


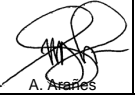
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>February 8, 2025</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>011B / 7M0367-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-CAMRY</b>	Document No.:	<b>WI-ENG-PDE-174A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	10	Page No.:	1 of 6



  

<b>PARTS:</b>	1. All parts: Connector 6098-3802 (W); Black corrugated tube (no slit) $\phi 5$ L=652 $\pm$ 6mm; AVSSf 0.3 B wires L= 816 $\pm$ 3mm; Black tape			JIG:	1. Insertion jig 2. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1	<p><b>Table Lay-out</b></p> 	<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
02/08/25	10	Additional Quality pointers "No insufficient tape" as countermeasure to customer claim. Improved Visual inspection/Quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
07/02/24	9	Transfer Offline process to Taping process assembly and transfer some process to P2 due to process improvement. Update table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a				
12/15/23	8	Separate Clamp setting and Clamp assembly to Clamp assembly process (WI-ENG-PDE-755) and update process sequence due to process improvement. Update Quality pointers (specify which part has a length of 25 +/- 3 and Tape width) as countermeasure to DCS (DC-0723-133). Inclusion of Car model TOYOTA-CAMRY.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	November 3, 2017	

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



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 8, 2025

Process Name/Title:

Model code/Part number:

011B / 7M0367-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-174A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

10

Page No.:


2 of 6

PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1  Connector Setting to Insertion jig 6098-3802 (W)	<div><div><div>INSERTION JIG</div><div></div></div><div><div></div><div></div></div><div><div></div><div></div><div></div></div></div> <div><div></div><div></div></div>	N/A	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div></div><div></div><div></div><div>NG</div></div> <div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div>


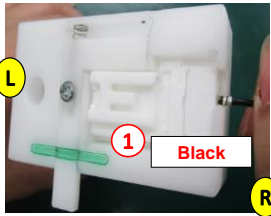
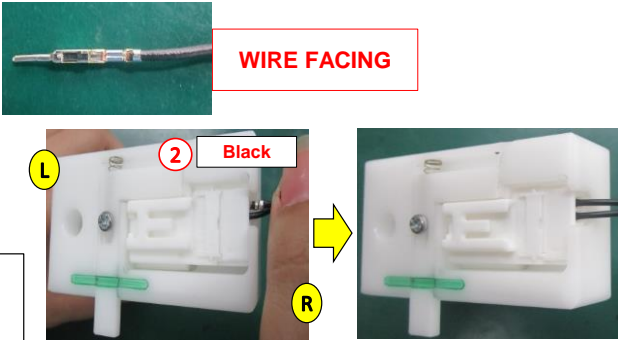
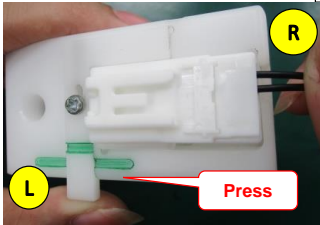
**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	February 8, 2025					
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: <b>011B / 7M0367-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-CAMRY</b>	Document No.:	WI-ENG-PDE-174A			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	10	Page No.:

<b>PARTS:</b>		1. Black corrugated tube (no slit) $\phi 5$ L=652 $\pm$ 6mm 2. AVSSf 0.3 B/B wires L= 816 $\pm$ 3mm [2pcs.]		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=652 $\pm$ 6mm	<div> <div> 1. Get the corrugated tube (no slit) <b><math>\phi 5</math> L=652<math>\pm</math>6mm</b> using left hand and insert two (2) Black wires using right hand. </div>  </div>		N/A	1. No wrong usage of parts 2. No deformed terminal
4	Wire insertion to connector 6098-3802 (W)	<div> <div>  </div> <div>  </div> <div>  </div> </div>		N/A	<b>Important reminders/note/s:</b> 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.  <b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance

<b>CONFIDENTIAL:</b> 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> NBC (Philippines)  <b>MASTER COPY</b> </div>	DCC Stamp
--	--	-----------

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

February 8, 2025

Model code/Part number:

011B / 7M0367-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:







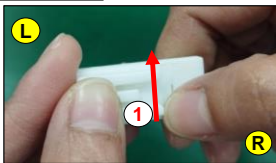


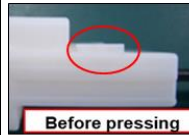

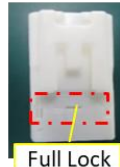
WI-ENG-PDE-174A

Revision No.:

10

Page No.:

4 of 6

PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><div><p>Right thumb-Lower Left thumb-middle</p></div><div><p>Right thumb-upper Left thumb-middle</p></div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><div><p>Right thumb-middle Left thumb-middle</p></div><div><p>5. Lift then press the connector in the middle using left and right hand.</p><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div></div>	<div>LOCKING JIG</div>  <div><p>Before pressing</p><p>After pressing</p></div> <div><div><p>Full Lock</p><p>Half Lock</p></div></div>	<p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <p><b>Important reminders/note/s:</b> 1. <b>MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b> 2. Use provided jig tool per model to avoid damaged lock.</p> <p><b>Document reference/s:</b> 1. Please refer to <b>GL-PRO-ASY-017</b> for the verification of connector lock.</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

Model code/Part number:

011B / 7M0367-7020A

Customer:

TRJ

Car Model:

TOYOTA-CAMRY

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

February 8, 2025

Validity Date:

n/a

Document No.:

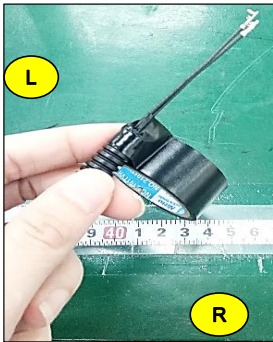
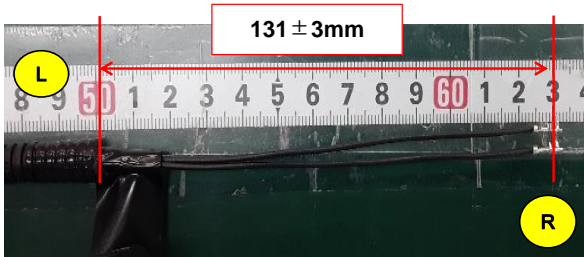
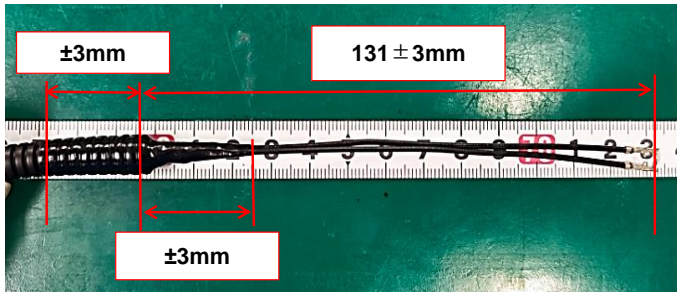


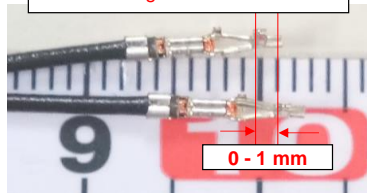


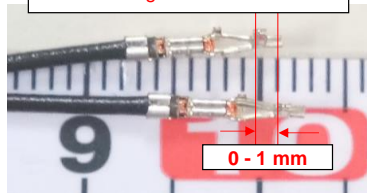
WI-ENG-PDE-174A

Revision No.:

10

Page No.:

5 of 6

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1  Taping 1 COT to wire near connector	<div><div></div><div></div><div><p>1. Hold the assy parts using left hand. Get the <b>Black tape</b> using right hand then start taping between COT to wire using both hands.</p></div><div><p>2. Measure form end of COT up to terminal pointed tip <b>131±3mm</b> then continue the taping process using both hands</p></div><div></div><div><p>3. After taping, check the measurement, terminal alignment and taping condition.</p></div></div> <td><div>MEASURING TAPE</div><div></div><div></div></td> <td><div><b>Important reminders/Note/s:</b></div><div>1. Please use <b>calibrated/verified measuring tape</b> when getting the measurement.</div><div><b>Document references:</b></div><div>1. Refer to <b>WI-PRO-ASY-001A</b> for <b>Taping process</b></div><div><div>1. No flip-out tape</div><div>2.No peel-off tape</div><div>3. No loose tape</div><div>4. No wrong dimension</div><div>5. No wrong use of tape</div><div>6. No missing tape</div><div>7. No insufficient tape</div></div><div><div>Wire alignment tolerance</div><div></div></div></td>		<div>MEASURING TAPE</div> <div></div> <div></div>	<div><b>Important reminders/Note/s:</b></div> <div>1. Please use <b>calibrated/verified measuring tape</b> when getting the measurement.</div> <div><b>Document references:</b></div> <div>1. Refer to <b>WI-PRO-ASY-001A</b> for <b>Taping process</b></div> <div><div>1. No flip-out tape</div><div>2.No peel-off tape</div><div>3. No loose tape</div><div>4. No wrong dimension</div><div>5. No wrong use of tape</div><div>6. No missing tape</div><div>7. No insufficient tape</div></div> <div><div>Wire alignment tolerance</div><div></div></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**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

