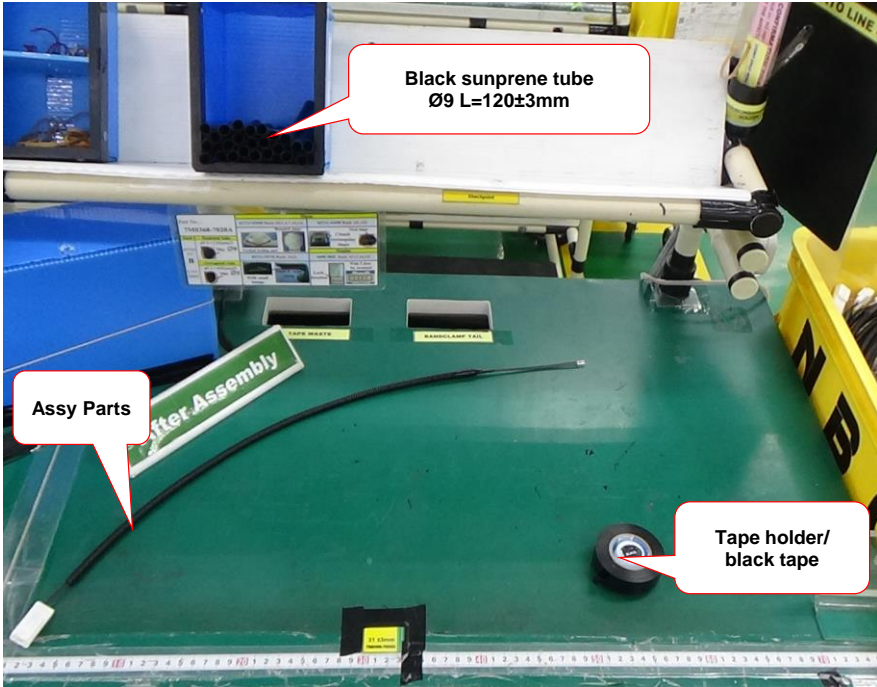



	WORK INSTRUCTION					Effectivity Date:		July 02, 2024	
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 011B / 7M0367-7020A		Customer: TRJ	Car Model: TOYOTA-CAMRY		Document No.: WI-ENG-PDE-174B	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.: 6		Page No.: 1 of 5

PARTS:		1. Assy parts ; Black Tape ; Black VM tube (Sunprene) Ø9 L=120±3mm				JIG:		n/a	
NO.		PROCESS NAME		6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1		P1 Table Lay-out		<div><div>Table Lay-out</div></div>		<div><div>Safety Instruction</div><div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div>1. No missing parts/tools 2. No excess parts/tools</div>	


Revision History						Prepared by		Reviewed by		Approved by		Noted by	
07/02/24	6	Transfer process from P1. Update Table lay-out, Measurement and Visual inspection/Quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
05/17/23	5	Inclusion of table lay-out and quality pointers; improve by two's inspection; improve important reminders				J. Loterte	C. Villanueva	A. Arañes	n/a				
03/22/21	4	Revise due to standardize the color of clamp in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements and update pictures.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 10, 2018		

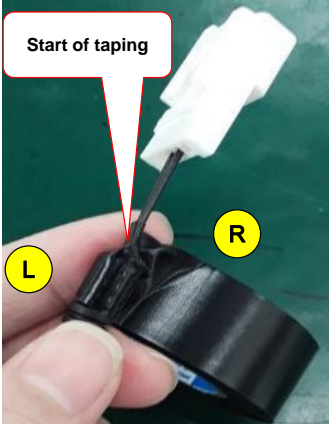
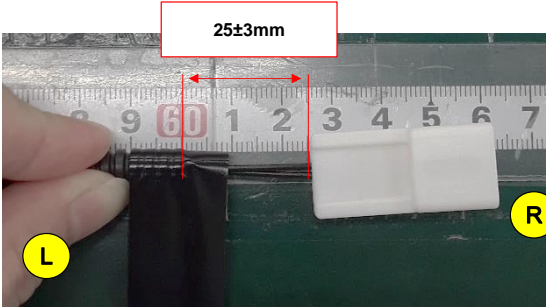
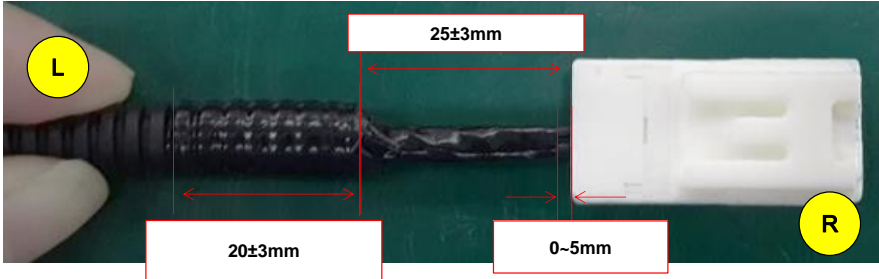

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	WORK INSTRUCTION			Effectivity Date:	July 02, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	011B / 7M0367-7020A	Customer:	TRJ	Car Model:	TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-174B	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	6	Page No.:	2 of 5


PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	<div>6</div> <div>P1</div> <div>Taping 2 Black corrugated tube (no slit) to wire near connector</div>	<div><div>Start of taping</div><div></div><div>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</div></div> <div><div></div><div>2. Hold the corrugated tube using left hand, measure from end of corrugated tube up to the edge of connector 25±3mm using both hands.</div></div> <div><div></div><div>3. After taping, check the measurement and tape condition.</div></div>		<div>MEASURING TAPE</div> <div></div>	<div>Important reminders/Note/s: 1.Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1.Refer to WI-PRO-ASY-001 for taping procedure.</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</div>	


