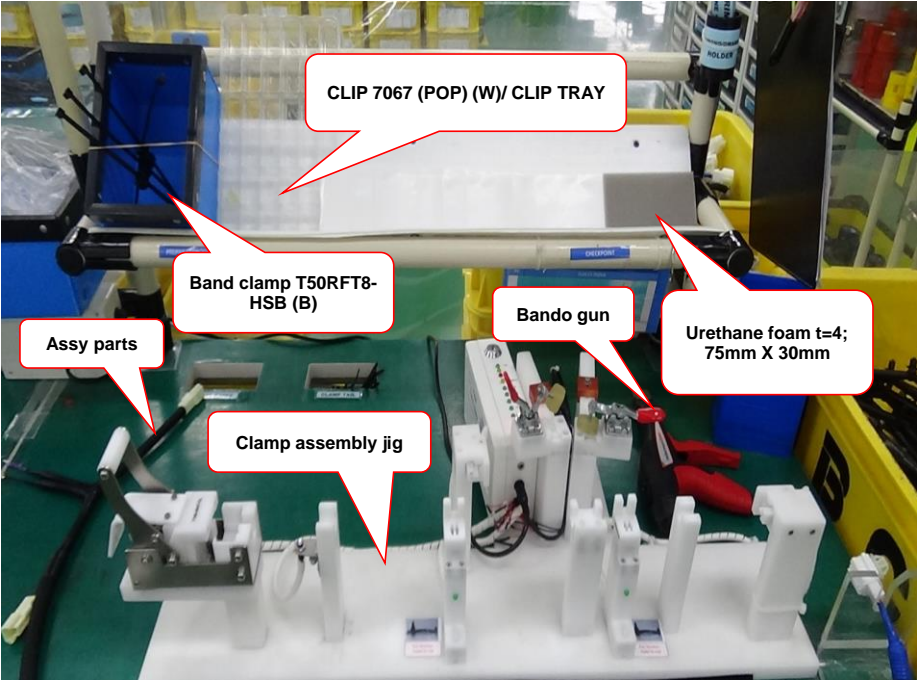


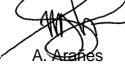
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	CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: TM3 / 7L0117-7020A		Customer: TRQSS		Car Model: SUBARU ASCENT	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO	
				Document No.:		WI-ENG-PDE-1021		
				Revision No.:		0		
				Page No.:		1 of 9		

PARTS:		1. Assy part; Clamp T50RFT8-HSB (B); Urethane foam t=4; 75mm X 30mm; Clip 7067 (POP) (W)		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div>TABLE LAY-OUT</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>Document reference/s: 1. Refer to WI-ENG-PDE-316A-C for Taping assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/12/24	0	Initial issue. Seprate clamp assy from Taping assembly process.				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		September 12, 2024	

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**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

TM3 / 7L0117-7020A

Customer:

TRQSS

Car Model:

SUBARU ASCENT

Document No.:

WI-ENG-PDE-1021

Purpose:

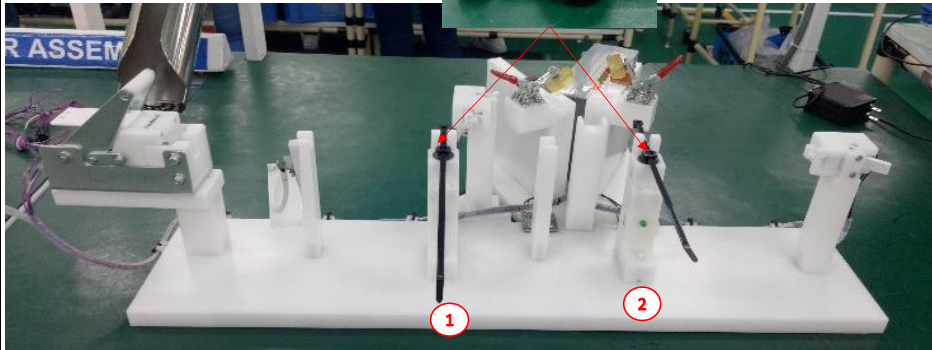
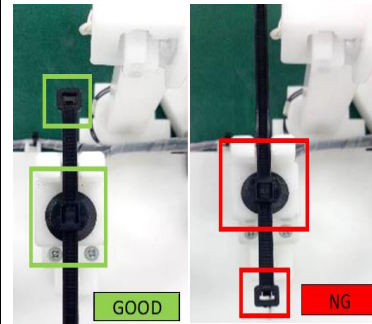
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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Page No.:

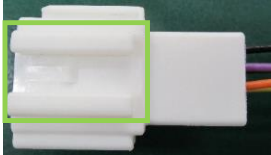
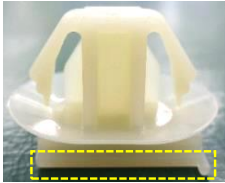
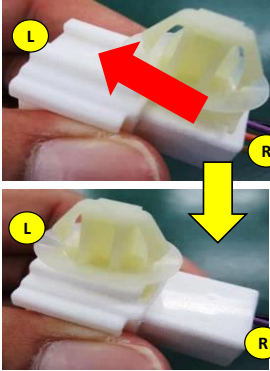
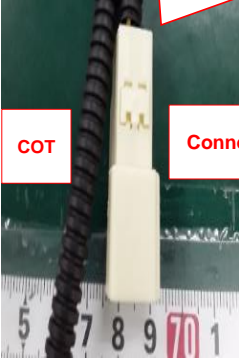
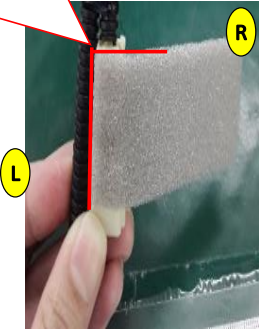
2 of 9

PARTS:		1. Clamp T50RFT8-HSB (B) [2pcs.]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div><div>(T50RFT8-HSB) (B)</div><div>1. Get 2pcs. of clamp T50RFT8-HSB (B) then set to clamp location 1 and 2 using both hands.</div></div>		n/a	<div><div>Clamp Orientation Illustration</div><div>1. No wrong use of clamp 2. No wrong orientation of clamp</div><div>Important reminders/Note/s: <i>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</i></div></div>

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	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: TM3 / 7L0117-7020A		Customer: TRQSS	Car Model: SUBARU ASCENT	Document No.:	WI-ENG-PDE-1021	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:	3 of 9	

