



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE

PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-651B

Revision No.:

2

Page No.:

1 of 6

PARTS:

1. Assy parts ; Clamp 82711-1E360 (W); Black tesa tape 51036; Brown tape

JIG:

1. Cutter jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

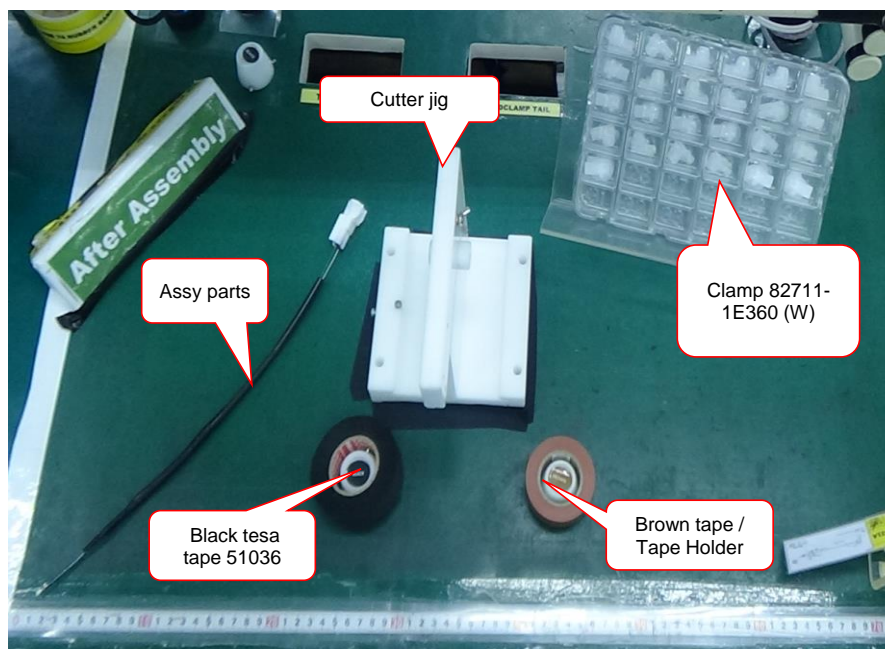
QUALITY POINTERS

1

P2

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.

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/24/24	2	Separate and transfer Clamp process to Clamp Assembly Process. Inclusion of Improve measurement and visual inspection/qualit checkpoints.	A. Hernandez	Villanueva	A. Arañes	n/a				
04/17/23	1	Document purpose from prelaunch to masspro. Improve table lay-out. Improve work procedure and illustration due to improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	A. Hernandez	C. Villanueva	A. Arañes	
03/16/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				n/a

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

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-651B

Revision No.:

2

Page No.:

2 of 6

PARTS:

1. Assy part
2. Black tesa tape 51036

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

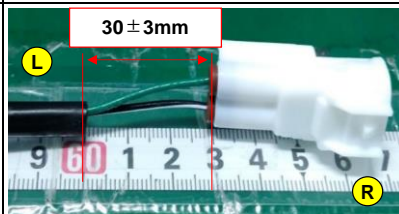
TOOLS/PPE

QUALITY POINTERS

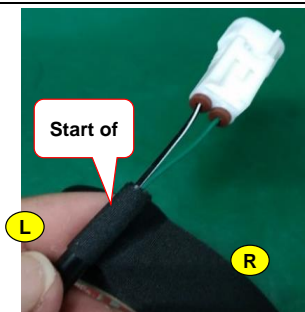
2

P2

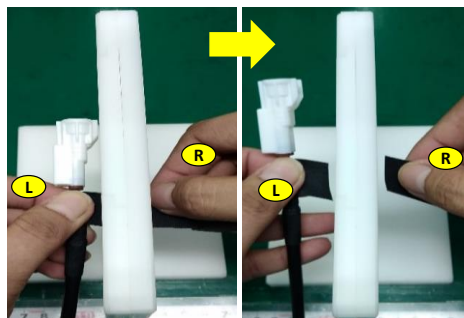
Taping 1
Black tesa tape 51036 to
wire near connector