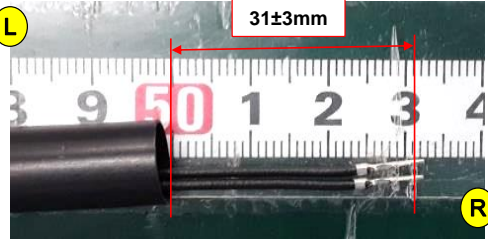


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	WORK INSTRUCTION			Effectivity Date:	July 02, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-174B		
	Model code/Part number: 011B / 7M0367-7020A		Customer: TRJ	Car Model: TOYOTA-CAMRY	Revision No.: 6 Page No.: 3 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Assy parts 2. Black VM tube (Sunprene) ø9 L=120±3mm 3. Black tape [1pc]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Wire insertion to Black VM tube (Sunprene) ø9 L=120±3mm <div>6</div>	 <div>1. Get the Black VM tube (Sunprene) ø9 L=120±3mm using right hand then insert the wires using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal	
4	Taping 3 Black VM tube (Sunprene) to Black corrugated tube (no slit) <div>P1</div> <div>6</div>	<div><div>1. Measure from end of Black VM tube (Sunprene) up to terminal pointed tip 31±3mm using both hands.</div></div> <div><div>2. Hold the Black VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.</div></div> <div>3. After taping, check the taping condition and measurement.</div>	<div>MEASURING TAPE</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</div>	<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>	

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**WORK INSTRUCTION**

Process Name/Title:

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Effectivity Date:

July 02, 2024

Model code/Part number:

011B / 7M0367-7020A

Customer:

TRJ

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TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-174B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

4 of 5

PARTS:

1. Assy parts

JIG:

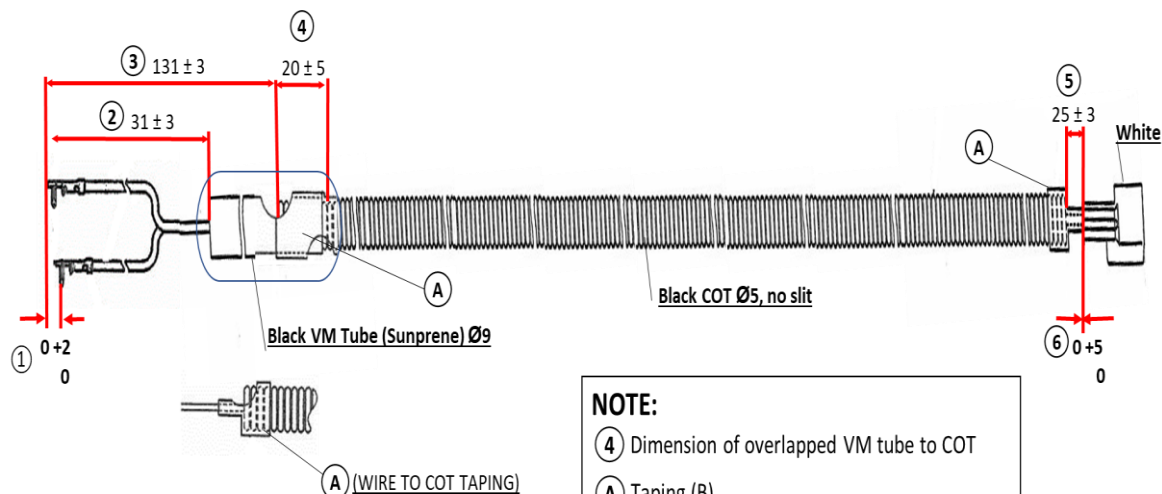
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NO.**PROCESS NAME****6****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Measurement

**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

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

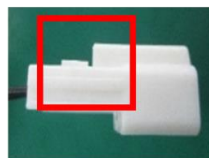
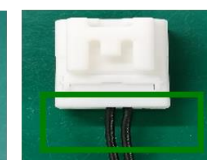
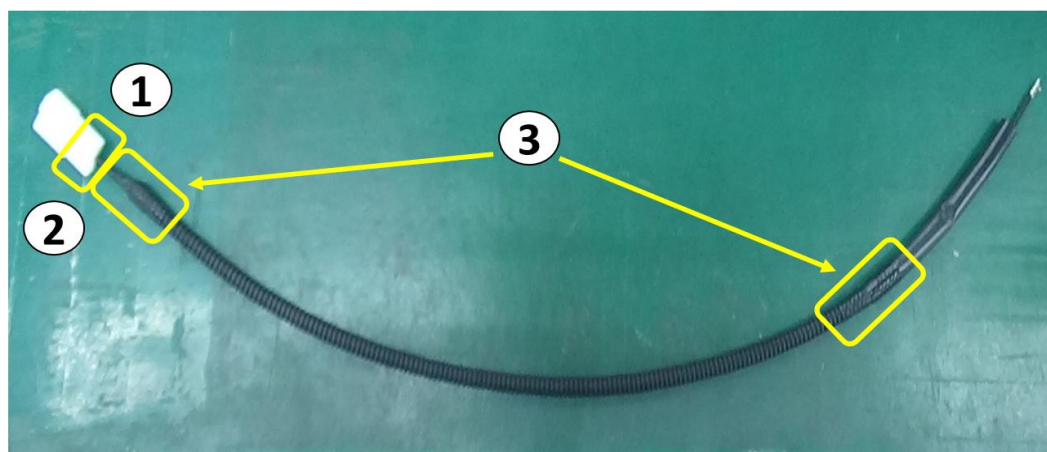
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7M0367-7020A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD**

① **No Unlock / Halflock Connector**

② **No Wrong Insert**

③ **No Missing Tape (Taping on COT-wire and taping on VM tube)**

④ **No Deformed Terminal**

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