_	WORK INSTRUCTION Effectivity Date: March 21, 2024								
		Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
		Model code/Part number:	GC7(FHI)/ 15G060-0010	Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-016A		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 1 of 5		
PARTS:	1	1. Connector 505570-0600 (W)				JIG:	1. Insertion jig		
N	0.	PROCESS NAME	WORK P	ROCEDURE/ ILLUSTRA	ATION	TOOLS/PPE	QUALITY POINTERS		
		P1 insertion jig 505570-0600 (W)  O600 and set it to jig usin right hand. Note: Follow the connect orientation.  L			1. Get the connector 505570-0600 and set it to jig using right hand.  Note: Follow the connector orientation.  2. Press the lock button using left index finger. You will notice the holes that needs to be	Safety Instruction  Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  Housekeeping  1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.  Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No removed wires or wrong insertion 2. Must have slight movement after insertion 3. No stuck-up terminal tip 4. No deformed terminal  Important reminders/Note/s:  1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push procedure. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion must be from left to right.  Document reference/s:  1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.		
			BEFORE PRESSING	AFTER PRESSING					
	1	•	Revision History			Prepared by R	Reviewed by Approved by Noted by		
03/21/24		Separate Connector setting and Wire i to SV tube (Vinyl).	nsertion process. Change from 1 piece to 3 piece flo	ow. Change term from Vinyl tube	D.Castillio C.Villanuev a A. Arañes r	n/a			
08/08/23		· · · ·	DEL "SUBARU-LEGACY". (Refer to ENGDRR-144	. ,	a	rañes Catulo	late item		
10/19/22	3 ii	Remove validity date. Improve Qualiy provement.	pointers: Reminders/Notes and references on page	no. 1,3 and 4 due to document	M. Ariola J. Loterte C.Villanuev A. A	raños	.Villanueva A. Aranes n/a		
Eff. Date	f. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date: October 07, 2019								



Process Name/Title:   TAPING ASSEMBLY PROCESS   Validity Date:   n/a		_		WORK INS	Effectivity Date:	March 21, 2024				
PARTS:   1. AVSS 0.3 Black, Yellow, Green and Red L= 170mm   JIG:   1. Insertion jig    NO.   PROCESS NAME   WORK PROCEDURE/ ILLUSTRATION   TOOLS/PPE   QUALITY POINTERS    WIRE SEQUENCE FROM LEFT TO RIGHT   1. No loose insertion   2. No wrong insertion   3. One by one insertion   4. No deform terminal 5. No wrong wire facing    Important reminders/Note/s:   1. Make sure wires are properly insertion   2. No wrong wire facing   3. No wrong wire facing   4. No deform terminal for using right hand. Conduct pull-push 2x. Repeat the process for G-Y and B wires. Note: Follow wire sequence based on visual reference attached to jig.   1. Refer to Wi-PRO-CNC-017 for left to right.   1. Refer to Wi-PRO-C			Process Name/Title:			n/a				
PARTS:  1. AVSS 0.3 Black, Yellow, Green and Red L= 170mm  NO. PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TOOLS/PPE  QUALITY POINTERS  1. No locse insertion 2. No wrong insertion 3. One by one insertion 4. No deform 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. 3. Insertion to conduct pull-push 2x. Repeat the process for G-Y and B wire process fo			Model code/Part number:			Document No.:		WI-ENG-PDE-01	6A	
NO. PROCESS NAME  WIRE SEQUENCE FROM LEFT TO RIGHT  WIRE FACING  1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing  Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct pull-push 2x. Repeat the process for G-Y and B wires. Note: Follow wire sequence based on visual reference attached to jig.  N/A  N/A  N/A  N/A  N/A  N/A  N/A  N/			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	2 of 5
Wire insertion to Connector 505570-0600 (W)  Wire insertion to R R R R  Wire insertion to Connector 505570-0600 (W)  R R R  R  R  R  R  R  R  R  R  Insertion to terminal solt using right hand. Conduct pull-Push-Pull-Push afte insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion to terminal solt using right hand. Conduct pull-Push-Pull-Push afte insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.  Document reference/s: 1. Refer to WI-PRO-CNC-017 for	PARTS:	1. AVS	S 0.3 Black, Yellow, Green	JIG:	1. Insertion jig					
WIRE FACING  1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing  Important reminders/Note/s:  1. Get R wire and insert to terminal slot using right hand. Conduct pull-push-pull-push afte insertion. Do not exert extra force. Conduct pull-push and B wires. Note: Follow wire sequence based on visual reference attached to jig.  N/A  N/A  N/A  1. No loose insertion 2. No wrong insertion 4. No deform terminal 5. No wrong insertion 6. No deform terminal 5. No wrong insertion 6. No deform terminal 6. No deform terminal 6. No wrong insertion 6. No deform terminal 6. No wrong insertion 6. No deform terminal 6. No deform terminal 6. No wrong insertion 6. No deform terminal 6. No deform terminal 6. No wrong insertion 6. No deform terminal 6. No deform terminal 6. No deform terminal 6. No wrong insertion 6. No deform terminal 6. No deform t	NO.	I	PROCESS NAME	WORK F	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	QUALITY POINTERS		
Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.			Wire insertion to Connector	WIRE SEQUENCE FROM LE		1. Get R wire and insert to terminal slot using right hand. Conduct pull-push 2x. Repeat the process for G-Y and B wires. Note: Follow wire sequence based on visual		1. No loos 2. No wror 3. One by 4. No defo 5. No wror  1. Make inserte Condu inserti Do not 2. Plea termin 3. Inserte left to i  1. Ref Wire a 2. Ref	e insertion ng insertion one insertion rm terminal ng wire facing  ant reminders/No e sure wires are p d. ct Pull-Push-Pull- on. exert extra force. se hold the wire r al during insertior rtion of wire must right.  ocument reference er to WI-PRO-CNO and Strip length to er to GL-PRO-AS	te/s: roperly Push after near n. be from ne/s:

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			WORK INS	TRUCTION		Effectivity Date:		March 21, 202	4	
		Process Name/Title:	Validity Date:	n/a						
		Model code/Part number:	GC7(FHI) / 15G060-0010	Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:		WI-ENG-PDE-01	6A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	3 of 5	
PARTS: /s		s SV tube (Vinyl) ø6 L=112	±3m	3. Assy parts		JIG:	1. Insertion	ı iia		
73		nector 7282-5976 (W)	· ·							
NO.	P	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE					QUALITY POINTERS		
3	P1	Wire insertion to SV tube (Vinyl) Ø6 L=112±3mm	1. Get the SV tube (Vinyl) ø6 L=112±3mm using right hand and insert the wires on tu using left hand.  3. Compare the wire insertion to visual aid then check the condition of terminal claw.	2. Press the unlock	Release  Release			g use of parts claw must be see	n in connector	
4		Connector setting to insertion jig 7282-5976 (W)	INSERTION Connector handle ndication light Visual reference  Jig lock L  Adjustable lock	CONNE	Get the innector do insert to using yith hand.  Press  R  2. Press the lock using right thumb after insertion	N/A	1. No wron	g setting of conne	ctor	

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			WORK INST		Effectivity Date:	March 21, 2024				
		Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a			
		Model code/Part number:	GC7(FHI) / 15G060-0010	Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:		WI-ENG-PDE-01	6A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	4 of 5	
PARTS:	1. Conr 2. Assy	nector 7282-5976 (W) parts	5976 (W) JIG:					1. Insertion jig		
NO.	F	ROCESS NAME	WORK P	ROCEDURE/ ILLUSTRA	ATION	TOOLS/PPE	QUALITY POINTERS			
5	P1	Wire Insertion to Connector 7282-5976 (W)	Wire sequence  1. Get the R wire and insert to terminal Repeat the process for G-Y and B wires Note: Follow wire sequence based on the sequence of the sequenc	Slot using right hand. Condus.			3. One by 4. No defo 5. No wron  Import 1. Make inserte Conduinserti Do not 2. Plea termina 3. Inserte left to i  1. Refo Wire a 2. Refo	ng insertion one insertion rm terminal ng wire facing  ant reminders/No e sure wires are p d. ct Pull-Push-Pull- on. exert extra force. se hold the wire r al during insertion rtion of wire must	roperly  Push after  near  n. be from  ce/s:  C-017 for olerance.	



			WORK INSTR			Effectivity Date:		March 21, 202	4
		Process Name/Title:	TAPING .	Validity Date:	n/a				
		Model code/Part number:	GC7(FHI) / 15G060-0010	Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:		WI-ENG-PDE-01	6A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	5 of 5
PARTS:	1. Assy	y parts				JIG:	1. Insertion	n jig	
NO.	ı	PROCESS NAME	WORK PRO	OCEDURE/ ILLUSTR	RATION	TOOLS/PPE	QUALITY POINTERS		ΓERS
6	P1	Connector lock	Before After  1. Pull down the handle using right hand to lock the connector.	2. Press the unusing left thumb	Release  Allock button to release the lock b. Then slowly remove the harness the lock if properly pressed.	n/a 1. No unlock/half-locked o		ck/half-locked conr	nector
7		Pass WIP to P2			1. Put WIP to WIP holder.	N/A		rtant reminders/Note ree (3) Piece flow ree volume of the control	e/s:

