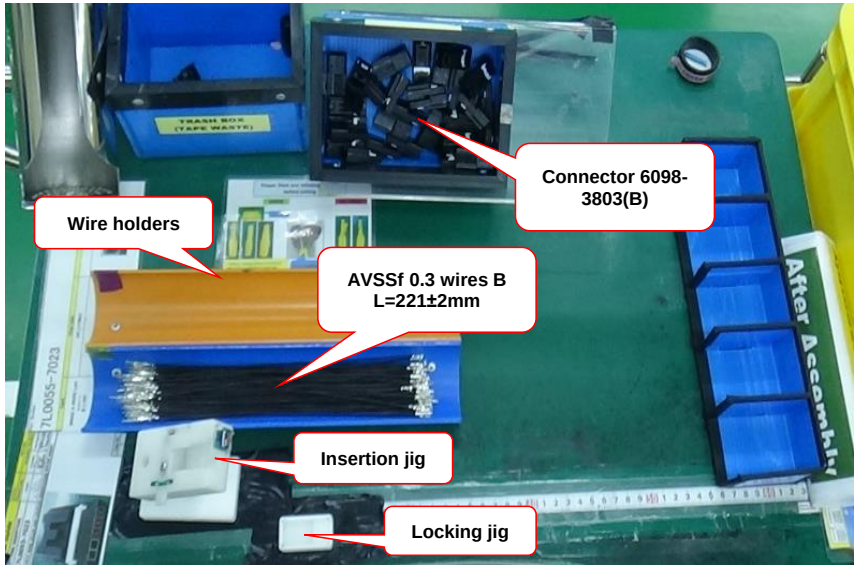
	WORK INSTRUCTION			Effectivity Date:	May 22, 2024		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	320B / 7L0055-7023	Customer: TRQSS / Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-282		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	1 of 5

PARTS:	1. All parts: Connector 6098-3803 (B); AVSSf 0.3 B L=221±2mm	JIG:	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	1 n/a	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.	***Document references:*** *1. Refer to **WI-PRO-CNC-017** for Wire and Strip length tolerance.* 1. No missing pats/tools 2. No excess parts/tools

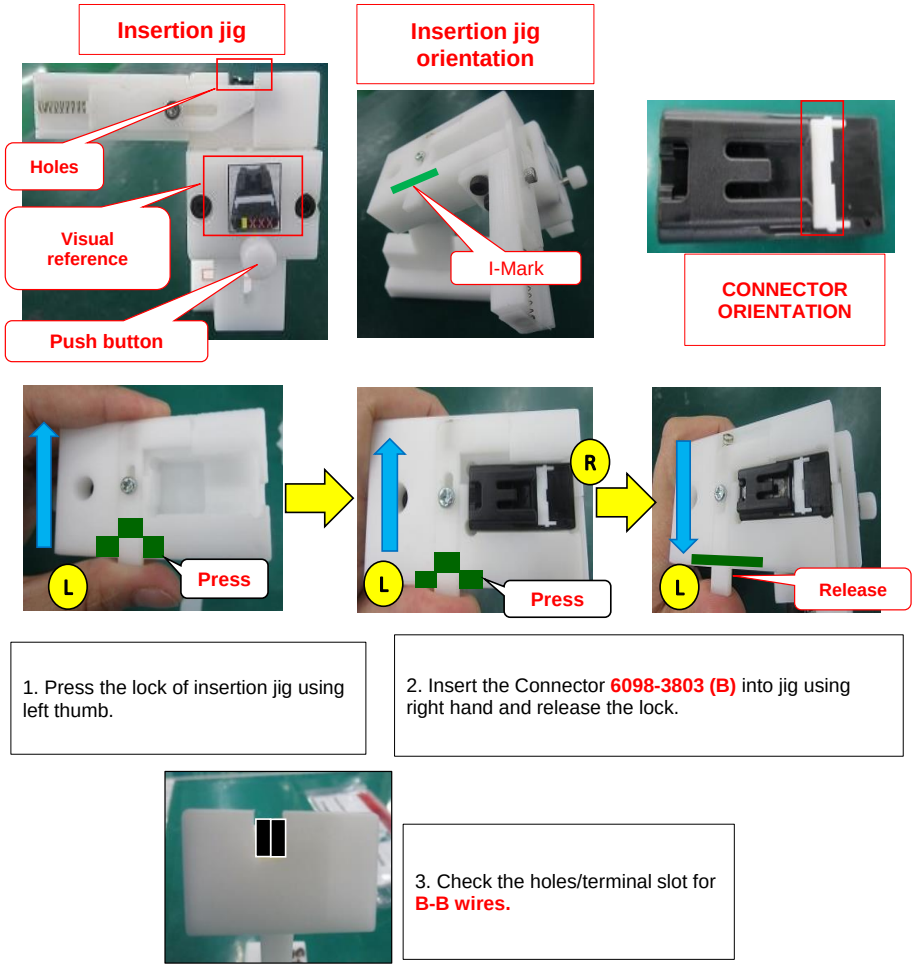
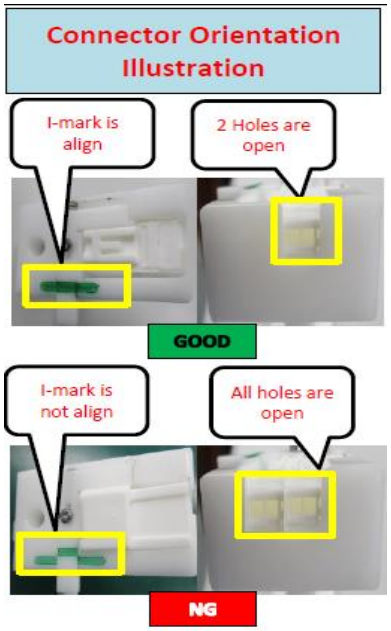
Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/22/24	1	Transfer to new format from Kitting Assembly process to Offline Assembly process. Inclusion of table lay-out, Measurement, Quality checkpionts and Car model **"TOYOTA RAV 4".** Update connector lock Work Procedure/Illustration.	D. Castillo	C. Villanueva	A. Arañes	n/a				
06/11/21	0	Excluded form Production WI (WI-PRO-ASY-147) to have separate Work instruction. Improve all process illustrations and quality pointers.	J.Loterte	C. Villanueva	A.Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 9, 2021		

