



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 23, 2024

Process Name/Title:

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-759

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS:

1. Assy parts

2. Black SV tube (vinyl) $\varnothing 5$ L=187 \pm 3mm3. Black Corrugated tube $\varnothing 5$ L=491 \pm 4mm

4. Black tape

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

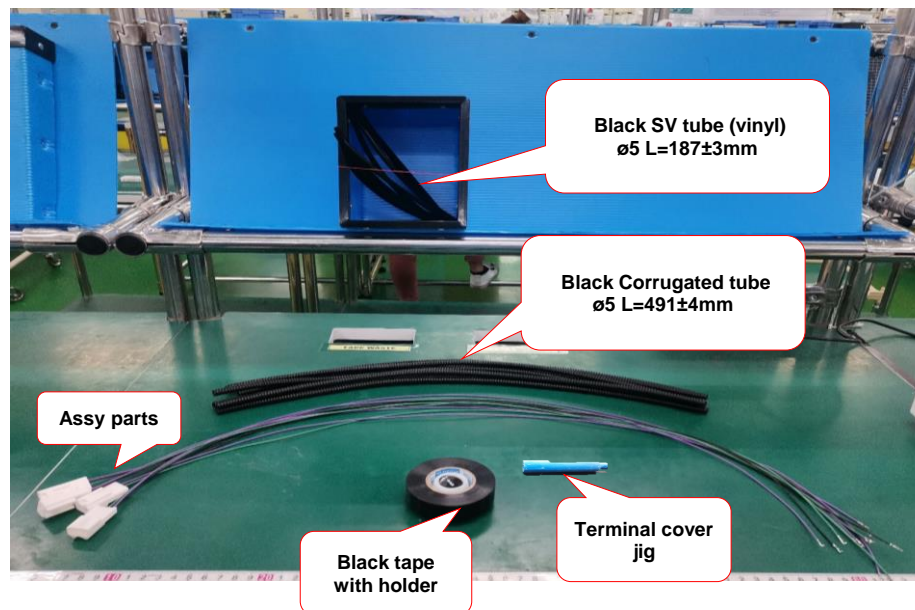
QUALITY POINTERS

1

P1

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required 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
3. No wrong position of parts/tools

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|------------|---------|--|-------------|--------------|-----------|-------|-------------|--------------|-------------|----------|
| 01/23/2024 | 1 | Change Pre-launch to Mass pro. Inclusion of table lay-out and separate insertion process and clamp assembly process. | A.Hernandez | C.Villanueva | A. Arañes | n/a | A.Hernandez | C.Villanueva | A. Arañes | n/a |
| 12/13/2023 | 0 | Initial issue. | A.Hernandez | C.Villanueva | A. Arañes | n/a | A.Hernandez | C.Villanueva | A. Arañes | n/a |

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:

January 23, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Document No.:

WI-ENG-PDE-759

Purpose:



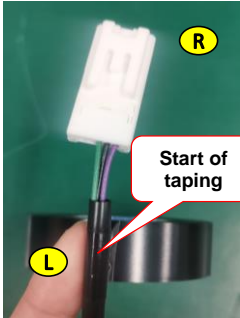
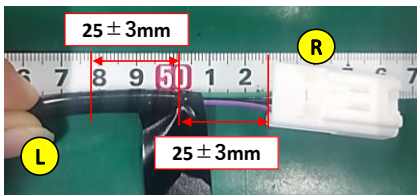
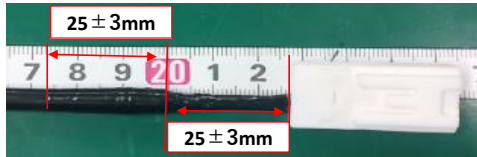

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 7

| | | | | | |
|--------|---|--|--|--|---|
| PARTS: | | 1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=187±3mm 3. Black tape | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | Wire insertion to Black SV tube (Vinyl) Ø5 L=187±3mm | <div></div> <div>1. Get the Black SV tube (Vinyl) Ø5 L=187±3mm using left hand then get the B-V L=752±3mm wires and insert using right hand.</div> <div></div> | | n/a | 1. No wrong use of parts. 2. No damaged terminal |
| 3 | P1 Taping 1 Black SV tube (Vinyl) to Wire near connector | <div></div> <div>1. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start pre-taping using both hands.</div> <div></div> <div>2. Hold theSV tube (Vinyl) using right hand and measure the end of the Corrugated tube up to end of connector 25mm.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div> | | <div>MEASURING TAPE</div> <div></div> | 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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. |

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:

January 23, 2024

Process Name/Title:

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-759

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



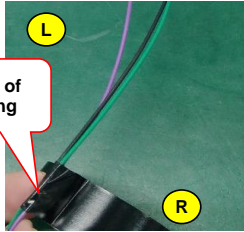
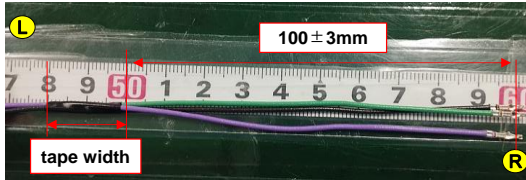

