
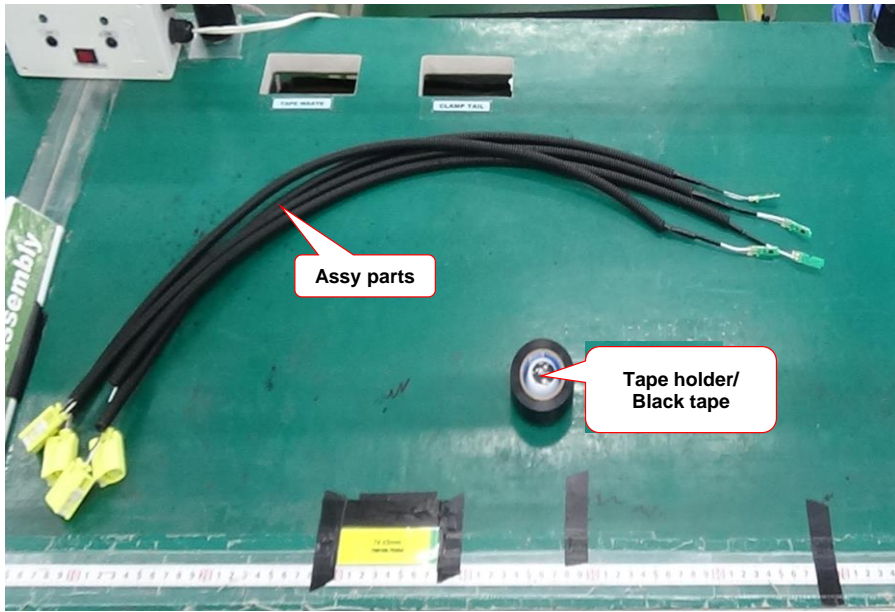


|   |  |  |               |                            |                   |           |        |
|---|--|--|---------------|----------------------------|-------------------|-----------|--------|
|  | WORK INSTRUCTION                           |  |               | Effectivity Date:          | November 12, 2024 |           |        |
|   | TAPING ASSEMBLY PROCESS                    |  |               | Validity Date:             | n/a               |           |        |
|   | Process Name/Title:                        |  |               | Document No.:              | WI-ENG-PDE-1168B  |           |        |
|   | Model code/Part number: ES1 / 7N0164-7020B |  | Customer: TRJ | Car Model: SUBARU-FORESTER |                   |           |        |
| Purpose:  |  | <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |               | Revision No.:              | 1                 | Page No.: | 1 of 7 |

|        |                           |  |  |   |   |
|--------|---------------------------|--|--|---|---|
| PARTS: | 1. Assy parts: Black tape |  |  | JIG:  | n/a   |
| NO.    | PROCESS NAME              | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE   | QUALITY POINTERS                                      |
| 1      | P2                        | <div>TABLE LAY-OUT</div>  <div>Assy parts</div> <div>Tape holder/Black tape</div> |  | <div><b>Safety Instruction</b><br/>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b><br/>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b><br/>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> | 1. No missing parts/tools<br>2. No excess parts/tools |

|                  |         |  |           |               |             |             |                              |
|------------------|---------|--|-----------|---------------|-------------|-------------|------------------------------|
| Revision History |         |  |           | Prepared by   | Reviewed by | Approved by | Noted by                     |
| 11/12/24         | 1       | Change Purpose from Pre-launch to Masspro. | M. Ariola | C. Villanueva | A. Arañes   | n/a         |                              |
| 11/11/24         | 0       | Initial issue.                             | M. Ariola | C. Villanueva | A. Arañes   | n/a         |                              |
| Eff. Date        | Rev. No | Details of Change                          | Revised   | Reviewed      | Approved    | Noted       | Est. Date: November 11, 2024 |

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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November 12, 2024

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Model code/Part number:

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Customer: TRJ

Car Model: SUBARU-FORESTER

Validity Date:

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Purpose:

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☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Black tape
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

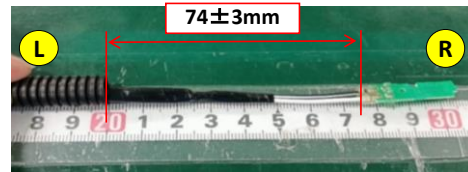
TOOLS/PPE

QUALITY POINTERS

2

P2

Taping 2  
Corrugated tube to SV  
tube (Vinyl)

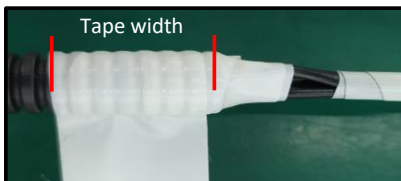


1. Measure from the COT up to edge of hotmelt **74±3mm** using both hands.

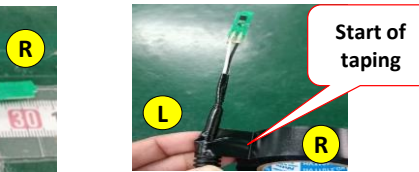
### Taping procedure



1. **1 wind** pre-tape in the middle of COT and SV tube (Vinyl).



