

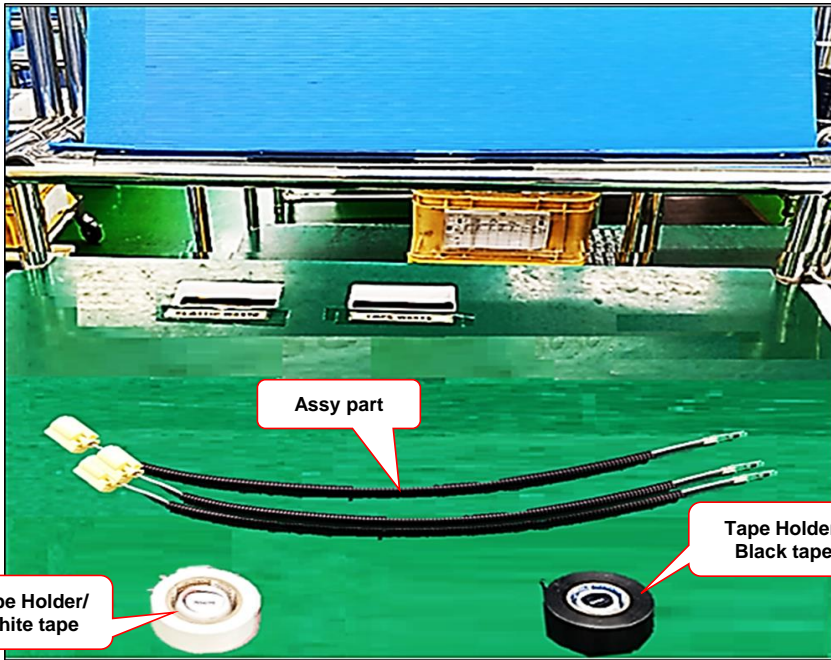




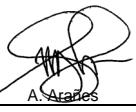
WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	July 15, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-866		
Revision No.:	1	Page No.:	1 of 4

Process Name/Title:	NB8 / 7N0208-7020a		
Model code/Part number:	NB8 / 7N0208-7020a	Customer:	TRJ
Car Model:	SUBARU-LEGACY		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Assy part 2. Black tape 20mm 3. White tape 20mm	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p>Table Lay-out</p>  <p>Assy part</p> <p>Tape Holder/ White tape</p> <p>Tape Holder/ Black tape</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No excess/lacking assy parts

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
07/15/24	1	Change from Pre-Launch to Masspro. Separate the offline process and clamp assembly process.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
07/02/24	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 02, 2024		

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☐ PROTOTYPE

☐ PRE-LAUNCH

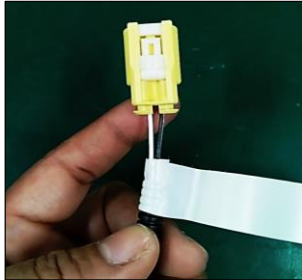
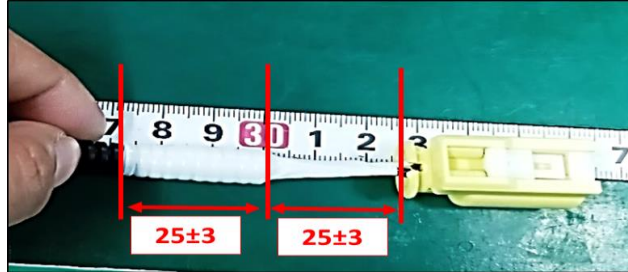

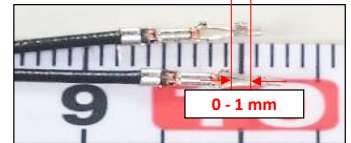

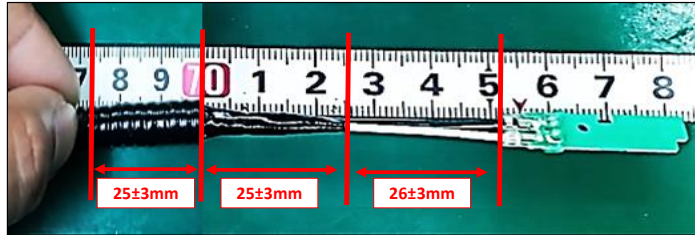

☒ MASSPRO

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PARTS:		1. Assy part 2. White tape (20mm) 3. Black tape (20mm)		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Taping 1 Black Corrugated tube to Wire near connector	 1 Hold the COT tube using left hand. Get the White tape using right hand and start taping.  2. After taping, check the dimension and taping condition.			<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</div> <div>MEASURING TAPE</div>  <div>Wire alignment tolerance</div>  <div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references; 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div>
3	Taping 2 Black Corrugated tube to Wire near terminal	 1 Hold the COT tube using left hand. Get the Black tape using right hand and start taping.  2. After taping, check the dimension and taping condition. 			

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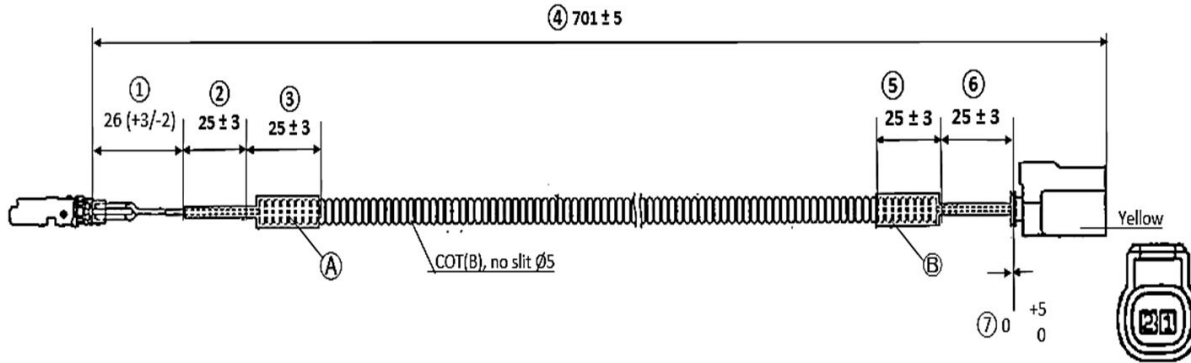

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy Parts		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Measurement			<p>1. No wrong dimension</p> <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>MEASURING TAPE</p> 

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

TAPING

7N0208-7020a



Note: With By two's inspection

1

No Wrong Use Color of Tape

2

Check the Tape Appearance

3

No Wrong Dimension

4

No Missing Tape

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