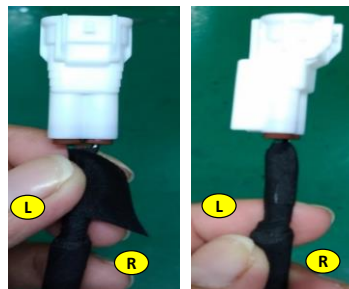
1. Measure from end of Black SV tube (Vinyl) up to edge of connector **30±3mm** using both hands.



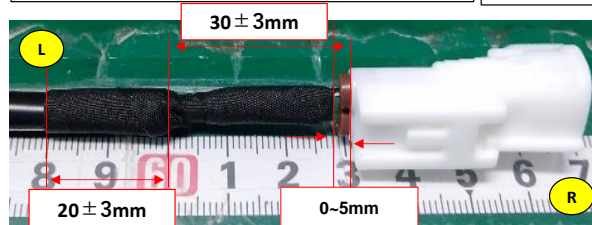
2. Hold the tube using left hand, get the **Black tesa tape 51036** using right hand then start taping process using both hands.



3. Cut the tape using tape cutter using both hands.



4. After cut, conduct pressing of end tape using both hands.



5. Check the taping condition, measurement and wire alignment.

MEASURING TAPE



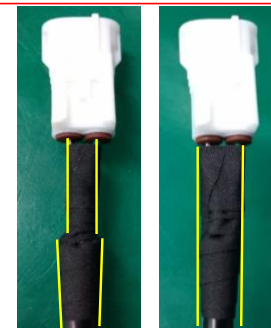
TAPE CUTTER



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

Important reminders/Note/s:
Please use calibrated/verified measuring tape when getting the measurement.

TAPING CONDITION REFERENCE



GOOD

If the taping on wires is NOT align with tube appearance

NG

If the taping on wires is align with tube appearance and loose

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****TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-651B

Purpose:

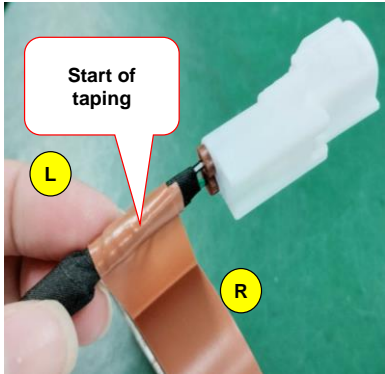
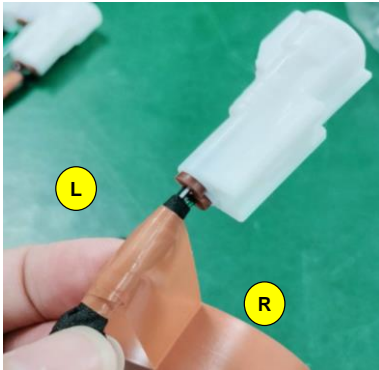
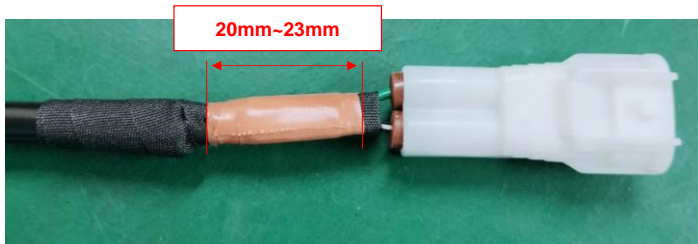
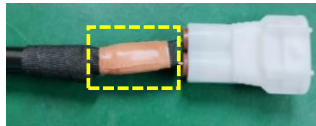
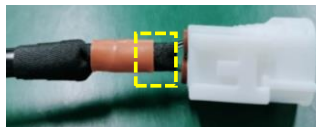
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

