			WORK INSTRUCTION									June 3, 2024		
			Process Name/Title:									n/a		
			Model code/Part number:	YKC /	7N0034-7020	Customer: TRJ	Car Model:	SUZUK	(I SOLIO	Document No.:		WI-ENG-PDE-9	800	
			Purpose:	PROTOTYP	PE	PRE-LAUNCH	MASS	PRO		Revision No.:	0	Page No.:	1 of 5	
PARTS:		1. Assy	parts; White tape						JIG:	1. Clamp a	assembly jig			
NO).	F	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	(QUALITY POINTERS		
1	Table Lay-out Assy parts Table Lay-out White tape/ Tape Holder							Clamp asse	embly jig	Safety Instruction Be sure to wear prescribed personal protective equipme during operation (gloves, finger cotsetc.) Housekeeping 1. Maintain and alwar practice 5's. 2. Personal things of the workplace is prohibited. Keep it in your locker. Alert level For any trouble, inforthe Assembly Assist: Supervisor or Line Leader for immedia corrective action.	Docume 1. Refer t Strip Len 2. Refer t Taping as 1. No miss 2. No exce	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-373A-B for Taping assembly process 1. No missing parts/tools 2. No excess parts/tools		
	Revision History							Prepared by	Reviewed by	Approved by	Noted by			
06/03/24	0	Initial iss Separate	Clamp assembly process due t	o process improvemnet.	Improved Measurement a	and Visual inspection/Quality	D.Castillo	C.Villanueva	A. Arañes	JA Castillo	South Thomas		N/A	
Eff. Date			···	Details of 0	Change		Revised	Reviewed	Approved No		June 3, 2024	r A. Atares	IV/A	

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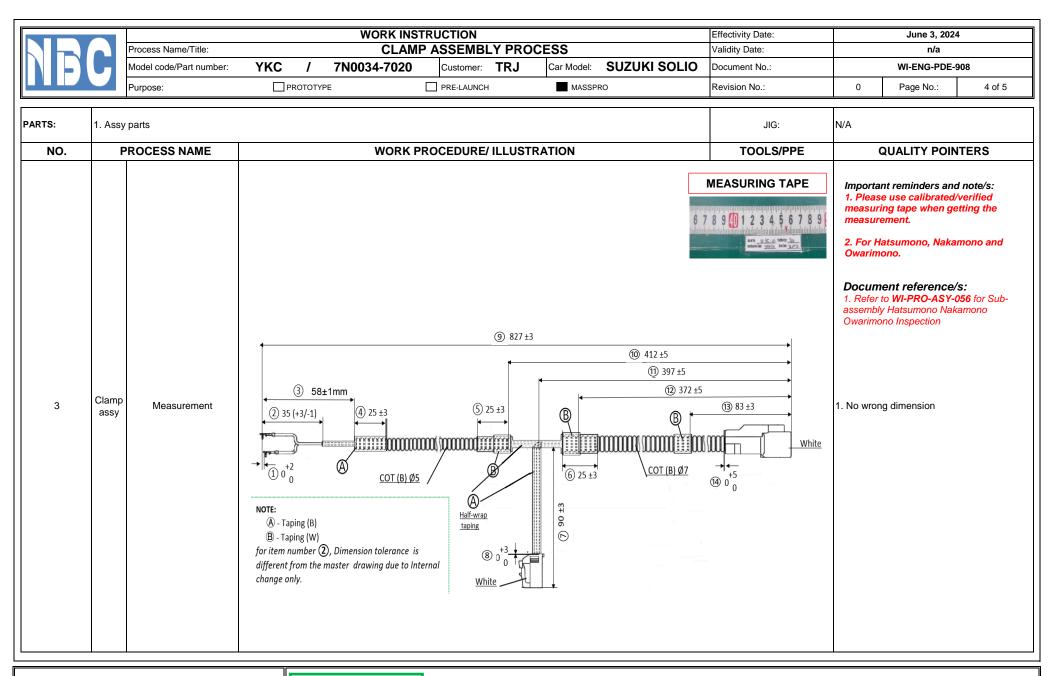
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WORK INSTRUCTION Effectivity Date: Ju														
	AL	Process Name/Title:		-		P ASSEMBLY F	PROCE	SS	Validity Date:		n/a			
		Model code/Part number:	YKC	7	7N0034-7020	Customer: TR	RJ (Car Model: SUZUKI SOLIC	Document No.:		WI-ENG-PDE-908			
		Purpose:	PRO	TOTYPE		PRE-LAUNCH		MASSPRO	Revision No.:	0	Page No.:	2 of 5		
PARTS:	1. Assy 2. Whit	parts e tape							JIG:	1. Clamp a	assembly jig			
NO.	F	ROCESS NAME			WORK P	ROCEDURE/ ILL	.USTRA	TION	TOOLS/PPE	(QUALITY POINT	TERS		
2	Clamp	Clamp assembly	CONNECTOR SETTING WHITETAPE 10mm (No slit) 1. Get the assy parts and set to taping jig using both hands. (See above picture for correct setting). First, set the Connector 4G5400-0000 (W) to Checker 1 then lock. Second, set the Connector 7283-1020 (W) then pull the checker fixture for continuity checking. Continue to set the harness, last set the B-B wires together within the stopper jig then press by toggle clamp. Continue if the sequence light in location 1 was ON. 2. Check if the Clamp is ON. Check if location 1 sequence light was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.						Counter Toggle clamp: O	1. No wror 2. Make so stopper jig 3. No wror 4. No exces 5. No miss Importa 1. Counter harness p	Important reminders/note/s: 1. No wrong insert 2. Make sure no gap between terminal and stopper jig 3. No wrong use of tape 4. No excess windings 5. No missed tape Important reminders/note/s: 1. Counter will be the basis of quantity of harness per box. Only LEADER are allowed to reset the counter.			

