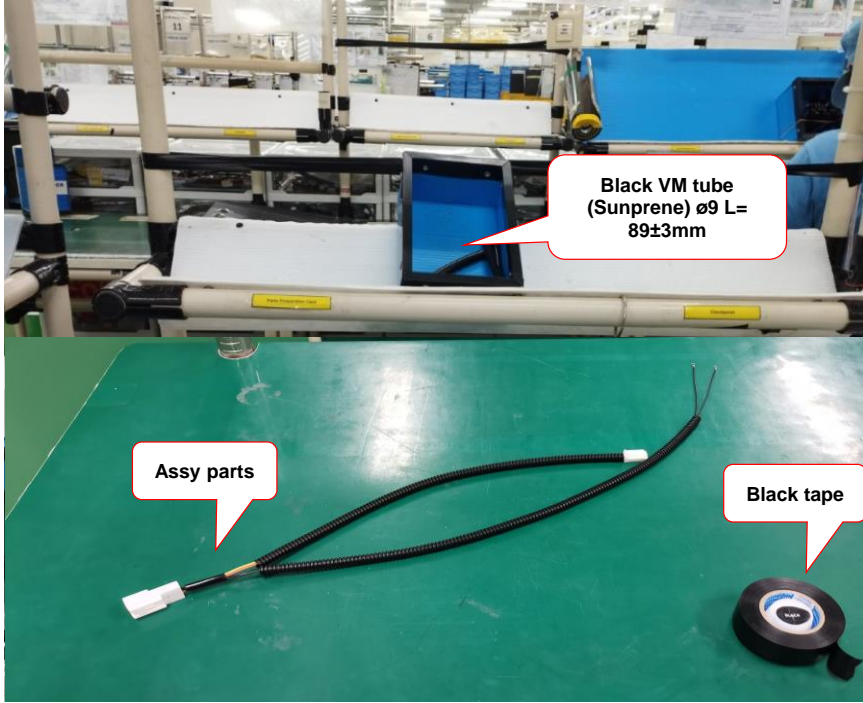



	WORK INSTRUCTION				Effectivity Date:	September 28,2023		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 382D / 7N0175-7020A		Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-727B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 4

PARTS:	1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) ø9 L= 89±3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; display: inline-block;">TABLE LAY-OUT</div>  </div>		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
09/28/2023	2	Remove the unnecessary process on pg.2	J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a	
09/21/2023	1	Change purpose from pre-launch to mass pro	M. Manalac	J. Loterte	C. Villanueva	A. Alvin					
09/15/2023	0	Initial Issue	M. Manalac	J. Loterte	C. Villanueva	A. Alvin					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 15,2023			

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; display: inline-block;"> NBC (Philippines) MASTER COPY </div>
	DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 28,2023

Model code/Part number:

382D

/

7N0175-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-727B

Purpose:

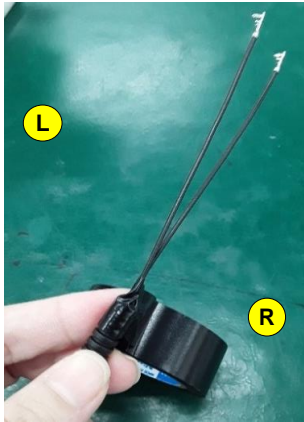
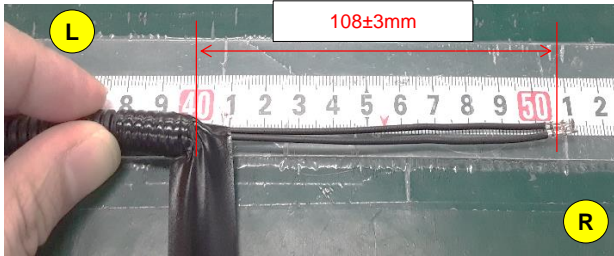
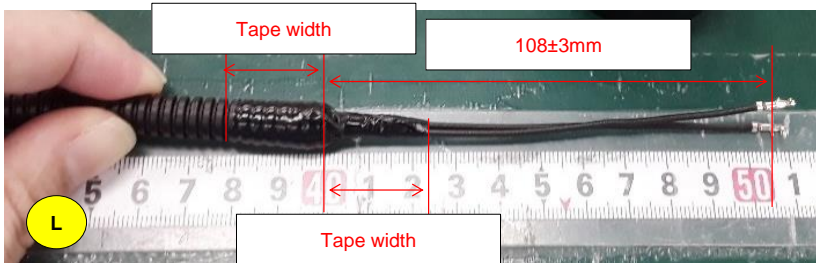

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:


2 of 4


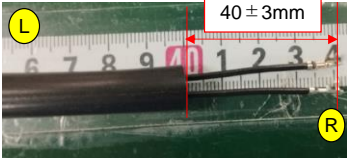

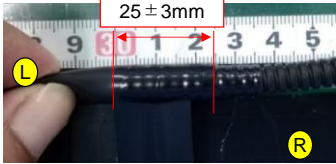

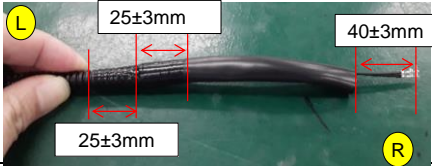


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	<div>2</div> WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black corrugated tube to Wire near terminal	<div><div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div><div>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</div><div>2. Measure from COT to terminal pointed tip 108±3mm using both hands and continue the taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></div><div>3. Check the measurement, wire alignment and taping condition after taping.</div></div> <div><div>MEASURING TAPE</div></div>		<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. Check the tape from COT to Vinyl (Conduct bending for verification) 2.No flip out tape. 3.No tape peeling. 4.No loose tape</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:	September 28,2023		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 382D / 7N0175-7020A		Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-727B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	3 of 4

PARTS:	1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L= 89 \pm 3mm 3. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L= 89 \pm 3mm	 <div> <p>1. Get the Black VM tube (Sunprene) $\varnothing 9$ L=89\pm3mm using right hand then insert the assy parts using left hand.</p> </div>		n/a	1. No wrong use of parts
4	P2 Taping 1 Black Corrugated tube to Black VM (Sunprene)	<div>  <p>1. Measure from end of tube up to terminal pointed tip 40\pm3mm using both hands.</p> </div> <div>  <p>Start of taping</p> </div> <div>  <p>25\pm3mm</p> <p>3. Confirm measurement of 25\pm3mm from end of tape up to end of tube then continue the taping process using both hands.</p> </div> <div>  <p>25\pm3mm</p> <p>4. Confirm measurement of 25\pm3mm from end of tube up to end of tape then continue the taping process using both hands.</p> </div> <div>  <p>25\pm3mm</p> <p>40\pm3mm</p> <p>25\pm3mm</p> <p>5. After taping, check the measurement, terminal appearance and taping condition.</p> </div>		<div> <p>MEASURING TAPE</p>  </div>	<p>1. Check the tape from COT to Vinyl (Conduct bending for verification)</p> <p>2.No flip out tape.</p> <p>3.No tape peeling.</p> <p>4.No loose tape</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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.	<div> <p>NBC (Philippines)</p> <p>MASTER COPY</p> </div>	DCC Stamp
--	---	-----------

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 28,2023

Validity Date:

n/a

Model code/Part number:

382D

/

7N0175-7020ACustomer: **TRJ**Car Model: **TOYOTA-CAMRY**

Document No.:

WI-ENG-PDE-727B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

4 of 4

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P2****7N0175-7020A****1****No Missing Tape****on Y-taping and VM tube (Sunprene)**

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