3 of 6

PARTS:		1. Assy parts 2. Brown Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Spot taping	<div><div><p>Start of taping</p><p>L</p><p>R</p></div><div><p>L</p><p>R</p></div><div><p>1. Hold the assy parts using left hand, get the Brown tape using right hand then start taping process using both hands.</p><p>2. Conduct windings of tape until it covers the end of tesa tape then conduct 2 windings of tape before cut using both hands.</p></div><div><p>20mm~23mm</p></div><div><p>3. After taping, check the taping condition. Spot taping must be from 20mm~23mm only.</p></div></div>		n/a	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</div> <div><p>GOOD NO EXPOSED END OF TESA TAPE</p></div> <div><p>NG WITH EXPOSED END OF TESA TAPE</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****TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-651B

Purpose:

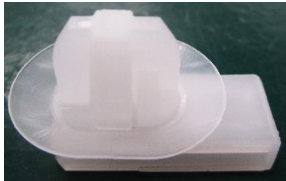
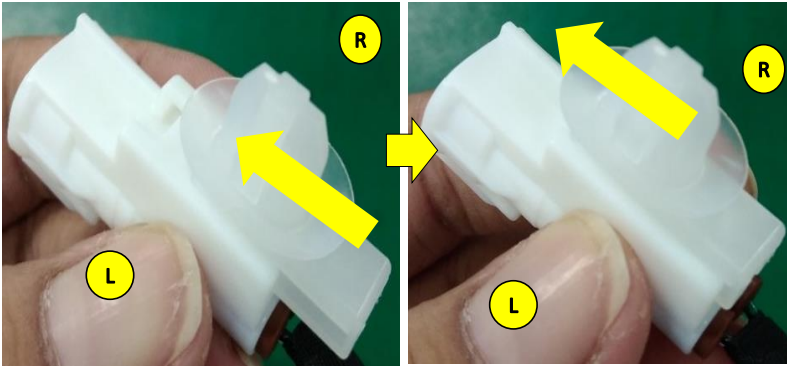
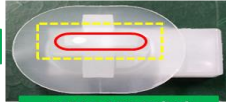
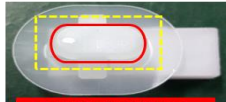
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

4 of 6

PARTS:		1. Assy parts 2. Brown Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clip attachment 82711-1E360 (W)	<div></div> <div>CLAMP ORIENTATION</div> <div></div> <div>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</div>		n/a	<div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div></div> <div><div>NG</div><div>82711-12B10 (W)</div></div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</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

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Process Name/Title:

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-651B

Revision No.:

2

Page No.:

5 of 6

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

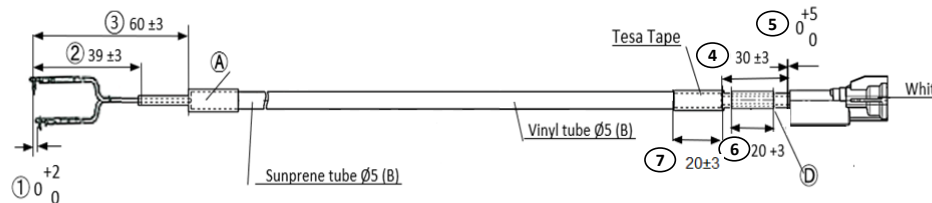
2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

Illustration:



NOTE:

A - Taping (B)

D - Taping (BR) *** Check the presence of spot tape

WIRE TYPE TABLE

No.	Color	Wire Type
1	G	TVSS 0.3f
2	B/W	TVSS 0.3f

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.

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:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-651B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

6 of 6

PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P2****7R0120-7021A****1 No Locked Connector****3 No Missing / Wrong Use of Tape****5 No Missing Clamp****2 No Wrong Insert****4 No Terminal Backing Out****6 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