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|--|---|--|--|--|---------------|------------------------|---|---------------------------------|------------------|
| | WORK INSTRUCTION | | | | | Effectivity Date: | | January 21, 2025 | |
| | TAPING ASSEMBLY PROCESS | | | | | Validity Date: | | n/a | |
| | Process Name/Title: | | | Model code/Part number: TM3 / 7L0115-7020 | | Customer: TRQSS | | Car Model: SUBARU-ASCENT | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | | Document No.: | | WI-ENG-PDE-315B | |
| | | | | | Revision No.: | | 3 | | Page No.: 1 of 6 |

| PARTS: | 1. Assy parts; Black tape | | | | | JIG: | n/a | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---------------------------|---|-------------|---------------|---------------|--|-------------------------|--|-----------|---------|-------------------|---------|----------|----------|-------|----------|---|---|------------|---------------|-----------|-----|----------|---|---|-------------|------------|---------------|-----------|----------|---|---|-------------|------------|---------------|-----------|----------|---|----------------|-------------|---------------|--------------|-----------|-------------|-------------|-------------|----------|-----------------|-------------------|---------------|-----|------------|-----------------|--|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | | TOOLS/PPE | QUALITY POINTERS | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | P2 | <div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">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> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <div style="display: flex; justify-content: space-between;"> <div> Revision History <table border="1" style="width: 100%; border-collapse: collapse; font-size: 0.8em;"> <tr> <th>Eff. Date</th> <th>Rev. No</th> <th>Details of Change</th> <th>Revised</th> <th>Reviewed</th> <th>Approved</th> <th>Noted</th> </tr> <tr> <td>01/21/25</td> <td>3</td> <td>Separate Foam attachment and Assembly jig to Clamp assembly process. Transfer Y-taping and Taping 2 from P1. Inclusion of measurement. Improved Table lay-out and Visual inspection/Quality checkpoint.</td> <td>D.Castillo</td> <td>C. Villanueva</td> <td>A. Arañes</td> <td>n/a</td> </tr> <tr> <td>10/14/22</td> <td>2</td> <td>Change tolerance from 35+/-3mm to 35+3/-1mm as countermeasure of encountered NG dimension from end of tape up to terminal tip. Improve quality pointers: Reminders/notes and references on process no.3,4,6,7 and 8 due to document. Improve. Work procedure/Illustration on process no. 7- Visual/by two's inspection.</td> <td>M. Catapang</td> <td>J. Loterte</td> <td>C. Villanueva</td> <td>A. Arañes</td> </tr> <tr> <td>09/28/21</td> <td>1</td> <td>Improve all process description and illustration; Change from pre-launch to masspro</td> <td>M. Catapang</td> <td>J. Loterte</td> <td>C. Villanueva</td> <td>A. Arañes</td> </tr> <tr> <td>08/03/21</td> <td>0</td> <td>Initial issue.</td> <td>M. Catapang</td> <td>C. Villanueva</td> <td>A. Shimamura</td> <td>A. Arañes</td> </tr> </table> </div> <div> <table border="1" style="width: 100%; border-collapse: collapse; font-size: 0.8em;"> <tr> <th>Prepared by</th> <th>Reviewed by</th> <th>Approved by</th> <th>Noted by</th> </tr> <tr> <td style="text-align: center;"> D. Castillo </td> <td style="text-align: center;"> C. Villanueva </td> <td style="text-align: center;"> A. Arañes </td> <td style="text-align: center;">n/a</td> </tr> <tr> <td>Est. Date:</td> <td colspan="3">August 03, 2021</td> </tr> </table> </div> </div> | | | | | | | | | Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | 01/21/25 | 3 | Separate Foam attachment and Assembly jig to Clamp assembly process. Transfer Y-taping and Taping 2 from P1. Inclusion of measurement. Improved Table lay-out and Visual inspection/Quality checkpoint. | D.Castillo | C. Villanueva | A. Arañes | n/a | 10/14/22 | 2 | Change tolerance from 35+/-3mm to 35+3/-1mm as countermeasure of encountered NG dimension from end of tape up to terminal tip. Improve quality pointers: Reminders/notes and references on process no.3,4,6,7 and 8 due to document. Improve. Work procedure/Illustration on process no. 7- Visual/by two's inspection. | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | 09/28/21 | 1 | Improve all process description and illustration; Change from pre-launch to masspro | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | 08/03/21 | 0 | Initial issue. | M. Catapang | C. Villanueva | A. Shimamura | A. Arañes | Prepared by | Reviewed by | Approved by | Noted by | D. Castillo | C. Villanueva | A. Arañes | n/a | Est. Date: | August 03, 2021 | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| 09/28/21 | 1 | Improve all process description and illustration; Change from pre-launch to masspro | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 08/03/21 | 0 | Initial issue. | M. Catapang | C. Villanueva | A. Shimamura | A. Arañes | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Prepared by | Reviewed by | Approved by | Noted by | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| D. Castillo | C. Villanueva | A. Arañes | n/a | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Est. Date: | August 03, 2021 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 21, 2025

