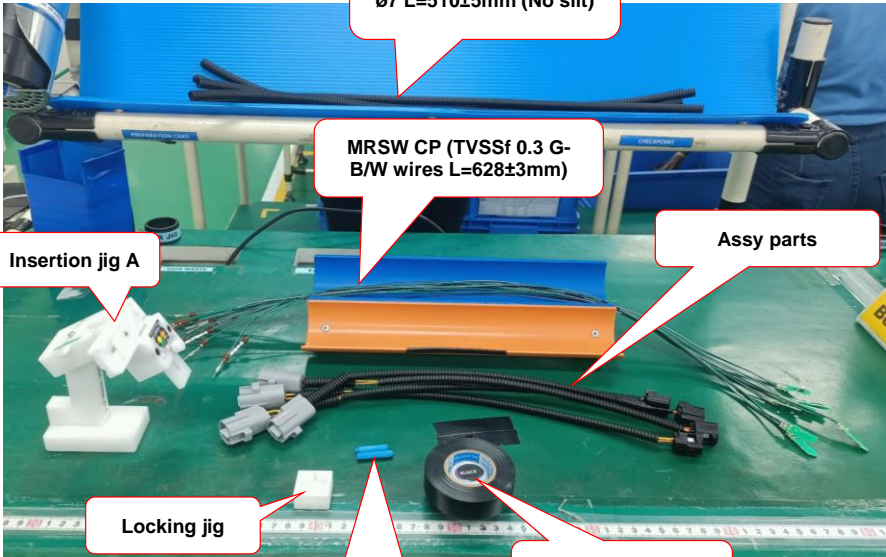

	WORK INSTRUCTION				Effectivity Date:	November 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-875A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 7

PARTS:	1. All parts: Assy part; Black corrugated tube $\varnothing 7$ L=510 \pm 5mm (No slit); MRSW CP (TVSSf 0.3 G-B/W wires L=628 \pm 3mm); Black tape			JIG:	1. Insertion jig 2. locking jig 3. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<div> <div>TABLE LAY-OUT</div>  </div>		<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </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>	Document references: 1. Refer to WI-ENG-PDE-883 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
11/18/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a	
04/16/24	0	Initial issue	D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	



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				Effectivity Date:	November 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-875A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 7

PARTS: 1. Assy parts 2. MRSW CP (TVSSf 0.3 G-B/W wires L=628±3mm) 3. Black corrugated tube ø7 L=510±5mm (No slit)		JIG: 1. Terminal cover jig
-----------------------------------------------------------------------------------------------------------------------------------	--	-------------------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black corrugated tube ø7 L=510±5mm (No slit)	<div>  <p>1. Get the MRSW CP (TVSSf 0.3 G-B/W wires L=628±3mm) using both hands then insert the terminal cover jig using right hand.</p> </div> <div>  <p>2. Get the Black corrugated tube ø7 L=510±5mm (No slit) using left hand then insert the wires using right hand.</p> </div>	<div> TERMINAL COVER JIG  </div>	Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts 2. No damaged rubber seal
3	Wire insertion to assy parts (Black corrugated tube ø7 L=45±3mm (No slit))	<div>  <p>1. Hold the COT (no slit) ø7 L=45±3mm using left hand then insert the MRSW CP TVSSf 0.3 G-B/W wires L=628±3mm using right hand.</p> </div> <div>  <p>2. After insertion, remove the cover jig using right hand.</p> </div>	<div> TERMINAL COVER JIG  </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.	<div>  </div>	<div>  </div>
------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------	----------------------------------------------------------------------------------------------------



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 18, 2024

Model code/Part number:

930B

/

7N0204-7020C

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-875A

Purpose:

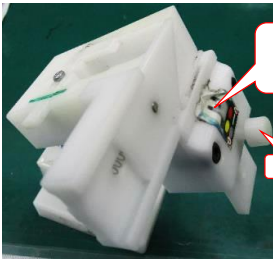
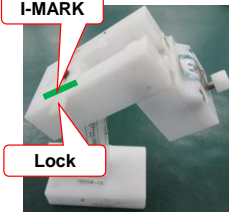