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			Effectivity Date:	May 22, 2024		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	320B / 7L0055-7023	Customer: TRQSS / Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-282		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	2 of 5

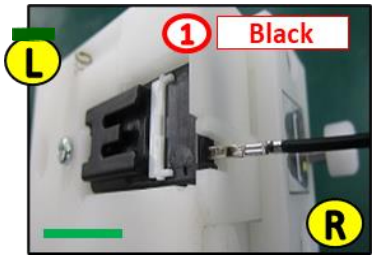
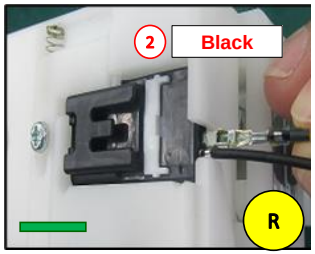
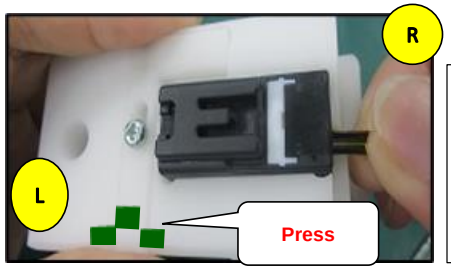
PARTS:	1. Connector 6098-3803 (B)			JIG:	1. Insertion Jig`
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	n/a	Connector Setting to Insertion jig 6098-3803 (B)	 1. Press the lock of insertion jig using left thumb. 2. Insert the Connector **6098-3803 (B)** into jig using right hand and release the lock. 3. Check the holes/terminal slot for **B-B wires.**	n/a	 1. Use the provided jig per model 2. No wrong orientation of connector

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

PARTS:	1. AVSSf 0.3 B L=221±2mm [2pcs]	JIG:	1. Insertion jig

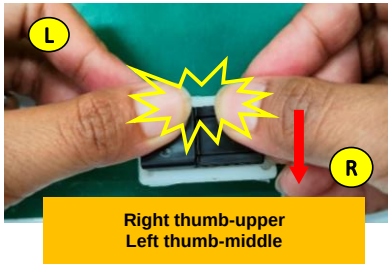
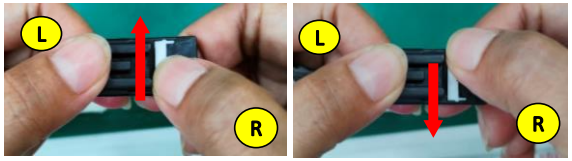
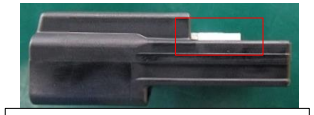
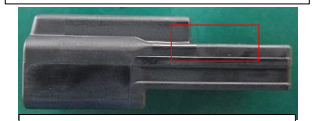
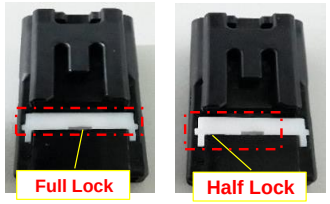
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to connector 6098-3803 (B)	 Wire facing   1. Get the first black wire and insert to connector using right hand. Conduct one by one insertion from left to right. 2. Get the 2nd black wire and insert to connector using right hand.  3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	n/a	***Important reminders/Note/s:*** *1.Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing ***Document references:*** *1. Refer to **WI-PRO-CNC-017** for Wire and Strip length tolerance.*

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			Effectivity Date:	May 22, 2024	
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 320B / 7L0055-7023	Customer: TRQSS	Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-282	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 4 of 5

