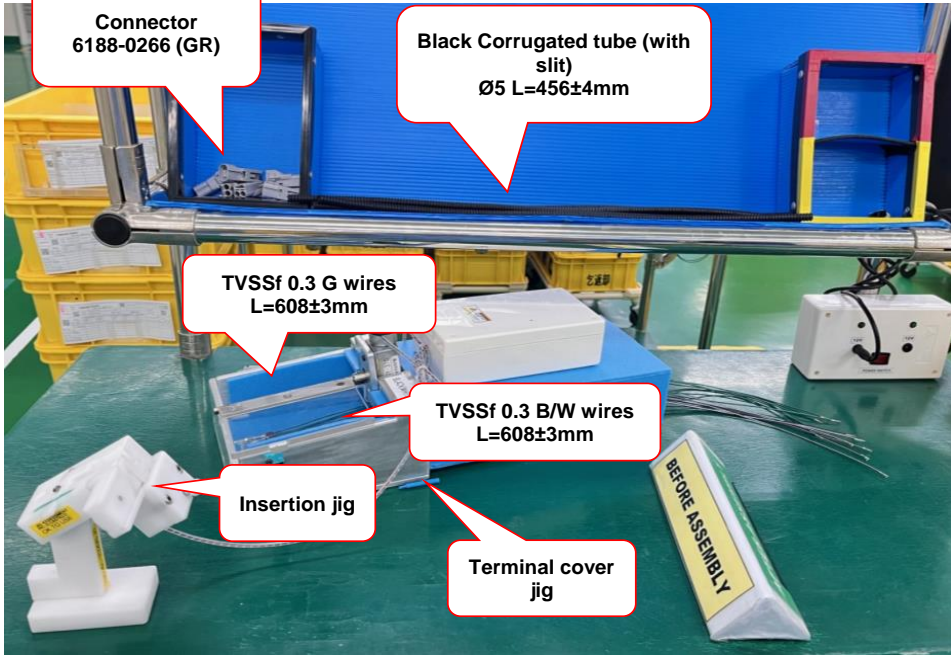
	<b>WORK INSTRUCTION</b>						Effectivity Date:		<b>February 28, 2025</b>	
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Model code/Part number: <b>339D / 7N0161-7020B</b>			Customer: <b>TRJ</b>		Car Model: <b>TOYOTA-BZ4X</b>		Document No.: <b>WI-ENG-PDE-1219</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		0	Page No.: 1 of 6

<b>PARTS:</b>		1. TVSSf 0.3 G wire L=608±3mm; TVSSf 0.3 B/W wire L=608±3mm; Connector 6188-0266 (GR): Black Corrugated tube (with slit) Ø5 L=456±4mm						JIG:		1. Insertion jig with switch cover 2. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>						<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	OFF LINE	<div>Table Lay-out</div> 						<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

Revision History								Prepared by	Checked by	Reviewed by	Approved by	
02/28/25	0	Initial issue. Separate process from Taping assembly process.					D.Castillo	J. Loterte	C.Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change					Revised	Checked	Reviewed	Approved	Est. Date:	February 28, 2025

