

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 5, 2023

Model code/Part number:

**890B / 7L0100-7021**Customer: **TRQSS**Car Model: **TOYOTA-C-SUV**

Document No.:

**WI-ENG-PDE-405B**

Purpose:

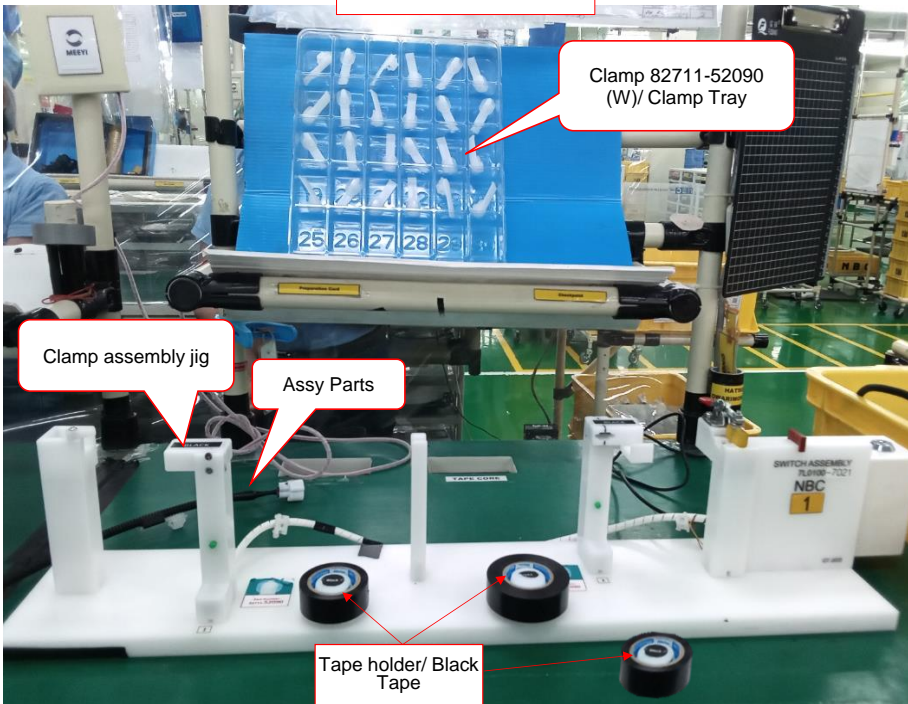
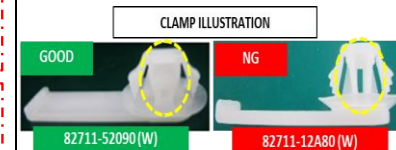
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

1 of 7

<b>PARTS:</b>	1. Assy parts; Clamp 82711-52090 (W); Black tape [3pcs]			JIG:	1. Clamp Assembly Jig					
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>				
1	P2	Table lay-out	<div><p><b>TABLE LAY-OUT</b></p></div>			<div><p><b>Safety Instruction</b> Be sure to wear prescribed 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></div>	<div><p><b>CLAMP ILLUSTRATION</b></p></div> <p>1. No missing parts/tools 2. No excess parts/tools</p>			
<b>Revision History</b>						<b>Prepared by</b>	<b>Reviewed by</b>	<b>Approved by</b>	<b>Noted by</b>	
07/05/23	3	Change the No.3 procedure 2 measurement from 25mm to tape width; change template, inclusion of Car Model				J. Loterte	C. Villanueva	A. Arañes	n/a	
05/10/23	2	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a	
09/23/22	1	Improve: Work procedure/Illustration on process no. 2,3 ,4, 5 and 6; Quality pointers and notes on pg. no. 1, 2, 3, 4, 5 and 6				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
02/11/22	0	Initial Issue. PCB 2 chips ( 61C619-0002) to 1 chip (7N0994-7060) Wire color of Gray (GR) to Green (G)				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Est. Date:	February 11, 2022			

**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:

July 5, 2023

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

-

Model code/Part number:

890B / 7L0100-7021

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Document No.:

WI-ENG-PDE-405B

Purpose:

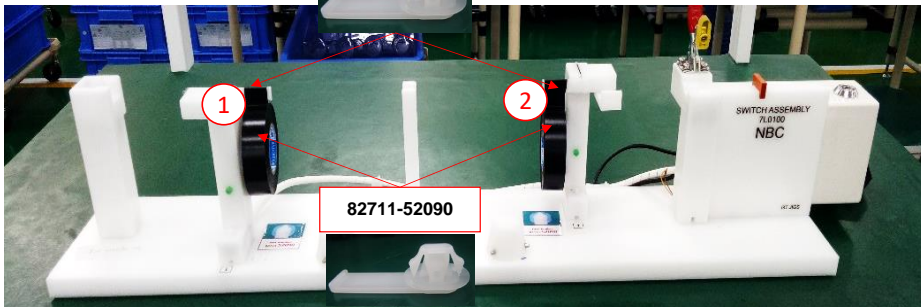
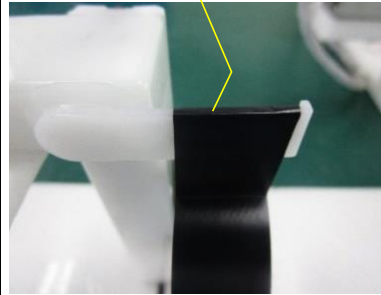
☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

3

Page No.:

2 of 7

PARTS:		1. Clamp 82711-52090 (W) [2pcs] 2. Black tape [2pcs]		JIG:	1. Clamp Assembly
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Clamp setting	<div><div>82711-52090 (W)</div><div>82711-52090</div></div> <div><div>1. Get 2 pieces of clamp <b>82711-52090</b> using both hands and set to <b>location ① and ②</b> using both hands.</div><div>2. Initially attach <b>Black tape</b> on <b>location ① and ②</b> using both hands.</div></div>		n/a	<div><p><b>Important reminders/Note/s:</b></p><p><b>1. Please check the clamp before start of assembly to avoid wrong use of parts.</b></p><p>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape</p></div> <div><div>STANDARD TAPING FOR CLAMP</div><div>One side tape under clamp</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:

July 5, 2023

Model code/Part number:

**890B / 7L0100-7021**

Customer:

**TRQSS**

Car Model:

**TOYOTA-C-SUV**

Document No.:

**WI-ENG-PDE-405B**

Purpose:

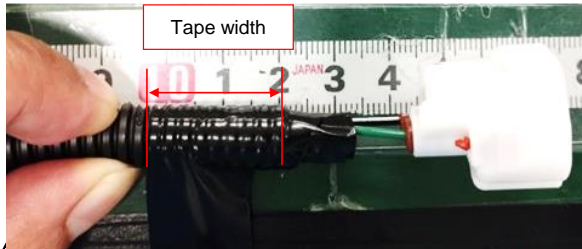
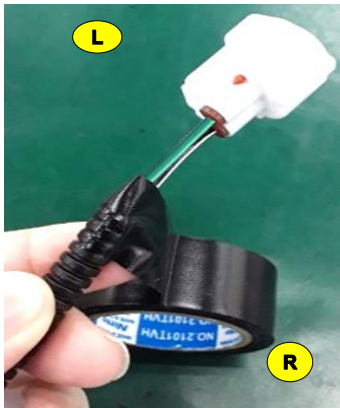
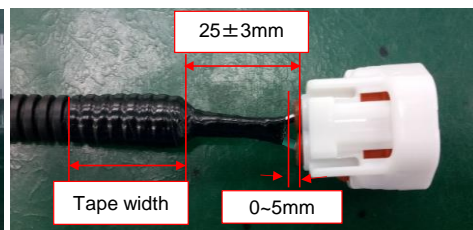
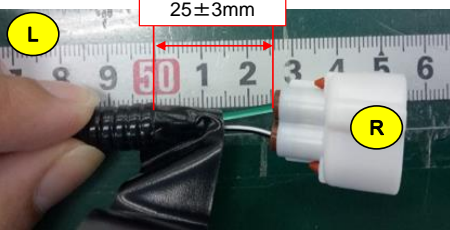

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

3

Page No.:

3 of 7

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	P2 Taping 1 COT to wire near connector	<div></div> <p>1. Hold the corrugated using left hand. Get <b>Black tape</b> using right hand and start pre-taping using both hands.</p> <p>2. Confirm measurement of <b>tape width</b> from end of tape up to end of COT then continue the taping process using both hands.</p> <div></div> <p>3. Measure the end of the corrugated tube up to the edge of connector <b>25mm</b>. Then continue taping using right hand.</p> <p>4. After taping, check the measurement and tape condition.</p>		<b>MEASURING TAPE</b> 	<b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>  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

**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:

July 5, 2023

Model code/Part number:

890B / 7L0100-7021

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Document No.:

WI-ENG-PDE-405B

Purpose:

