



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

March 15, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

311D/ 7L0156-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1197

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 6

PARTS:

1. Connector 6098-3802 (W)
2. AVSSF 0.3 B wires L=167±2mm

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

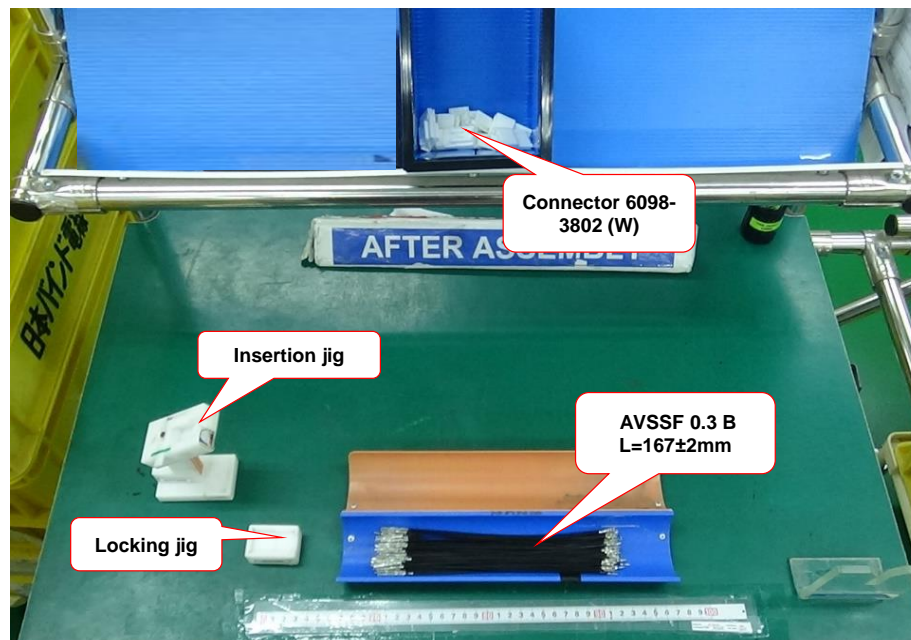
QUALITY POINTERS

1

Offline

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
03/15/25	1	Change Purpose from Pre-launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
02/12/25	0	Initial issue.	M. Ariola	n/a	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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:

March 15, 2025

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

311D/ 7L0156-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1197

Purpose:


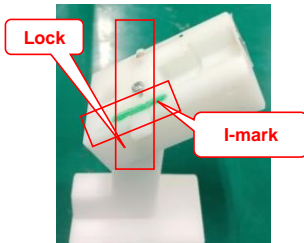
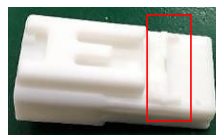
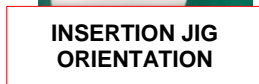
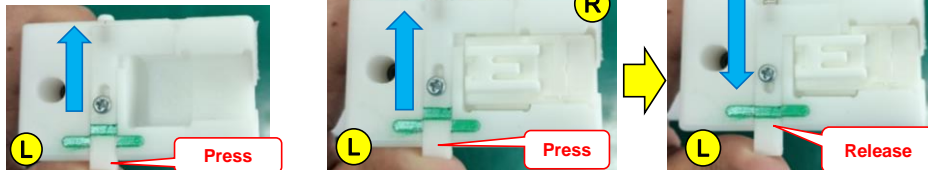





☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector Setting to insertion jig 6098-3802 (W)	<div><div><p>Holes</p></div><div><p>Lock</p><p>I-mark</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><p>Press</p><p>Press</p><p>Release</p></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock.</p><div><p>B B</p></div><p>3. Check the holes/terminal slot for B-B wires.</p></div></div>		n/a	<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><p>I-mark is align</p></div><div><p>1 hole is open</p></div><p>GOOD</p><div><p>I-mark is not align</p></div><div><p>all holes are open</p></div><p>NG</p><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</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**

Effectivity Date:

March 15, 2025

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

311D/ 7L0156-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1197

Purpose:


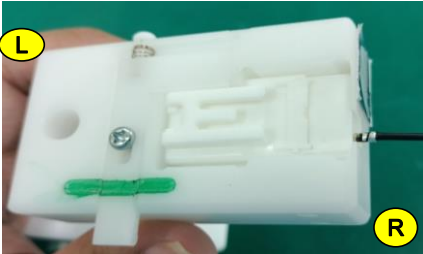
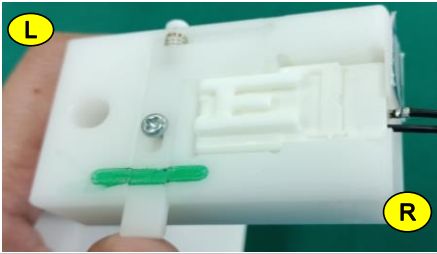

