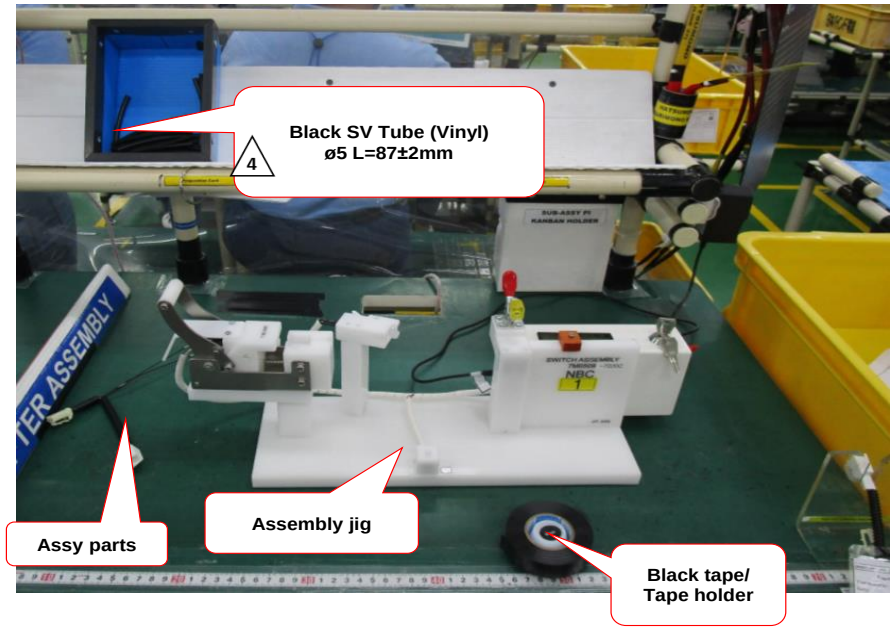
	WORK INSTRUCTION			Effectivity Date:	January 21, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: ES1 / 7M0509-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-357B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 4	Page No.:	1 of 6

PARTS: △4	1. Assy parts: Black SV Tube (Vinyl) ø5 L=87±2mm (with slit); Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	**Table Lay-out**  	**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 workplace 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 missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
01/21/25	4	Change SV tube (Vinyl) length from L=89±3mm to L=87±2mm due to encountered minimum dimension in SV tube to wire near terminal. Improved Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
09/21/24	3	Inclusion of number of windings in Y-taping process as counutermeaure to cuctomer claim. Inclusion of car model "SUBARU-FORESTER". Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a				
02/25/23	2	Improve quality pointers on page no. 3,5 and 6 as Document improvement; Inclusion of Qualtiy checkpoints on page no.7. Standardized tube description; SV tube (Vinyl)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
11/25/21	1	Change from Pre-launch to masspro. Provide continuity jig and improve work procedure and illustration	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 21, 2021		

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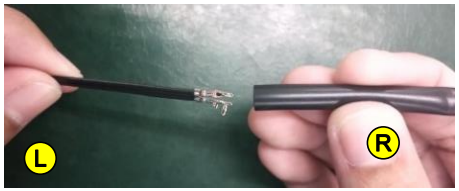
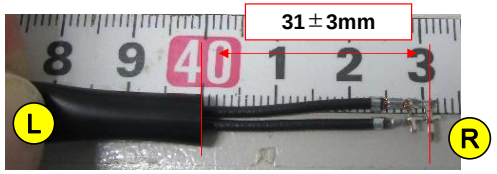
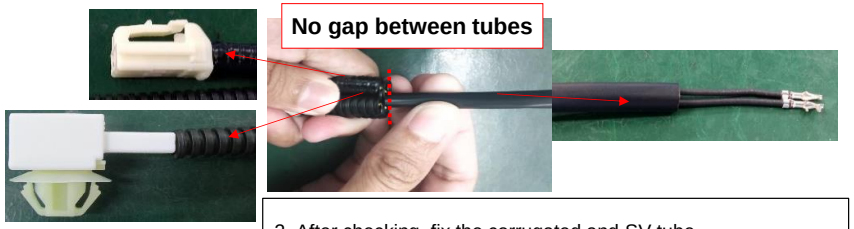
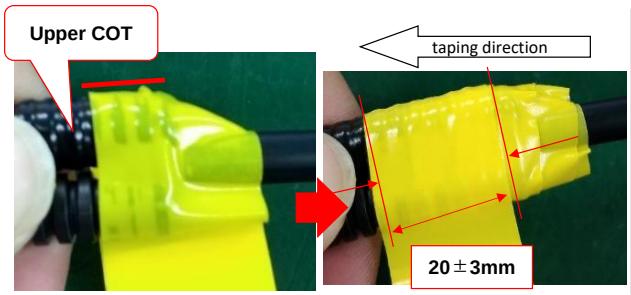
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 2 of 6

