




Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañas	N/A
7/04/2024	0	Initial Issue		A. Hernandez	C. Villanueva	A. Arañas				
Eff. Date	Rev. No	Details of Change			Prepared by	Reviewed by	Approved by	Noted by	Est. Date:	April 10, 2024

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 4, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

310D / 75S744-7050A

Customer: TRJ

Car Model:

RAV4

Document No.:

WI-ENG-PDE-868

Purpose:




☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

2 of 7

PARTS:		1. Connector 4A1230-0000 (W); 2. AVSS 0.3 R L=166±2mm; WG L=168±2mm; BR L=172±2mm;		JIG:	n/a																				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																				
3	n/a Wire insertion to connector PBVP-10V-S (W)	<div><div>VISUAL REFERENCE</div></div> <div><div>Wire facing</div></div> <div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td></tr><tr><td>R</td><td>WG</td><td></td><td></td><td>BR</td></tr><tr><td>166</td><td>168</td><td></td><td></td><td>172</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td></tr></table></div> <div></div> <div>4. Hold the connector PBVP-10V-S (W) then get the Red wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to WG wire in terminal Slot 2 and BR wire in terminal Slot 5. Note: Follow the insertion sequence based on the illustration.</div> <div>5. After insertion, check the wire condition.</div> <div>NOTE: SET ASIDE THE ASSY PARTS</div>		1	2	3	4	5	R	WG			BR	166	168			172	X	X	X	X	X	n/a	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminder's/Note: 1. Make sure wires are properly inserted. 2. Conduct Pull-Push-Pull-Push after insertion. 3. Do not exert extra force. 4. Please hold the wire near terminal.</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. 2. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</div>
1	2	3	4	5																					
R	WG			BR																					
166	168			172																					
X	X	X	X	X																					

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

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 4, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

310D / 75S744-7050A

Customer: TRJ

Car Model:

RAV4

Document No.:

WI-ENG-PDE-868

Purpose:



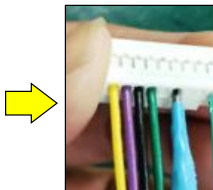
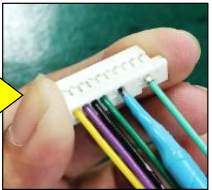
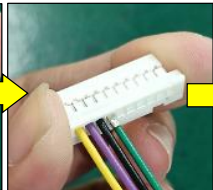


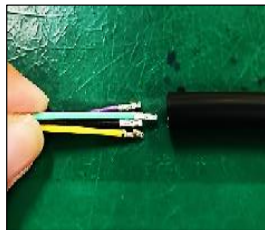
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

3 of 7

PARTS:		1. Assy parts 2. Connector PBVP-10V-S (W) 3. Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm		4. AVSSF 0.3 GR/B L=113±1mm; R L=166±2mm; WG L=168±2mm; BR L=172±2mm; B L=285±2mm; V L=285±2mm; Y L=285±2mm; G L=285±2mm; LG L=289±2mm;		B		JIG:	n/a																														
NO.	PROCESS NAME			WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS																														
4	n/a	Wire insertion to connector PBVP-10V-S (W)	<div><div><div>VISUAL REFERENCE</div></div><div><div><div>Wire facing</div></div><div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>Y</td><td>V</td><td>B</td><td>G</td><td>GR/B</td><td>GR/B</td><td>GR/B</td><td>GR/B</td><td>LG</td><td>LG</td></tr><tr><td>285</td><td>285</td><td>285</td><td>285</td><td>113</td><td>113</td><td>113</td><td>113</td><td>289</td><td>289</td></tr></table></div></div></div>					1	2	3	4	5	6	7	8	9	10	Y	V	B	G	GR/B	GR/B	GR/B	GR/B	LG	LG	285	285	285	285	113	113	113	113	289	289	n/a	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminder's/Note: 1. Make sure wires are properly inserted. 2. Conduct Pull-Push-Pull-Push after insertion. 3. Do not exert extra force. 4. Please hold the wire near terminal.</div>
		1	2	3	4	5	6	7	8	9	10																												
Y	V	B	G	GR/B	GR/B	GR/B	GR/B	LG	LG																														
285	285	285	285	113	113	113	113	289	289																														
<div><div></div><div>6. Hold the connector PBVP-10V-S (W) then get the Yellow wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to V-B-G. Get the GR/B wire then insert to terminal slot 6. Insert LG wires to Slot 9. Note: Follow the insertion sequence based on the illustration.</div><div>7. After insertion, check the terminal tip condition, must be visible.</div></div>																																							
5		Y-V-B-G-GR/B-LG Wire insertion to Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm PBVP-10V-S (W)	<div><div></div><div>8. Hold the wires using left hand, get the Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm using right hand then insert the long wires.</div><div>Note: Make sure the GR/B wire is on top of Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm.</div></div>						<div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. 2. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</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

