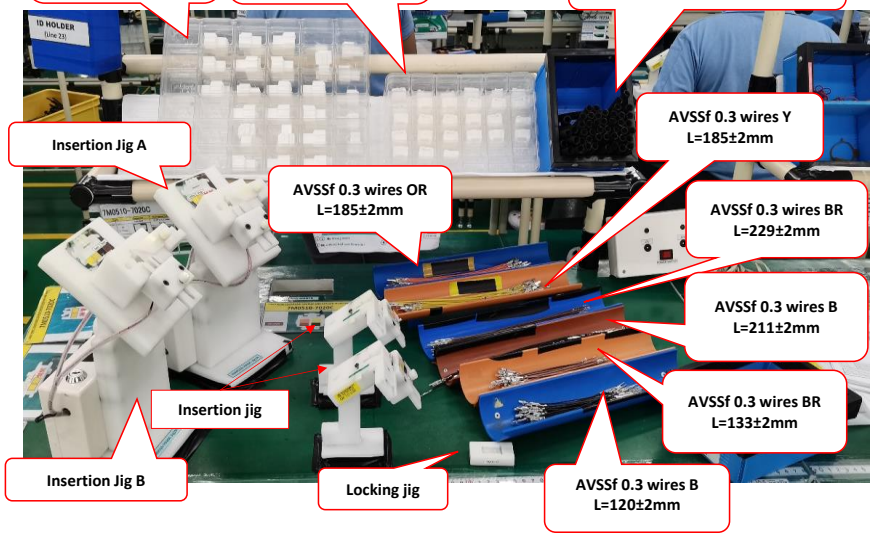
	WORK INSTRUCTION			Effectivity Date:	January 5, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.: 1 of 12

PARTS:	1. All parts: Connector 7186-8849 (W); AVSSf 0.3 wires Y-OR L=185±2mm; AVSSf 0.3 wires BR L=229±2mm; BR L=133±2mm; B L=120±2mm; B L=211±2mm; Connector 4F5450-0000 (W); Black Corrugated tube ø7 L= 127±3mm (no slit)	JIG:	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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.	***Document reference/s:*** ***1.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** ***2. Refer to WI-ENG-PDE-374 7M0510-7020C for Offline Assembly process*** 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
01/05/23	5	Transfer process from Offline assembly process to Taping assembly process. Update table lay-out and Quality checkpoint. Transfer other process to WI-ENG-PDE-366B due to Process improvement.	D. Castillo	C. Villanueva	A. Arañes	n/a
08/30/22	4	Improve quality pointers and notes in: Process no.1 and 2 and additional locking method in process4, procedure2 as document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
08/09/22	3	Removal of spot taping measurement in process no.10 and improve description, illustration, quality pointers and notes as process improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	November 6, 2021		

