

	WORK INSTRUCTION				Effectivity Date:		August 15, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 178D / 7N0127-7021A		Customer: TRJ		Car Model: TOYOTA-COROLLA		
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-432		
				Revision No.:		4		Page No.:	1 of 5

PARTS:		1. Assy Parts; Black Corrugated tube $\phi 7$ L=469 \pm 3mm; Black Tape		JIG:		1. Terminal cover jig			
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE		QUALITY POINTERS				
1	P1	Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; text-align: center; color: red;">TABLE LAY-OUT</div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> 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-bottom: 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;"> 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 2. Refer to WI-ENG-PDE-925 for Offline assembly process 1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools		


Revision History								Prepared by		Reviewed by		Approved by		Noted by	
08/15/24	4	Separate Connector setting, Wire insertion and Connector lock process to Offline assembly process due to process improvement. Inclusion of car model "TOYOTA-COROLLA" and Measurement. Update table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C.Villanueva	 A. Arañes	N/A					
02/08/23	3	Work instruction improvement. Inclusion of Quality checkpoint (Page 7).	M.Ariola	J.Loterte	C.Villanueva	A. Arañes									
09/09/22	2	Change of tolerance of 34mm+/-3mm as immediate action for encountered NG dimension from end of tape to terminal pointed tip. Improve work procedure/illustration on process no.2, 3, 4, 5 and 6.	K.Doria	J.Loterte	C.Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 21, 2022							



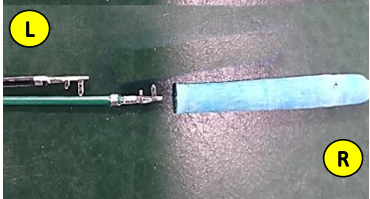

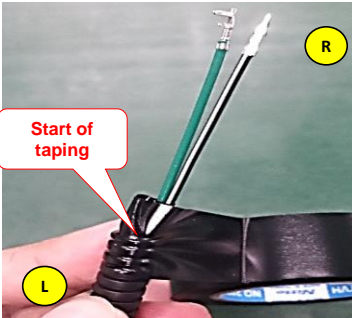

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	August 15, 2024					
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: 178D / 7N0127-7021A		Customer: TRJ	Car Model: TOYOTA-COROLLA		Document No.:	WI-ENG-PDE-432		
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

PARTS:		1. Black corrugated tube ø7 L= 469±3mm (no slit) 2. Assy parts		3. Black tape		JIG:	1.Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to corrugated tube ø7 L=469±3mm (no slit)	<div></div> <div>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</div> <div>2. Get the Black Corrugated tube ø7 L=469±3mm (no slit) using right hand and insert to G-B/W wires using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>				<div></div>	1. No wrong usage of parts 2. No deformed terminal
3	Taping 1 Black COT to wire near terminal	<div></div> <div>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands.</div>				<div></div>	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 Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.

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:

August 15, 2024

Model code/Part number:

178D / 7N0127-7021A

Customer:

TRJ

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-432

Purpose:

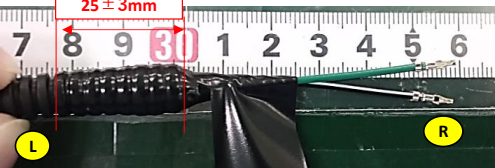
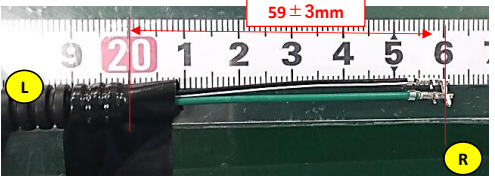

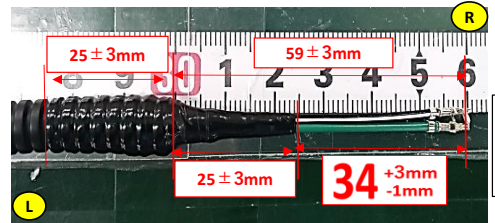

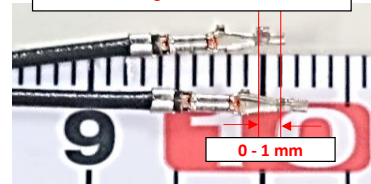
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:


3 of 5

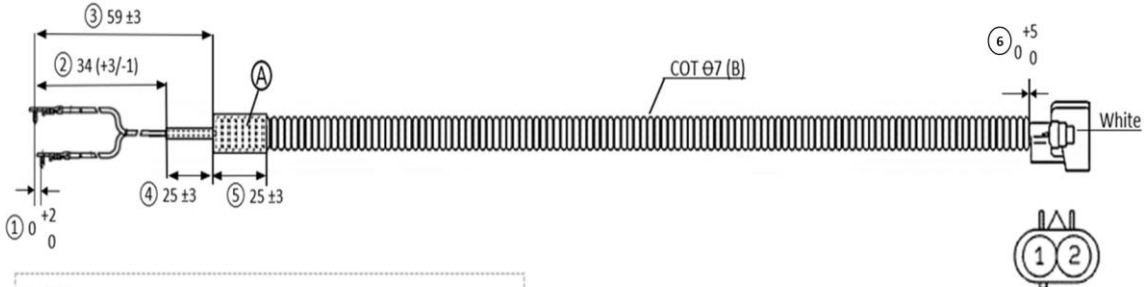

PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Black COT to wire near terminal (Continuation)	<div><p>2. Confirm measurement from end of tape up to end of COT 25±3mm then continue the taping process using both hands.</p></div> <div><p>3. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p></div> <div><p>4. Measure from end of tape up to terminal pointed tip 34+3/-1mm then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<div>Wire alignment tolerance</div>  <p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. 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:	August 15, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 178D / 7N0127-7021A		Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.: WI-ENG-PDE-432		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	4 of 5

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
4	P1 Measurement	<div></div> <div>NOTE: Ⓐ Taping (B) for item number ② , Dimension tolerance is different from the master drawing due to Internal change only.</div>	<div>MEASURING TAPE</div> 	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</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:

August 15, 2024

Validity Date:

n/a

Model code/Part number:

178D / 7N0127-7021A

Customer:

TRJ

Car Model: TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-432

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

5 of 5

PARTS:

1.Assy Parts

JIG:

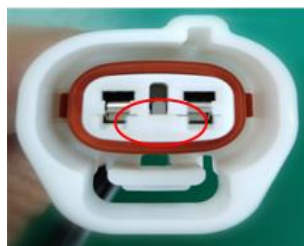
n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

7N0127-7021A



GOOD



NO GOOD



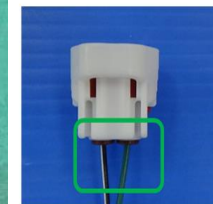
① No Unlock/ Half Lock Connector

② No Wrong Insert

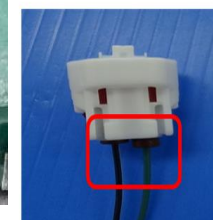
③ No Missing Tape

④ No Terminal Backing Out

④



GOOD



NO GOOD

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