Model code/Part number:

TM3 / 7L0115-7020

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Document No.:

WI-ENG-PDE-315B

Purpose:



PROTOTYPE



PRE-LAUNCH



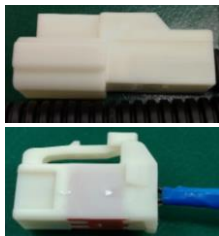
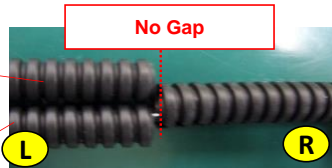
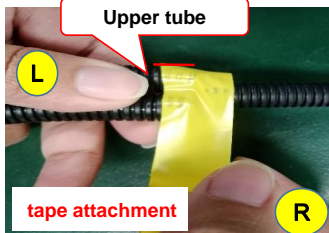

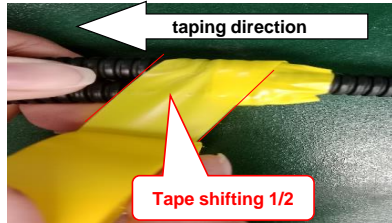
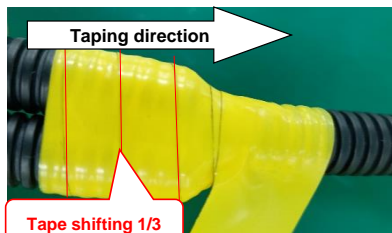
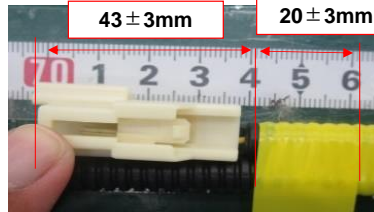
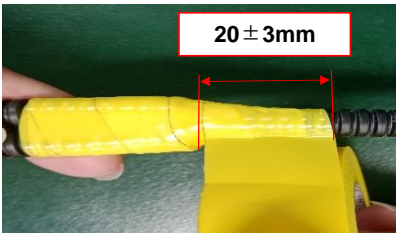
MASSPRO

