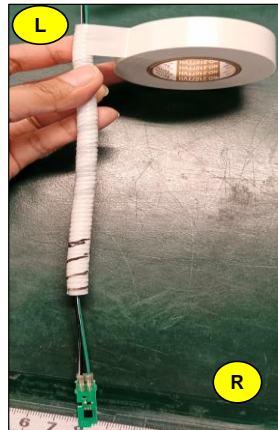
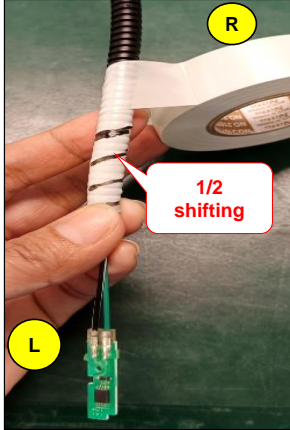
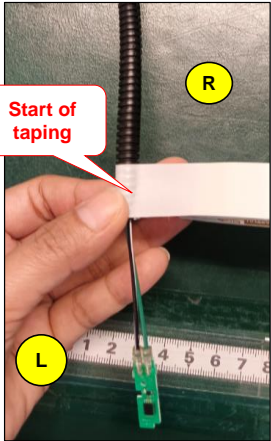
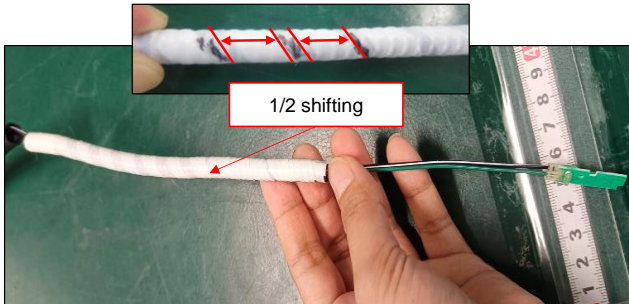

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Half-wrap Taping	<div><p>1. Hold the <b>Black corrugated tube (w/slitted)</b> using left hand. Get the black tape using right hand. Conduct <b>2 windings</b> of tape before shifting using both hands.</p><p>2. Make <b>1/2 shifting</b>. Repeat the process until the end of corrugated tube. Make <b>3 windings</b> of tape then cut the tape.</p><p>3. Check the taping condition.</p></div>		<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Notes</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. Used <b>WHITE TAPE</b> to easily visualize the tape shifting, but actual should be <b>BLACK TAPE</b>.</li><li>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</li></ol> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li></ol>

**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:

311D

/

7L0154-7023

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

October 02, 2024

Validity Date:

n/a

Document No.:


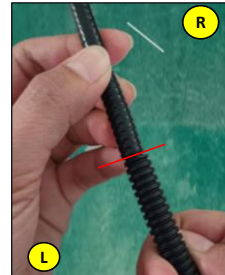

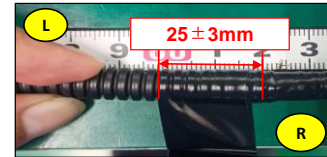
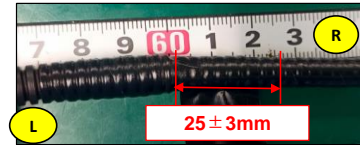
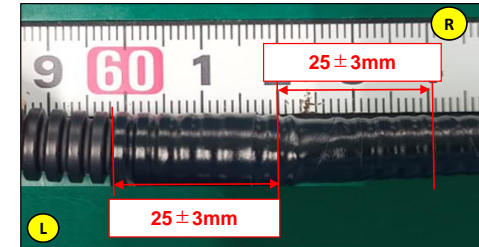

WI-ENG-PDE-1026A

Revision No.:

1

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<p>Taping 2 Black Corrugated tube (No slit) to Corrugated tube (w/ slit)</p>  <p>1. Measure from end of the Corrugated tube (No slit) up to end of hotmelted wire <b>272mm</b> using both hands.</p>  <p>2. Fix the <b>Corrugated tube (No slit)</b> and the <b>Corrugated tube (w/slit)</b> using both hands.</p>  <p>3. Get the black tape and start taping process using both hands.</p>  <p>4. Measure from end of tape up to end of Corrugated tube (No slit) <b>25±3mm</b>.</p>  <p>5. Measure from end of Corrugated tube (No slit) to end of tape <b>25±3mm</b>.</p>  <p>6. After taping, check the measurement and taping condition.</p>		<p><b>MEASURING TAPE</b></p> 	<p><b>Important reminders/Notes</b></p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing 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**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 02, 2024**Model code/Part number: **311D / 7L0154-7023** Customer: **TRQSS** Car Model: **TOYOTA-RAV4**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

**WI-ENG-PDE-1026A**

Revision No.:

**1**

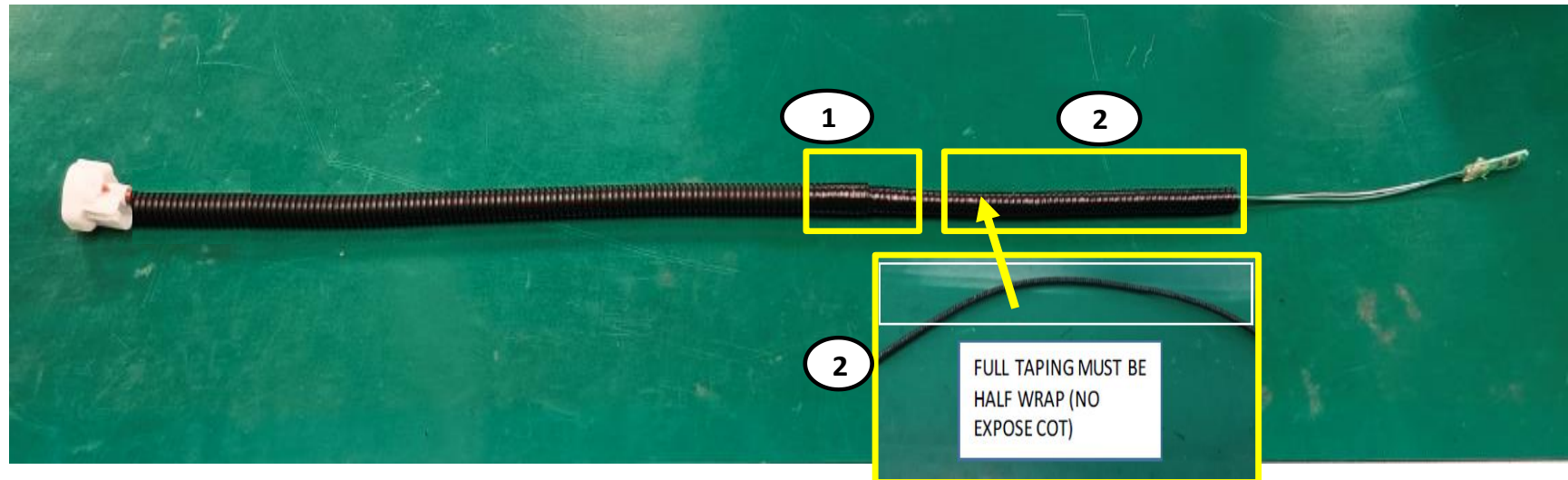
Page No.:

**5 of 5**

PARTS: n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7L0154-7023****1****No MISSING TAPE****2****No EXPOSED 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