February 8, 2025

Model code/Part number:

**011B / 7M0367-7020A**Customer: **TRJ**Car Model: **TOYOTA-CAMRY**

Validity Date:

n/a

Document No.:

**WI-ENG-PDE-174A**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

10

Page No.:

6 of 6

**PARTS:**

1. Assy parts

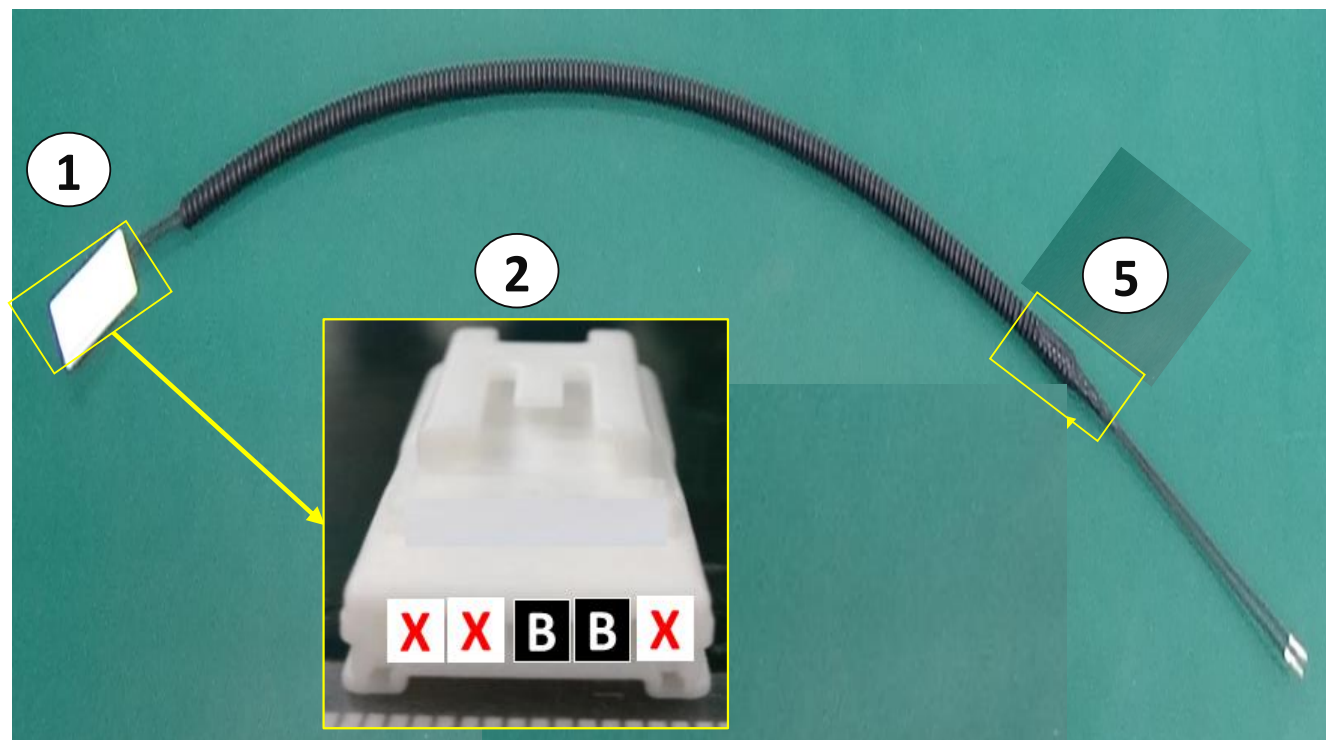
JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS**

# TAPING - P1

# 7M0367-7020A



- 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