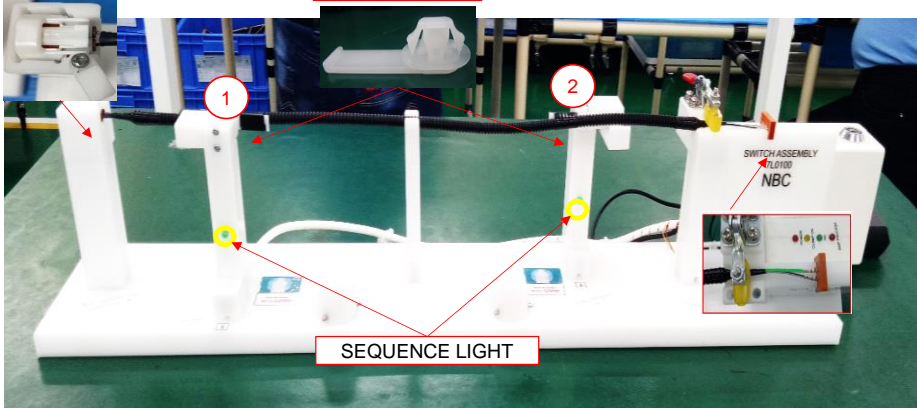


☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

3

Page No.:

4 of 7

PARTS:	1. Assy parts		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	<div>Clamp Assembly</div> <div><div>Connector setting</div><div>82711-52090</div><div></div><div>SEQUENCE LIGHT</div><div>1. Get the assy part and set into jig. (See above picture for correct setting). First, set the connector 6189-0451 (W) to Receiver base 1. Last, set the terminal within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</div><div>2. Check if all LED light for POWER ON, CLAMP ON was ON. Check also if sequence light of location 1 is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div><div>3. Hold the clamp on location ① and start taping (3 windings) using both hands. Press the SW button after taping. Continue to location ② if light was on.</div><div>4. Hold the clamp on location ② and start taping(3 windings) using both hands. Press the SW button after taping. Go sound will be heard.</div><div>5. Conduct POINT CHECKING before removing of harness from jig.</div></div>	n/a	<div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div> <div><div>NG</div><div></div><div>82711-12A80 (W)</div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No wrong use of clamp</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:

July 5, 2023

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

-

Model code/Part number:

890B / 7L0100-7021

Customer:

TRQSS

Car Model:

TOYOTA-C-SUV

Document No.:

WI-ENG-PDE-405B

Purpose:



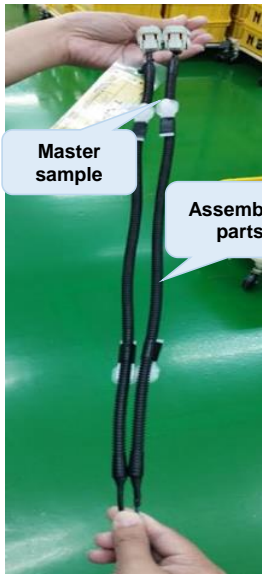
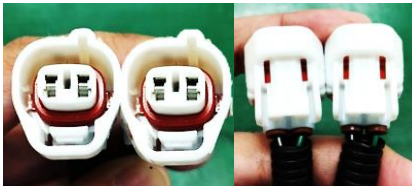



☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

3

Page No.:

5 of 7

PARTS:		1. Assembled parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Visual Inspection	<div><p>ACTUAL PRODUCT</p></div>		<div>MASTER SAMPLE</div> 
			<div><div><p>Master sample</p></div><div><p>Assembled parts</p></div><div><p>2. Check the <b>connector lock</b> and <b>wire insertion</b></p></div><div><p>4. Check the <b>taping condition</b> and <b>terminal appearance</b>. Must be <b>no deformed terminal</b>.</p></div><div><p>3. Check the <b>presence of clamp</b> and the <b>taping condition</b>.</p></div><div><p>1. Conduct <b>alignment of harness (Master sample vs. Assembled parts)</b> using both hands.</p></div></div>		
		<div>CLAMP ILLUSTRATION</div> <div><div><p>GOOD</p><p>82711-52090 (W)</p></div><div><p>NG</p><p>82711-12A80 (W)</p></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:

July 5, 2023

Validity Date:

-

Model code/Part number:

**890B / 7L0100-7021**

Customer:

**TRQSS**

Car Model:

**TOYOTA-C-SUV**

Document No.:

**WI-ENG-PDE-405B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

3

Page No.:

6 of 7

**PARTS:**

1. Assy parts

JIG:

n/a

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

6

P2

Measurement



**Important reminders/Note/s:**  
**1. Please use calibrated/verified measuring tape when getting the measurement.**

1. No wrong dimension

**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:

July 5, 2023

Model code/Part number:

**890B / 7L0100-7021**

Customer:

**TRQSS**

Car Model:

**TOYOTA-C-SUV**

Document No.:

**WI-ENG-PDE-405B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☐ MASSPRO

Revision No.:

3

Page No.:

7 of 7

**PARTS:**

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P2****7L0100-7021****GOOD****NO GOOD****1** No **Unlocked/ Half Locked Connector****2** No **missing tape****3** **4** No **Missing clamp****5** No **Deformed terminal**

**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