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

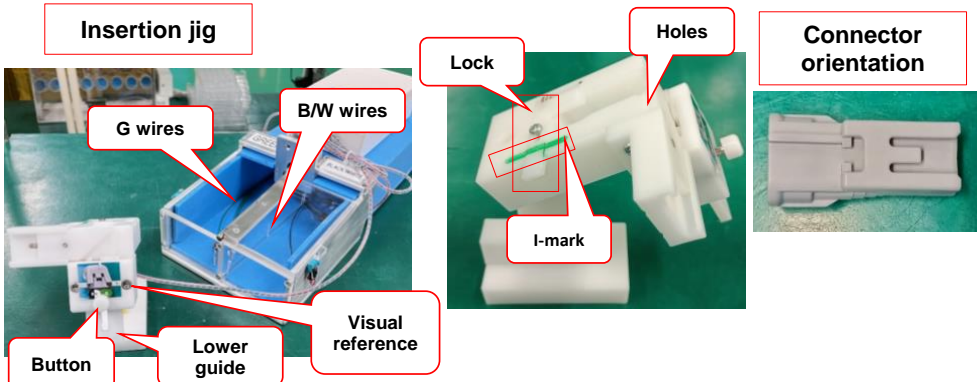
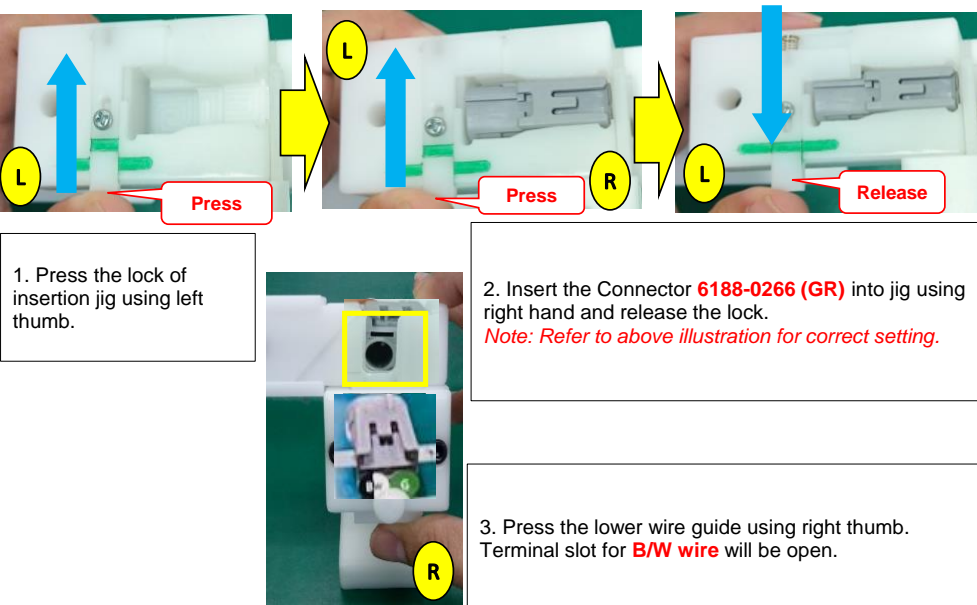
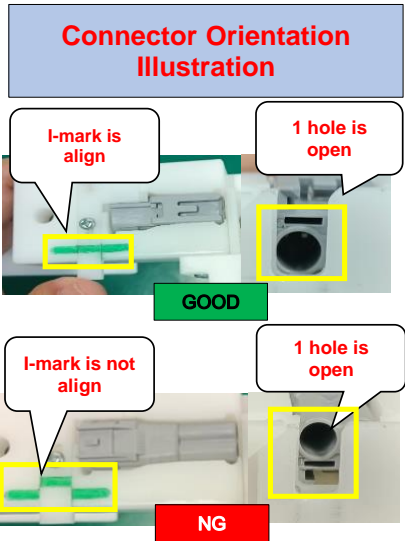
DCC Stamp



WORK INSTRUCTION  
OFFLINE ASSEMBLY PROCESS


Effectivity Date:	February 28, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1219		
Revision No.:	0	Page No.:	2 of 6

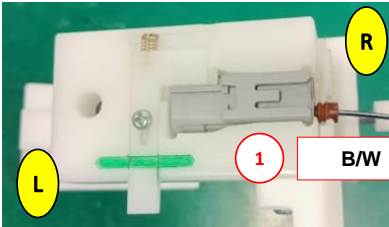
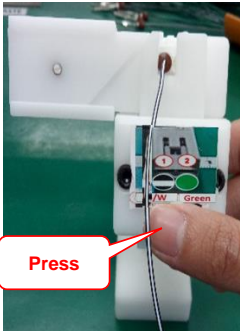
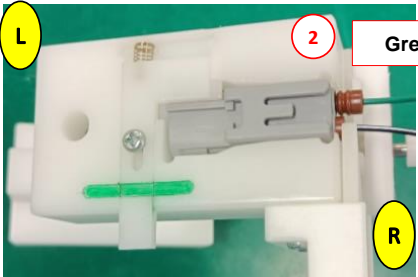
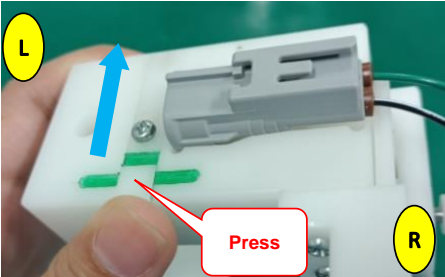
Process Name/Title:	339D / 7N0161-7020B		
Model code/Part number:	339D / 7N0161-7020B	Customer:	TRJ
		Car Model:	TOYOTA-BZ4X
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Connector 6188-0266 (GR)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	OFF LINE Connector setting to insertion jig 6188-0266 (GR)	<div><p><b>Insertion jig</b></p><p><b>Visual reference</b></p></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the Connector <b>6188-0266 (GR)</b> into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p><p>3. Press the lower wire guide using right thumb. Terminal slot for <b>B/W wire</b> will be open.</p></div>	n/a	<div><p><b>Connector Orientation Illustration</b></p><p><b>GOOD</b></p><p><b>NG</b></p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</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

