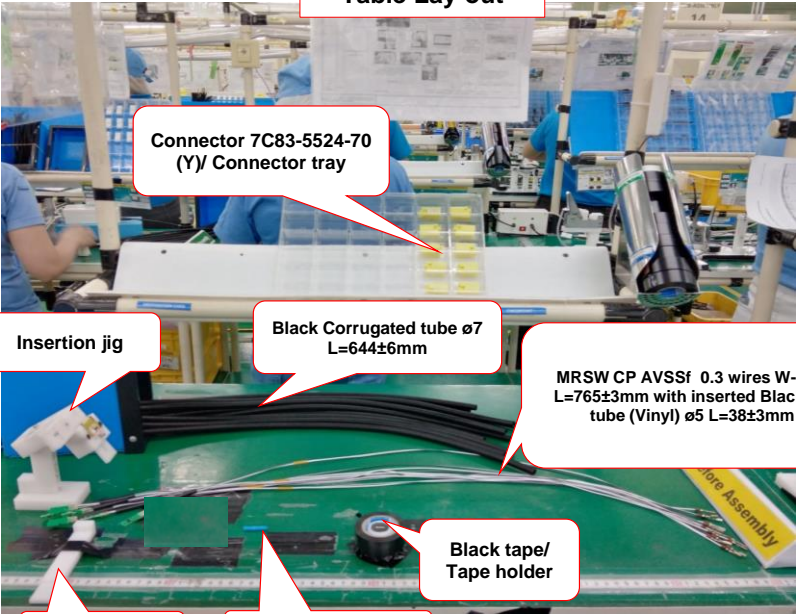

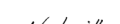






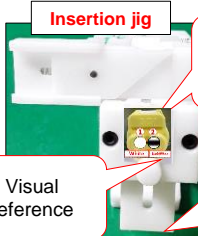
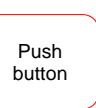
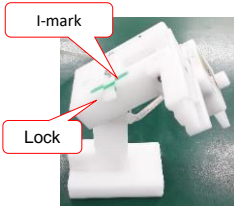





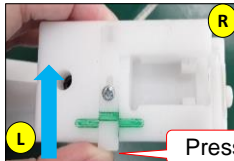
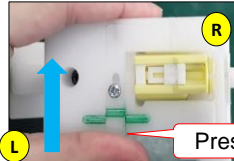
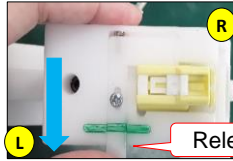

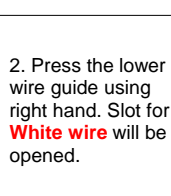
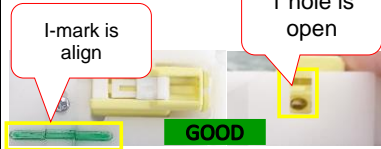
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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-620A		
	Model code/Part number:	ES1 / 7N0165-7020A	Customer:	TRJ	Car Model:	SUBARU-FORESTER	
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	1 of 6

PARTS:	1. All parts: Connector 7C83-5524-70 (Y); MRSW CP AVSSf 0.3 wires W-B/W L=765±3mm with inserted Black SV tube (Vinyl) ø5 L=38±3mm; Black Corrugated tube ø7 L=644±6mm; Black tape			JIG:	1. Locking jig 3.Insertion jig 2. Terminal cover jig 4. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 <div>3</div> Table Lay-out	<div> <div>Table Lay-out</div>  </div>		<div> Safety Instruction Be sure to wear required 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>	Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-006 Wire Taping with Vinyl Tube 1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
								 D. Castillo	 C. Villanueva	 A. Arañes	n/a
06/11/24	3	Transfer Taping 2 to WI-ENG-PDE-620B due to process improvement. Integrate connector lock to Clamp assembly process due to jig improvement. Update Table lay-out and Quality checkpoints.		D.Castillo	C. Villanueva	A. Arañes	n/a				
04/06/23	2	Change taping procedure due to tape redcuton project (Page 5-8)		M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
01/25/23	1	Change document purpose from Pre-launch to masspro. Provide additional jig (measuring jig). Improve work procedure and illustration in process no.2 and 6. Additional table layout.		M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	January 19, 2023		

