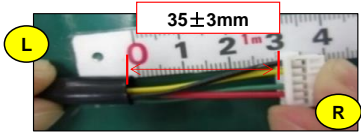
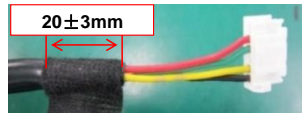
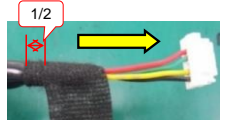
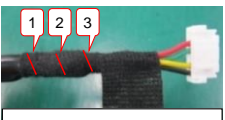

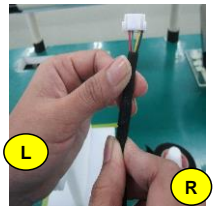
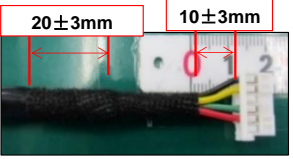
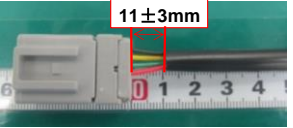


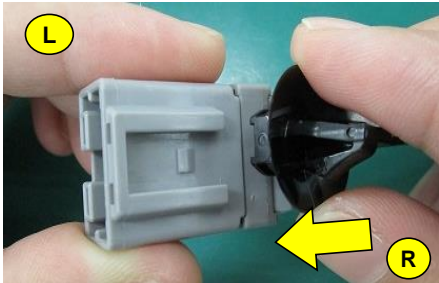



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	November 06, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: GC7 / 15E210-0091		Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-107B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	1 of 2

PARTS:		1. Tesa Tape (51618) 2. Assy parts		JIG:	1. Tesa cutter
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2 Taping 1 SV tube (Vinyl) to wire near connector <div style="border: 1px solid black; padding: 2px; display: inline-block;"> 6 HIGH </div>	  <p>1. Hold the SV tube (Vinyl) to adjust the distance of connector to end of SV tube (Vinyl).</p> <p>2. Fold the SV tube (Vinyl) then conduct taping, 1 wind before shifting.</p>    <p>3. Make 1/2 shifting, 3 winds going to right direction.</p> <p>4. 1 wind before end of tape.</p> <p>5. Cut the tape using the provided cutter.</p>    <p>6. Press the end tape using left hand.</p> <p>7. After taping, check the measurement and taping condition.</p> <p>8. Check the measurement from tube to connector.</p>		<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong dimension 5. No damage parts</p> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> TESA TAPE CONDITION  Whitish appearance of Tesa Tape due to thickness variation Judgement: GOOD </div> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. The dimension from tube to connector (11±3mm) must be controlled based on drawing. If encountered out of specification, STOP the process, CALL the attention of the Leader and WAIT for instruction then continue the process.</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
11/06/24	6	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Change from 1 piece to 3 piece flow due to process improvement. Change term from Vinyl tube to SV tube (Vinyl). Inclusion of CAR MODEL "SUBARU-LEGACY".	D.Castillo	C. Villanueva	A. Arañes	n/a			
11/12/22	5	Include Quality pointers of process no.1- Taping 1 Vinyl tube to wire near connector.	M. Ariola	C. Villanueva	A. Shimamura	A. Arañes			
10/27/22	4	Improve Quality pointers: Reminders/Notes on page no. 1 and 2 due to document improvement.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 03, 2019	

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	WORK INSTRUCTION			Effectivity Date:	November 06, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: GC7 / 15E210-0091		Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-107B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	2 of 2

PARTS:	1. Clamp B001200839 2. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div><div>6</div><div>HIGH</div></div> Clamp attachment (Clip type Clamp B001200839) P2	<div><div>L</div><div>R</div></div> <div>Clamp B001200839</div> <div></div> <div><div>L</div><div>R</div></div> <div>1. Get the clamp using right hand, hold the connector using left hand. Insert the clamp and slightly push into connector using right hand. Click sound will be heard if insertion was OK.</div> <div>2. Make sure clamp is fully inserted.</div>		N/A	Important reminders/Note/s: <i>1. Only one side of the clamp can be inserted to connector</i> 1. No loose attachment of clamp 2. No damage parts
3	<div><div>6</div></div> Pass WIP to P3	<div></div> <div>1. Put WIP to WIP holder.</div>		N/A	Important reminders/Note/s: <i>1. Three (3) Piece flow</i> 1. No WIP overflow

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