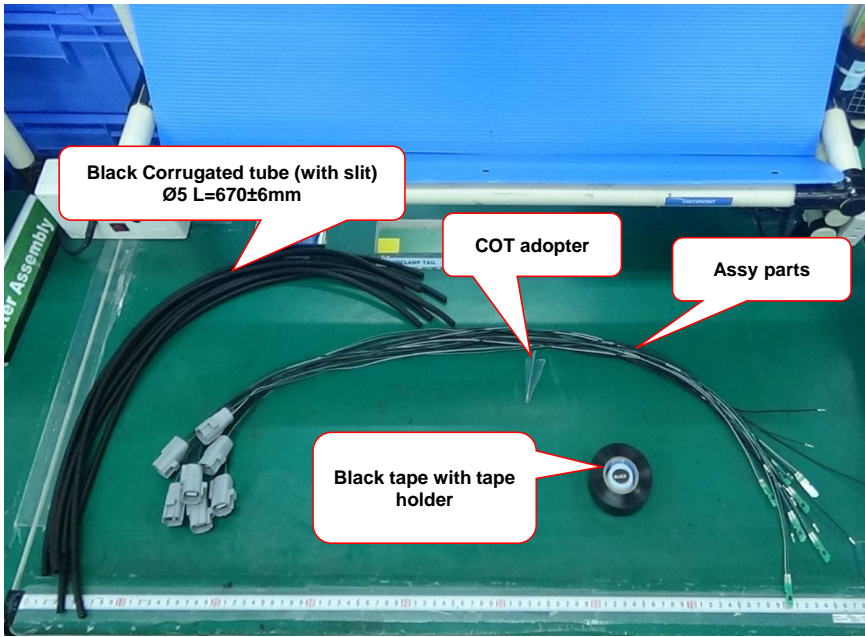




	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: October 21, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-1125A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 1	Page No.: 1 of 4

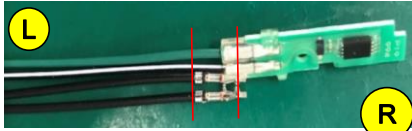


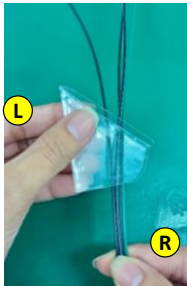
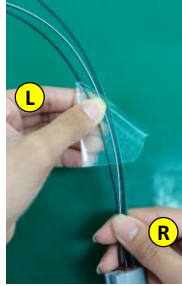


PARTS: 1. Assy parts; Black Corrugated tube (with slit) Ø5 L=670±6mm; Black tape		JIG:	1. COT adopter
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1	<div style="text-align: center;"> Table Lay-out </div> 	<div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid 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 solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-1124 for Offline assembly process	
		1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
10/21/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
10/17/24	0	Initial issue. Separate wire insertion to connector and connector lock to Offline assembly process.	D.Castillo	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 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.

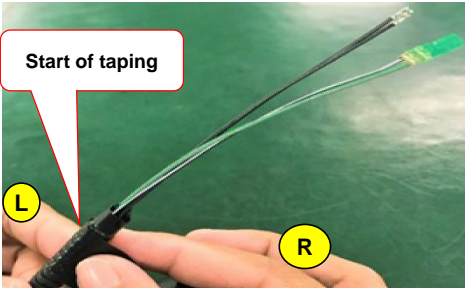
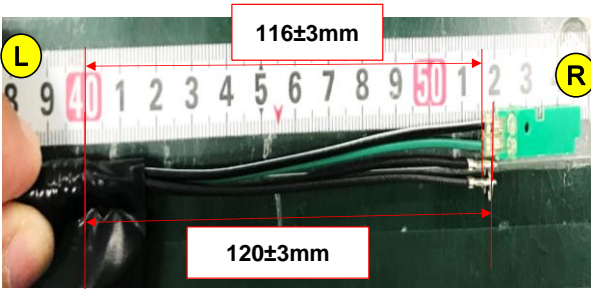
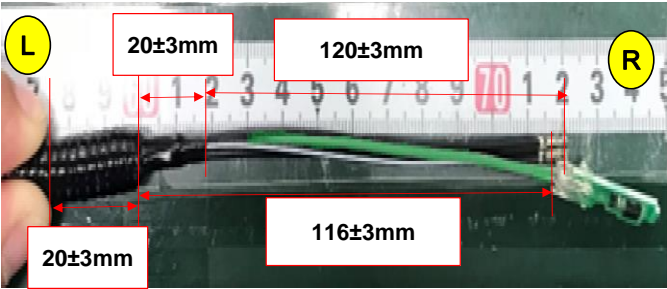
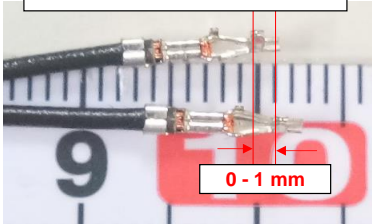
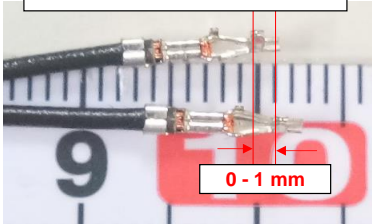
NBC (Philippines)
MASTER COPY