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WORK INSTRUCTION Effectivity Date: June 3, 2024														
		Process Name/Title: CLAMP ASSEMBLY PROCESS								ite:	n/a			
		Model code/Part number:								WI-ENG-PDE-908				
		Purpose:	PROTOTYF		PRE-LAUNCH		MASSPR		Revision N		0	Page No.:	3 of 5	
PARTS:	1. Assy 2. White									JIG:	1. Clamp ε	assembly jig		
NO.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION							OLS/PPE	QUALITY POINTERS			
2	Clamp Assy	Clampa assembly (Continuation)	4. Get the Whit both hands on I using right hand 5. Get the Whit hand then cond location 3. Mak	whiteTAPE 10mm (no slit) ocation 1. Make 3 windings then cut using right hand. GO	sw But using right hand the light on location using right both hands on the tape. Press	then conducte tape. Presen 2 was ON. then conducte tape. Presen 3 was ON. 6. Conducted.	WHITETAPE 10mm (No slint) ct spot taping uss the SW buttle. ct spot taping uss the SW buttle.	using ton		Counter Counter Counter Counter Counter Counter	1. Make sustopper jig. 1. No wron 2. Make sustopper jig 3. No wron	ng insert ure no gap betweer ng use of tape ess windings	n terminal and	

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			WORK INST	Effectivity Date:	June 3, 2024						
	Process Name/Title:	Process Name/Title: CLAMP ASSEMBLY PROCESS							n/a		
	Model code/Part number:	YKC /	7N0034-7020	Customer: TRJ	Car Model:	SUZUKI SOLIO	Document No.:		WI-ENG-PDE-9	908	
	Purpose:	PROTOTYF	'E	PRE-LAUNCH	MASSPRO		Revision No.:	0	Page No.:	5 of 5	
PARTS: 1. As	sy parts						JIG:	n/a			
VISUAL INSPECTION/ QUALITY CHECKPOINTS											
PARTS: 1. As	ssy parts		VISI	UAL INSPECTION/ QU	JALITY CHECK	KPOINTS	JIG:	n/a			

CLAMP ASSY

7N0034-7020



No Missing Spot Tape (White Tape)



No Missing Tape (Black Tape)

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