
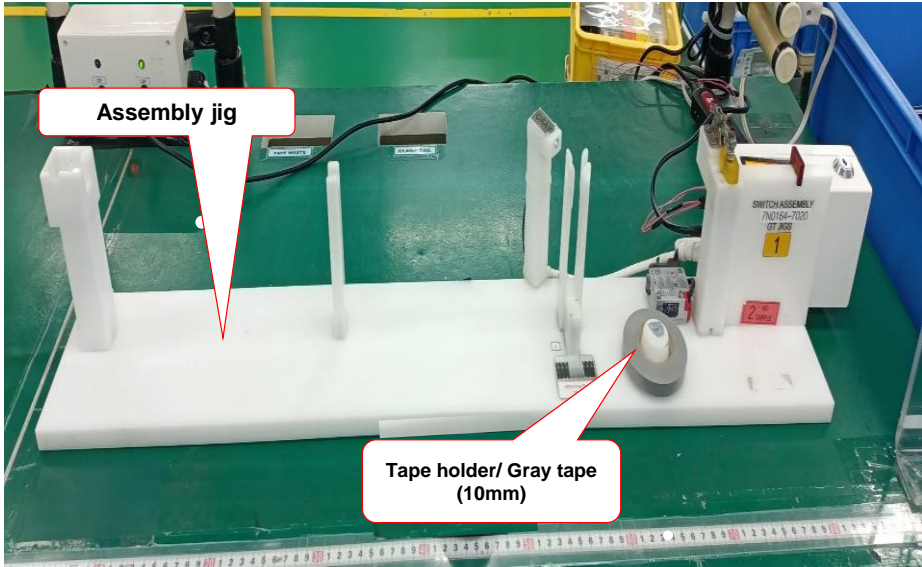


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|---|---|--|---------------|----------------------------|-------------------|--|----------------|------------------|
|  | WORK INSTRUCTION | | | | Effectivity Date: | | July 10, 2024 | |
| | Process Name/Title: CLAMP ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: ES1 / 7N0164-7020 | | Customer: TRJ | Car Model: SUBARU-FORESTER | Document No.: | | WI-ENG-PDE-937 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | | 0 | Page No.: 1 of 4 |

| | | | | | | | | |
|--------|--------------|---|--|--|---|--|---|--|
| PARTS: | | 1. Assy parts: Black tape: Gray tape (10mm) | | | JIG: | | 1. Clamp assembly jig | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | | QUALITY POINTERS | |
| 1 | CLAMP ASSY | <div>Table Lay-out</div>  <div>Assembly jig</div> <div>Tape holder/ Gray tape (10mm)</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-623A-B for Offline 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 |
| | | | | | | | | | | | |
| 07/10/24 | 0 | Initial issue. Separate assembly (Spot taping) from Taping to Clamp assembly process. | | | | D.Castillo | C. Villanueva | A. Arañes | n/a | | |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted | Est. Date: | July 10, 2024 |

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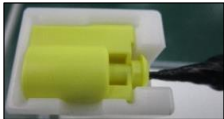