PARTS:	1. Assy parts 2. Black tape	△4 3. Black SV Tube (Vinyl) ø5 L=87±2mm	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Taping 1 Black corrugated tube to wire near connector	 △4 1. Get the **Black SV Tube (Vinyl) ø5 L=87±2mm** using right hand then insert the **B-B wires** using left hand.		***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (Special).***
3		Y-taping	 **31±3mm** 1. Check the measurement from end of Black SV Tube (Vinyl) up to end of terminal tip **31±3mm** before start of **Y-Taping** process.  **No gap between tubes** 2. After checking, fix the corrugated and SV tube.  **Upper COT** taping direction **20±3mm** 3. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape **2 windings.** Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±2mm.** ***Note**: Do not exert excessive force during pulling & winding of tape*	**Measuring tape** 	1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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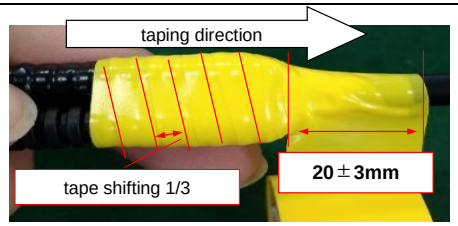
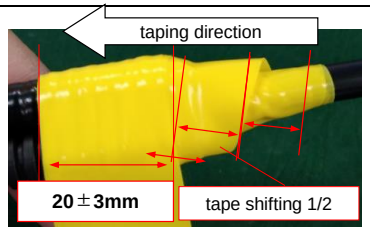
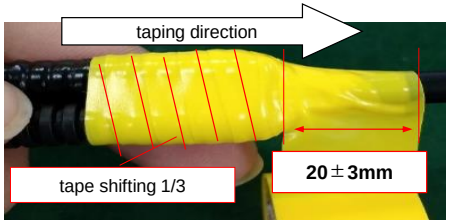
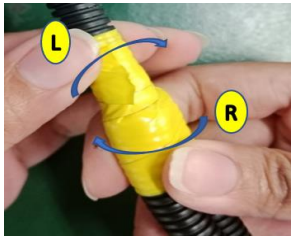
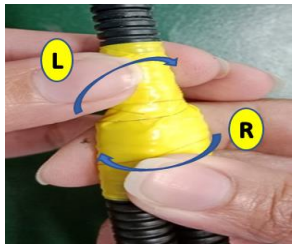
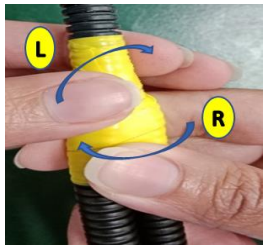
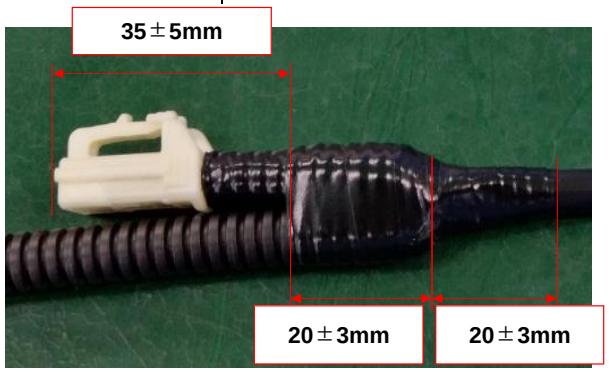
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 3 of 6