	WORK INSTRUCTION				Effectivity Date:	October 21, 2024					
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1125A			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:		1. Assy parts 2. Black Corrugated tube (with slit) ø5 L=670±6mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Spot taping	<div>  <div>1. Fix the hotmelted wire and terminal pointed tip using both hands.</div> </div> <div>  <div>2. Hold the wires using left hand, get the Black tape using right hand then make 2 windings of tape using both hands. <i>Note: Position of spot taping must be right beside Gray tape.</i></div> </div> <div>  </div>			1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape
3	Wire insertion to Black Corrugated tube (with slit) ø5 L=670±6mm	<div>   </div> <div>  </div> <div> 1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand </div> <div> 2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) ø5 L=670±6mm using right hand and insert to COT adaptor. Pull the adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted. </div>		<div> ADAPTOR JIG </div> 	1. No wrong use of parts 2. No wires left in between the 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.	<div> NBC (Philippines) MASTER COPY </div>	DCC Stamp
--	---	-----------

	WORK INSTRUCTION				Effectivity Date:	October 21, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1125A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 4

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P1 Taping 1 Black corrugated tube (with slit) to wire near terminal and PCB	<div><p>Start of taping</p></div> <div><p>116±3mm</p><p>120±3mm</p></div> <div><p>20±3mm</p><p>120±3mm</p><p>116±3mm</p><p>20±3mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p><p>2. Measure from end of COT up to terminal pointed tip 120±3mm and COT to PCB 116±3mm then continue the taping process using both hands.</p><p>3. After taping, check the measurement, terminal alignment and taping condition.</p></div> <td>n/a</td> <td colspan="2"><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document reference/s:</p><p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p><p>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</p><div><p>Terminal alignment tolerance</p><p>0 - 1 mm</p></div></td>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>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</p> <div><p>Terminal alignment tolerance</p><p>0 - 1 mm</p></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:

October 21, 2024

Model code/Part number:

240B / 7M0514-7021BCustomer: **TRJ**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1125A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

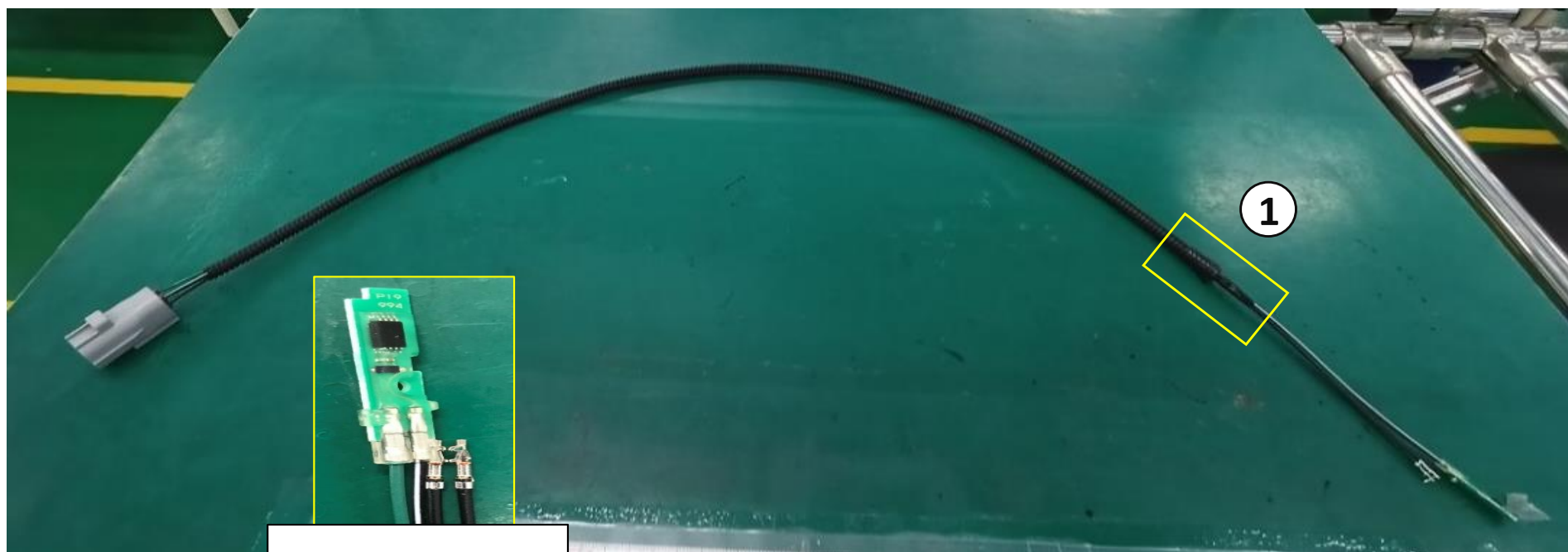
Page No.:

4 of 4**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7M0514-7021B**

Proper alignment of
B-B wires and hotmelt

1**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