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		TAPING ASSEMBLY PROCESS				Validity Date:		n/a					
		Process Name/Title:		Model code/Part number: ES1 / 7N0165-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-620A			
		Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:
PARTS:		1. Black Corrugated tube $\phi 7$ L=644 \pm 6mm 2. Connector 7C83-5524-70 (Y)				3. MRSW CP AVSSf 0.3 wires W-B/W L=765 \pm 3mm with inserted Black SV tube (Vinyl) $\phi 5$ L=38 \pm 3mm				JIG:		1. Insertion jig 2. Terminal cover jig	
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
2		Wire insertion to Black Corrugated tube $\phi 7$ L=644 \pm 6mm (no slit)		<div><div><p>1. Get the terminal cover jig using right hand then insert to both terminals (W-B/W wires) using right hand.</p></div><div><p>1. Hold the corrugated tube $\phi 7$ L=644\pm6mm using left hand then get the hotmelted W-B/W wires and insert to COT using right hand.</p></div><div><p>3. After insertion, remove the cover jig using right hand.</p></div></div>				<div><div>TERMINAL COVER JIG</div></div>		<div><div>Document references:</div><div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div><div>1. No wrong usage of parts 2. No damaged rubber seal</div></div>			
3		Connector setting to insertion jig 7C83-5524-70 (Y)		<div><div><div><p>Insertion jig</p></div><div><p>Push button</p></div><div><p>I-mark</p></div><div><p>Lock</p></div><div><p>Visual reference</p></div><div><p>Lower wire guide</p></div><div><p>Connector Orientation</p></div><div><p>Insertion jig orientation</p></div></div><div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div><div><p>I-mark is align</p></div><div><p>1 hole is open</p></div></div></div>				n/a		<div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div><div><div>Connector Orientation Illustration</div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div></div>			

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Car Model:

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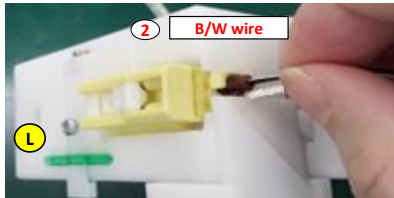
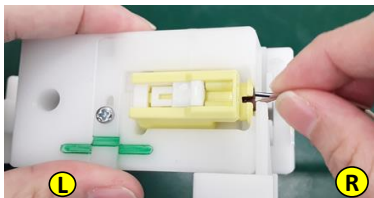




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts ; Connector 7C83-5524-70 (Y)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector 7C83-5524-70 (Y)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand. Get the White wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. Press the button using right thumb. The slot for Black/White wire will be opened.</div></div> <div><div>3. Get the Black/White wire then insert to terminal slot 2 using right hand.</div></div> <div><div>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deform terminal</p> <p>5. No wrong wire facing.</p> <div><div>EMERGED RUBBER SEAL CROSS SECTIONAL VIEW</div><div><div>Not fully inserted rubber seal</div></div><div>RUBBER SEAL CONDITION ILLUSTRATION</div><div></div></div>

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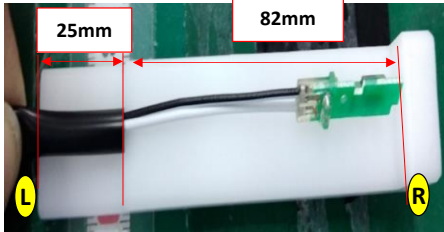
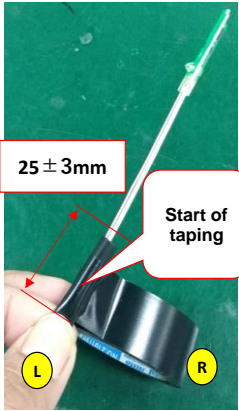

