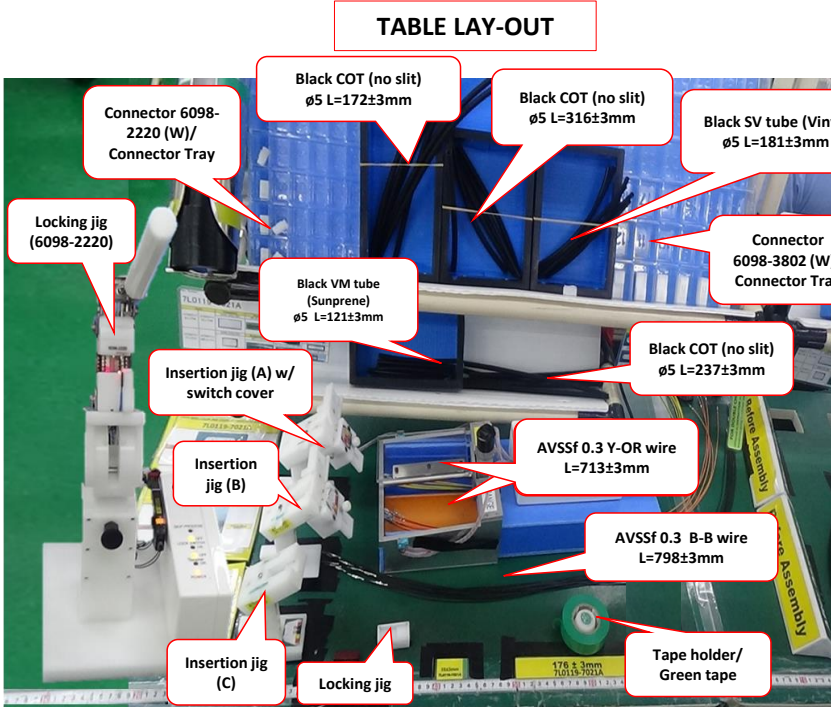
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: July 02, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS		Car Model: TOYOTA-HIGHLANDER	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Document No.: WI-ENG-PDE-393A	
Revision No.: 4				Page No.: 1 of 13		

PARTS: 1. All parts: Connector 6098-2220 (W); Y-OR wire L=713±3mm; Black COT (no slit) Ø5 L=316±3mm; Black COT (no slit) Ø5 L=172±3mm; Black SV tube (vinyl) Ø5 L=181±3mm; Connector 6098-3802 (W); B wire L=798±3mm; Black VM tube (sunprene) Ø5 L=121±3mm; Black COT (no slit) Ø5 L=237±3mm; Green tape [1pc.]		JIG: 1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out		<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
07/02/24	4	Transfer Taping 2 and Taping 3 to WI-ENG-PDE-393B due to process improvement. Update table lay-out and Visual inspection. Additional Work procedure/Illustration and notes on page 4-5 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W).				D.Castillo	C.Villanueva	A. Arañes	n/a		
07/26/23	3	Updated Template; Inclusion of CAR MODEL: TOYOTA-HIGHLANDER ; Change Table lay-out Illustration; Inclusion of Locking process for Connector 6098-2220(W);Improve Quality pointers/Notes and references (page 4 and 5).				M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
05/05/23	2	Change of wordings from Black vinyl tube to Black SV tube (Vinyl) and from Black sunprene tube to Black VM tube (Sunprene) to align with standard tube description.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 03, 2022

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.	<div> NBC (Philippines) MASTER COPY </div>	DCC Stamp
--	--	-----------

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Model code/Part number:

096D / 7L0119-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-393A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:


2 of 13


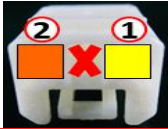
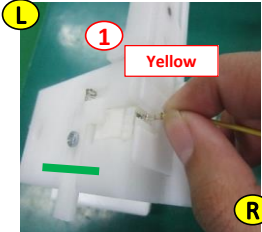
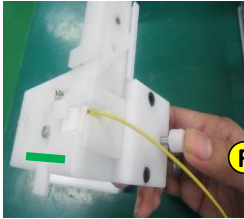
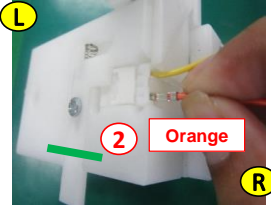
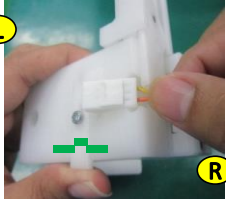
PARTS:	1. Connector 6098-2220 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-2220 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>Insertion jig</div><div>Y-wire</div><div>OR-wire</div><div>I-MARK</div><div>Holes</div><div>Button</div></div><div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div><div><div><div><div></div><div></div><div></div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></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			Effectivity Date:	July 02, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.: WI-ENG-PDE-393A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	3 of 13

PARTS:	1. AVSSf 0.3 Y/OR wires L=713±3mm			JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-2220 (W)	<div><p>WIRE FACING</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>1. Get the Y wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of Y wire, press the button using right thumb. The slot for OR wire will be opened.</p></div> <div><p>3. Get the OR wire then insert to terminal slot 2 using right hand.</p></div> <div><p>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.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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:

July 02, 2024

Model code/Part number:

096D / 7L0119-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-393A

Purpose:

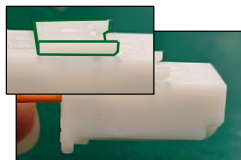
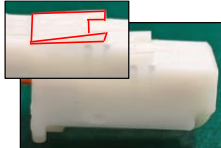
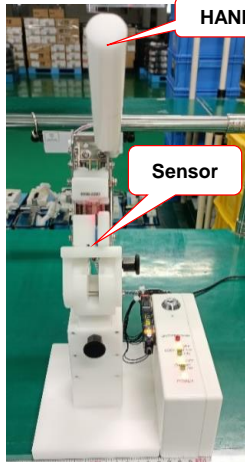
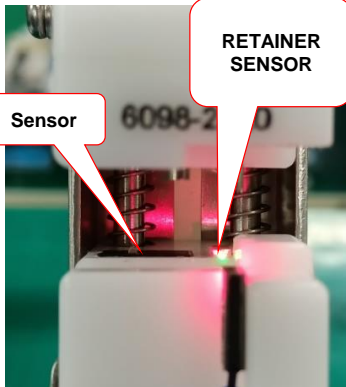
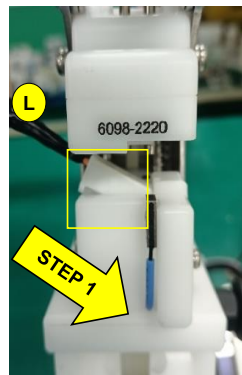
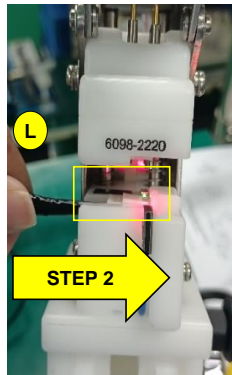
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

4 of 13

PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P1	Connector lock	<div><div><div>CONNECTOR RETAINER ILLUSTRATION</div><div>SIDE VIEW</div><div><div></div><div>GOOD</div></div><div><div></div><div>NG</div></div></div><div><div><div><div>HANDLE</div><div>Sensor</div></div><div><div><div>RETAINER SENSOR</div><div>Sensor</div></div><div><div><div>STEP 1</div></div><div><div><div>STEP 2</div></div></div></div><div>2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock. NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</div></div><div><div>1. Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be NO half-locked condition prior connector locking.</i></div></div></div></div></div>				<div>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector. 2. Maintain 10mm proper holding of wire to connector 3. Connector must be fully inserted to connector slot. 4. Make sure no offset setting before locking process. 5. No wrong setting of connector. 6. No damaged connector lock 7. No unlocked/ half-locked connector.</div> <div><div>4</div><div>Important reminders/Note/s:</div><div><div>1. Incomplete locking process will alarm the jig. 2. No retainer in connector cannot proceed. 3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Model code/Part number:

096D / 7L0119-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-393A

Purpose:

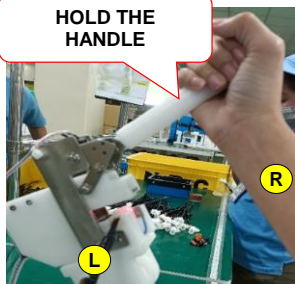
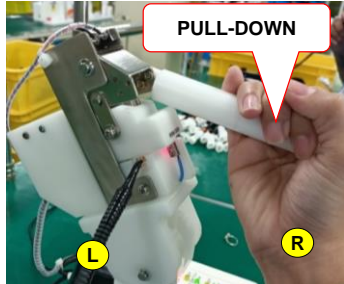
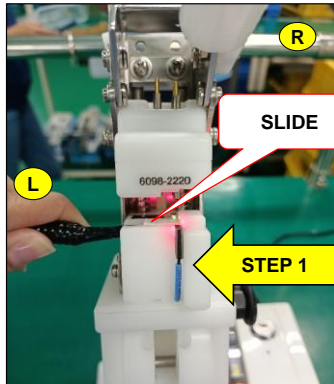
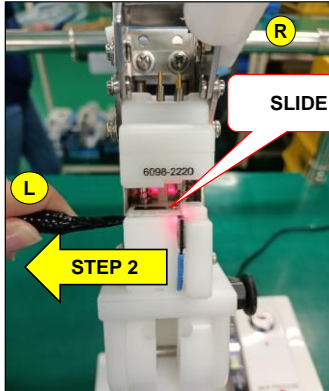
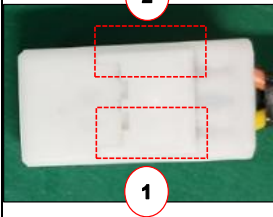

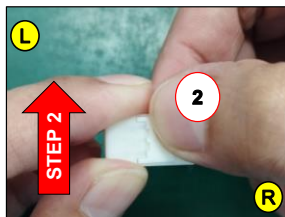
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:


5 of 13



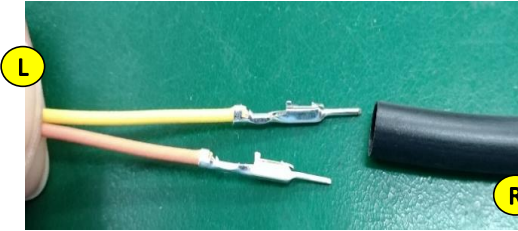
PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION <div>4</div>		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock (Continuation)			
		<div><div><div><div><div></div><div></div></div><div><div></div><div></div></div></div><div><div><div></div><div><div></div><div></div></div></div><div><p>3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div></div></div>		<div>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</div> <div>2. Maintain 10mm proper holding of wire to connector</div> <div>3.Connector must be fully inserted to connector slot.</div> <div>4. Make sure no offset setting before locking process.</div> <div>5.No wrong setting of connector.</div> <div>6. No damaged connector lock</div> <div>7. No unlocked/ half-locked connector</div> <div><div>4</div><div>Important reminders/Note/s:</div><div>1. Incomplete locking process will alarm the jig.</div><div>2. No retainer in connector cannot proceed.</div><div>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</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

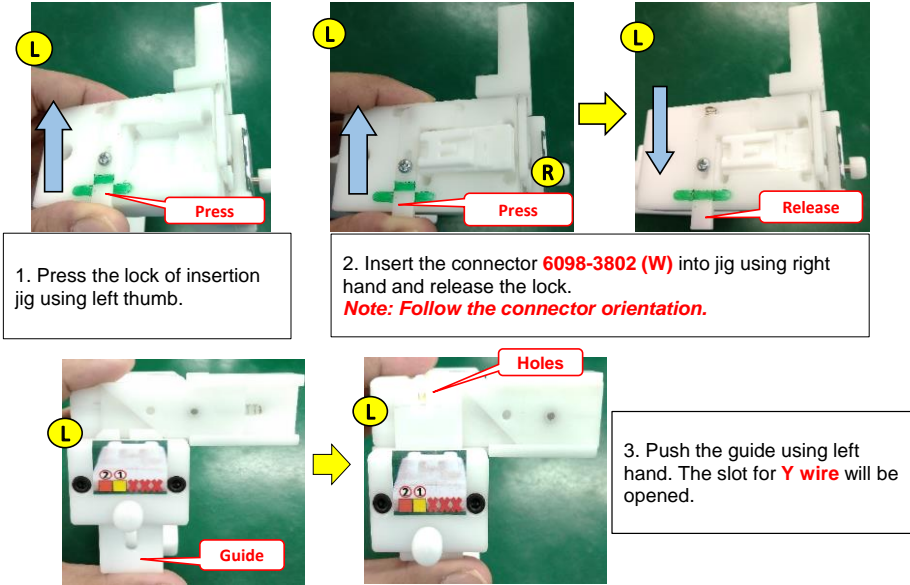
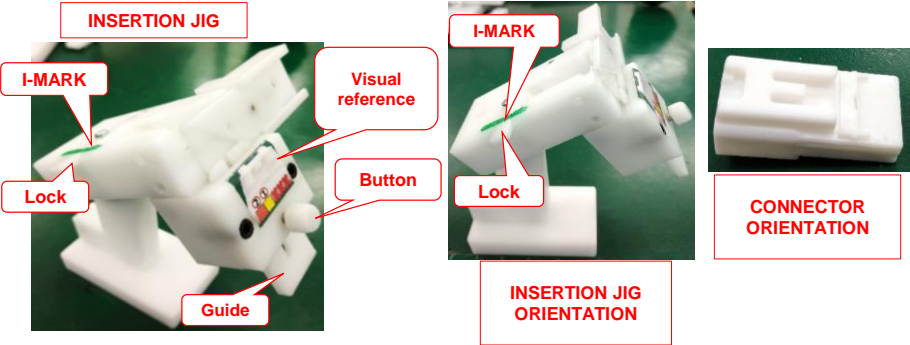
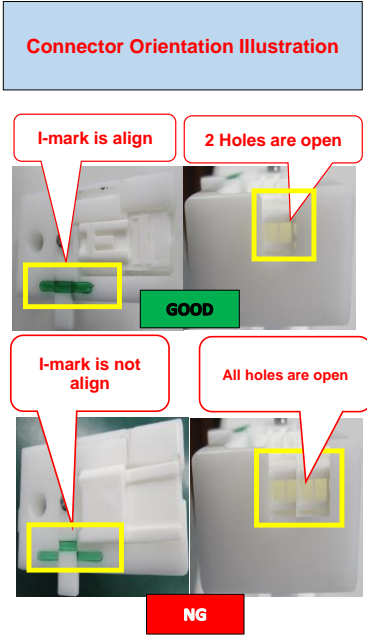
DCC Stamp

