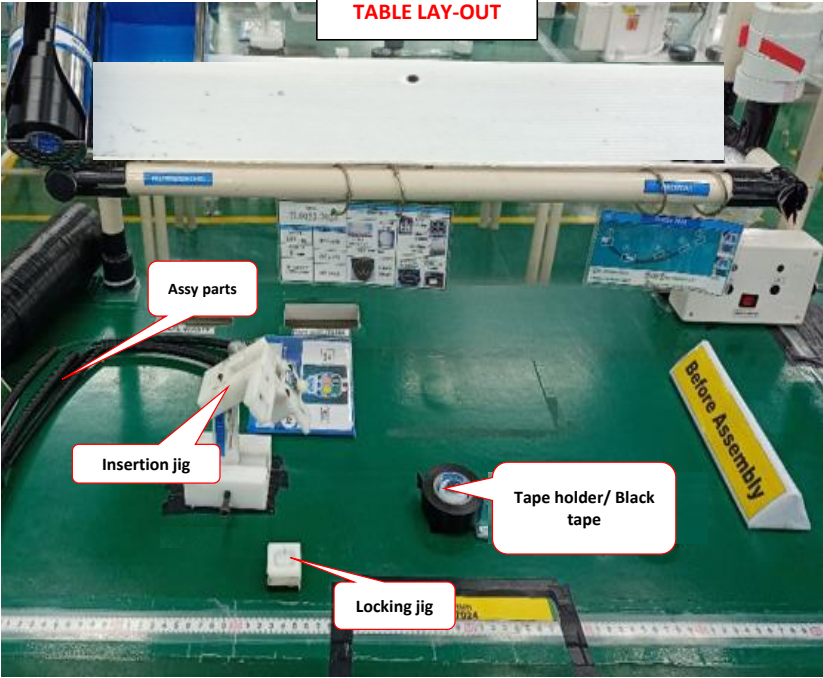




	WORK INSTRUCTION				Effectivity Date:	September 20, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a	
	Model code/Part number: 420B/440B / A7448C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:	WI-ENG-PDE-735B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.: 1 of 8

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P2 Table lay-out	<div> <div>TABLE LAY-OUT</div>  </div>		<div> <div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<div> <div>1. No missing parts/tools</div> <div>2. No excess parts/tools</div> </div>	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
09/20/2023	1	Change purpose from Pre-launch to masspro. Additional Table lay-out; Update Work procedure/Illustration on page no. 3 and 4.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/11/2023	0	Initial Issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 11, 2023



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

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420B/440B / A7448C

Customer:

TRQSS

Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-735B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 8

PARTS:

1. Assy parts
2. Black tape

JIG:

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

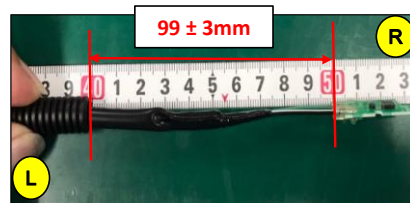
TOOLS/PPE

QUALITY POINTERS

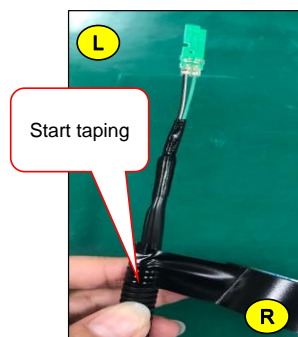
2

P2

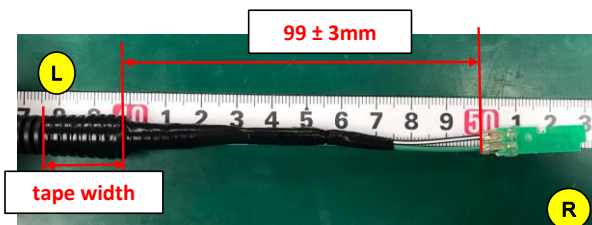
Taping 1
Black Corrugated tube to
Black SV tube (Vinyl)



1. Measure from end of Black Corrugated tube (No slit) up to Hotmelted wires (G-B/W wires) **99±3mm** using both hands.



2. Hold the assy parts using left hand, then get the black tape using right hand then start taping process using both hands.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Note/s:
1. Please use calibrated/Verified measuring tape when getting the measurement.