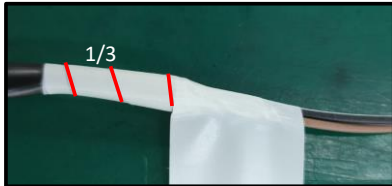



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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black SV tube (Vinyl) to wire near PCB	<div></div> <div>1. Conduct measurement on measuring jig by placing the assy parts on guide dimension. (See illustration)</div> <div></div> <div>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</div> <div><div>TAPING PROCEDURES</div><div></div><div>3. Attach tape then conduct 1 winding while folding the SV tube (Vinyl)</div><div></div><div>4. Shift the tape 1/3 shifting going to wires <i>note: 1/3 shifting must be within the foded SV tube (VINYL)</i></div></div> <div><div>MEASURING TAPE</div><div>MEASURING JIG</div></div> <div><div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div><div>Important reminders/Note/s: 1. Used <u>WHITE TAPE</u> to easy visualization of shifting lines, but in actual should be <u>BLACK TAPE</u> 2. Please use calibrated/verified measuring tape when getting the measurement. 3. First dimension will be conducted using measuring jig</div><div></div><div>Position the finger in wire to avoid deformed hotmelt</div></div>			

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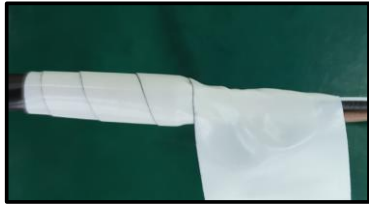
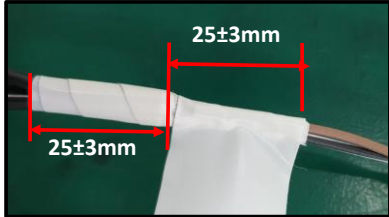

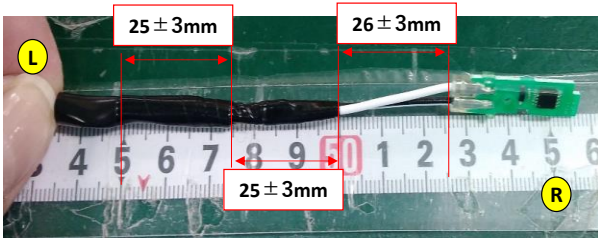


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PARTS:		1. Assy parts 2. Black tape		JIG:	1.Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black SV tube (Vinyl) to wire near PCB (Continuation)	<div><div></div><div>5. Conduct <u>1 wind</u> before shifting</div><div></div><div>6. Conduct <u>2x windings</u> before end of tape</div><div></div><div>7. Conduct <u>3x</u> pressing at the end of tape to prevent peel off</div><div></div><div>8. After taping, check the taping condition and measurement.</div></div> <div><div>MEASURING TAPE</div></div> <div><div>MEASURING JIG</div></div>		<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE2. Please use calibrated/verified measuring tape when getting the measurement.3. First dimension will be conducted using measuring jig <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension	

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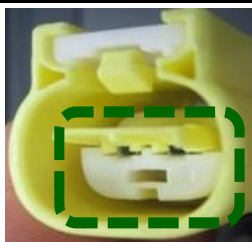
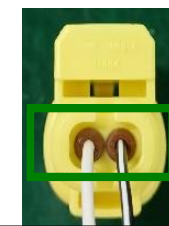
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0165-7020A****GOOD****NG****GOOD****NO GOOD****1**

No Unlock/ Half Lock Connector
Check the **CONNECTOR LOCK** if properly locked.

2

No Wrong Insert

3

No Terminal Backing out

4

No Missing Parts

5

No Missing tape

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