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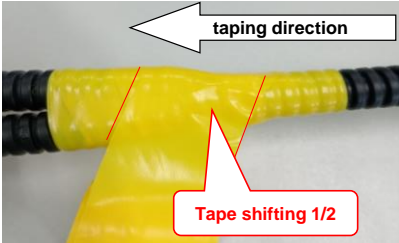
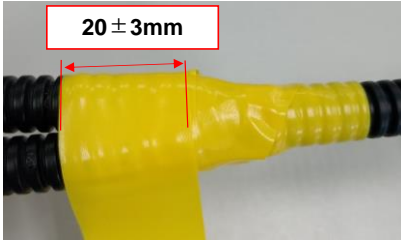
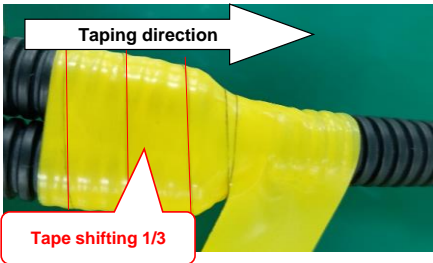
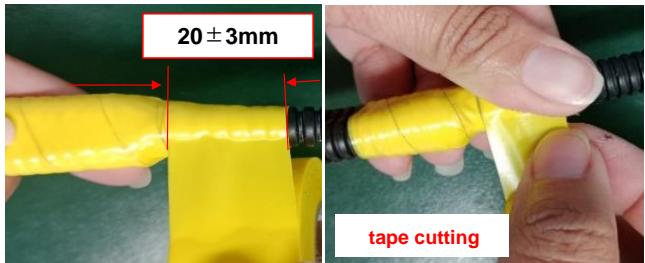
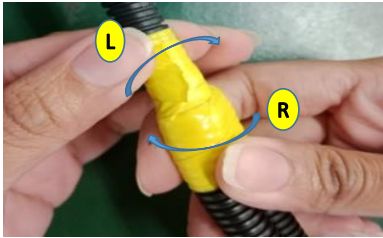
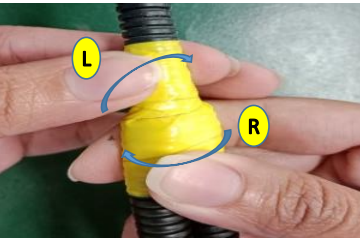
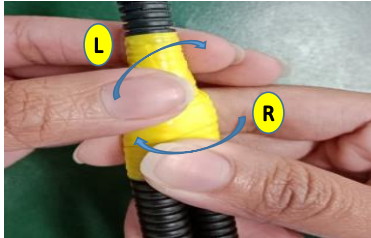
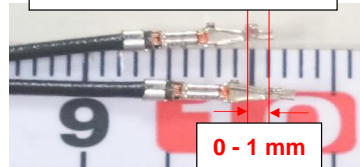
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|--------|--------------------------------|--|--|-----------|------------------|
| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P2 <div>3</div> Y-taping | <div><div><p>CORRECT FACING</p></div><div><p>No Gap</p><p>L R</p><p>1. Fix the 3 corrugated tube. Note: Follow the correct facing.</p></div><div><div><p>Upper tube</p><p>tape attachment</p><p>L R</p></div><div><p>pre-tape</p></div><div><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</p></div><div><div><p>taping direction</p><p>Tape shifting 1/2</p></div><div><p>3. Winding the tape 1/2 shifting going to the left side.</p></div><div><div><p>Taping direction</p><p>Tape shifting 1/3</p></div><div><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div></div><div><div><p>43 ± 3mm</p><p>20 ± 3mm</p></div><div><p>4. Measure Connector up to end of tape 43±3mm. Make 2 windings, width must be 20±3mm.</p></div><div><div><p>20 ± 3mm</p></div><div><p>6. Make 2 windings, width must be 20±3mm.</p></div></div></div><div><p>Document reference/s:</p><p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p><p>Important reminders/Note/s:</p><p>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p><p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p></div></div></div></div> | | | |

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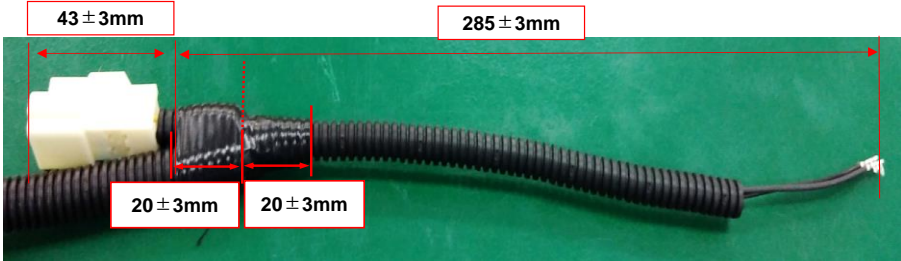
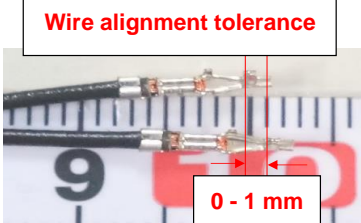
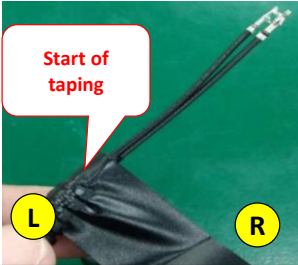