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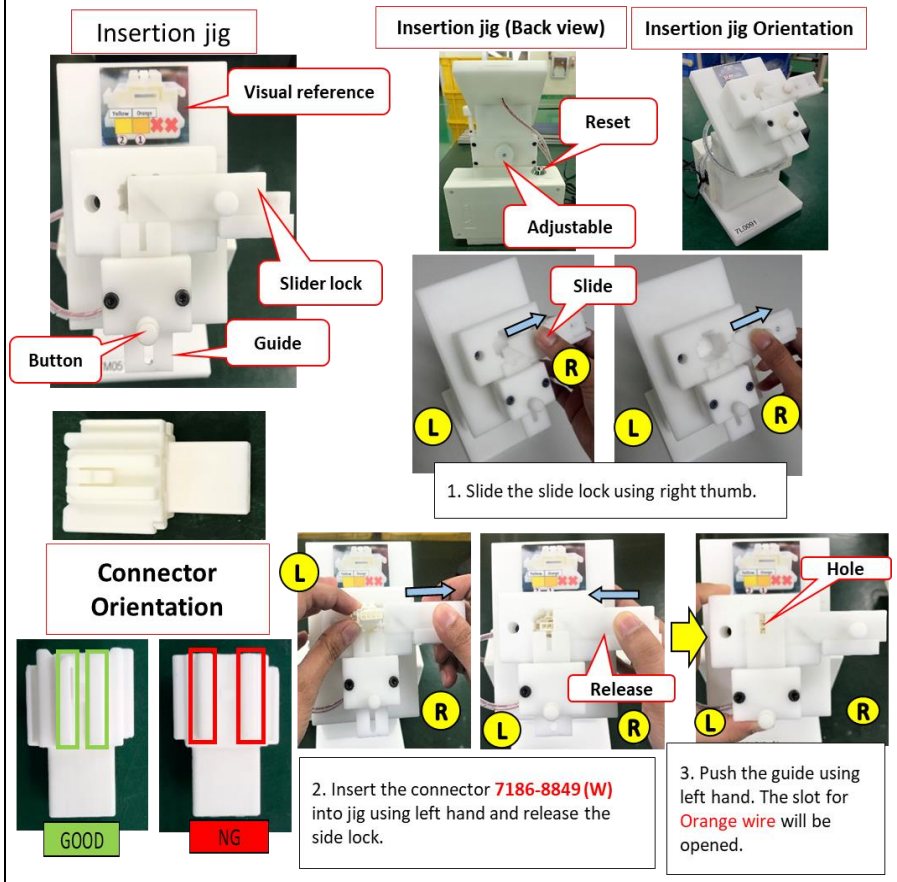
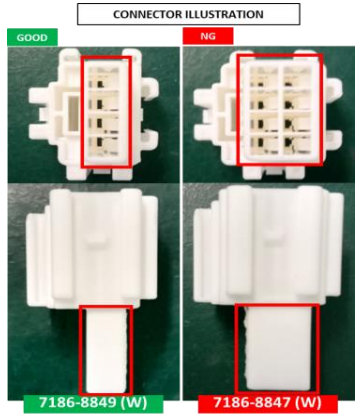
PARTS:	1. Connector 7186-8849 (W)	JIG:	1.Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	5 P1	Connector setting to insertion jig 7186-8849 (W)		n/a	***Important reminders/Note/s:*** ***1. Cannot insert the inverted connector.*** 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 

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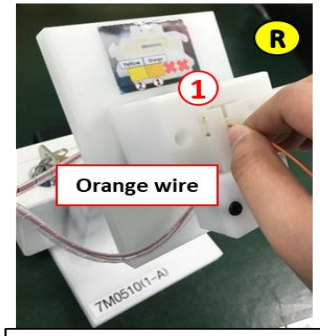
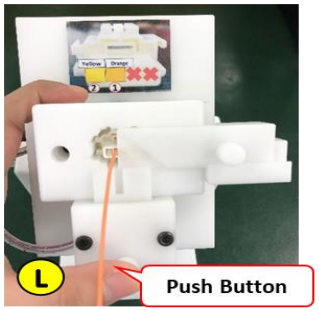
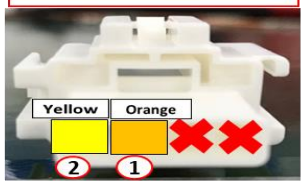
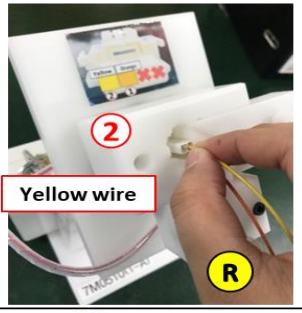
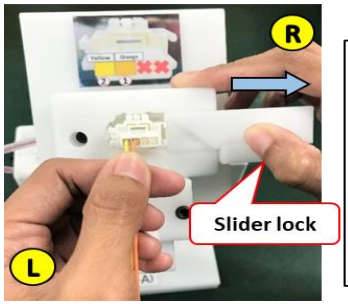
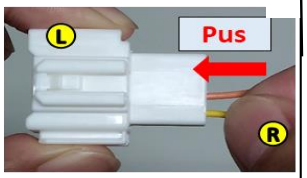
	WORK INSTRUCTION			Effectivity Date:	January 5, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	5	Page No.:	3 of 12