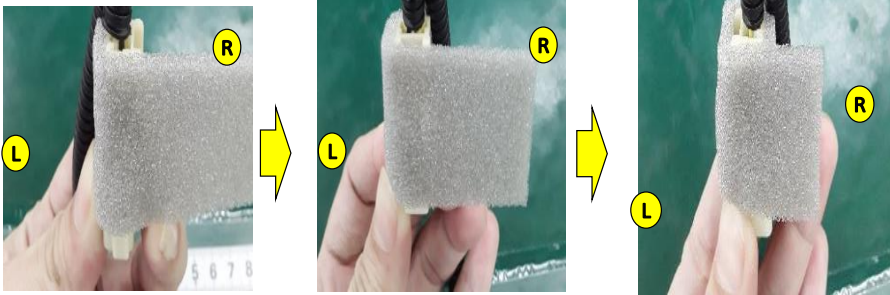
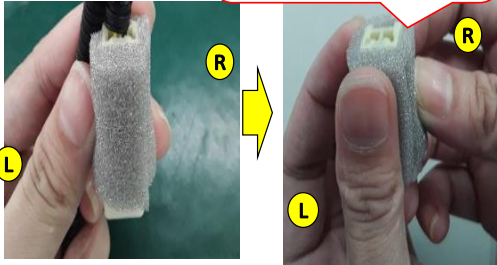
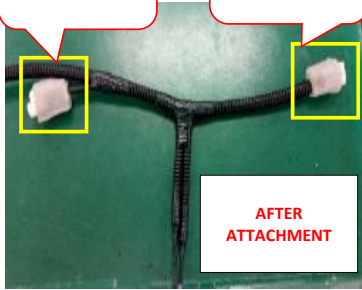
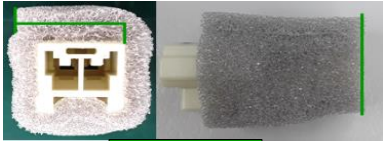
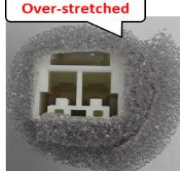
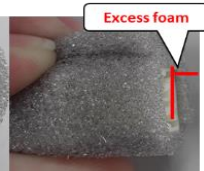
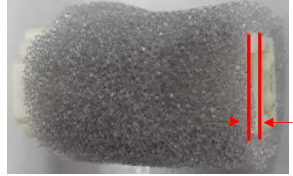
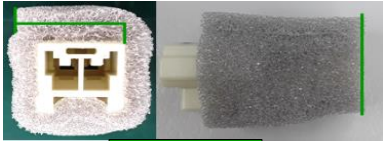
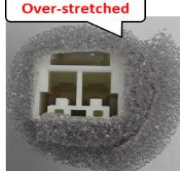
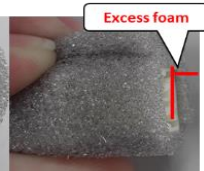
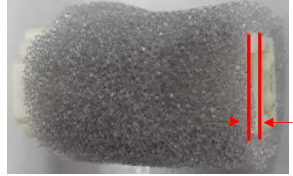
PARTS:	1. Assy parts 2. Clip 7067 (POP) (W)			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clip attachment	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>CLIP ORIENTATION</p></div> <div><p>1. Hold the connector using left hand, get the clip 7067-0 (POP) (W) then insert using right hand.</p></div>		n/a	1. No loose attachment 2. No wrong usage of parts 3. No missing clamp
4	Clamp Assy Urethane foam manual attachment to connector 7282-1020 (W) (FIRST) 7282-1028 (W) (SECOND)	<div><p>Step 1: Identify the right facing to attached the foam</p><p>COT Connector</p></div> <div><p>Step 2: Get the Urethane foam and begin the attachment. <i>Note: Foam and connector must be align</i></p></div>			n/a

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	WORK INSTRUCTION			Effectivity Date:	September 12, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: TM3 / 7L0117-7020A		Customer: TRQSS	Car Model: SUBARU ASCENT	Document No.: WI-ENG-PDE-1021		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 9


PARTS:		1. Urethane foam t=4; 75mm X 30mm [2pcs.]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	Clamp Assy Urethane foam manual attachment to connector 7282-1020 (W) (FIRST) 7282-1028 (W) (SECOND) (Continuation)	<div>Step 3: Attached the foam in all sides of the connector. Note: Follow the attachment sequence based on the illustration</div> <div></div> <div><div>Step 4: Press the Urethane foam side by side after attachment.</div><div></div><div></div><div>AFTER ATTACHMENT</div></div> <td>n/a</td> <td colspan="2"><div>DO NOT STRETCH THE URETHANE FOAM</div><div></div><div>GOOD</div><div><div>Over-stretched</div><div></div><div>Excess foam</div><div></div></div><div>NG</div><div>1. No damaged Urethane foam 2. No missing Urethane foam 3. No stretched Urethane foam</div><div></div><div>0~3mm tolerance from Urethane foam to Connector</div></td>	n/a	<div>DO NOT STRETCH THE URETHANE FOAM</div> <div></div> <div>GOOD</div> <div><div>Over-stretched</div><div></div><div>Excess foam</div><div></div></div> <div>NG</div> <div>1. No damaged Urethane foam 2. No missing Urethane foam 3. No stretched Urethane foam</div> <div></div> <div>0~3mm tolerance from Urethane foam to Connector</div>	

