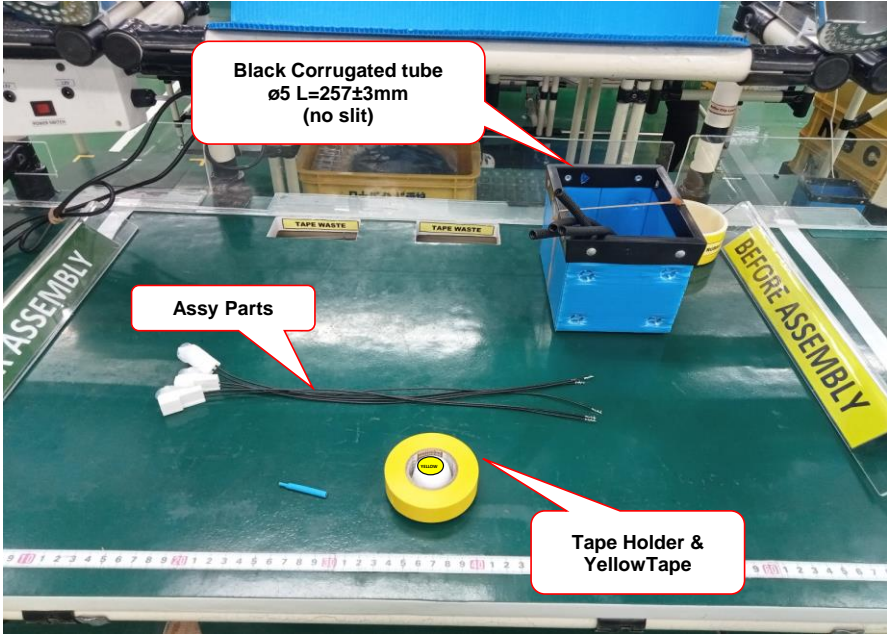



	WORK INSTRUCTION						Effectivity Date:		May 15, 2025			
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a			
	Process Name/Title:			Model code/Part number: 400D / 7L0161-7020			Customer: TRQSS		Car Model: TOYOTA-bZ4X(BEV)		Document No.: WI-ENG-PDE-1206	
	Purpose:			<input type="checkbox"/> PROTOTYPE			<input type="checkbox"/> PRE-LAUNCH			<input checked="" type="checkbox"/> MASSPRO		
Revision No.:		2		Page No.:		1 of 5						

PARTS:		1. Assy Parts 3. Yellow Tape 2. Black Corrugated tube ø5 L=257±3mm (no slit)						JIG:		n/a			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS	
1		P1		<div style="text-align: center;"> TABLE LAY-OUT </div> 						<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance	

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
05/15/25	2	Change pre-launch to mass pro						A.Buban	n/a	C.Villanueva	A.Arañes				
03/25/25	1	Change COT length from L=260mm to L= 257mm						A.Buban	J.Loterte	C.Villanueva	A.Arañes				
02/19/25	0	Initial issue						A.Buban	J.Loterte	C.Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Checked by	Reviewed by	Approved by	Est. Date:	February 19, 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.		<div style="border: 2px solid green; padding: 5px; text-align: center;"> NBC (Philippines) MASTER COPY </div>	
--	--	--	--

DCC Stamp

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 15, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

400D / 7L0161-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X(BEV)

Document No.:

WI-ENG-PDE-1206

Purpose:



PROTOTYPE



PRE-LAUNCH




MASSPRO

Revision No.:

2

Page No.:

2 of 5

PARTS:		1.Assy Parts 2.Black Corrugated tube $\phi 5$ L=257 \pm 3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Wire Insertion to Black Corrugated tube $\phi 5$ L=257\pm3mm (no slit)</div> <div>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</div> <div>2. Get the Black corrugated tube (no slit) $\phi 7$ L=257\pm3mm using right hand then insert the B-B wires using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1.No wrong of parts 2.No wire left between 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



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

400D / 7L0161-7020

Customer:

TRQSS

Car Model: TOYOTA-bZ4X(BEV)

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

May 15, 2025

Validity Date:

n/a

Document No.:

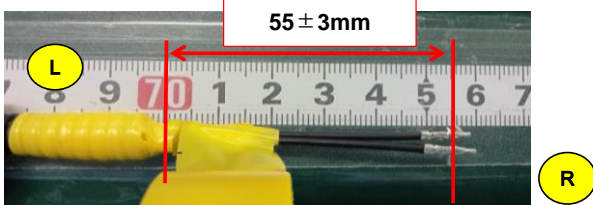
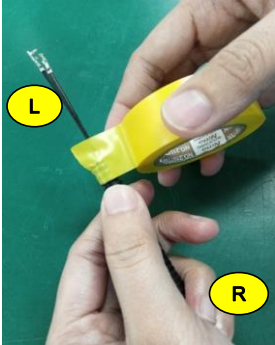
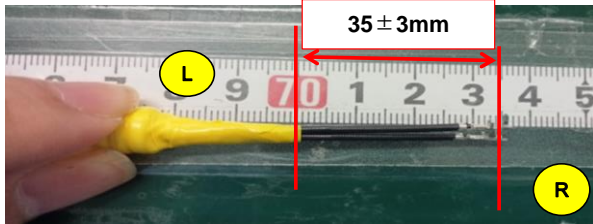
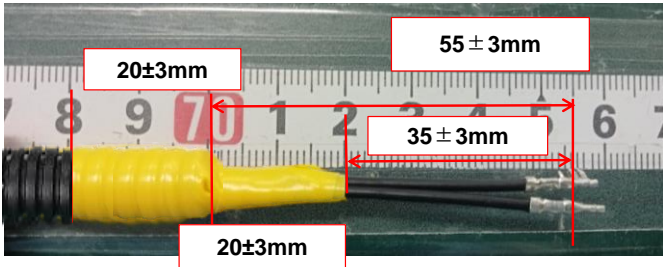
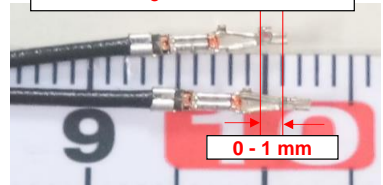

WI-ENG-PDE-1206

Revision No.:

2

Page No.:

3 of 5

PARTS:		1. Assy Parts 3. Yellow Tape 2. Black Corrugated tube $\phi 5$ L=257 \pm 3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div>1. Hold the assy parts using left hand. Get the Yellow tape using right hand then start taping between COT to wire using both hands.</div><div><div><div>2. Measure from end of COT up to terminal pointed tip 55\pm3/-1 then continue the taping process using both hands</div><div>3. Measure from end of tape up to terminal pointed tip 35\pm3/-1 then continue the taping process using both hands</div><div>4. After taping, check the measurement, terminal alignment and taping condition.</div></div></div><div></div></div>		 <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape</div>	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001A for Taping process

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:

May 15, 2025

Validity Date:

n/a

Model code/Part number:

400D / 7L0161-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X(BEV)

Document No.:

WI-ENG-PDE-1206

Purpose:



PROTOTYPE



PRE-LAUNCH



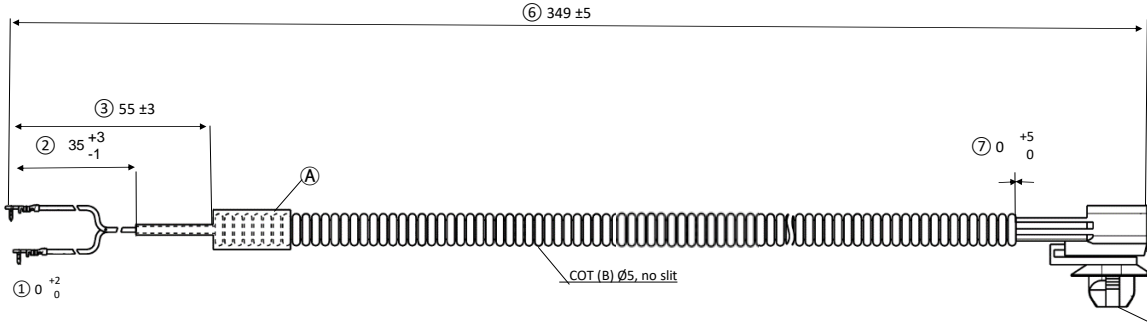
MASSPRO

Revision No.:

2

Page No.:

4 of 5

PARTS:	1.Assy Parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	<div><p>⑥ 349 ±5</p><p>③ 55 ±3</p><p>② 35 ⁺³₋₁</p><p>① 0 ⁺²₀</p><p>⑦ 0 ⁺⁵₀</p><p>COT (B) Ø5, no slit</p><p>NOTE:</p><p>Ⓐ - Taping (Y)</p><p>Ⓒ - Clamp (W)</p><p>*Unit of dimension is in millimeter (mm)</p></div>		<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono,Nakamono,and Owarimono .</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY -056 for sub-assembly Hatsumono,Nakamono,and Owarimono</p> <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:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 15, 2025

Validity Date:

n/a

Model code/Part number:

400D / 7L0161-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X(BEV)

Document No.:

WI-ENG-PDE-1206

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

5 of 5

PARTS:

1. Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING P-1****7L0161-7020****① No Missing Clamp****② No Missing and No Wrong used of 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