

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Model code/Part number:

310B / 7M0521-7021Customer: **TRJ**Car Model: **TOYOTA-RAV4**

Document No.:

WI-ENG-PDE-416B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

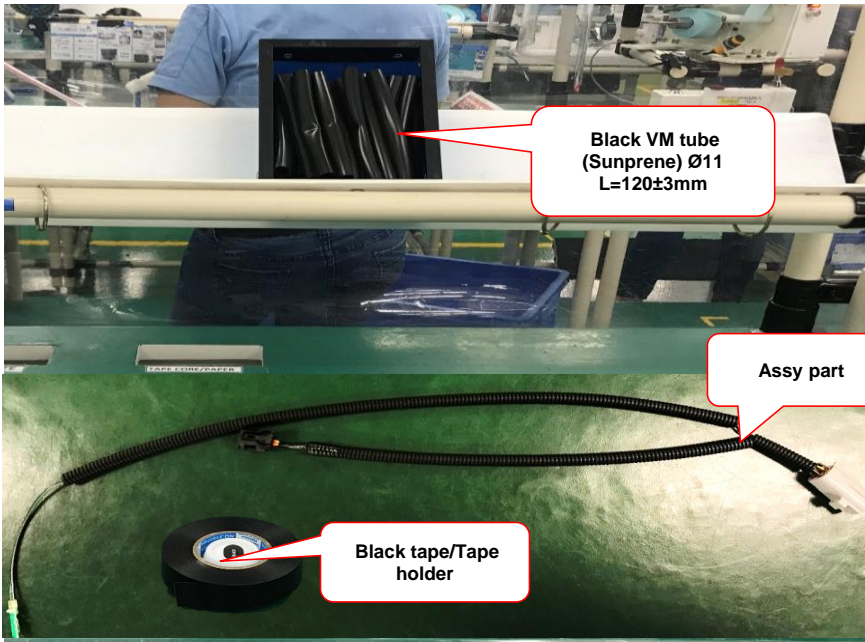
1 of 7

PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø11 L=120±3mm; Black tape

JIG:

n/a

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


Revision History

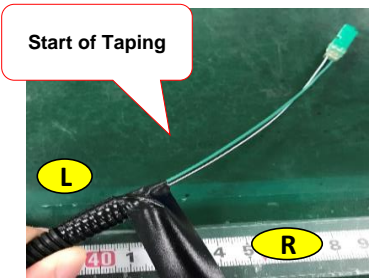
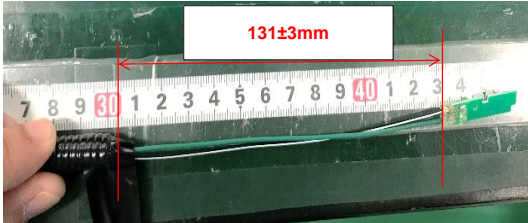
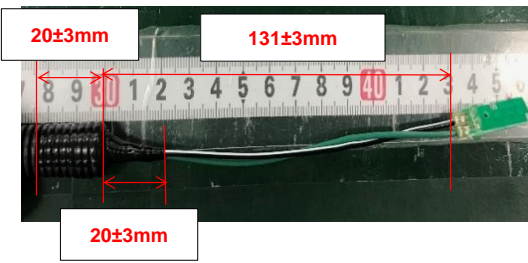

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
06/11/24	2	Inclusion of Car model "TOYOTA-RAV 4" and Measurement.	D.Castillo	C.Villanueva	A. Arañes	N/A
03/10/23	1	Standardized tube description: VM tube (Sunprene);Inclusion of Quality Checkpoints on page no. 6; Improve Quality pointers: Reminders, notes and references on page no.2,3,4 and 5.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
02/23/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
			Est. Date:	February 23, 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.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310B / 7M0521-7021		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-416B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 2 of 7