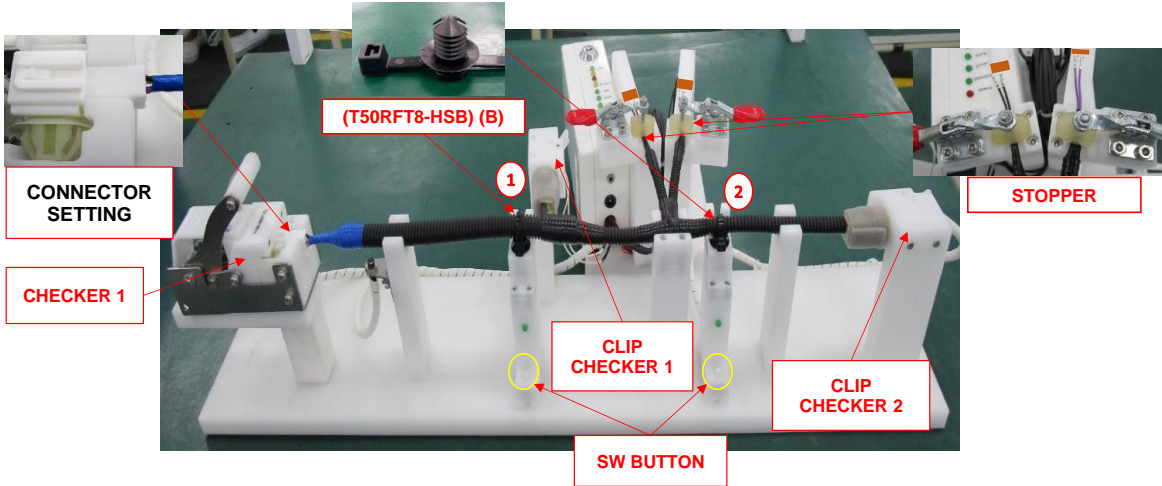
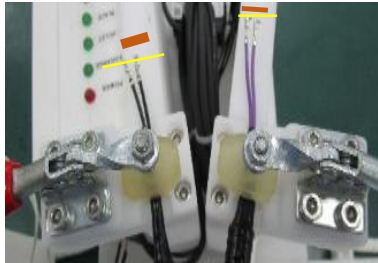
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	5 of 9

PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	Clamp Assy	<div>  <p> (T50RFT8-HSB) (B) CONNECTOR SETTING CHECKER 1 CLIP CHECKER 1 CLIP CHECKER 2 SW BUTTON STOPPER </p> </div> <div> <p>1. Get the assy parts. First, set the connector 7186-8847 (W) to Checker 1 then pull the checker fixture for continuity checking. Color sensor light will beep/buzz if sensor detects Blue tape. Second, set the connector 7282-1020 (W) to Clip checker1 for continuity checking. Third, set the connector 7282-1028 (W) to Clip checker 2 for continuity checking. Last, set the B-B wires and V-V wires with terminal end together within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p> <p>2. Check if all LED light for POWER ON, WIRE1 and WIRE2, CLAMP ON, SENSOR was ON. Check also if clamp location ① sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> </div>		<div>  <p>STOPPER</p> </div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals.</p> <p>1. No damaged clamp 2. No missing clamp 3. No loose/tight attachment</p>	

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WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

TM3 / 7L0117-7020A

Customer:

TRQSS

Car Model:

SUBARU ASCENT

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

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Revision No.:

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PARTS:

1. Assy parts

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

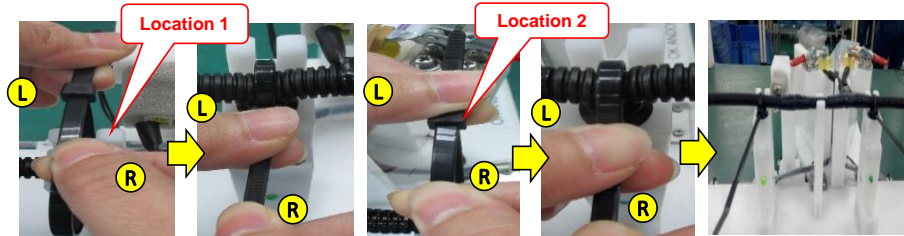
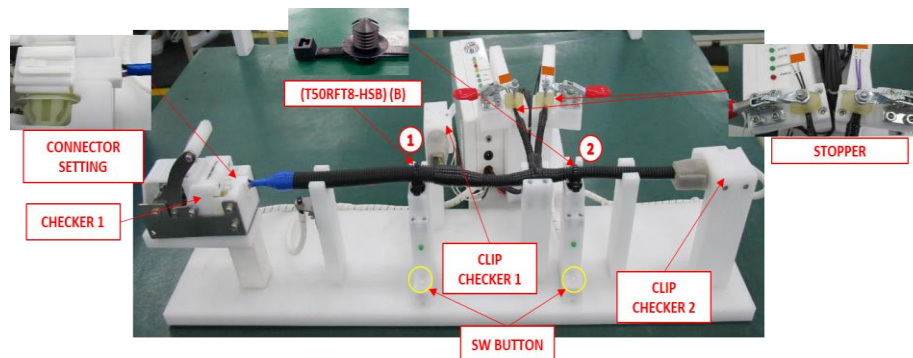
TOOLS/PPE

QUALITY POINTERS

5

Clamp Assy

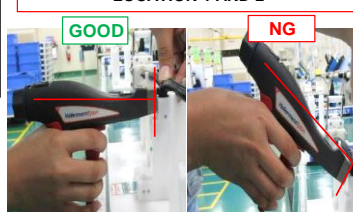
Clamp Assembly
(Continuation)



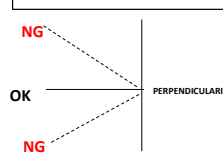
3. Initially tighten the band clamp on location 1 and 2 using both hands.

4. Get the bando gun and cut the band clamp (T50RFT8-HSB) on location 1 using right hand. Press the SW button after cutting. Continue the process if clamp location 2 if light was ON.

BAND CLAMP CUT POSITION FOR LOCATION 1 AND 2



BANDO GUN ALIGNMENT

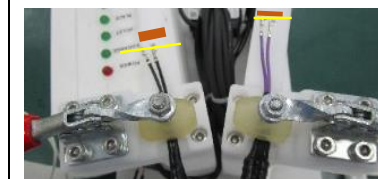


Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: ø5 - 1~2, ø7 - 3~4

Bando Gun



1. No damaged clamp
2. No missing clamp
3. No loose/tight attachment

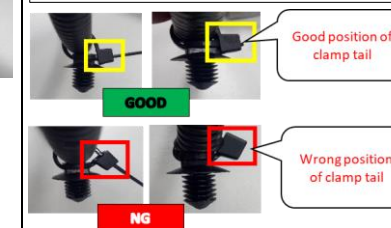


STOPPER

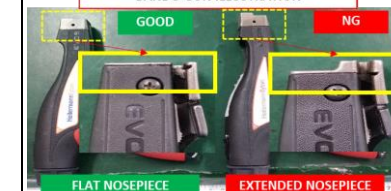
Important reminders/Note/s:

1. Make sure no gap between stopper and terminals.

Clamp Orientation (T50RFT8-HSB)




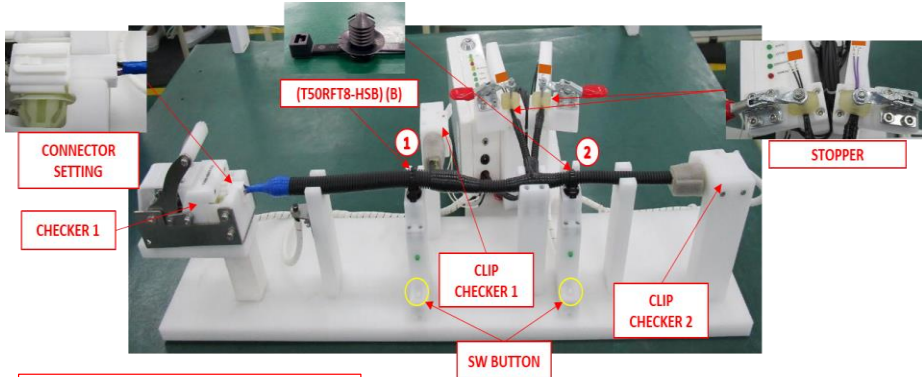
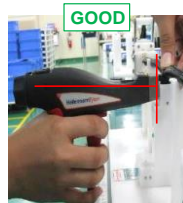