	WORK INSTRUCTION				Effectivity Date:		July 02, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS		Car Model: TOYOTA-HIGHLANDER		Document No.: WI-ENG-PDE-393A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.:

PARTS:		1. Assy parts 2. Black corrugated tube (no slit) Ø5 L=316±3mm		3. Black corrugated tube (no slit) Ø5 L=172±3mm 4. Black SV tube (Vinyl) Ø5 L=181±3mm		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
5	Wire insertion to Black corrugated tube (no slit) Ø5 L=316±3mm Ø5 L=172±3mm	<div>  <div> 1. Get the corrugated tube Ø5 L=316±3mm using right hand then insert the Y-OR wire using left hand. </div> </div> <div>  <div> 2. Get the corrugated tube Ø5 L=172±3mm using right hand then insert the Y-OR wire using left hand. </div> </div>				n/a		1. No wrong use of parts 2. No deformed terminal	
6	Wire insertion to Black SV tube (vinyl) Ø5 L=181±3mm	<div>  <div> 1. Get the SV tube (vinyl) Ø5 L=181±3mm using right hand then insert the Y-OR wire using left hand. </div> </div>				n/a		1. No wrong use 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.		<div>  </div>	DCC Stamp
--	--	--	-----------


	WORK INSTRUCTION				Effectivity Date:	July 02, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.: WI-ENG-PDE-393A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.:


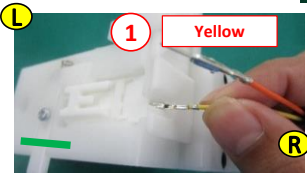
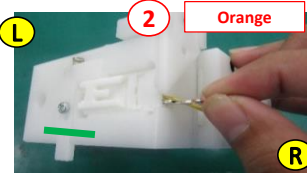
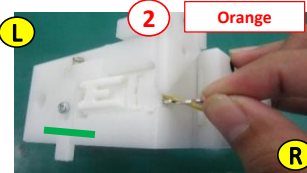
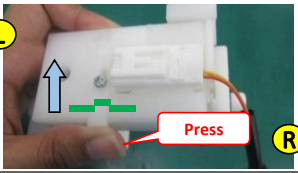

PARTS:		1. Connector 6098-3802 (W)		JIG:	1.Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
7	P1 Connector setting to insertion jig 6098-3802 (W)	<div></div>	n/a	<div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p></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:	July 02, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.: WI-ENG-PDE-393A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	8 of 13


PARTS:	1. Assy parts 2. AVSSf 0.3 B wires L=798±3mm [2pcs.] 3. Black VM tube (Sunprene) Ø5 L=121±3mm			JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the assy part and hold the Y wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of Y wire press the button using right hand. Slot for OR wire will be opened.</p></div> <div><p>3. Get the OR wire then insert to terminal slot 2 using right hand.</p></div> <div><p>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.</p></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2.Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 3.Insertion of wire must be from left to right.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
9	Wire insertion to Black VM tube (sunprene) Ø5 L=121±3mm	<div></div> <div>1.Get the black VM tube (sunprene) Ø5 L=121±3mm using right hand then insert the B-B wires L=798±3mm (n=2) using left hand.</div>		n/a	<div>1. No wrong use of parts</div> <div>Document reference/s: 1.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