1. No flip-out tape
2. No peel-of tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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WORK INSTRUCTION

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Effectivity Date:

September 20, 2023

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Model code/Part number:

420B/440B / A7448C

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Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-735B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

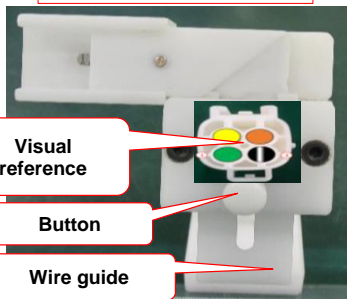
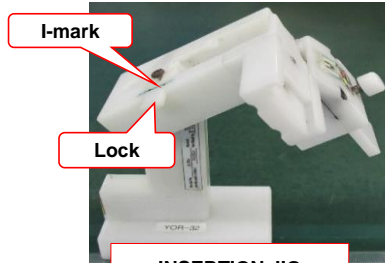
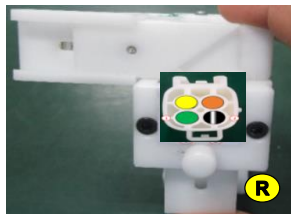
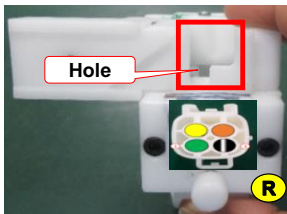
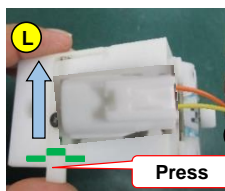

☒ MASSPRO

Revision No.:

1

Page No.:

3 of 8

PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div><div>INSERTION JIG</div><div><div>Visual reference</div><div>Button</div><div>Wire guide</div></div><div><div>I-mark</div><div>Lock</div><div>INSERTION JIG ORIENTATION</div></div><div><div>R</div></div><div><div>Hole</div><div>R</div></div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Release</div></div><div>1. Push the lower wire guide upward using right thumb. Slot for Green wire will be opened.</div><div>2. Press the lock using left thumb.</div><div>1. Push the wire guide upward using right hand. Slot for Green wire will be opened.</div></div> <div>n/a</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>			

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TAPING ASSEMBLY PROCESS

Validity Date:

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Model code/Part number:

420B/440B / A7448C

Customer:

TRQSS

Car Model:

TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-735B

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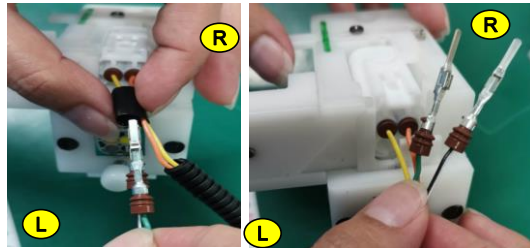
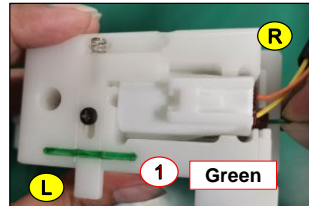

