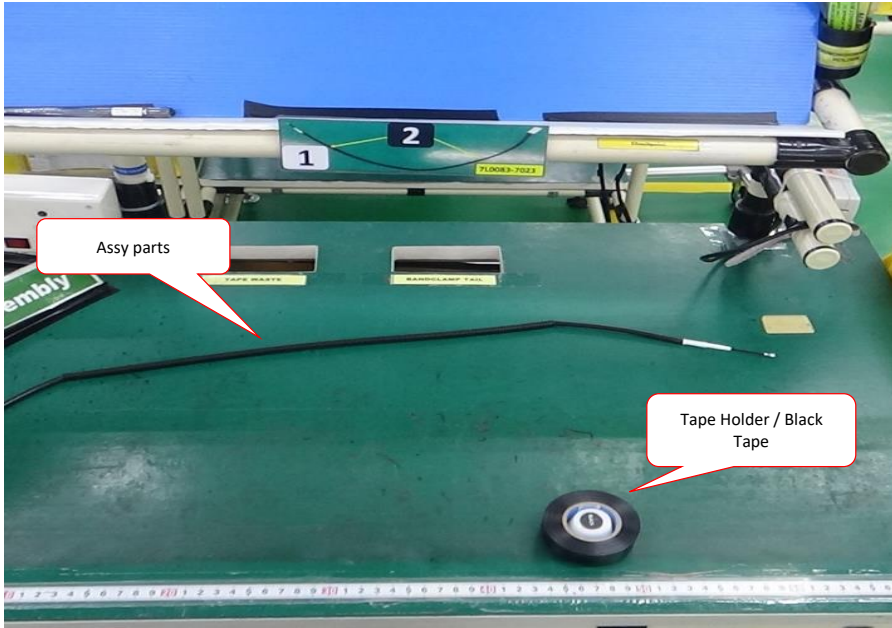
	WORK INSTRUCTION				Effectivity Date:	June 11, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 550B / 7L0083-7023		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-447B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5


PARTS:	1. Assy parts; Black Tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<p style="text-align: center;">Table Lay-out</p> 		<p>Safety Instruction Be sure to wear prescribed 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>	1. No missing parts/tools 2. No excess parts/tools

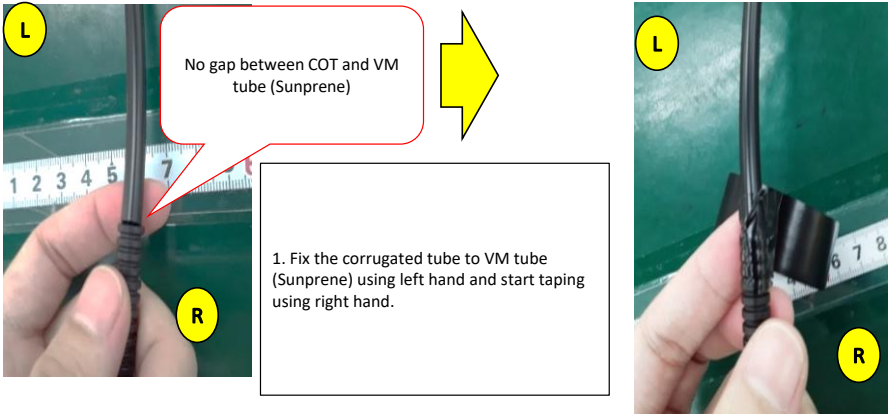
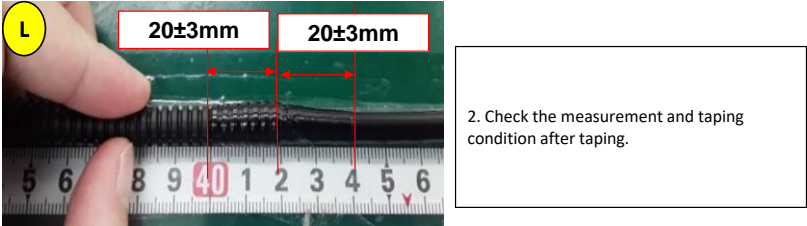

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.		D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 11, 2024

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			Effectivity Date:	June 11, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	550B / 7L0083-7023	Customer:	TRQSS	Car Model:	TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-447B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	0	Page No.:	2 of 5			

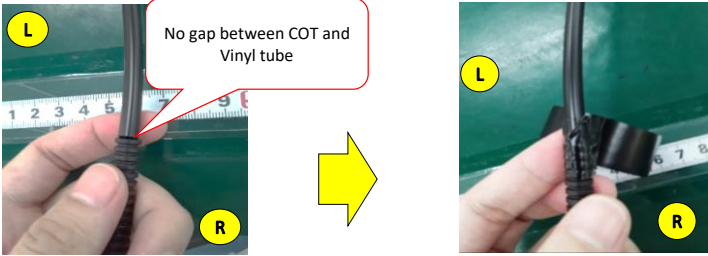
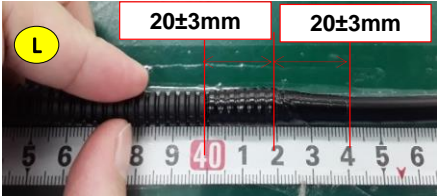