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Y-taping (Continuation)	 4. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube. Make **2 windings**, width must be **20±3mm**.  5. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±2mm.**  6. Winding the tape **1/3 shifting** going to the right side until it reach the other side of tube. Make **3 windings**, width must be **20±3mm.** Then cut the tape  7. conduct proper pressing of end tape using left hand **(top part)**  8. conduct proper pressing of end tape using left hand **(Middle part)**  9. conduct proper pressing of end tape using left hand **(bottom part)**	**Measuring tape**  10. Check the Measurment and condition of tape.	**Important reminders/Note/s:** ***1. Use YELLOW TAPE for easy visualization f shifting lines, but actual should be BLACK TAPE*** ***2. Please use calibrated/verified measuring tape when getting the measurement*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (Special)*** 1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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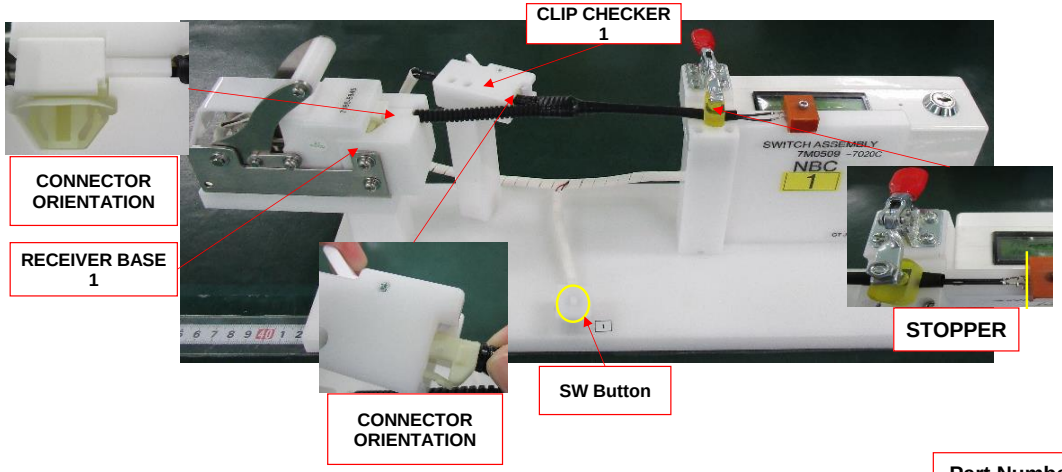
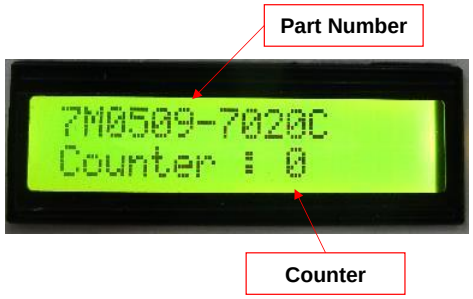
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 4 of 6

PARTS:	1. Assy parts	JIG:	1. Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Continuity Checking			

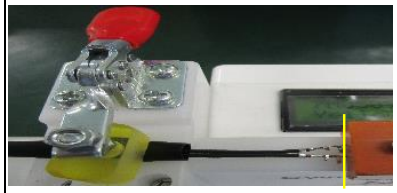


1. Get the assy parts and set into jig. *(See above picture for correct setting).* First, set the connector **7283-1028 (W)** to **Clip Checker 1** then lock. Second, set the connector **7186-8845 (W)** to **Receiver base 1** then push the checker fixture for continuity checking. Last, set the end of **B-B wire** together within the stopper then press by **Toggle clamp**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.



2. Press the **SW button** after setting of assy parts. **Go** sound will be heard

3. **CONDUCT POINT CHECKING** then remove the assy from jig. First, remove the toggle clamp. Second, push the checker fixture of **Receiver base 1** then remove the connector **7186-8845 (W).** Last, press the **clip checker** then remove the connector **7283-1028 (W).**



Important reminders/Note/s:

1. Make sure no gap between the terminal and stopper jig.

2. Counter will be the basis of quantity of harness per box. Only LEADER are allowed to reset the counter.

1. No wrong insert
2. Make sure no gap between terminal and stopper jig

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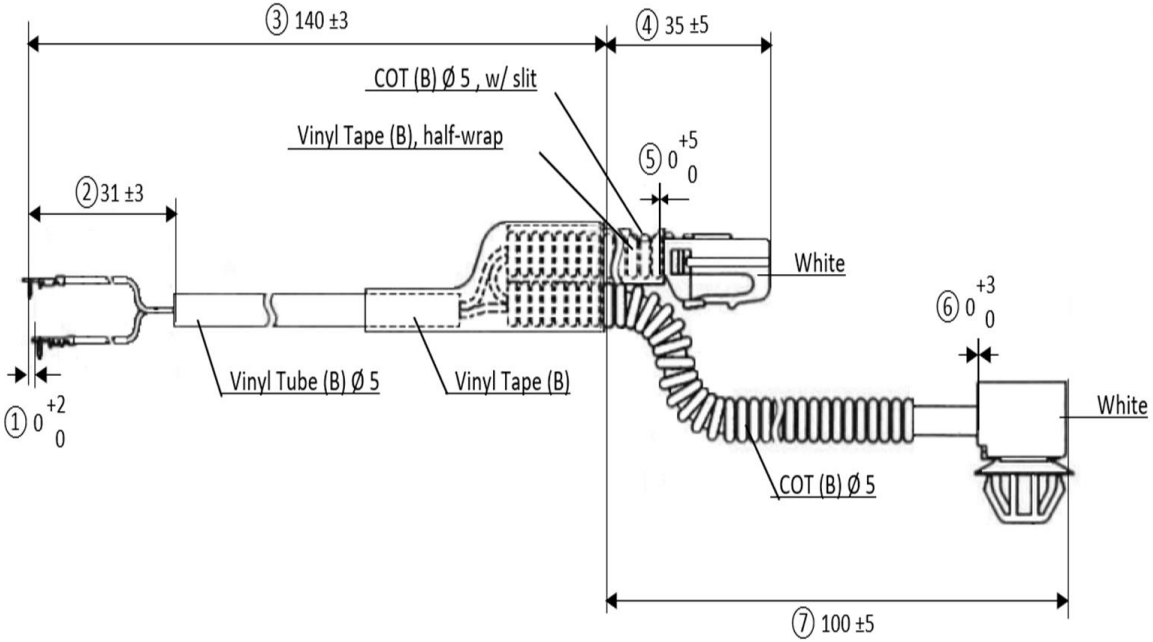
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement		**MEASURING TAPE** 	***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension

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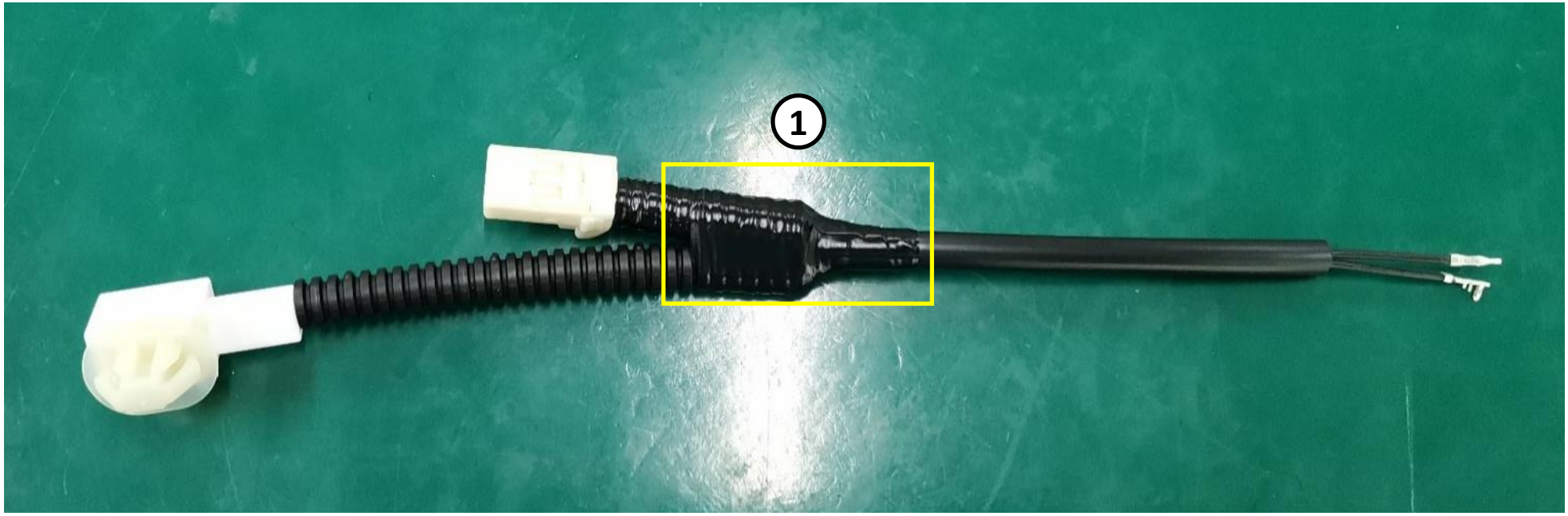
PARTS:	1. Assy parts	JIG:	n/a

4 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

TAPING-P2 | 7M0509-7020C



1 **No Missing Tape (Y-taping)**

2 **No Deformed Terminal**

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