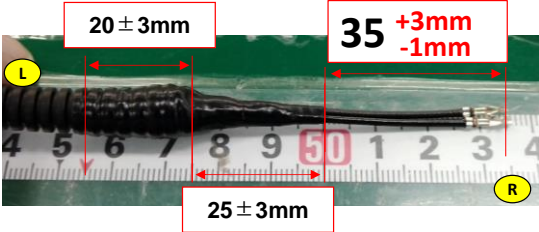
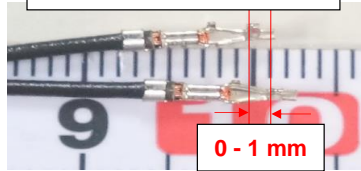
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|  | WORK INSTRUCTION | | | Effectivity Date: | January 21, 2025 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | Validity Date: | n/a | | |
| | Model code/Part number: TM3 / 7L0115-7020 | | Customer: TRQSS | Car Model: SUBARU-ASCENT | Document No.: WI-ENG-PDE-315B | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | Revision No.: | 3 | Page No.: | 3 of 6 |

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|---|----------------------------------|--|------------------|--|
| PARTS: 1. Assy parts 2. Black tape | | JIG: | | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 2 | P2 Y-taping (Continuation) | <div>  <p>7. Winding the tape 1/2 shifting going to the left side.</p> </div> <div>  <p>8. Make 2 windings, width must be 20±3mm.</p> </div> <div>  <p>9. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p> </div> <div>  <p>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</p> </div> <div>  <p>11. conduct proper pressing of end tape using left hand (top part). <i>Note: Reference only.</i></p> </div> <div>  <p>12. conduct proper pressing of end tape using left hand (Middle part). <i>Note: Reference only.</i></p> </div> <div>  <p>13. conduct proper pressing of end tape using left hand (bottom part). <i>Note: Reference only.</i></p> </div> | | <p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"> No loose tape No flip-out tape No peel-off tape No wrong use of tape No wrong dimension-out tape No exposed wire No gap between tubes <div> <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p> </div> |

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| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | Revision No.: | 3 | Page No.: | 4 of 6 |

| | | | | | | | |
|---------------|--|--|------------------|--|-----|--|--|
| PARTS: | 1. Assy parts 2. Black tape | | | JIG: | n/a | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS | | | |
| 2 | Y-taping (Continuation) | <div></div> <div>14. Check the Measurement and condition of tape.</div> | n/a | <div></div> <div>Wire alignment tolerance</div> | | | |
| 3 | Taping 2 Black Corrugated tube to wire near terminal | <div><div><div>Start of taping</div></div><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>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</div><div></div><div>3. After taping, check the measurement, taping condition and terminal appearance.</div></div> | n/a | <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references: 1. Refer to WI-PRO-COM-001A 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 use of tape 6. No wrong dimension 7. No insufficient tape</div> <div></div> <div>Wire alignment tolerance</div> | | | |

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Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH




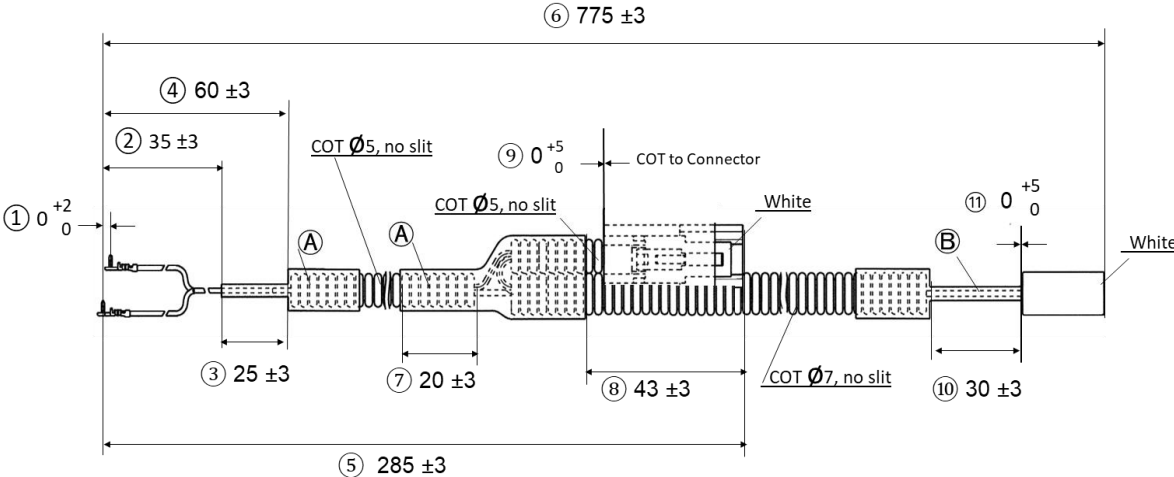
MASSPRO

Revision No.:

3

Page No.:

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| | | | | |
|--------|-----------------------------------|---|-----------|---|
| PARTS: | 1. Assy parts | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 4 | P2 <div>3</div> Measurement | <div><div>MEASURING TAPE</div></div>  <div><p>NOTE:</p><p>Ⓐ - Taping (B)</p><p>Ⓑ - Taping (L)</p><p>*Unit of measurement is in millimeter (mm)</p></div> | | <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p> |

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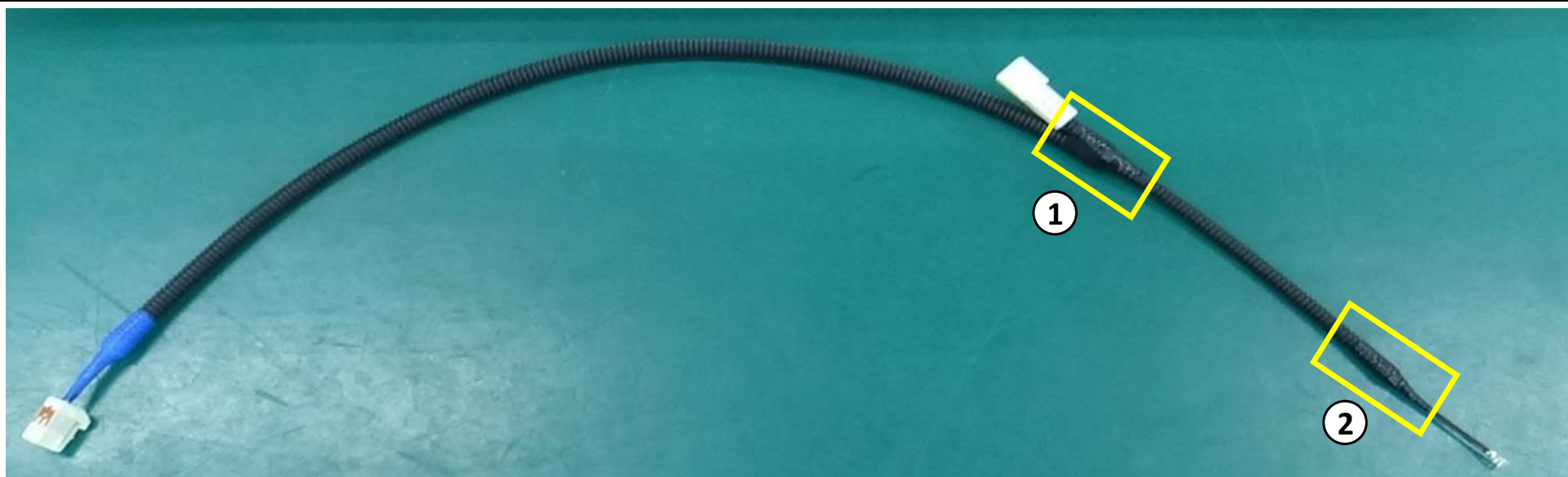
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7L0115-7020****1****2****No Missing Tape****No wrong use of tape (Black)**

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