PARTS:		1.Black tape 2.Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 2 COT to VM tube (Sunprene)	<div><div>1. Fix the corrugated tube to VM tube (Sunprene) using left hand and start taping using right hand.</div></div> <div><div>2. Check the measurement and taping condition after taping.</div></div>		<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Refer to WI-PRO-ASY-001 for taping procedure. 1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 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			Effectivity Date:	June 11, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	550B / 7L0083-7023	Customer:	TRQSS	Car Model:	TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-447B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		0	Page No.:	3 of 5		

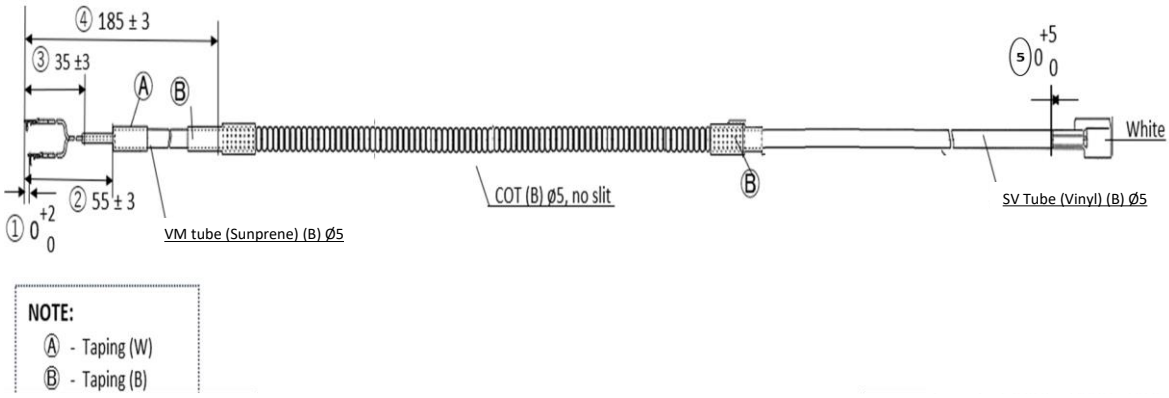

PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 3 Corrugated tube to SV tube (Vinyl)	<div></div> <div>1. Fix the corrugated tube to SV tube (Vinyl) using left hand and start taping using right hand.</div> <div></div> <div>2. Check the measurement and taping condition after taping.</div>		<div>Measuring tape</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Refer to WI-PRO-ASY-001 for taping procedure. 1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 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				Effectivity Date:		June 11, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 550B / 7L0083-7023		Customer: TRQSS		Car Model: TOYOTA-HIGHLANDER	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		Revision No.:		0	Page No.:

PARTS:		1.Assy part		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P2	Measurement  <div>NOTE: A - Taping (W) B - Taping (B)</div>	<div>MEASURING TAPE</div> 	<p>Important reminders and 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 Owarimono Inspection</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:

June 11, 2024

Model code/Part number:

550B / 7L0083-7023

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-447B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 5

PARTS:

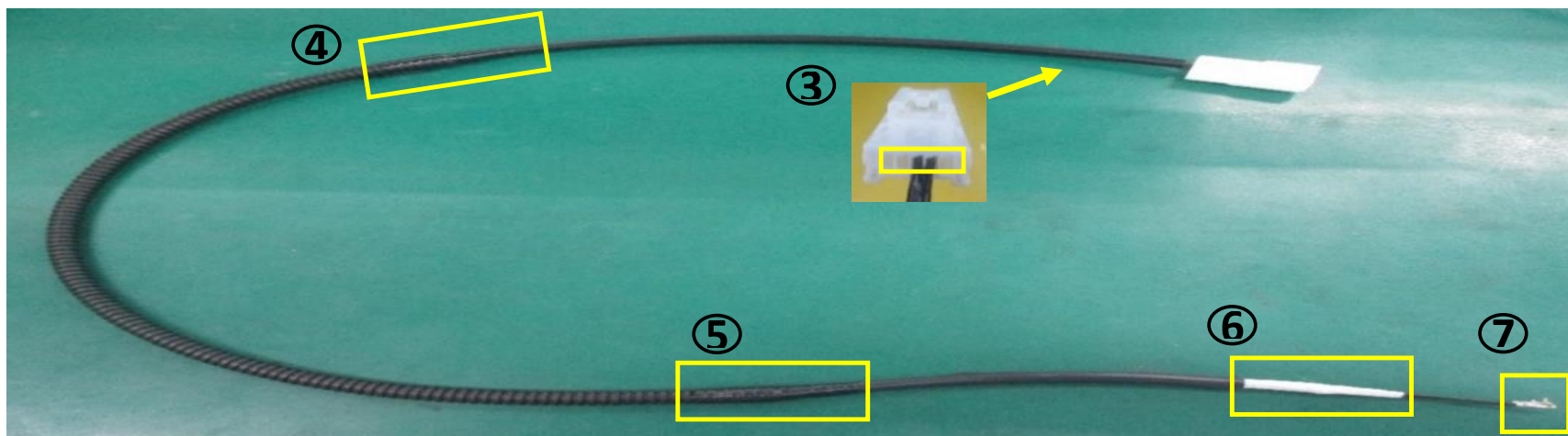
1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****7L0083-7023**

①

**GOOD****NO GOOD**① **No Unlock/Halflock connector**② **No Terminal Backing Out**③ **No Wrong Insert**④ ⑤ **No Missing Tape**⑥ **No Wrong use of Tape (white)**⑦ **No Deform 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