PARTS:	1. AVSSf 0.3 wires Y-OR L=185±2mm			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	5 P1	Wire insertion to Connector 7186-8849 (W)	 1. Get the **Orange wire** then insert to terminal slot **1** using right hand. Conduct **Pull-Push-Pull-Push** after insertion.  2. Press the button using left hand. The slot for **Yellow wire** will be opened. VISUAL REFERENCE   3. Get the Yellow wire then insert to terminal slot **2** using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. **GO** sound will be heard.  4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.  5. After removing the connector from jig, conduct **Pushing (1x)** of **Y wire** using right hand to confirm that wire is fully inserted. Repeat the process		1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***3. Conduct Pushing of wires after removing the connector from jig.*** ***4. Pushing of wires will be done one by one of every inserted wires*** ***Document reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.***

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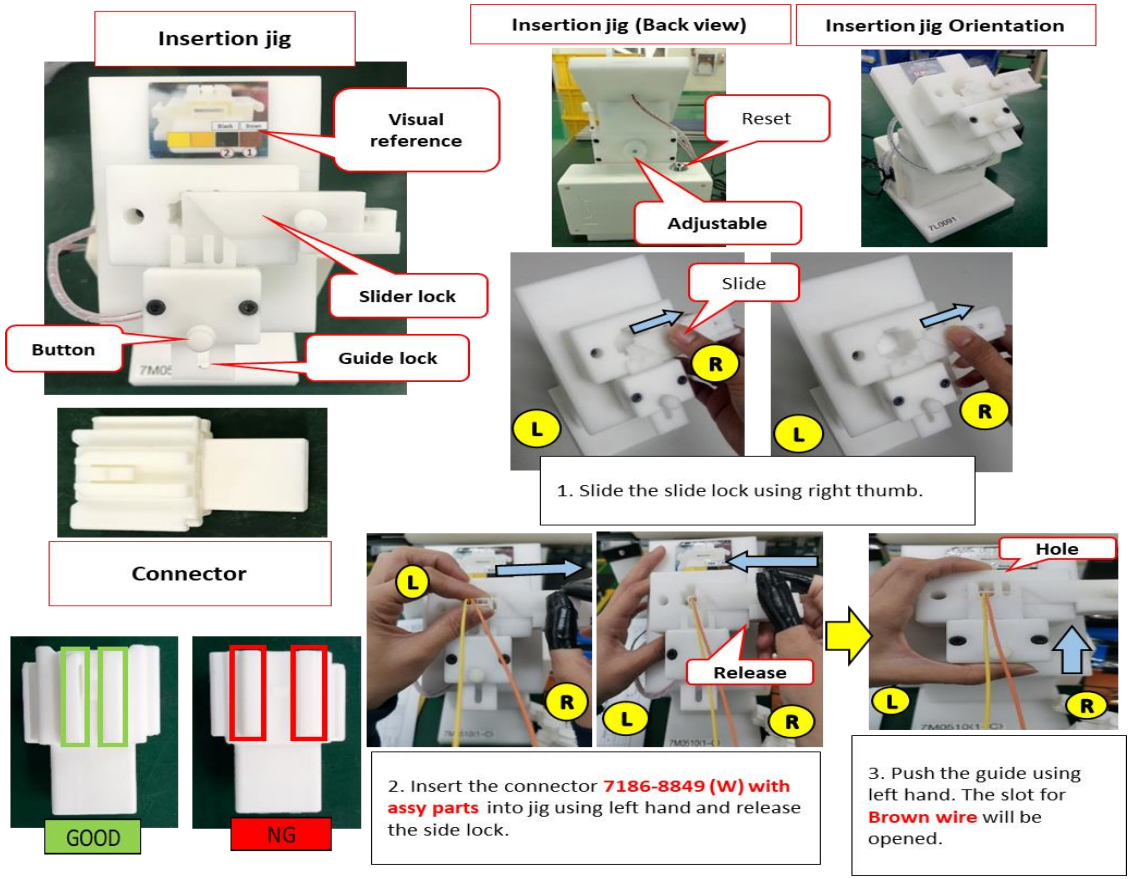
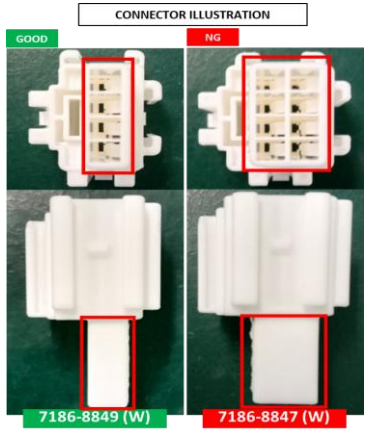
NBC	WORK INSTRUCTION			Effectivity Date:	January 5, 2023
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.: WI-ENG-PDE-366A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.: 5	Page No.: 4 of 12