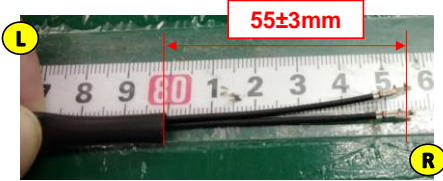
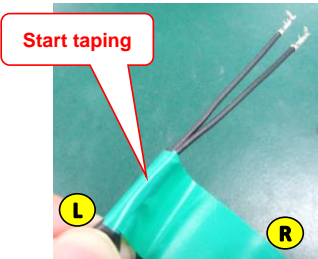
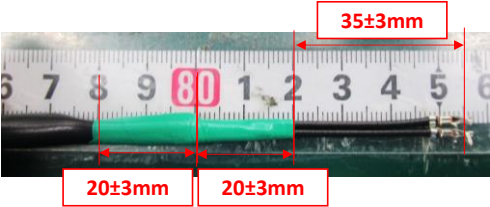

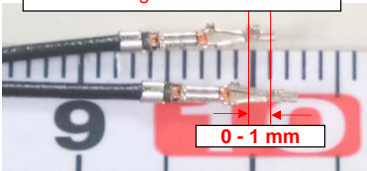

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

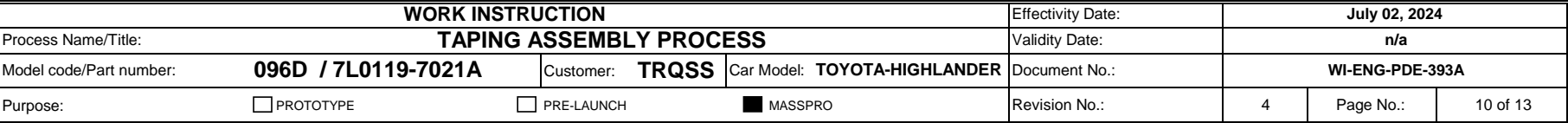
	WORK INSTRUCTION				Effectivity Date:	July 02, 2024				
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER		Document No.:	WI-ENG-PDE-393A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.:	9 of 13	


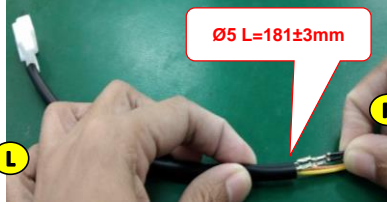
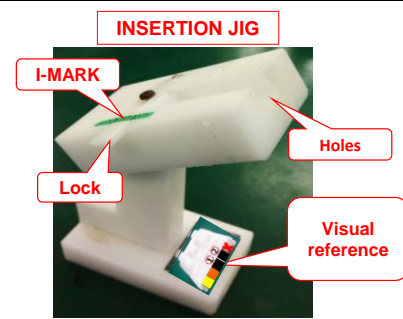



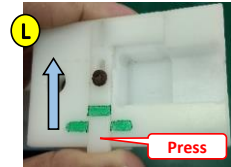
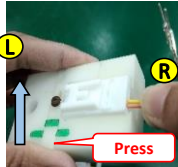
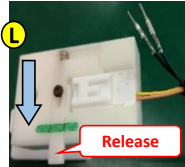

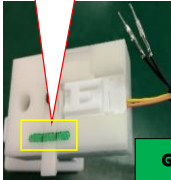
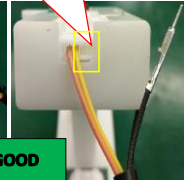
PARTS:	1. Assy parts 2. Green tape		3. Black corrugated tube (no slit) Ø5 L=237±3mm		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
10	Taping 1 Black corrugated tube to wire near terminal	<div><p>1. Measure from end of sunprene tube up to terminal pointed tip 55±3mm using both hands.</p></div> <div><p>2. Get the Green tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>				<div><p>Wire alignment tolerance</p></div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div>Important reminders/Note/s: 1. Use <u>GREEN TAPE</u> only 2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>	
11	Wire insertion to Black corrugated tube (no slit) Ø5 L=237±3mm	<div><p>1. Get the corrugated tube Ø5 L=237±3mm (no slit) using right hand and insert B-B wires using left hand.</p></div>			n/a	<div>1. No wrong use of parts 2. No deformed terminal</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