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 2 Black corrugated tube to wire near hotmelt	<div><p>Start of Taping</p><p>1. Hold the corrugated tube Ø7 L= 460±4mm using left hand then start taping between COT and wire using right hand.</p></div> <div><p>131±3mm</p><p>2. Measure from end of the corrugated tube up to edge of hotmelt 131±3mm then continue the taping process.</p></div> <div><p>20±3mm 131±3mm 20±3mm</p><p>3. After taping, check the measurement and tape condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure</p>	


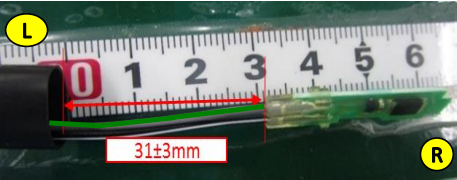



CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310B / 7M0521-7021		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-416B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 3 of 7


PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø11 L=120±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		<div><div><div>L</div><div>R</div></div><div>1. Get the VM tube (Sunprene) Ø11 L=120±3mm using right hand then insert the G-B/W wire using left hand.</div></div>		n/a	1. No wrong use of parts
4	P2 Taping 3 Black VM tube (Sunprene) to Black Corrugated tube	<div><div><div>L</div><div>R</div></div><div>1. Measure from end of the VM tube (Sunprene) up to edge of hotmelt 31±3mm.</div></div> <div><div><div>L</div><div>R</div></div><div>2. Hold the VM tube (Sunprene) using left hand then start taping using right hand.</div></div> <div><div><div>20±3mm</div><div>31±3mm</div><div>20±3mm</div></div><div>3. After taping, check the measurement and tape condition.</div></div>		<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. 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 6. No wrong use of tape Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.

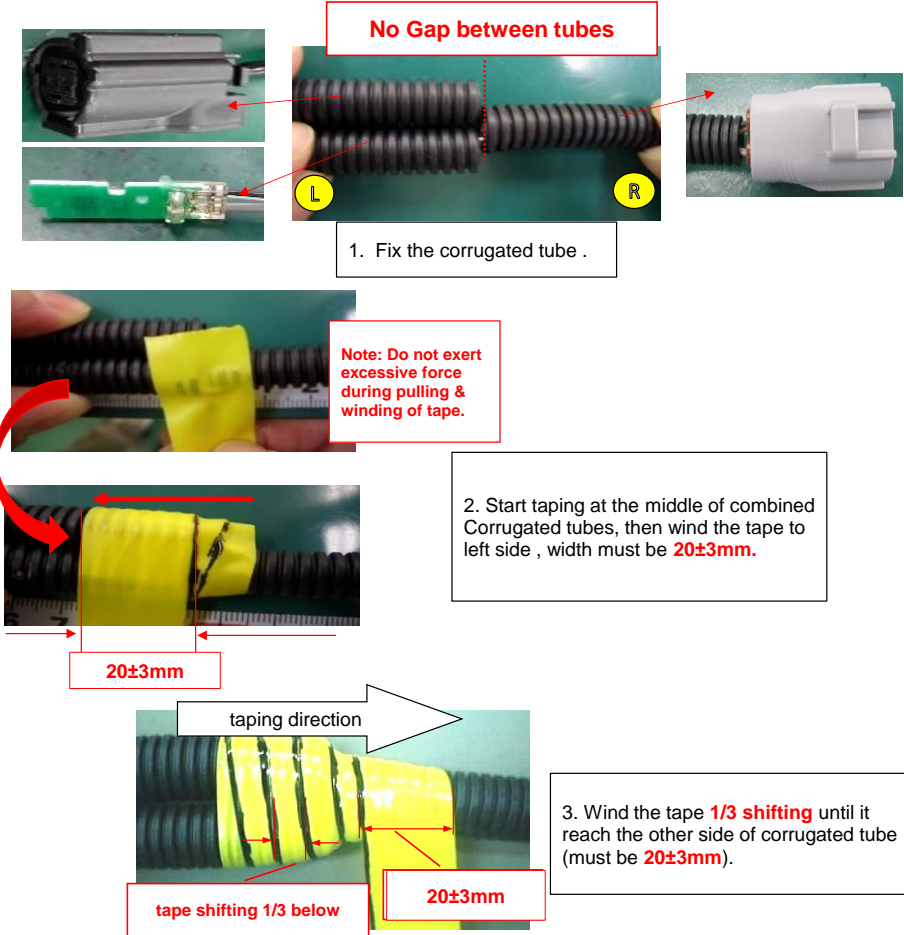
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp


	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310B / 7M0521-7021		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-416B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 4 of 7

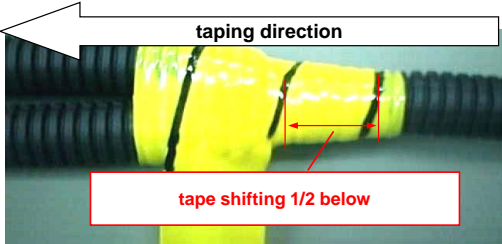
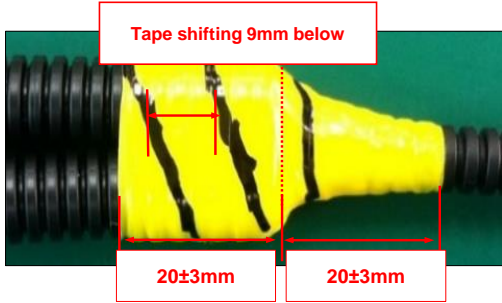

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P2	Y-Taping <div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines but actual should be BLACK TAPE</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</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				Effectivity Date:	June 11, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 310B / 7M0521-7021		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-416B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	5 of 7

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P2 Y-Taping (Continuation)	<div><p>4. Wind the tape backward 1/2 shifting</p></div> <div><p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div>	<div>MEASURING TAPE</div> 	<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>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</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</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:

June 11, 2024

Model code/Part number:

310D/ 7N0191-7020ACustomer: **TRJ**Car Model: **TOYOTA-RAV 4**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-416B

Revision No.:

1

Page No.:

6 of 7

PARTS:

1. Assy parts

JIG:

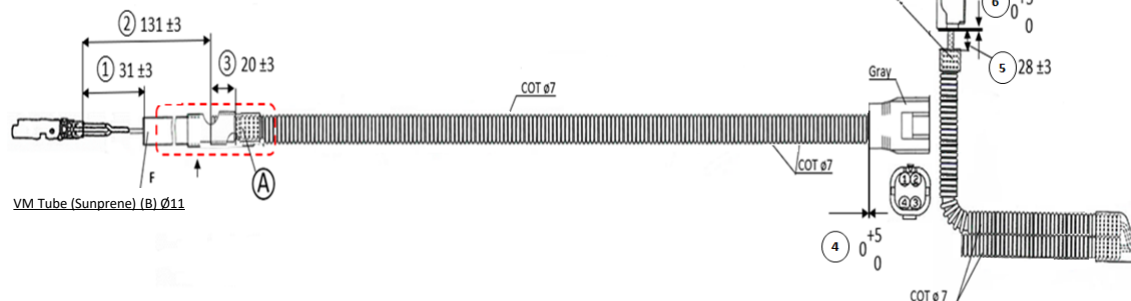
n/a

NO.**PROCESS NAME****2****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**NOTE:**

A - Taping (B)

**MEASURING
TAPE****Important reminders and note/s:****1. Please use calibrated/verified measuring tape when getting the measurement.****2. For Hatsumono, Nakamono and Owarimono.****Document reference/s:****1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection**

1. No wrong dimension

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:

June 11, 2024

Validity Date:

n/a

Model code/Part number:

310B / 7M0521-7021Customer: **TRJ**

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-416B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

7 of 7

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****7M0521-7021****1 2 No MISSING 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