3. Conduct **1 wind** before shifting.



2. Hold the tube using left hand, get the **Black tape** using right hand then start taping process using both hands.  
(Please refer below for the taping procedure).



2. Shift the tape **1x shifting** going to COT must be tape width.



4. Shift the tape **1/3 shifting** going to VT see above illustration for proper shifting.  
*Note: 1/3 shifting must be within the COT.*

### MEASURING TAPE



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

### NG Taping Illustration



Exceed **24mm**  
consider as **NG**

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ES1 / 7N0164-7020B

Customer: TRJ

Car Model: SUBARU-FORESTER

Document No.:

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Purpose:

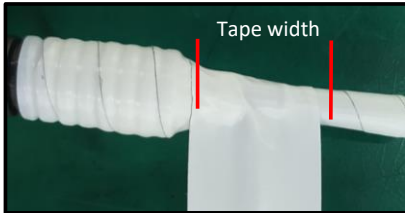
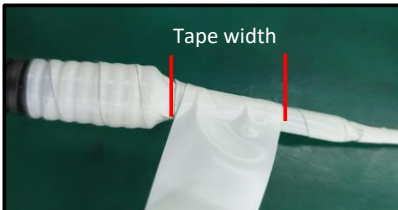

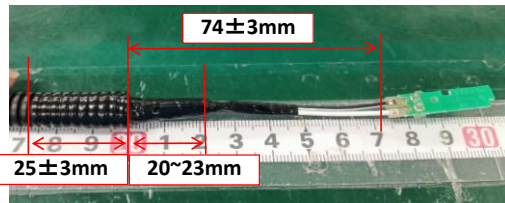

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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| PARTS: |   | 1. Black tape<br>2. Assy parts  |  | JIG:   | n/a  |
|--------|---|---|--|--|--|
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE  | QUALITY POINTERS   |
| 2      | P2<br>Taping 2<br>Corrugated tube to SV<br>tube (Vinyl)<br>(Continuation) | <div><p>5. Shift the tape <b>1x shifting</b> until reach the tape width.</p></div> <div><p>6. Conduct <b>2x windings</b> before end of</p></div> <div><p>7. Conduct <b>3x pressing</b> at the end of tape to prevent peel off.</p></div> <div><p>3. After taping, check the taping condition and measurement.</p></div> |  | <div><b>MEASURING TAPE</b></div>  | <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use <b>calibrated/verified measuring tape</b> when getting the measurement.</li><li>2. <b>USED WHITE TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL TAPE SHOULD BE BLACK TAPE.</b></li></ol> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> |

## NG Taping Illustration

Exceed **24mm**  
consider as **NG**

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## WORK INSTRUCTION

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Customer: TRJ

Car Model: SUBARU-FORESTER

Document No.:

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Purpose:


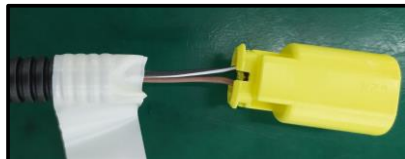
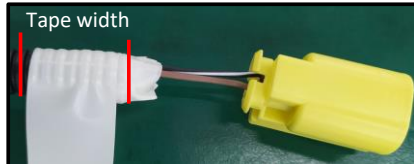
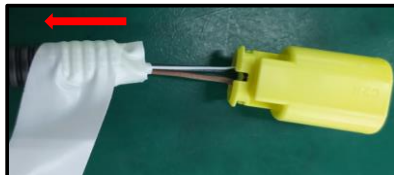
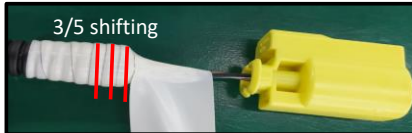
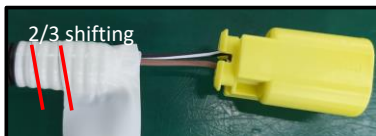

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|        |   |   |  |  |                  |
|--------|---|---|--|--|------------------|
| PARTS: |   | 1. Black tape<br>2. Assy parts  |  | JIG:   | n/a              |
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE  | QUALITY POINTERS |
| 3      | P2<br><br>Taping 3<br>Corrugated tube to wire<br>near connector | <div><div><p>Start of<br/>taping</p></div><div><p>1. Hold the corrugated tube using left hand, get the <b>Black tape</b> using right hand then start taping procedure using both hands.<br/><i>(Please refer below for taping procedure).</i></p><div><p>Taping<br/>Procedure</p></div></div><div><p>2. <b>2 winds</b> pre-tape in the middle of COT and wires.</p><div><p>Tape width</p></div></div><div><p>3. Shift the tape <b>1x shifting</b> going to</p></div><div><p>4. Conduct <b>1 wind</b> before shifting</p><div><p>3/5 shifting</p></div></div><div><p>5. Shift the tape <b>2/3 shifting</b> upward<br/><i>refer to above illustration for shifting direction</i></p></div><div><p>6. Shift the tape <b>3/5 shifting</b> upward<br/><i>note: 3/5 shifting must be within the cot</i></p></div></div> <div><div>MEASURING TAPE</div></div> |  | <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>2. USED WHITE TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL TAPE SHOULD BE <u>BLACK TAPE</u>.</b></p> <p>1. No flip-out tape<br/>2. No peel-off tape<br/>3. No loose tape<br/>4. No missing tape<br/>5. No wrong dimension<br/>6. No wrong use of tape</p> |                  |