PARTS:	1. Assy parts			JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	Wire insertion to assy parts	<div><div><p>Ø5 L=172±3mm</p></div><div><p>Ø5 L=181±3mm</p></div></div> <div><div>1. Hold the corrugated tube (no slit) Ø5 L=172±3mm using left hand then insert the assy parts using right hand.</div><div>2. Hold the SV tube (vinyl) (Ø5 L=181±3mm using left hand then insert the assy parts using right hand.</div></div>		n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong insertion
13	P1 Connector setting to insertion jig 6098-3802 (W) (Assy parts)	<div><div><p>INSERTION JIG</p></div><div><p>I-MARK</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div><div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div>3. Check the holes for B-B wires, it must be opened.</div></div></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div><p>I-mark is align</p></div><div><p>2 Holes are open</p></div></div><div><p>GOOD</p></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

NBC (Philippines)
MASTER COPY

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Model code/Part number:

096D / 7L0119-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-393A

Purpose:

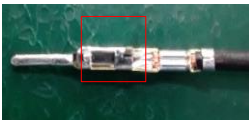
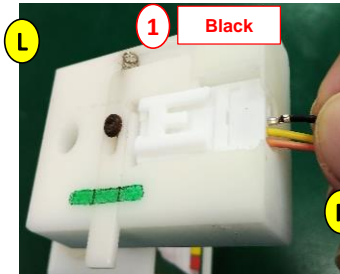
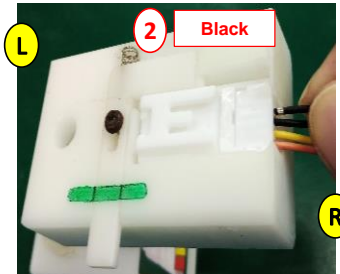
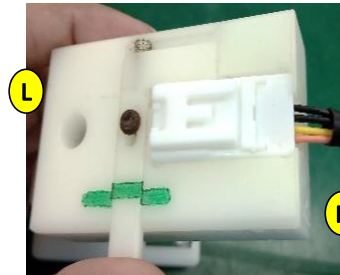
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

11 of 13

PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	Wire insertion to connector 6098-3802 (W) (Assy parts)	<div><div>WIRE FACING</div></div> <div><div>1. Get the assy part and hold the B wire then insert to terminal slot 1 using right hand. Note: Insertion of wire must be from left to right.</div></div> <div><div>2. Hold the B wire then insert to terminal slot 2 using right hand.</div></div> <div><div>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.</div></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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion of wire must be from left to right.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Model code/Part number:

096D / 7L0119-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-393A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH






☒ MASSPRO

Revision No.:

4

Page No.:

12 of 13

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	Connector lock		<div><div></div><div>LOCKING JIG</div></div>	<div><div>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</div><div>Important reminders/note/s: 1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK 2. Use provided jig tool per model to avoid damaged lock.</div><div>Document reference/s: 1. Refer to GL-PRO-ASS-017 for the Verification of Coupler lock</div><div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div><div><div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div></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**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Model code/Part number:

096D / 7L0119-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-393A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

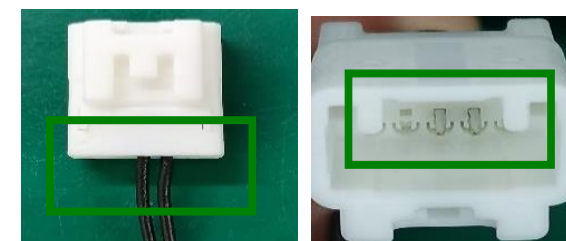
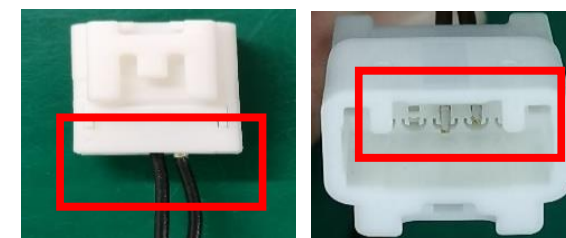
13 of 13

PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION****TAPING - P1****7L0119-7021A****GOOD****GOOD****NO GOOD****NO GOOD****1 No Deformed Terminal****2 No Terminal Backing Out****3 No Missing tape/Wrong Used of Tape (Green 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