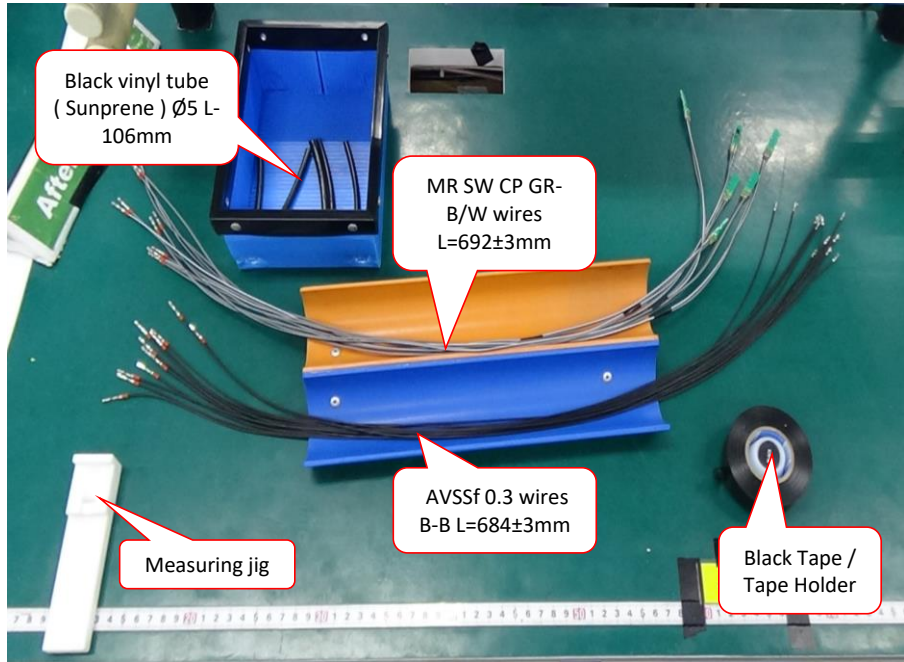







WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	October 15, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1094A		
Revision No.:	1	Page No.:	1 of 4

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	380D / 7L0140-7020B	Customer:	TRQSS
		Car Model:	TOYOTA-CAMRY
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. AVSSf 0.3 wires B-B L=684±3mm 2.Black VM VM tube (Sunprene) ø5 L= 106±3mm		3. Black tape 4.MR SW CP GR-B/W wires L=692±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div>TABLE LAY-OUT</div> 			<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)0</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>	<div>1. No wrong use of parts 2. No deformed terminal</div> <div>Document reference/s: 1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Please refer to WI-ENG-PDE- 669 for Offline Assembly Process</div>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
											n/a
10/15/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a					
10/14/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 14, 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.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

380D / 7L0140-7020B

Customer:

TRQSS

Car Model:

TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-1094A

Purpose:

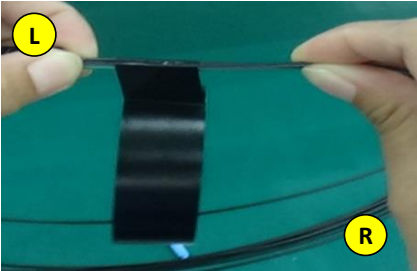

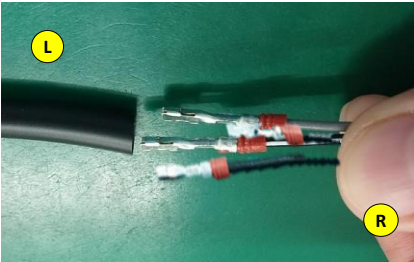
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 4

PARTS:	1. AVSSf 0.3 wires B-B L=684±3mm 2.Black VM tube (Sunprene) ø5 L= 106±3mm 3.MR SW CP GR-B/W wires L=692±3mm 4. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Spot Taping P1	  <div>1. Hold the assy parts using left hand, get black tape then start taping using both hand. Make 2 windings then cut the tape.</div> <div>2. After taping, check the wire alignment and taping condition.</div>	n/a	Important reminders/Note/s: 1. Use <u>BLACK TAPE ONLY</u>. 2. Please use calibrated/verified measuring tape when getting the measurement. 1. No flip-out tape. 2. No peel-off tape. 3. No loose tape. 4. No missing tape. 5. No wrong dimension. 3. No wrong use of tape.
3	Wire insertion to Black VM tube (Sunprene) ø5 L= 106±3mm (Assy parts)	 <div>1. Get the (B-B wires L-684mm , GR and BW L-692mm) using right hand then insert to sunprene tube ø5 L= 106±3mm (Assy parts) using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal Document reference/s: 1. Please refer to WI-PRO-CNC- for Wire and Strip length tolerance.

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:

October 15, 2024

Process Name/Title:

Model code/Part number:

380D / 7L0140-7020B

Customer:

TRQSS

Car Model:

TOYOTA-CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1094A

Purpose:

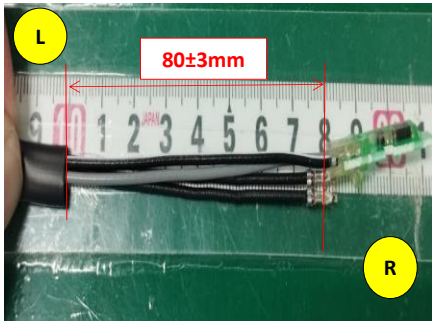

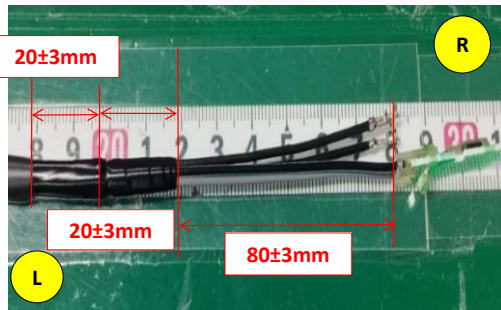

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 4

PARTS:		1.Assy part 2.Black Tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal and PCB	<div><p>1. Hold the VM tube (Sunprene) using left hand. Measure from end of sunprene up to the edge of hotmelted wires 80±3mm and up to terminal pointed tip using right hand.</p></div> <div><p>2. Hold the VM tube (Sunprene) using left hand. Get the Black 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. Note : Taping must be tape width 25±3mm.</p></div>		<div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</div> <p>Important reminders/Note/s:</p> <p>1. 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**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Model code/Part number:

380D / 7L0140-7020B

Customer:

TRQSS

Car Model:

TOYOTA-CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1094A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 4

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P1****7L0140-7020B****① No Missing Spot Tape (Black Tape)****② No Missing Tape (Black Tape)****③ No Missing VM tube (SUNPRENE)**

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