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Customer: TRJ

Car Model: SUBARU-FORESTER

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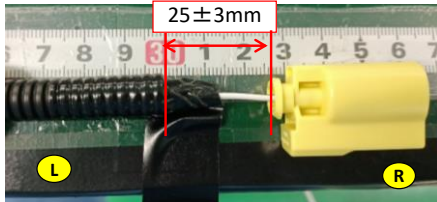
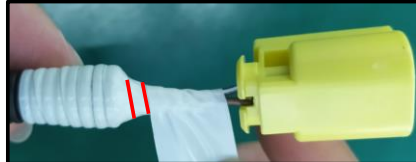
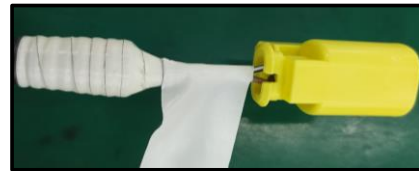
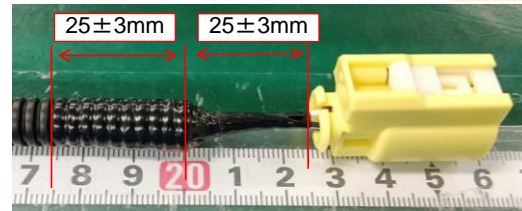
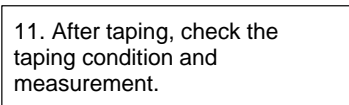

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|        |   |   |  |   |   |
|--------|---|---|--|---|---|
| PARTS: |   | 1. Black tape<br>2. Assy parts  |  | JIG:  | n/a   |
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE   | QUALITY POINTERS  |
| 3      | P2<br><br>Taping 3<br>Corrugated tube to wire<br>near connector<br>(Continuation) | <div><p>7. Measure from corrugated tube up to connector <b>25±3mm</b> using right hand then continue the taping procedure.</p></div> <div><p>8. Shift the tape <b>1/2 shifting</b> upward until reach the 0~5mm from connector to tape.</p></div> <div><p>9. Conduct <b>2x windings</b> before end of tape.</p></div> <div><p>10. Conduct <b>3x</b> pressing at the end of tape to prevent peel off.</p></div> <div><p>11. After taping, check the taping condition and measurement.</p></div> |  | <div>MEASURING TAPE</div>  | <p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. USED WHITE TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL TAPE SHOULD BE <b>BLACK TAPE</b>.</p> <p>1. No flip-out tape</p> <p>2. No peel-off tape</p> <p>3. No loose tape</p> <p>4. No missing tape</p> <p>5. No wrong dimension</p> <p>6. No wrong use of tape</p> |

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Model code/Part number:

**ES1 / 7N0164-7020B**Customer: **TRJ**Car Model: **SUBARU-FORESTER**

Validity Date:

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Purpose:


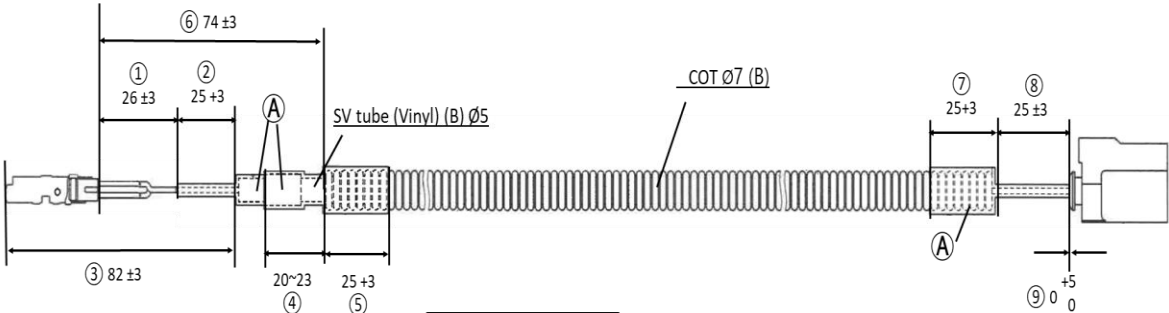
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|        |              |   |  |   |  |
|--------|--------------|---|--|---|--|
| PARTS: |              | 1. Black tape<br>2. Assy parts  |  | JIG:  | n/a  |
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE   | QUALITY POINTERS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

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7N0164-7020B**

① No **Missing Tape**  
(COT to wire near  
Connector)

② No **Missing Tape**  
(COT to wire near SV  
tube)

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