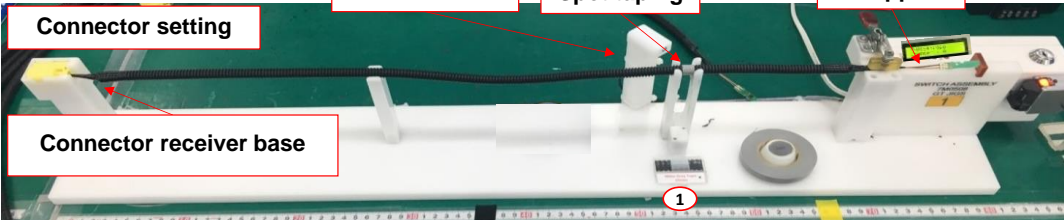







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|--------|---|---|--|---|------------------|
| PARTS: | | 1. Assy parts 2. Gray tape (10mm) | | JIG: | 1. Assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | CLAMP ASSY Assembly (Spot taping) | <div><div></div><div></div><div></div><div></div><div></div></div> <div><p>1. Get the assy parts then set into jig (<i>See above illustration</i>). First, the connector to receiver base. Last, put the PCB into stopper jig then pull the toggle clamp using both hands. Make sure the end tape of wire is within the tolerance.</p><p>2. Check in the counter if CLAMP was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Get the Gray tape using right hand and start spot taping on location 1 using both hands make 3 winds. Check if the Color sensor was ON. Press the SW button. GO buzzer will be heard.</p><p>4. Conduct POINT CHECKING after taping and before removal from jig.</p></div> <div><div></div><div></div><div></div></div> | | <div><div></div><div><p>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals</p><p>1. No wrong use of tape 2. No excess/lacking tape windings</p></div><div><div></div><div></div><div></div></div><div><p>Make sure the end tape of wire is within the tolerance.</p></div></div> | |

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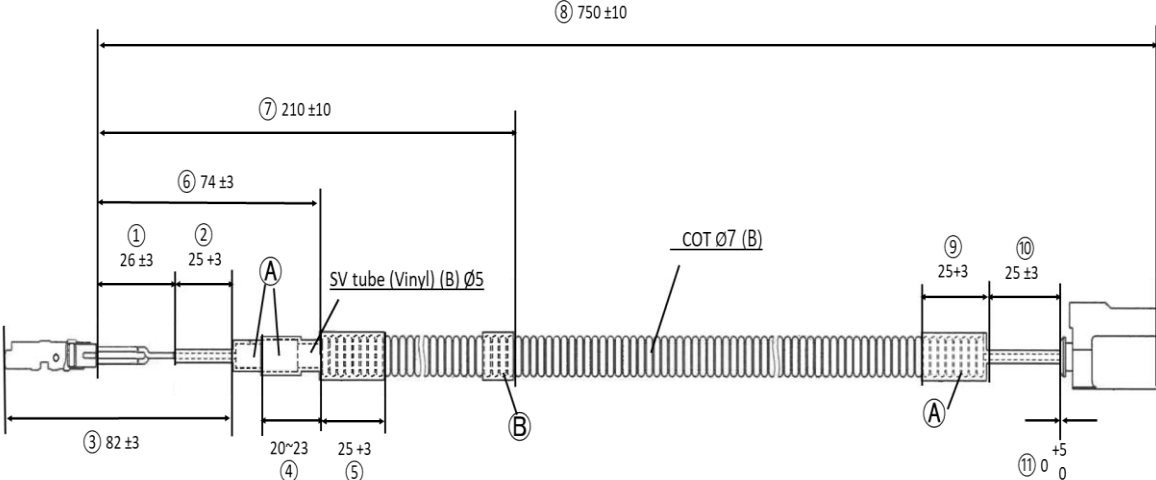
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| | | | | |
|--------|---------------|------------------------------|---|---|
| PARTS: | 1. Assy parts | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 3 | CLAMP ASSY | Measurement | <div>MEASURING 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> <p>1. No wrong dimension</p> |

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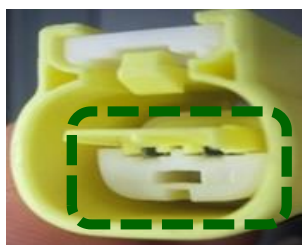
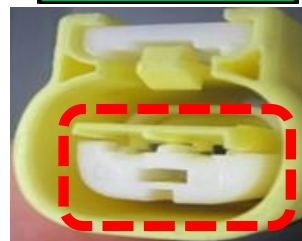
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0164-7020****GOOD****NG**

1

**No Unlock/ Half Lock
Connector**

2

No Missing tape (SV tube (Vinyl) to Wire;

3

COT to SV tube (Vinyl);

4

COT to wire near connector

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