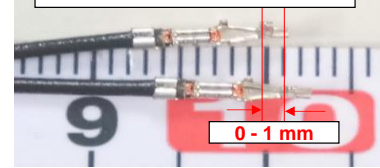




☒ MASSPRO

Revision No.:

1

Page No.:

3 of 7

| | | | | | |
|--------|---|--|--|--|---|
| PARTS: | | 1. Assy parts 2. Black corrugated tube $\phi 5$ L=491 \pm 4mm (No Slit) 3. Black tape | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P1 Spot taping | <div><p>1. Combine the assy parts then align all terminals.</p></div> <div><p>2. Conduct measurement from wires to terminal pointed tip 120\pm3mm using both hands.</p></div> <div><p>3. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</p></div> <div><p>4. After taping, check the measurement and taping condition.</p></div> | | <div><p>MEASURING TAPE</p></div> | <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p><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 use of tape 6. No wrong dimension</p></div> |
| 5 | Wire insertion to Black corrugated tube | <div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-G-V wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) $\phi 5$ L=491\pm4mm (no slit) using right hand then insert the B-G-V wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> | | <div><p>Terminal cover Jig</p></div> | <p>1. No wrong insertion 2. No deformed terminal</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

Effectivity Date:

January 23, 2024

Process Name/Title:

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-759

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


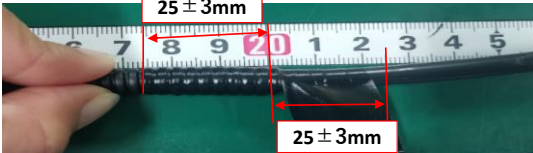
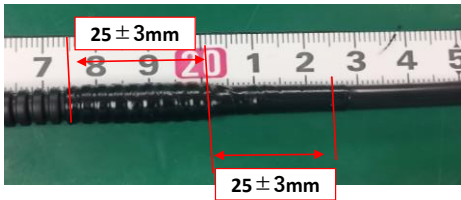

☒ MASSPRO

Revision No.:

1

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 |
| 6 | P1 Taping 2 Black Corrugated tube (no slit) to Black SV tube (Vinyl) | <div><div>Start of taping</div></div> <div><div>25 ± 3mm</div></div> <div><div>25 ± 3mm</div></div> <div>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div> <div>2. Hold the COT using right hand and measure the COT up to the SV tube (vinyl) 25mm. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></div> <div>3. After taping, check the measurement and taping condition.</div> | | <div>MEASURING TAPE</div>  | <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape</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**

Effectivity Date:

January 23, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

700B / 7N0038-7020A

Customer:

TRJ

Car Model:

TOYOTA LAND-CRUISER

Document No.:

WI-ENG-PDE-759

Purpose:

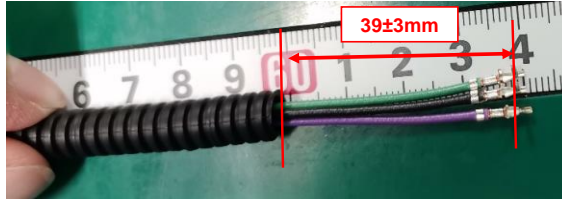

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 7

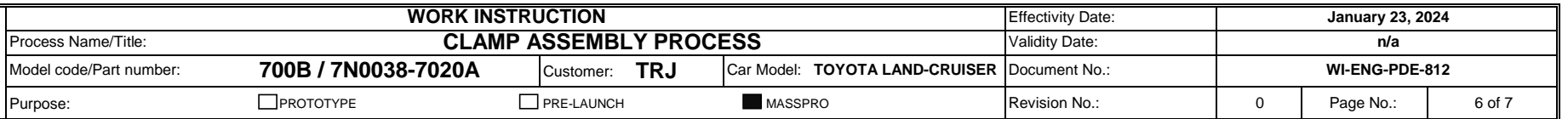
| PARTS: | | 1. Assy parts | | JIG: | 1. Locking jig |
|--------|---|---|--|---|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 7 | Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=491 \pm 4mm (Continuation) |  <div>4. Conduct measurement between end of COT up to pointed tip 39\pm3mm.</div> | | <div>MEASURING TAPE</div>  | 1. No wrong insertion 2. No deformed terminal Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. |
| | P1 | | | | |

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



| | | |
|---|---|------------------|
| <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.</p> | <p>NBC (Philippines)</p> <p>MASTER COPY</p> | <p>DCC Stamp</p> |
|---|---|------------------|

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 23, 2024

Validity Date:

n/a

Model code/Part number:

700B / 7N0038-7020A

Customer:

TRJ

Car Model:

TOYOTA LAND-CRUISER

Document No.:

WI-ENG-PDE-759

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

7 of 7

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P1****7N0038-7020A****1****No Missing Tape**

(on SV tube (vinyl) to wire near connector and SV tube (vinyl) to COT)

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