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	5 P1	Connector setting to insertion jig with Assy parts 7186-8849 (W)			***Important reminders/Note/s:*** ***1. Cannot insert the inverted connector.*** 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 

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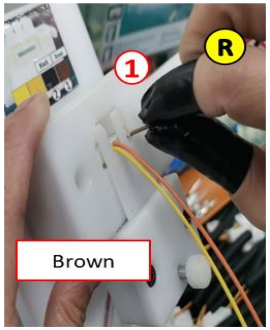
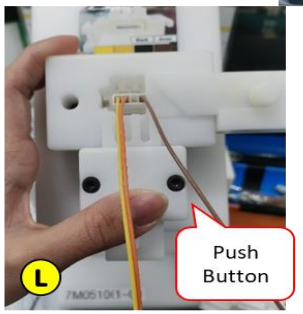
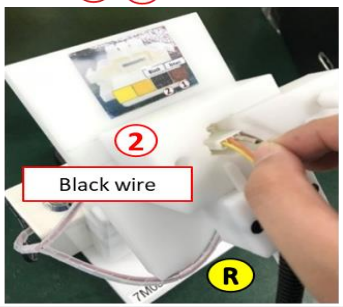
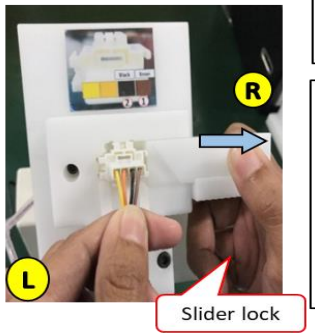
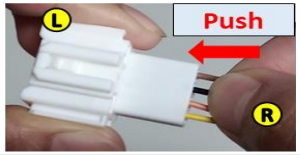
	WORK INSTRUCTION			Effectivity Date:	January 5, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	5	Page No.:	5 of 12

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	5 P1	Wire insertion to Connector with Assy parts 7186-8849 (W)	 1. Get the **Brown wire** then insert to terminal slot **1** using right hand. Conduct **Pull-Push-Pull-Push** after insertion. VISUAL REFERENCE  2. Press the button using left hand. The slot for **Black wire** will be opened.  3. Get the **Black wire** then insert to terminal slot **2** using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. **GO** sound will be heard.  4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.  5. After removing the connector from jig, conduct **Pushing (1x)** of **B wires** using right hand to confirm that wire is fully inserted. Repeat the process for **Y wire.**		1. No loose insert 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***3. Conduct Pushing of wires after removing the connector from jig.*** ***4. Pushing of wires will be done one by one of every inserted wires*** ***Document reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.***

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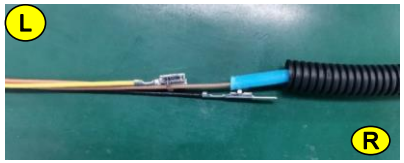
	WORK INSTRUCTION			Effectivity Date:	January 5, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	6 of 12

