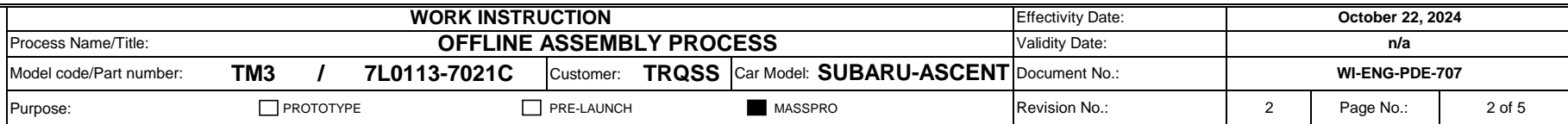
	WORK INSTRUCTION				Effectivity Date:	October 22, 2024			
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: TM3 / 7L0113-7021C		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-707	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	1 of 5	

PARTS:		1. Connector 7283-1030 (W); Jointed wire B-B 7L0113-2001C; Black corrugated tube Ø7, L=202±3mm (no slit)		JIG:	1. Insertion jig 2. Terminal cover jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	Table lay-out	<div><div>TABLE LAY-OUT</div><div><div><div>Connector 7283-1030 (W) / Connector Tray</div><div>Black Corrugated tube Ø7, L=202±3mm (no slit)</div><div>Jointed wire (7L0113-2001C)</div><div>Wire holder</div><div>Insertion jig</div></div></div></div>	<div><div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div>	<div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>7283-1030 (W)</div></div><div><div>NG</div><div>7283-1138 (W)</div></div></div> <div><div>1. No missing parts/tools 2. No excess parts/tools</div></div>


Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/08/24	2	Change process sequence due to removal of cover jig. Inclusion of Measurement. Update Visual inspection/Quality checkpoints. Inclusion of Measurement. Improved Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a			
09/23/23	1	Change purpose from Pre-launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
08/18/23	0	Initial issue	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 18, 2023	n/a

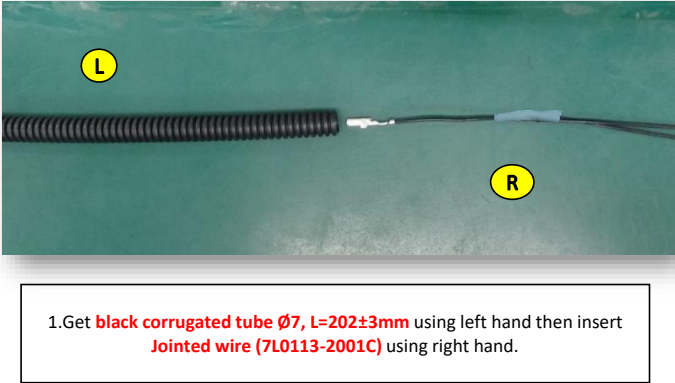
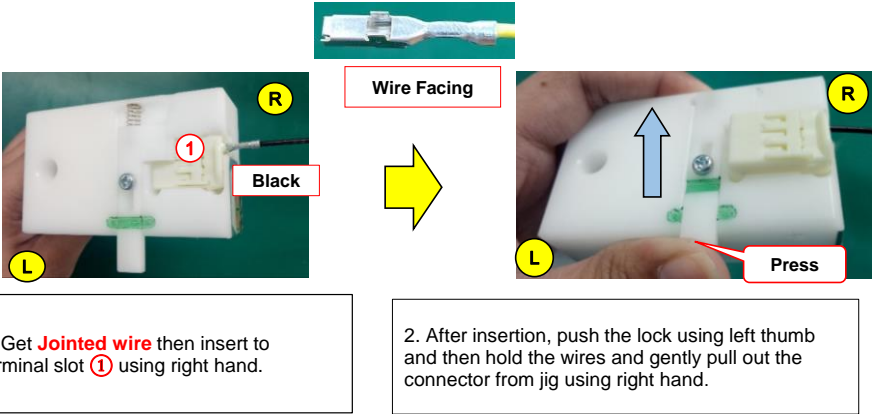
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	WORK INSTRUCTION				Effectivity Date:	October 22, 2024		
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	Model code/Part number: TM3 / 7L0113-7021C		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-707		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	3 of 5

PARTS:	1. Jointed wire B-B 7L0113-2001C; 2. Black corrugated tube Ø7, L=202±3mm (no slit)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Corrugated tube Ø7, L=202±3mm (no slit)	<div></div>		n/a	1. No deformed terminal 2. No wrong usage of parts
4	Wire insertion to Connector 7283-1030 (W)	<div></div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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Car Model:

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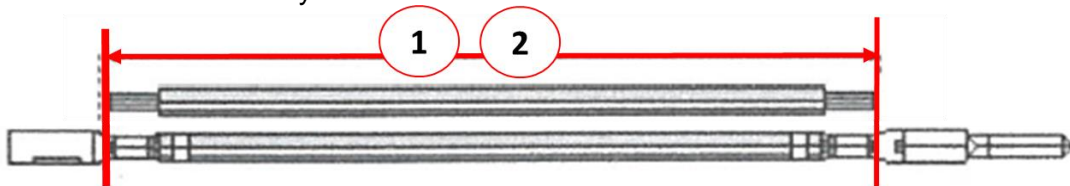


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	<div>2</div> <p>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</p> 	<div>MEASURING TAPE</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>
		<div>COT (No slit) Ø7 L=202±3mm</div> 	<div>3</div> <p>1. No wrong dimension</p>	

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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0113-7020****1****GOOD****NO GOOD****2****1****No Lock connector****2****No Wrong insert****3****GOOD****NO GOOD****4****3****No Terminal Backing Out****4****No Deformed terminal**

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