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 75S744-7050A

Customer: TRJ

Car Model:

RAV4

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

July 4, 2024

Validity Date:

n/a

Document No.:




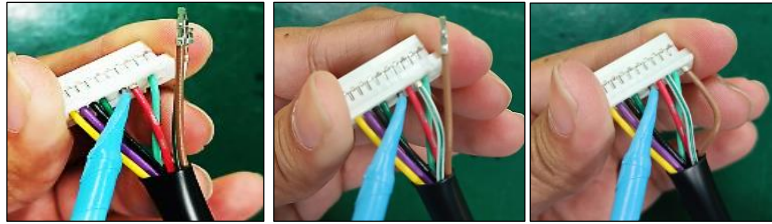
WI-ENG-PDE-868

Revision No.:

0

Page No.:

4 of 7

PARTS:		1. Assy parts		JIG:	n/a																											
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																											
6	n/a	Wire insertion of assy part (Connector 4A1230-0000 (W) with inserted wires) to Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm with assy part	<div></div> <div>9. Hold the assy part (Connector PBVP-10V-S (W) with inserted wires) using left hand then get the first assy part (Connector 4A1230-0000 (W) with inserted wires) using right hand then insert to Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm with inserted wire.</div>	N/A	1. No wrong insertion 2. No deformed terminal																											
7		Wire insertion to Connector PBVP-10V-S (W) with inserted wires	<div><div></div><div><div>Wire facing</div></div><div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>Y</td><td>V</td><td>B</td><td>G</td><td></td><td>GR/B</td><td>R</td><td>WG</td><td>LG</td><td>BR</td></tr><tr><td>285</td><td>285</td><td>285</td><td>285</td><td></td><td>113</td><td>166</td><td>168</td><td>289</td><td>172</td></tr></table></div><div></div></div> <div>10. Hold the Connector PBVP-10V-S (W) with inserted wires then get the Red wire and insert to terminal slot 7 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to W/G wire to Slot 8 and BR wire to Slot 10. Note: Follow the insertion sequence based on the illustration.</div>			1	2	3	4	5	6	7	8	9	10	Y	V	B	G		GR/B	R	WG	LG	BR	285	285	285	285		113	166
1	2	3	4	5	6	7	8	9	10																							
Y	V	B	G		GR/B	R	WG	LG	BR																							
285	285	285	285		113	166	168	289	172																							

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 4, 2024

Validity Date:

n/a

Model code/Part number:

310D / 75S744-7050ACustomer: **TRJ**

Car Model:

RAV4

Document No.:

WI-ENG-PDE-868

Purpose:


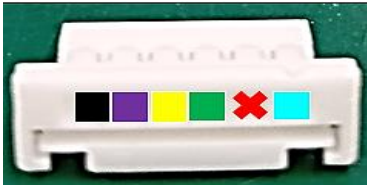



☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

5 of 7

PARTS:		1. Assy parts 2. Connector PBVP-06V-S (W); 3. Black SV tube (Vinyl) $\phi 5.5$; $t=0.5$; $L=122\pm 3$ mm		JIG:	n/a																	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																	
8	Wire insertion of Assy part to Black SV tube (Vinyl) $\phi 5.5$; $t=0.5$; $L=122\pm 3$ mm	 <p>11. Hold the assy part, get 1 pc of Black SV tube (Vinyl) $\phi 5.5$; $t=0.5$; $L=122\pm 3$mm then insert the B-V-Y-G and LG wires in inserted assy parts.</p>			1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing																	
9	Wire insertion of Assy part to Connector PBVP-06V-S (W)	 <p>Wire facing</p> <p>WIRE INSERTION ILLUSTRATION</p> <table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td></tr><tr><td>B</td><td>V</td><td>Y</td><td>G</td><td></td><td>LG</td></tr><tr><td>285</td><td>285</td><td>285</td><td>285</td><td></td><td>289</td></tr></table>    <p>12. Hold the connector PBVP-06V-S (W) then get the Black wire then insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to V-Y-G-LG wires. Note: Follow the insertion sequence based on the illustration.</p> <p>13. After insertion, check the terminal tip condition, must be visible.</p> <p>14. Conduct wire arrangement using both hands.</p>		1		2	3	4	5	6	B	V	Y	G		LG	285	285	285	285		289
1	2	3	4	5	6																	
B	V	Y	G		LG																	
285	285	285	285		289																	

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

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 4, 2024

Process Name/Title:

Model code/Part number:

310D / 75S744-7050A

Customer: TRJ

Car Model:

RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-868

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

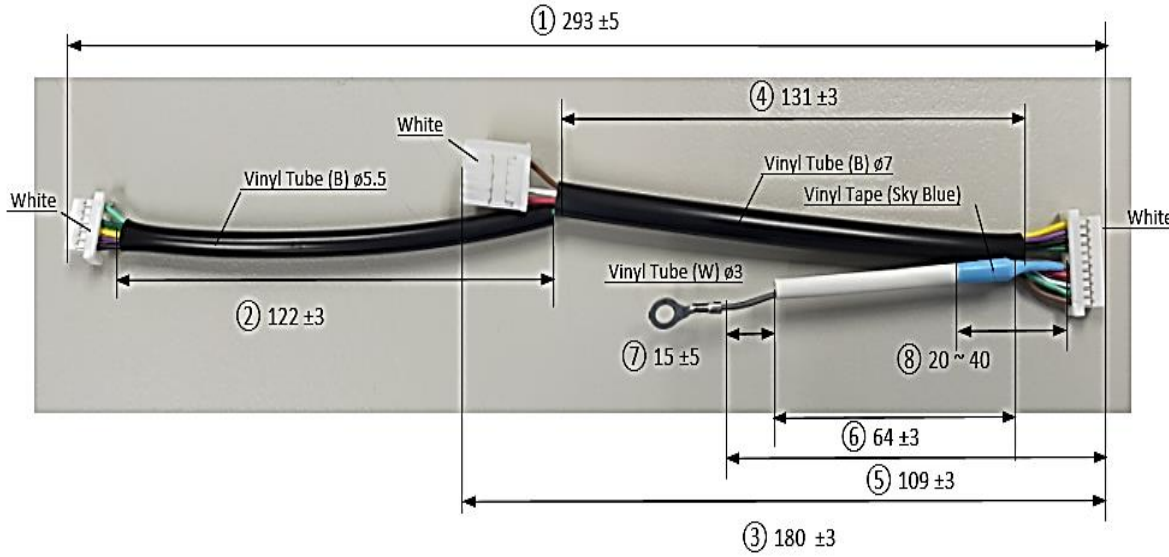

☐ MASSPRO

Revision No.:

0

Page No.:

6 of 7

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	n/a	Measurement			<ul style="list-style-type: none">1. No wrong orientation of connector2. No wrong use of connector3. No damaged connector4. No wrong insertion of wires5. No loose insertion6. No wrong insertion7. One by one insertion8. No wrong wire facing <div>MEASURING TAPE</div>  <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</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

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 75S744-7050A

Customer: TRJ

Car Model:

RAV4

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

July 4, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-868

Revision No.:

0

Page No.:

7 of 7

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION

75S744-7050A

2. Check the wire alignment. Make sure no tangled wires.

3. Check the Connector lock, locking of connector is included to Steering electrical test.

4. Check the orientation of harness.

5. Check if no missing parts.

6. Check the terminal if with backing out (not fully inserted) or deformed terminal.

CORRECT FACING

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