PARTS:	1. Assy parts 2. Black Corrugated tube ø7 L=127±3mm (no slit)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	5 P1	Wire insertion to Black Corrugated tube ø7 L=127±3mm (no slit)	 1. Get the terminal cover jig using right hand then insert the **Brown wire** using left hand.  2. Get the Corrugated tube **ø7 L=127±3mm (no slit)** using right hand and insert to assy parts. 3. After insertion, remove the terminal cover jig using right hand.	 Terminal cover jig	1. No deformed terminal 2. No wrong usage of parts

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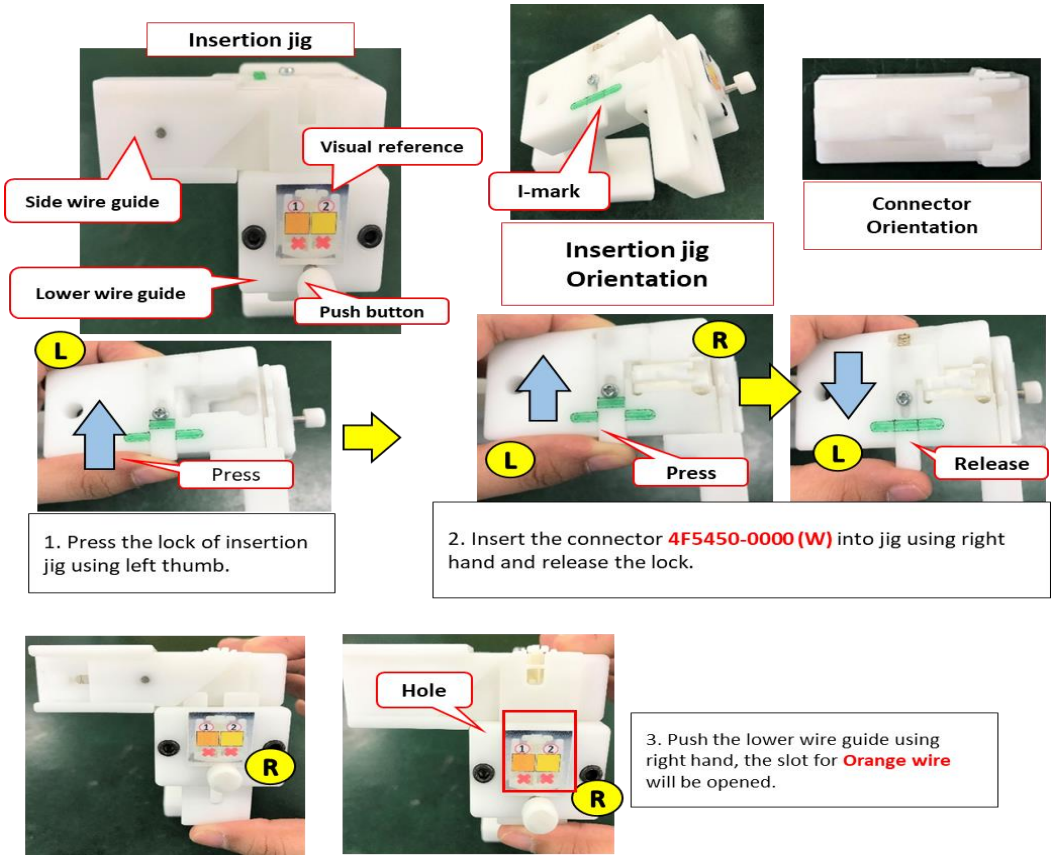
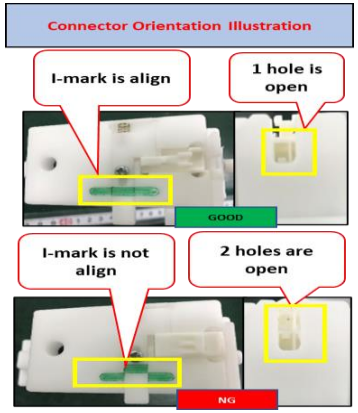
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	5	Page No.:	7 of 12