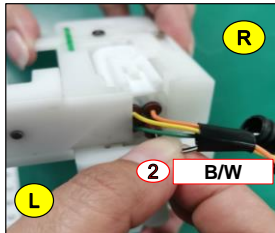

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


4 of 8


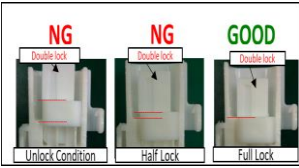



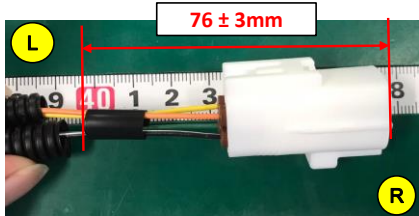
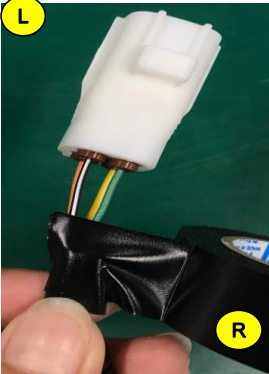
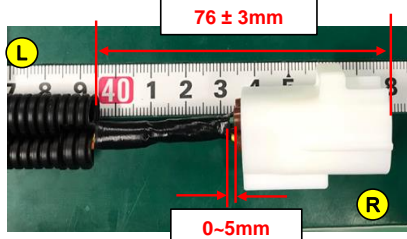

PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	<div>1</div> WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to Black SV tube (Vinyl) [Assy parts]	<div><div>1. Hold the assy parts using left hand then insert the G-B/W wires with assy parts using right hand.</div></div>	n/a	1. No wrong usage of parts 2. No deformed terminal
5		Wire insertion to connector 6189-0093 (W)	<div><div><div>1 Hold the Green wire then insert to terminal slot 1 using right hand.</div></div><div><div>2. Press the button using right thumb. The slot for B/W wire will be opened.</div></div><div><div>3. Hold the B/W wire then insert to terminal slot 2 using right hand.</div></div><div><div>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div></div>	n/a	<div>1. No wrong insertion of wires 2. No loose insertion 3. No wrong insertion 4. One by one insertion 5. No deformed terminal 6. 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.</div> <div>Document reference/s: 1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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	WORK INSTRUCTION				Effectivity Date:	September 20, 2023			
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 420B/440B / A7448C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:	WI-ENG-PDE-735B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Connector lock	<div>     </div> <div> 1. Put the connector into locking jig using both hands and then press 2x. Check the connector lock if properly lock. </div>		<div> LOCKING JIG  </div>	<div> 1. Use provided locking jig per model. 2. No unlock/half-locked connector </div> <div> Document reference/s: 1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure. </div>
7	P2 Taping 2 Black SV tube (Vinyl) to wire near connector	<div>  <div> 1. Measure from end of Black SV tube (Vinyl) up to Connector 76±3mm </div>  <div> 2. Hold the SV tube (Vinyl) using left hand then get the black tape using right hand then start taping on the 3/4 part of the SV tube (Vinyl) using both hands. </div>  <div> 3. After taping, check the measurement and taping condition </div> </div>		<div> MEASURING TAPE  </div>	<div> 1. No flip-out tape 2. No peel-of 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. Please use calibrated and verified measuring tape when getting the measurement. </div>

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WI-ENG-PDE-735B

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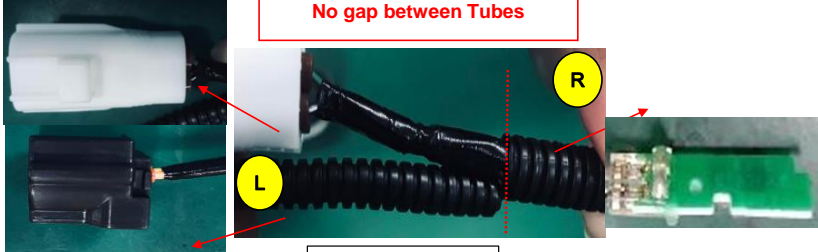
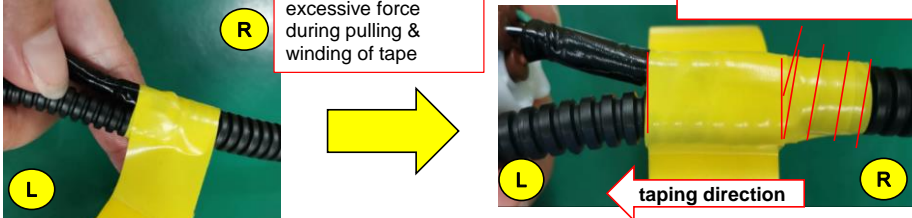
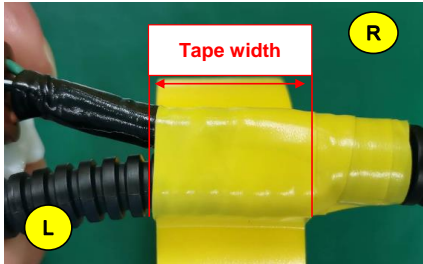