	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>February 28, 2025</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>339D / 7N0161-7020B</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-BZ4X</b>	Document No.:	<b>WI-ENG-PDE-1219</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 6

PARTS:		1. TVSSf 0.3 G wire L=608±3mm 2. TVSSf 0.3 B/W wire L=608±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFF LINE  Wire Insertion to connector 6188-0266 (GR)	<div>  <div>Terminal facing</div> <div>1. Get <b>Black/White wire</b> then insert to terminal <b>slot 1</b> using right hand.</div> </div> <div>  <div>Press</div> <div>2. Push the button after insertion. Hole for Green wire will be open.</div> </div> <div>  <div>3. Get <b>Green wire</b> then insert to terminal <b>slot 2</b> using right hand.</div> </div> <div>  <div>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div> </div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b>  1. Please hold the wire near terminal during insertion.  2. Insertion of wire must be inserted.  3. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> 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 lenght Tolerance.  2. Please refer to <b>GL-PRO-ASSY-029</b> for Pull-Push procedure.

**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**February 28, 2025**

Model code/Part number:

**339D / 7N0161-7020B**

Customer:

**TRJ**

Car Model:

**TOYOTA-BZ4X**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

4 of 6

**PARTS:**

1. Assy parts
2. Black corrugated tube (w/ slit)  $\varnothing 5$  L=456 $\pm$ 3mm

JIG:

1. Terminal cover jig

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

4

OFF  
LINEWire insertion to Black  
corrugated tube (w/ slit)  
 $\varnothing 5$  L=456 $\pm$ 3mm

1. Hold the assy parts using left hand and get the terminal cover jig using right hand.



2. Hold the assy parts using left hand and get the Black corrugated tube (w/ slit)  $\varnothing 5$  L=456 $\pm$ 3mm then insert using right hand.

**TERMINAL COVER  
JIG**

1. No wrong use of parts
2. No wires left between COT with slit



3. Remove the terminal cover jig.

**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:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 28, 2025

Model code/Part number:

339D / 7N0161-7020B

Customer:

TRJ

Car Model:

TOYOTA-BZ4X

Document No.:

WI-ENG-PDE-1219

Purpose:

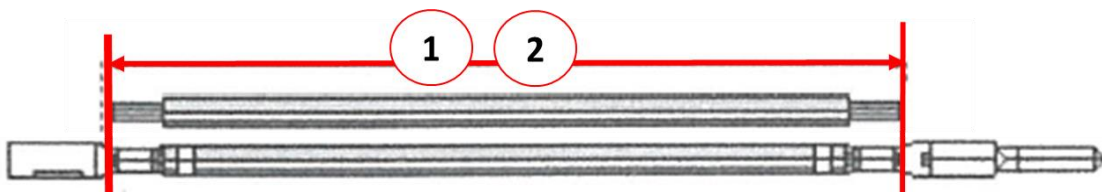

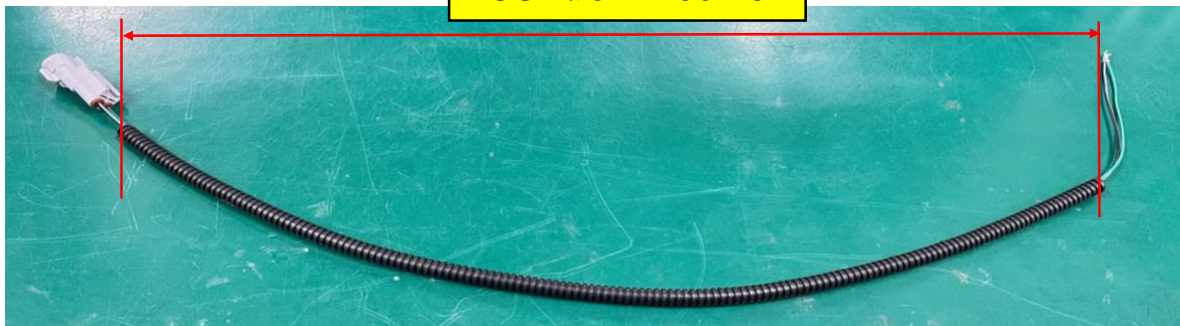
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 6

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	OFF LINE	Measurement	<p>Note:</p> <ol style="list-style-type: none"><li>1. Measurement point: End of core wire to the end of core wire</li><li>2. Terminal is reference only.</li></ol>  <p>MEASURING TAPE</p>  <p>COT <math>\varnothing 5</math> L=456 <math>\pm</math> 3</p> 		<p><b>Important reminders and note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. For Hatsumono and Owarimono.</li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</li></ol> <p>1. No wrong dimension</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:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 28, 2025

Validity Date:

n/a

Model code/Part number:

339D / 7N0161-7020B

Customer:

TRJ

Car Model:

TOYOTA-BZ4X

Document No.:

WI-ENG-PDE-1219

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

6 of 6

PARTS:

1. Assy parts

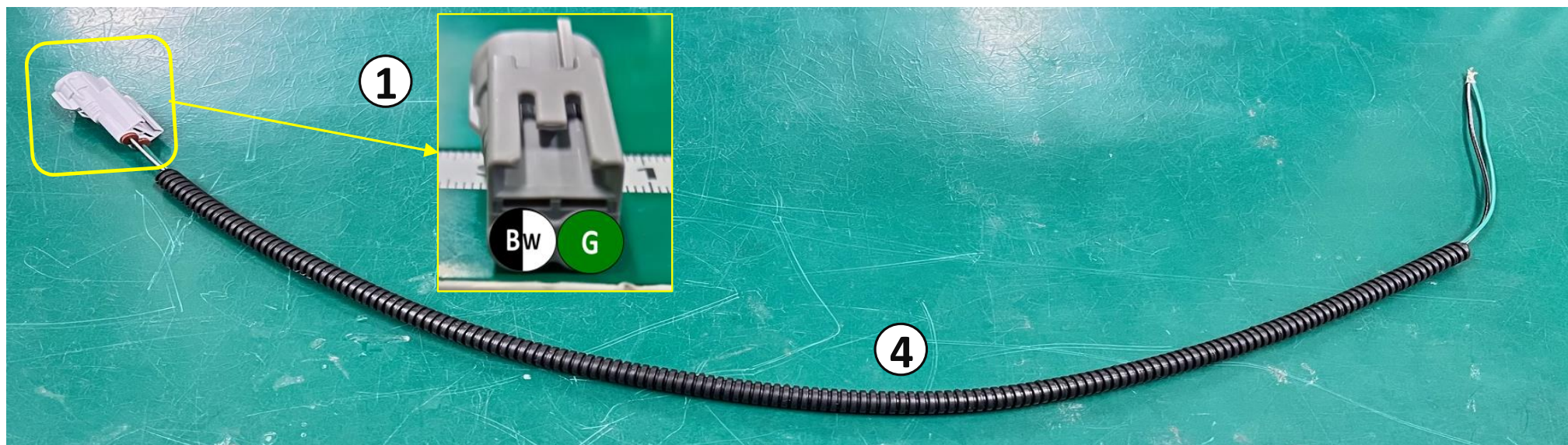
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## OFFLINE INSERTION

# 7N0161-7020B



① No Wrong Insert

② No Terminal Backing Out

③ No Deformed Terminal

④ No Missing COT (with slit)

**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