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 6

PARTS:	1. AVSSf 0.3 B wires L=167±2mm [2pcs]			JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire Insertion to Connector 6098-3802 (W)	<div data-bbox="808 387 1052 496"></div> <div data-bbox="1059 411 1254 467">WIRE FACING</div> <div data-bbox="555 550 976 804"></div> <div data-bbox="560 836 965 885">1. Get the 1st B wire then insert to connector using right hand.</div> <div data-bbox="1041 558 1476 812"></div> <div data-bbox="1041 836 1449 885">2. Get the 2nd B wire then insert to connector using right hand.</div> <div data-bbox="551 1013 929 1214"></div> <div data-bbox="938 1083 1460 1153">3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>Important reminders/note/s:</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</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

OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 311D/ 7L0156-7022

Customer: TRQSS

Car Model: TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 15, 2025

Validity Date:

n/a

Document No.:


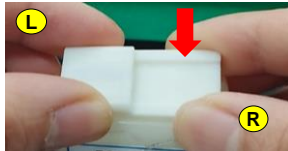



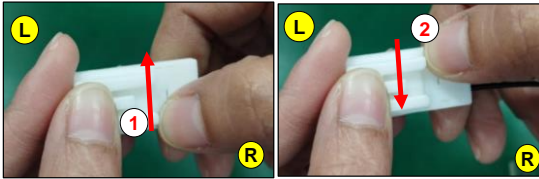




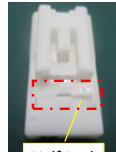
WI-ENG-PDE-1197

Revision No.:

1

Page No.:

4 of 6

PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div>LOCKING JIG</div> 	<p>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</p> <p>Important reminders/note/s: 1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK 2. Use provided jig tool per model to avoid damaged lock.</p> <p>Document reference/s: 1. Refer to GL-PRO-ASS-017 for the Verification of Coupler lock</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD Full Lock</p><p>NG Half Lock</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:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

March 15, 2025

Validity Date:

n/a

Model code/Part number:

311D/ 7L0156-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1197

Purpose:

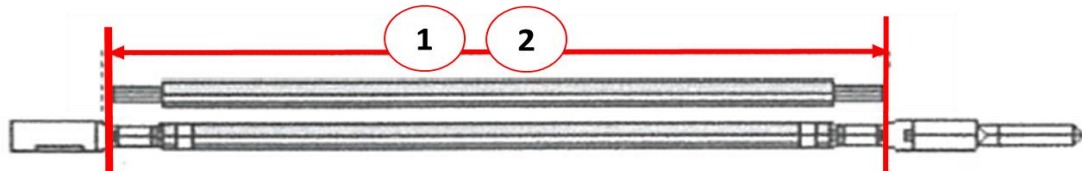

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 6

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			1. No wrong dimension	

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: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

March 15, 2025

Validity Date:

n/aModel code/Part number: **311D/ 7L0156-7022**Customer: **TRQSS**Car Model: **TOYOTA-RAV 4**

Document No.:

WI-ENG-PDE-1197Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

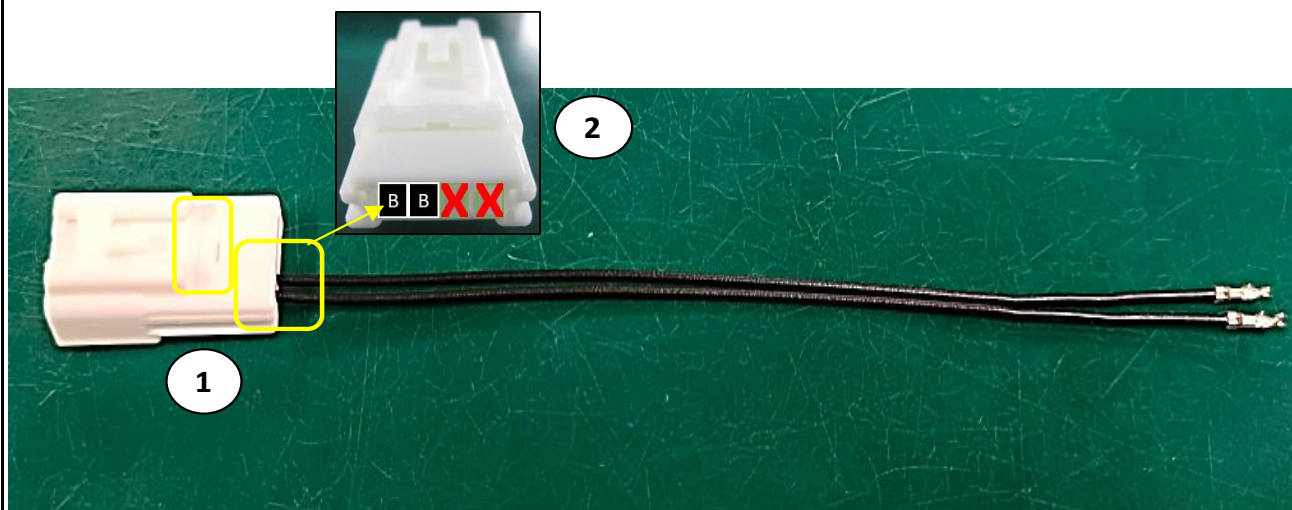
Page No.:

6 of 6**PARTS:**

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0156-7022**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Deformed 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