PARTS:	1. Connector 4F5450-0000 (W)			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
7	P1	Connector setting to insertion jig 4F5450-0000 (W)	 1. Press the lock of insertion jig using left thumb. 2. Insert the connector **4F5450-0000 (W)** into jig using right hand and release the lock. 3. Push the lower wire guide using right hand, the slot for **Orange wire** will be opened.		***Important reminders/Note/s:*** *1. Follow the connector orientation* 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 

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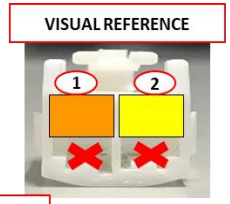
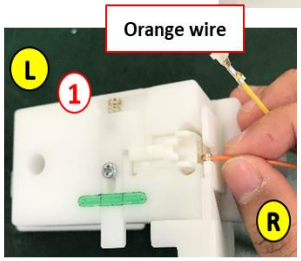
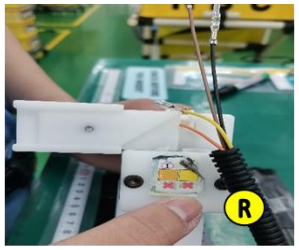
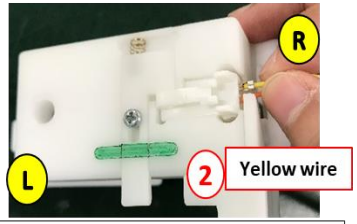
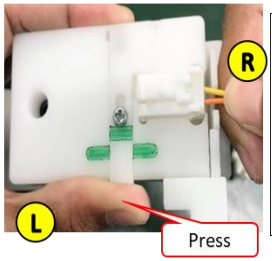
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	8 of 12

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Wire insertion to Connector 4F5450-0000 (W)	  1. Get the **Orange wire** using right hand and insert to connector.  2. Press the button using right hand, the slot for **Yellow wire** will be opened.  3. Get the **Yellow wire** using right hand and insert to connector.  4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***3. Conduct Pushing of wires after removing the connector from jig.*** ***4. Pushing of wires will be done one by one of every inserted wires*** ***Document reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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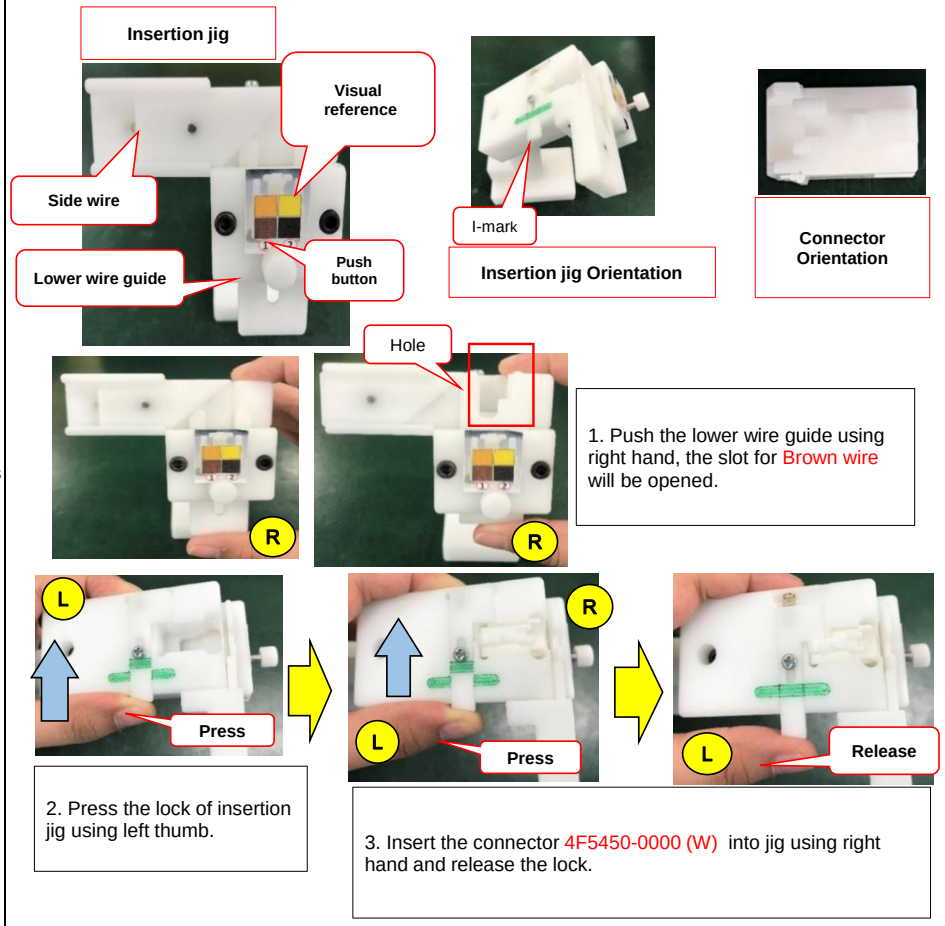
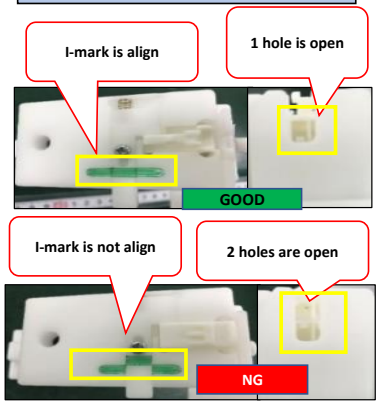
	WORK INSTRUCTION			Effectivity Date:	January 5, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.: 9 of 12