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

6 of 8

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	Y-Taping			
		<div><div><div></div><div>1. Fix the tubes</div></div><div><div><div></div><div>2. Start taping at the middle of combined Corrugated tube and SV tube (Vinyl), then wind the tape to left side.</div></div><div><div><div></div><div>3. Confirm Tape width measurement from end of tape up to end of Combined tubes then continue the taping process using both hands.</div></div></div></div></div>		<div><div>MEASURING TAPE</div><div></div></div>	<div>1. No flip-out tape 2. No peel-of 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>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</div>

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Validity Date:

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Model code/Part number:

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Car Model:

TOYOTA-LAND CRUISER

Document No.:

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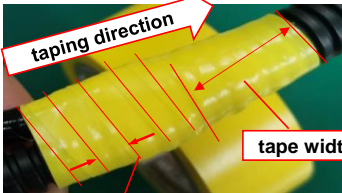
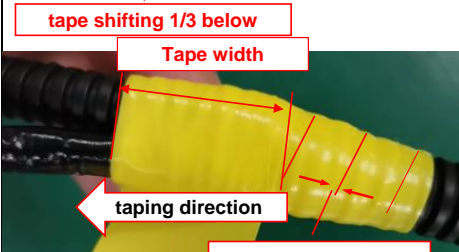
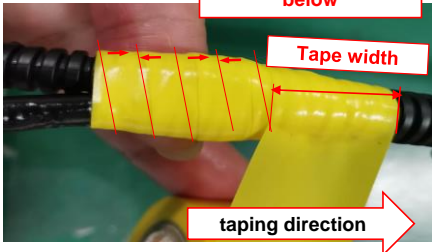
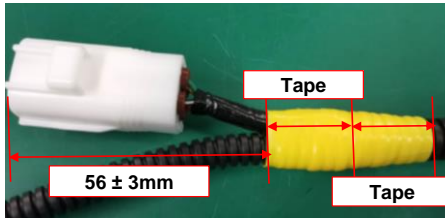

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

7 of 8

PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2 Y-Taping (Continuation)	<div></div> <div><p>4. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</p></div> <div></div> <div><p>5. Make 2 windings of tape then wind 1/2 shifting going to other side.</p></div> <div></div> <div><p>6. Make 2 windings of tape then wind the tape 1/2 shifting going to other side of corrugated tube then make 3 windings of tape and cut.</p></div> <div></div> <div><p>7. After taping, check the measurement and tape condition.</p></div>	<div>MEASURING TAPE</div> 	<p>1. No flip-out tape 2. No peel-of tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p>

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Model code/Part number:

420B/440B / A7448C

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TRQSSCar Model: **TOYOTA-LAND CRUISER**

Document No.:

WI-ENG-PDE-735B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

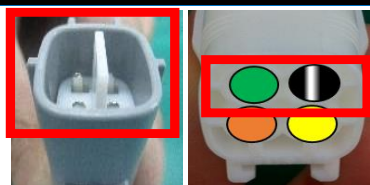
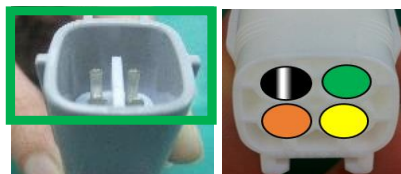
8 of 8

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P2****A7448C****NO GOOD****GOOD**

- ① **No WRONG INSERT**
No UNLOCKED/HALFLOCKED
NO TERMINAL BACKING OUT

- ② ③ **No MISSING TAPE**
④ **No DEFORMED TERMINAL/PCB**

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