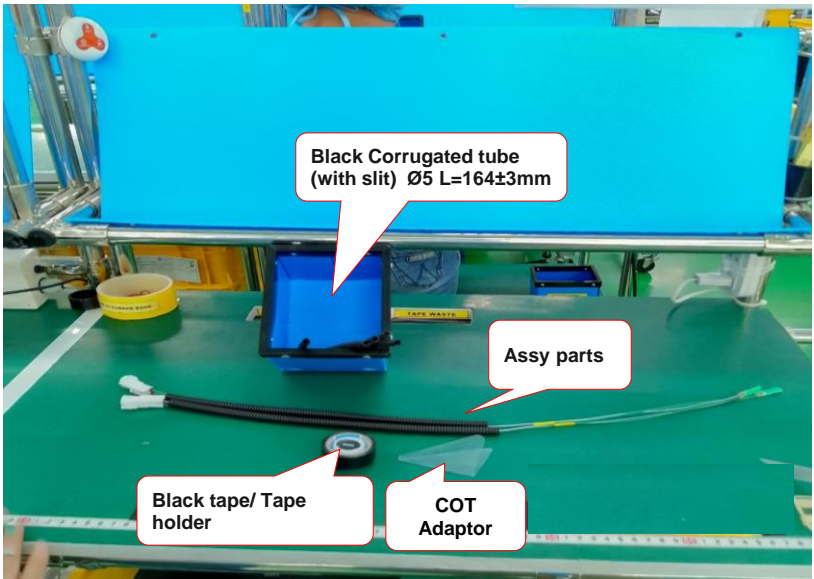
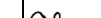






WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:	TAPING ASSEMBLY PROCESS			Effectivity Date:	Ocotber 3, 2024		
Model code/Part number:	311D / 7L0155-7023	Customer:	TRQSS	Car Model:	TOYOTA RAV4	Validity Date:	n/a
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-1054A		
				Revision No.:	1	Page No.:	1 of 5

PARTS:	1. Assy parts; Black Corrugated tube (with slit) Ø5 L=164±3mm; Black tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
1	P1	Table Lay-out		<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Important reminders/Note/s: 1. Refer to WI-ENG-PDE-675 for Offline assembly process 2. Refer to WI-PRO-CNC-017 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
											
10/03/24	1	Change pre launch to mass pro. Transfer insertion process to offline assembly process and clamp to clamp assembly process.	A.Hernandez	C.Villanueva	A. Arañes	n/a					
09/11/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 11, 2024			

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:

October 3, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

311D / 7L0155-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-1054A

Purpose:



PROTOTYPE



PRE-LAUNCH



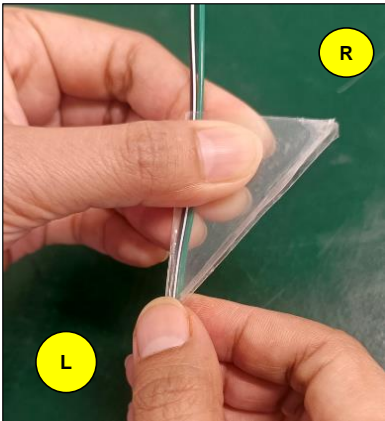
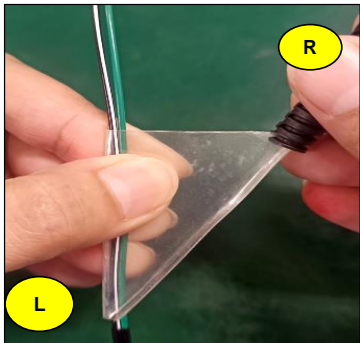
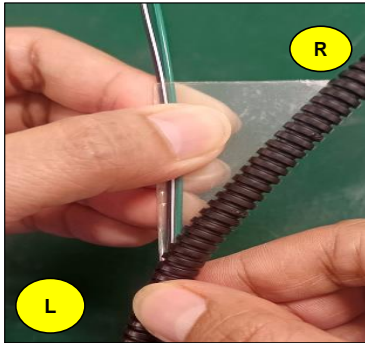

MASSPRO

Revision No.:

1

Page No.:

2 of 5

PARTS:		1. Assy parts 2. Black Corrugated tube (with slit) Ø5 L=164±3mm	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Black Corrugated tube (with slit) Ø5 L=164±3mm    <p>1. Hold the COT Adaptor using left hand. Insert the wires using right hand.</p> <p>2. Hold the COT Adaptor with wires using left hand , get the Black Corrugated tube (w/ slit) Ø5 L=164±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p>	<div>COT Adaptor</div> 	<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing 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

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 3, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

311D / 7L0155-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-1054A

Purpose:



PROTOTYPE



PRE-LAUNCH



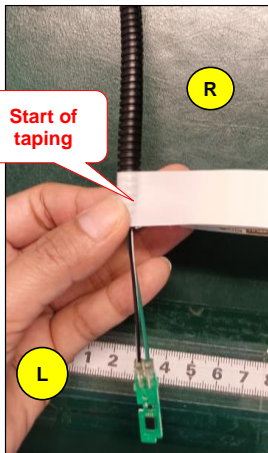
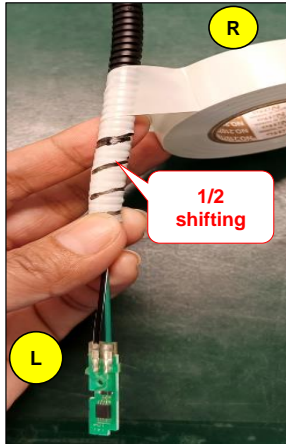
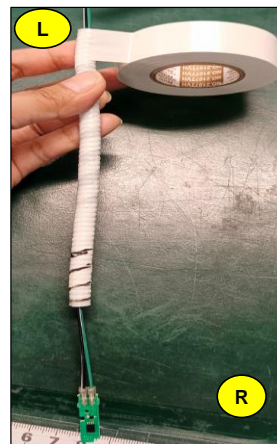

MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Half-wrap Taping	<div><div><p>Start of taping</p></div><div><p>1/2 shifting</p></div><div><p>1/2 shifting</p></div><div><p>1. Hold the corrugated tube (w/slit) using left hand. Get the black tape using right hand. Conduct 2 windings of tape before shifting using both hands.</p><p>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 windings of tape then cut the tape.</p><p>3. Check the taping condition.</p></div><div><p>MEASURING TAPE</p></div></div> <div><p>Important reminders/Notes</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. Used WHITE TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE.</p><p>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</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</p></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

Process Name/Title:

Model code/Part number:

311D / 7L0155-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

October 3, 2024

Validity Date:

n/a

Document No.:


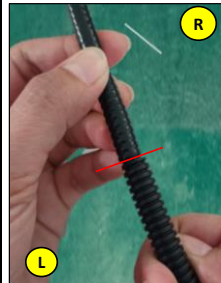

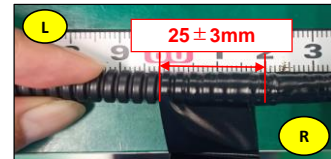
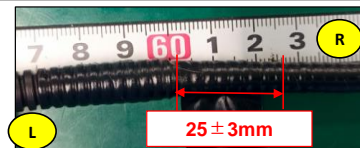
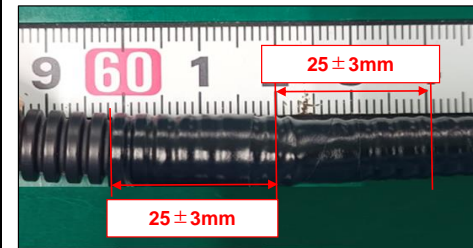

WI-ENG-PDE-1054A

Revision No.:

1

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Black Corrugated tube (No slit) to Corrugated tube (w/ slit)	<div><p>1. Measure from end of the Corrugated tube (No slit) up to end of hotmelted wire 272mm using both hands.</p></div> <div><p>2. Fix the Corrugated tube (No slit) and the Corrugated tube (w/slit) using both hands.</p></div> <div><p>3. Get the black tape and start taping process using both hands.</p></div> <div><p>4. Measure from end of tape up to end of Corrugated tube (No slit) 25±3mm.</p></div> <div><p>5. Measure from end of Corrugated tube (No slit) to end of tape 25±3mm.</p></div> <div><p>6. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing 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:

October 3, 2024

Validity Date:

n/a

Model code/Part number:

311D / 7L0155-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-1054A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

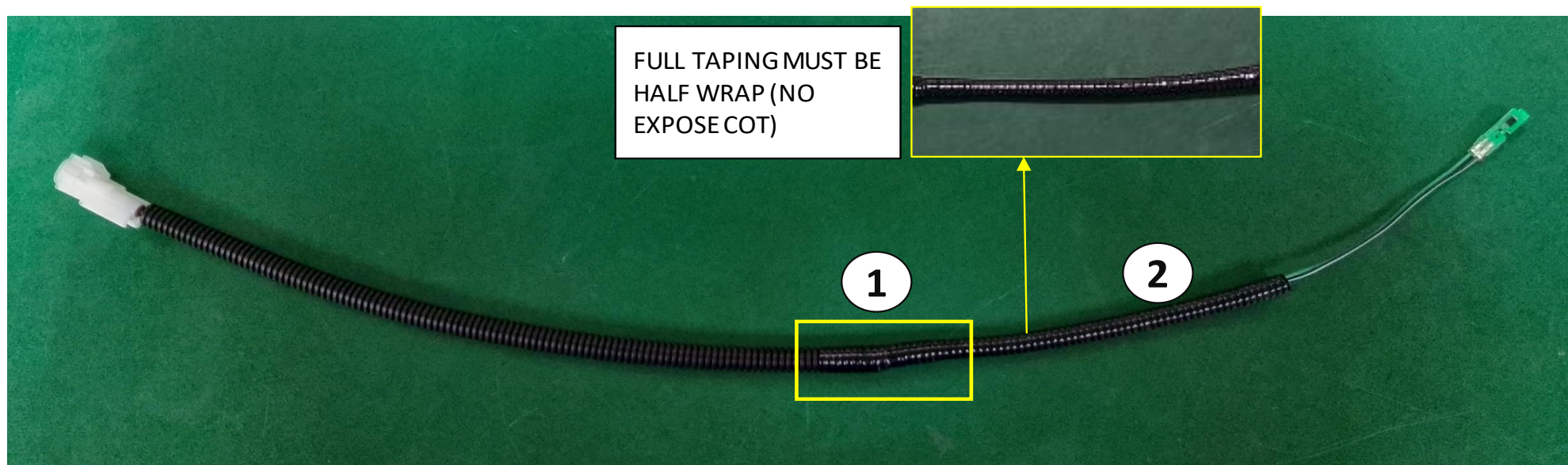
1

Page No.:

5 of 5

PARTS:

JIG:

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0155-7023****1 2 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