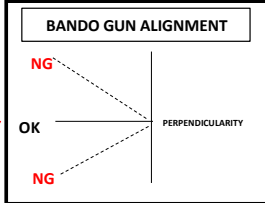


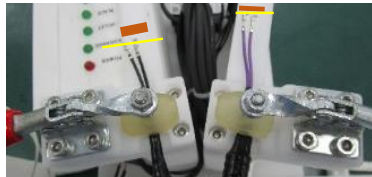




BANDO GUN ILLUSTRATION



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		Model code/Part number: TM3 / 7L0117-7020A		Customer: TRQSS		Car Model: SUBARU ASCENT		Document No.: WI-ENG-PDE-1021	
		Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 0	
								Page No.: 7 of 9	
PARTS:		1. Assy parts				JIG:		1. Clamp assembly jig	
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
5		Clamp Assy Clamp Assembly (Continuation)		<div></div> <div><div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div>BANDO GUN ALIGNMENT</div></div></div> <div><p>5. Cut the band clamp (T50RFT8-HSB) on location 2 using both hands. Press the sequence light button after cutting. Go sound will be heard if the result is GOOD.</p></div> <div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div> <div><p>6. CONDUCT POINT CHECKING before removing the harness from jig.</p></div> <div><p>7. After POINT CHECKING, push the checker fixture of Checker 1, remove the connector on Clip Checker 1 and Clip Checker 2, remove the toggle clamp (same timing).</p></div>		<div><div></div><div>Bando Gun</div><div></div><div>FLAT NOSEPIECE</div></div>		<div></div> <div>STOPPER</div> <div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals.</p></div> <div><div><div><div>Clamp Orientation (T50RFT8-HSB)</div><div><div></div><div></div></div><div><div>GOOD</div><div>Wrong position of clamp tail</div></div></div><div><div></div><div></div></div><div><div><div>FLAT NOSEPIECE</div><div>EXTENDED NOSEPIECE</div></div></div></div></div>	

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TM3 / 7L0117-7020A

Customer:

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Purpose:

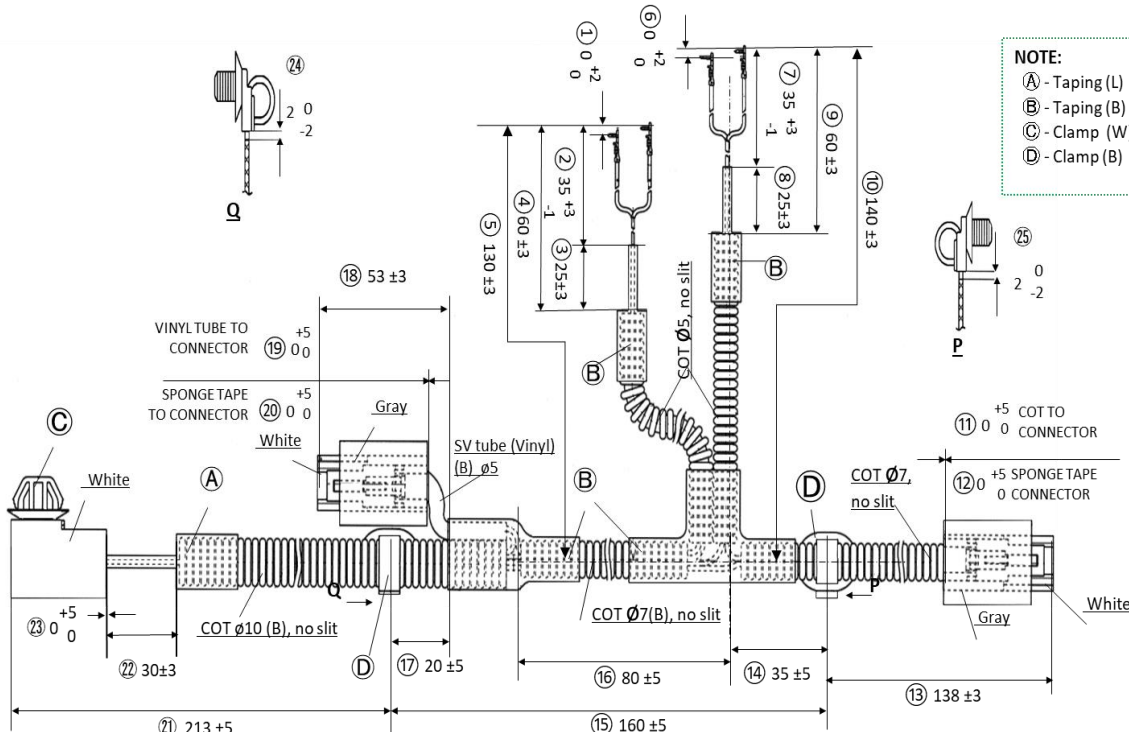
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Clamp Assy	<p>Measurement</p>  <p>MEASURING TAPE</p> <p>NOTE: A - Taping (L) B - Taping (B) C - Clamp (W) D - Clamp (B)</p> <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>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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PARTS:

1. Assy parts

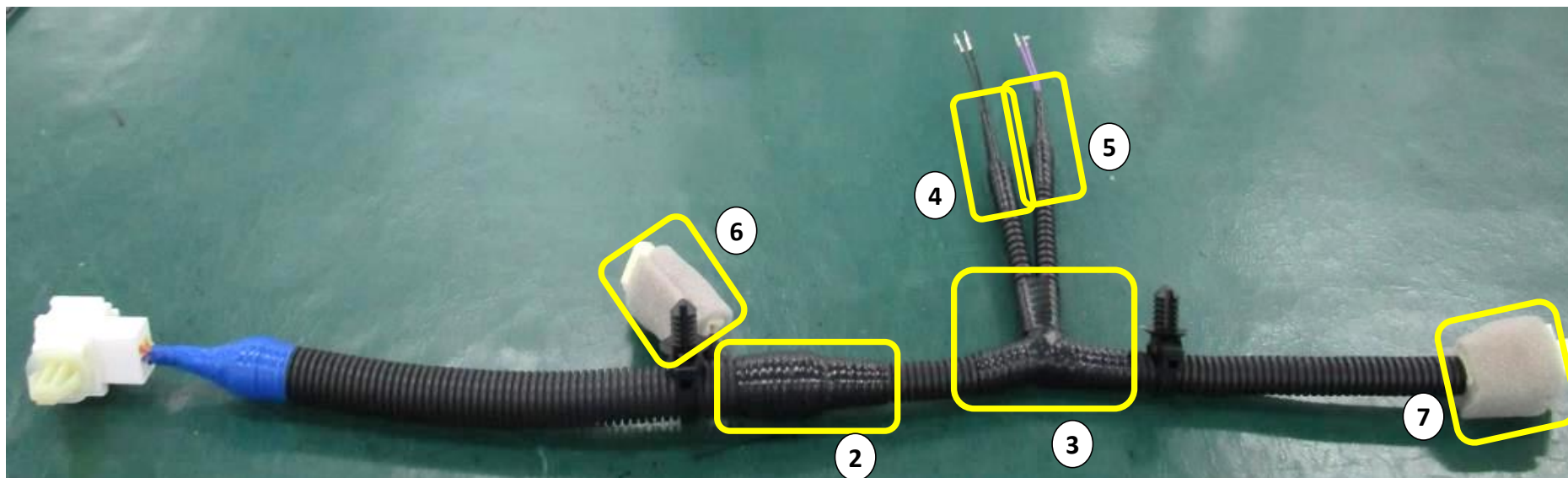
JIG:

n/a

QUALITY CHECKPOINTS

CLAMP ASSY

7L0117-7020A



1 No Wrong facing of clamp

2 3 4 5 No Missing Tape (Black tape)

6 7 No Missing Sponge tape

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