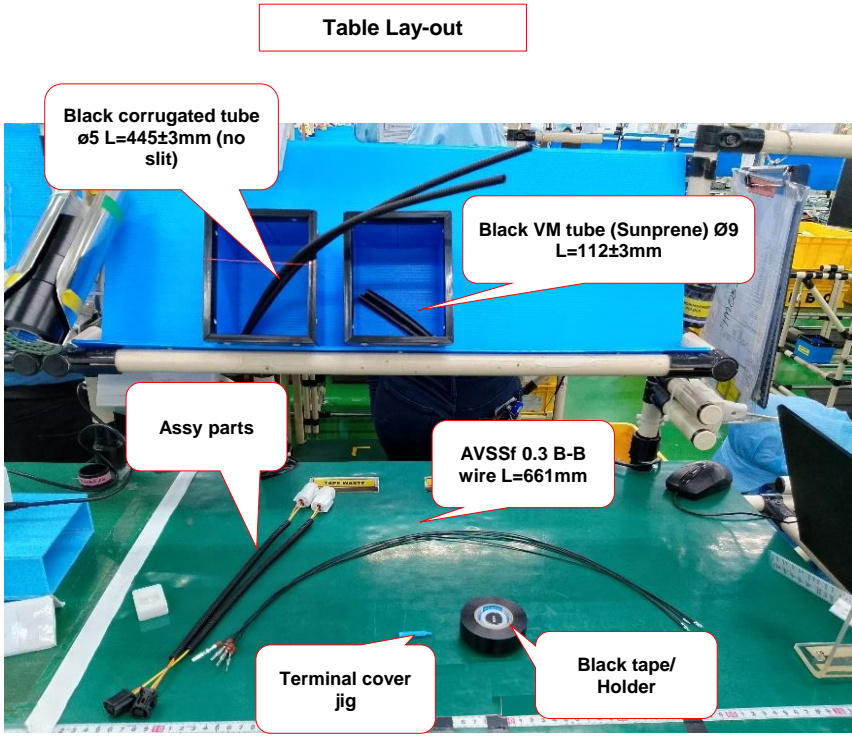


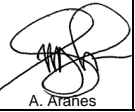
	WORK INSTRUCTION				Effectivity Date: January 14, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 311D / 7L0152-7023		Customer: TRQSS		Car Model: TOYOTA RAV 4	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-1002A		Revision No.: 2	
Page No.: 1 of 5						

PARTS: 1. Assy parts; 1. AVSSf 0.3 B-B wire L=661mm; Black corrugated tube ø5 L=445±3mm (no slit); Black VM tube (Sunprene) Ø9 L=112±3mm ; Black Tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out	<div style="text-align: center;"> <p>Table Lay-out</p>  </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		Important reminders/Note/s: 1. Refer to WI-ENG-PDE-675 for Offline assembly process 2. 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
01/14/25	2	Additional Quality pointers "No insufficient tape" and add document references (Page 2-4) as countermeasure to customer claim.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes
10/04/24	1	Change pre launch to mass pro. Inclusion of table lay-out. Transfer insertion process to offline assembly and clamp tp clamp taping assembly.	A.Hernandez	C. Villanueva	A. Arañes	n/a			
09/03/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 03, 2024	

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 style="border: 2px solid green; padding: 5px; text-align: center;"> NBC (Philippines) MASTER COPY </div>
--	--

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 14, 2025

Validity Date:

n/a

Model code/Part number:

311D / 7L0152-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Document No.:

WI-ENG-PDE-1002A

Purpose:

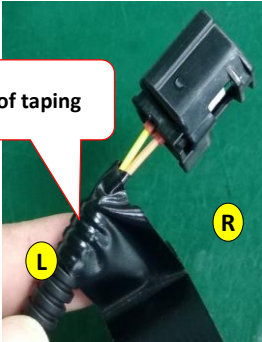
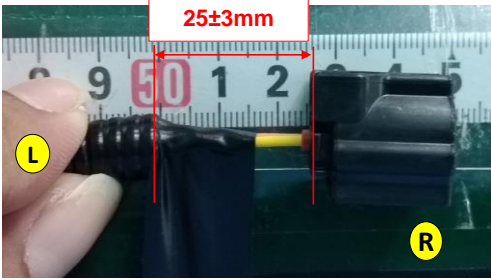
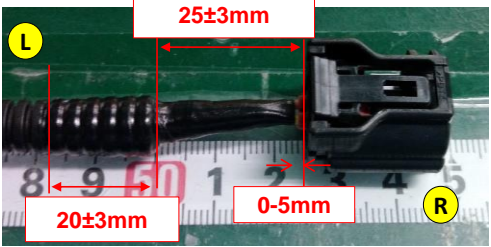

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

2 of 5

PARTS:	1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Black Corrugated tube to Wire near connector	<div data-bbox="683 427 884 494">Start of taping</div>  <div data-bbox="1055 459 1442 608">1. Hold the COT then get Black tape using right hand then start taping process using both hands.</div> <div data-bbox="577 751 1066 1031"><div data-bbox="728 746 884 783">25±3mm</div><div data-bbox="1077 810 1473 991">2. Measure from end of COT up to edge of connector 25±3mm then continue the taping process using both hands.</div><div data-bbox="577 1086 1066 1334"><div data-bbox="712 1082 884 1118">25±3mm</div><div data-bbox="622 1289 728 1326">20±3mm</div><div data-bbox="817 1278 907 1315">0-5mm</div><div data-bbox="1077 1145 1473 1267">3. After taping, check the measurement and taping condition.</div></div></div>	<div data-bbox="1496 762 1720 794">MEASURING TAPE</div>  <div data-bbox="1682 635 1727 671">2</div> <div data-bbox="1682 927 1727 963">2</div>	<div data-bbox="1758 517 2063 608">Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div data-bbox="1758 628 2063 699">Document reference/s: 1. Refer to WI-PRO-ASY-001A for taping procedure.</div> <div data-bbox="1727 783 1944 954">1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape</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:

January 14, 2025

Model code/Part number:

311D / 7L0152-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Document No.:

WI-ENG-PDE-1002A

Purpose:




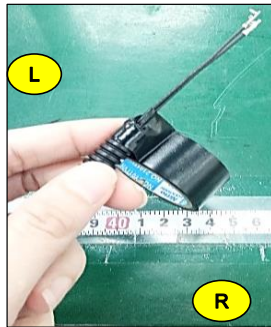

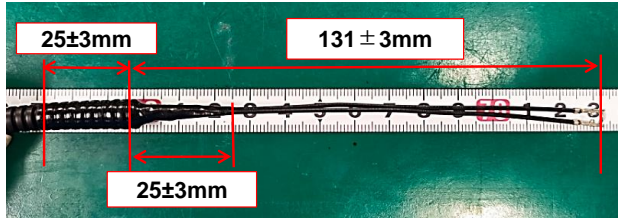


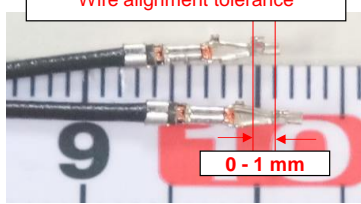
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:


3 of 5


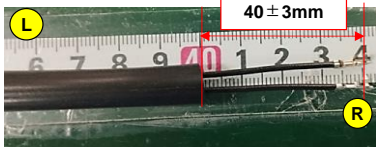

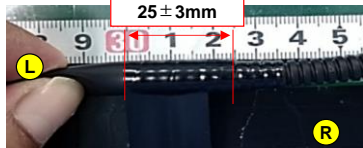





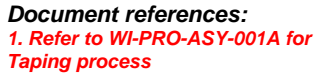
PARTS:		1. AVSSf 0.3 B-B wire L=661mm 2. Black corrugated tube ø5 L=445±3mm (no slit) 3. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		 1. Get the terminal cover jig using right hand then insert the 2 Black wires.  2. Get the Black corrugated tube $\phi 5$ L=445±4mm (no slit) using right hand and insert the 2 Black wires.  3. After insertion, remove the terminal cover jig using right hand.		n/a	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
4	P1	 1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping between COT to wire using both hands.  2. Measure form end of COT up to terminal pointed tip $131 \pm 3\text{mm}$ then continue the taping process using both hands  3. After taping, check the measurement, terminal alignment and taping condition.		 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001A for Taping process 1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape  Wire alignment tolerance 0 - 1 mm

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:	January 14, 2025			
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 311D / 7L0152-7023		Customer: TRQSS	Car Model: TOYOTA RAV 4	Document No.:	WI-ENG-PDE-1002A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	4 of 5	

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=112±3mm 3. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm	 <div> <p>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the assy parts using left hand.</p> </div>		n/a	1. No wrong use of parts 2. no deformed terminal
6	P1 Taping 3 COT to VM tube (Sunprene)	<div>  <p>1. Measure from end of tube up to terminal pointed tip 31±3mm using both hands.</p> </div> <div>  <p>2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.</p> </div> <div>  <p>3. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</p> </div> <div>  <p>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</p> </div> <div>  <p>5. After taping, check the measurement, terminal appearance and taping condition.</p> </div>		<div>   </div> <div>  </div> <div>  </div>	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape 8. Check the tape from COT to VM tube (Sunprene) (Conduct bending for verification)

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

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 14, 2025

Validity Date:

n/a

Model code/Part number:

311D / 7L0152-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Document No.:

WI-ENG-PDE-1002A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

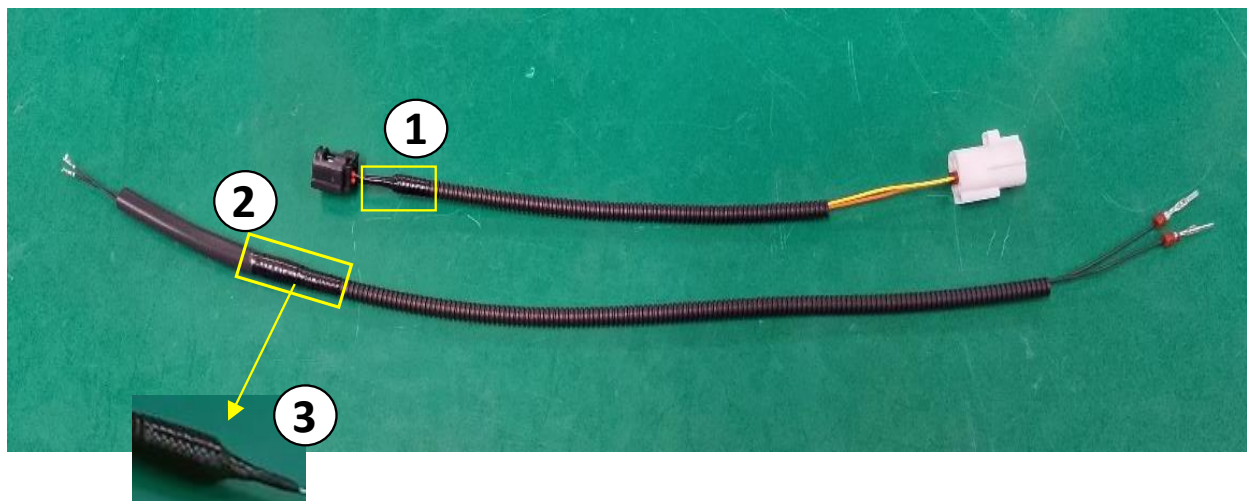
5 of 5

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS**TAPING - P1****7L0152-7023****① ② ③ No Missing TAPE****④ 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