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	**PROCESS NAME**		**1 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	n/a	Connector Lock	 1. Load the connetor into the jig holing both side of the connector, tip first. 2. Press the lower part of connector to fully insert into the locking jig. 3. Press the lower parts of connector using right hand while left hand holding the middle.  4. Press the upper part of connector using right hand while left hand holding the middle. 5. Lift then press the connector in the middle using left and right hand.  6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.	LOCKING JIG 	1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock. ***Important reminders/Note/s:*** *1. Manual locking may cause damaged connector* ***Document references***: *1.Refer **WI-PRO-KIT-001** Proper locking and checking of connector lock*  **Before pressing**  **After pressing** **GOOD** **NG** 

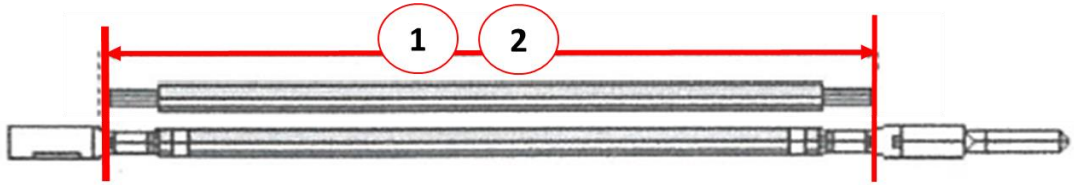
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	May 22, 2024	
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 320B / 7L0055-7023	Customer: TRQSS	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-282	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 5 of 6

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	Measurement	Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.  	MEASURING TAPE 	***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension

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

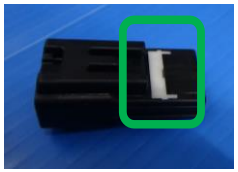
	WORK INSTRUCTION			Effectivity Date:	May 22, 2024		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	320B / 7L0055-7023	Customer: TRQSS / Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-282		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	5 of 5

PARTS:	1. Assy parts	JIG:	n/a

1 VISUAL INSPECTION/ QUALITY CHECKPOINTS

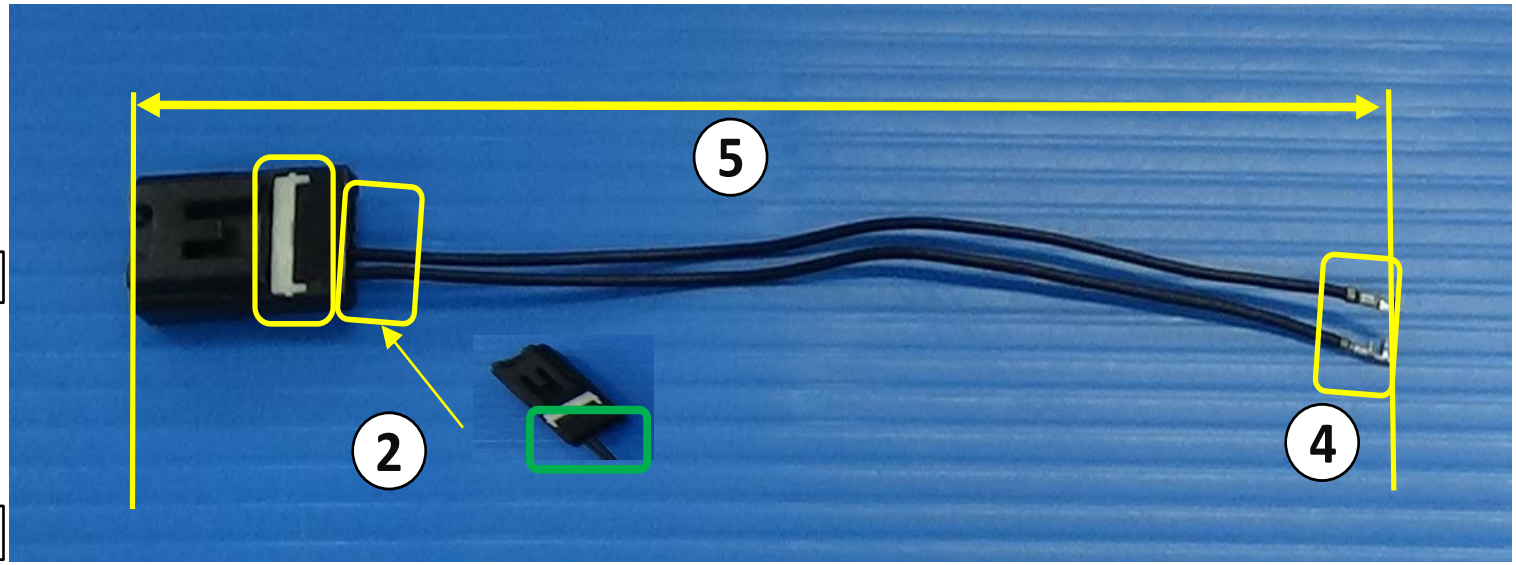
OFFLINE INSERTION 7L0055-7023

1



GOOD

NO GOOD



3

GOOD

NO GOOD

1 No Unlock connector

2 No Wrong insert

3 No Terminal Backing Out

4 No Deform terminal

5 Check the Alignment

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