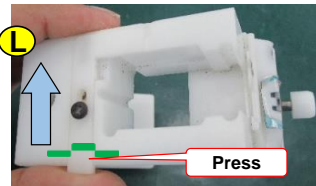



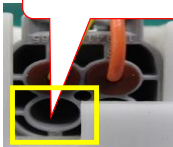



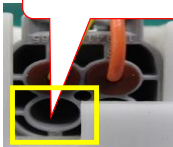


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


3 of 7


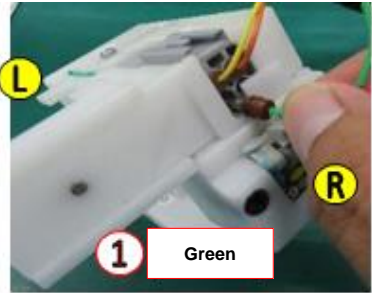

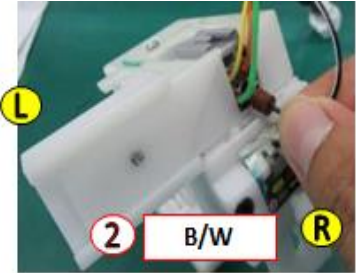
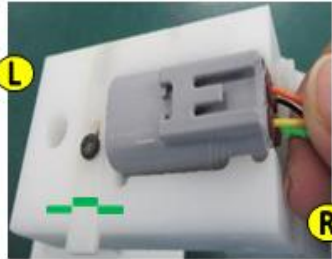
PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	<div><div>INSERTION JIG</div><div>Visual reference</div><div>Button</div><div>Lock</div><div>INSERTION JIG ORIENTATION</div><div>I-MARK</div><div>LOCK</div><div>CONNECTOR ORIENTATION</div></div> <div><div>1. Press the guide using right thumb. The slot for G wire will be opened.</div><div>2. Press the lock of insertion jig using left thumb.</div><div>3. Insert the connector 6188-0066 (GR) with inserted Y-OR wire using right hand</div></div> <div>n/a</div> <td><div><div>Connector Orientation Illustration</div><div><div>I-mark is</div><div>GOOD</div></div><div><div>1 Hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>NG</div></div><div><div>2 Holes are opened</div><div>NG</div></div></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><div>Important reminders/Note/s: 1. Follow the connector orientation</div></td>	<div><div>Connector Orientation Illustration</div><div><div>I-mark is</div><div>GOOD</div></div><div><div>1 Hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>NG</div></div><div><div>2 Holes are opened</div><div>NG</div></div></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> <div>Important reminders/Note/s: 1. Follow the connector orientation</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				Effectivity Date:	November 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-875A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 7

PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><p>WIRE FACING</p></div> <div><p>1 Hold the G wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for B/W wire will be opened.</p></div> <div><p>3. Hold the B/W wire then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<p>Important reminders/Note/s:</p> <p>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.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

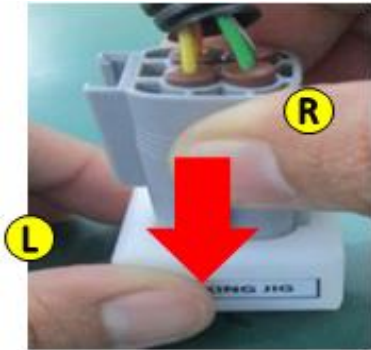
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY



DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	November 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-875A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	5 of 7

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Connector lock			




1. Put the connector into locking jig using both hands and then conduct **2x** pressing. Check the connector if properly locked.




Before pressing After pressing

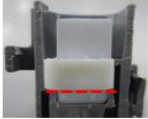
Connector Cross Sectional View



Unlock




Half Lock Condition



Full Lock Condition

NG **NG** **GOOD**

LOCKING JIG



Important reminders/Note/s:

1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR


1. Use the provided jig tool to lock the connector.
2. No unlock/half-locked connector
3. No damaged lock


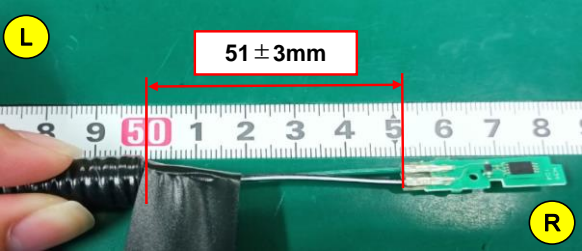
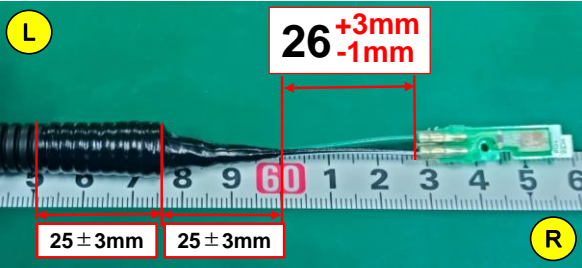

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	November 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-875A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	6 of 7

PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
7	P1	<div><div><p>Start of taping</p></div><div><p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div></div> <div><div><p>51 ± 3mm</p></div><div><p>2. Measure from end of the corrugated tube up to hotmelted wires 51±3mm then continue the taping process using both hands.</p></div></div> <div><div><p>26 ^{+3mm} _{-1mm}</p><p>25 ± 3mm 25 ± 3mm</p></div><div><p>3. After taping, check the measurement, terminal appearance and taping condition.</p></div></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>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</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>		

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:

November 18, 2024

Model code/Part number:

930B**/****7N0204-7020C**

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-875A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINT/ VISUAL INSPECTION**TAPING - P1****7N0204-7020C****1 No Unlocked /Half-locked Connector****2 No Wrong Insert****3 No Deformed Terminal****4 No Terminal Backing out****5 No Missing tape**

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