



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

240B / 7M0487-7020C

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-071

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

1 of 6

PARTS:

1. Assy parts; Black SV tube (Vinyl) $\phi 5$ L=59 \pm 3mm; Black tape

JIG:

1. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

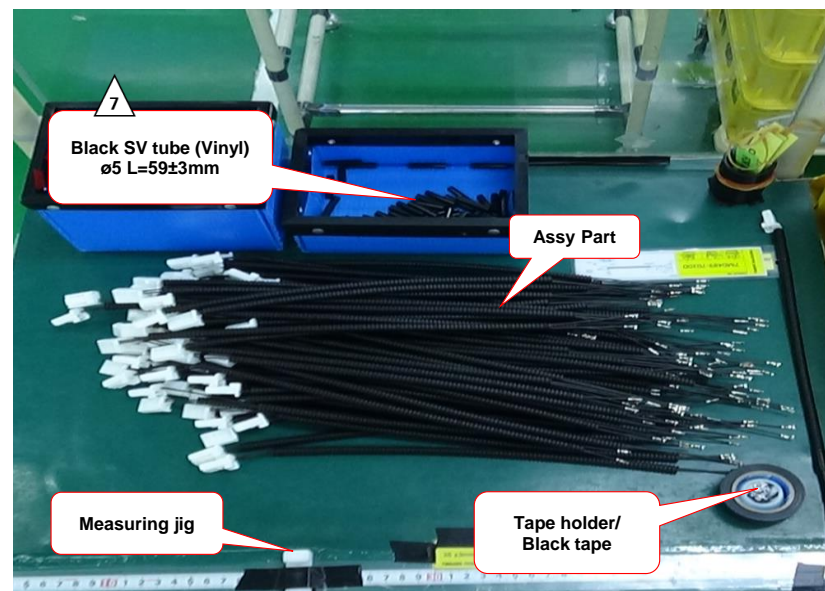
QUALITY POINTERS

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

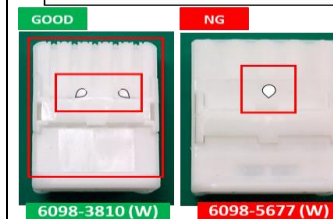
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

Document reference/s:

1. Refer to WI-ENG-PDE-821 for Offline assembly process

CONNECTOR ILLUSTRATION




Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/24/24	7	Transfer some process to Offline assembly and Clamp assembly process due to process improvement. Update table lay-out. Improve Measurement and Visual inspection. Inclusion of car model "Lexus-ES".	D. Castillo	C. Villanueva	A. Arañes	n/a				n/a
01/26/23	6	Inclusion of Batching quantity: 9pcs. Process identification per table by providing table 1 and table 2. Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
10/27/22	5	Improve Quality pointers; Reminders/notes and references on page no. 1,3,4,6,7,8,9,10,11 and 12; Improve work procedure/illustration on process no.4-Connector lock and process no.11- Visual/By two's inspection due to process improvement	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 21, 2020		


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 24, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0487-7020C		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-071	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	2 of 6

PARTS:	7			1. Black SV tube (Vinyl) ø5 L=59±3mm	JIG:	n/a
				2. AVSSf 0.3 Wires B L=386mm±2mm		

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	<div>7</div> <div>Wire Insertion to Black SV tube (Vinyl) ø5 L=59±3mm</div> <div></div> <div>1. Hold the assy part using left hand then insert the Black SV tube (Vinyl) ø5 L=59±3mm using right hand.</div>	n/a	1. No wrong usage of parts 2. 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

**WORK INSTRUCTION**

Effectivity Date:

May 24, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

240B / 7M0487-7020C

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-071

Purpose:


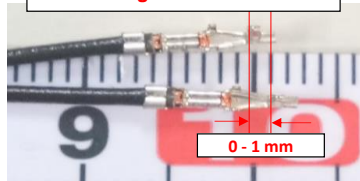
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:


3 of 6

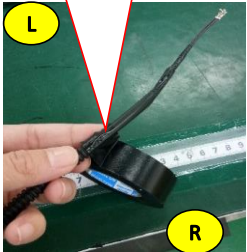
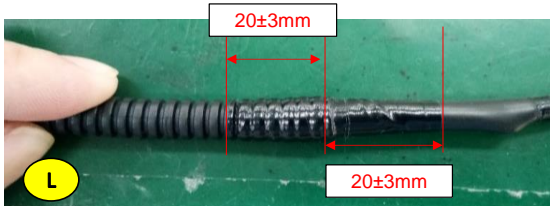

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 <div><div>7</div><div>Taping 1</div><div>Black SV tube (Vinyl) to wire near terminal</div></div>	<div><div>L</div><div><div>55±3mm</div></div></div> <div>1. Measure from SV tube (Vinyl) to terminal tip 55±3mm using both hands.</div>	<div><div>MEASURING TAPE</div><div></div></div>	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape</div> <div><div>Important reminders/Note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div><div>Wire alignment tolerance</div><div></div></div>	
		<div><div>L</div><div><div>R</div></div></div> <div>2. Hold the SV tube (Vinyl) using left hand, get Black tape using right hand and begin taping process.</div>			
		<div><div><div>35±3mm</div><div>20±3mm</div></div></div> <div>3. After taping, check the measurement, wire alignment and taping condition.</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			Effectivity Date:	May 24, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0487-7020C		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-071		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	4 of 6


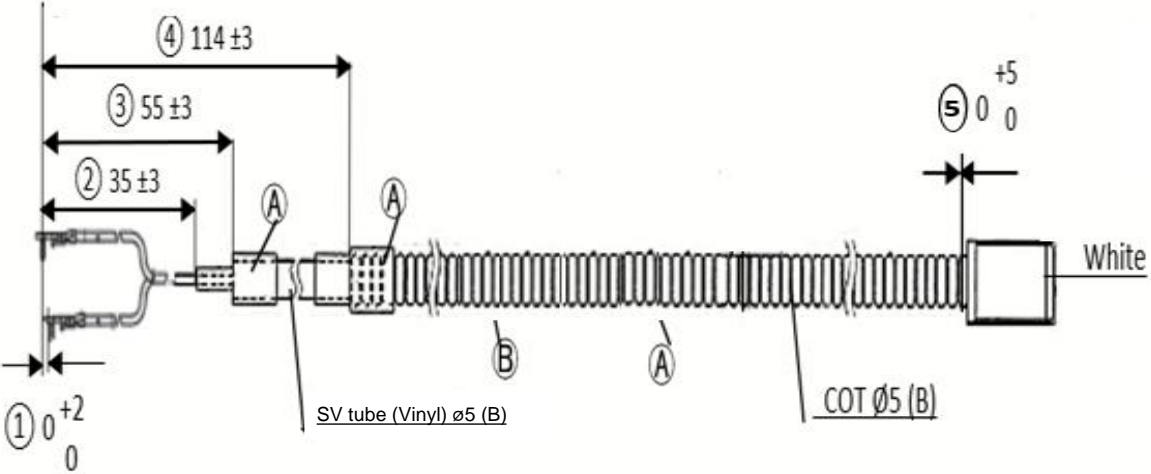
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P1 <div>Taping 2 Black Corrugated tube to Black SV tube (Vinyl)</div>	<div>No gap between COT and Black SV tube (Vinyl)</div>  <div>1. Fix the Corrugated tube and SV tube (Vinyl) using left hand, get the Black tape using right hand and start the taping process using both hands.</div>  <div>2. After taping, check the measurement and taping condition.</div>	<div>MEASURING TAPE</div> 	Important reminders/Notes/: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Make sure no gap between the COT and SV tube (Vinyl) 1. No loose tape 2. No flip-out tape 3. No peel-off 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			Effectivity Date:	May 24, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0487-7020C		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-071		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	5 of 6

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	7	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
4	P1	Measurement	<div><p>MEASURING TAPE</p></div>  <div>NOTE: Ⓐ - Taping (B)</div>		<p>Important reminders and note/s:</p> <p>1. Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1.No wrong dimension</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:

May 24, 2024

Model code/Part number:

240B / 7M0487-7020CCustomer: **TRJ**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-071

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

6 of 6**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****TAPING-P1****7M0487-7020C****1****No Missing Tape/Wrong use of tape (Black 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