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Connector setting to insertion jig with Assy parts 4F5450-0000 (W)	 1. Push the lower wire guide using right hand, the slot for Brown wire will be opened. 2. Press the lock of insertion jig using left thumb. 3. Insert the connector 4F5450-0000 (W) into jig using right hand and release the lock.	n/a	***Important reminders/Note/s:*** *1. Follow the connector orientation* 1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector **Connector Orientation Illustration** 

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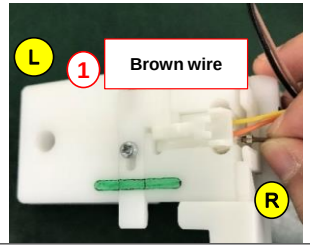
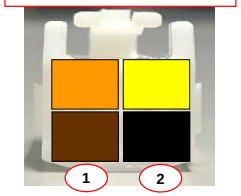
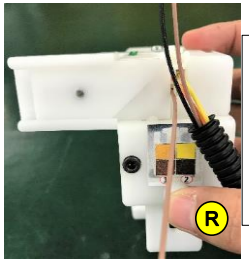
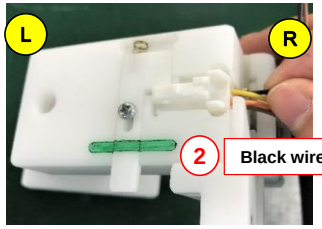
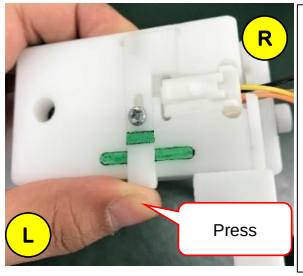
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	10 of 12

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	Wire insertion to Connector 4F5450-0000 (W)	 Wire facing  L 1 Brown wire R 1. Get the **Brown wire** using right hand and insert to connector. VISUAL REFERENCE  1 2  R 2. Press the button using right hand, the slot for **Black wire** will be opened.  L R 2 Black wire 3. Get the Black wire using right hand and insert to connector.  R L Press 4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	n/a	1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***3. Conduct Pushing of wires after removing the connector from jig.*** ***4. Pushing of wires will be done one by one of every inserted wires*** ***Document reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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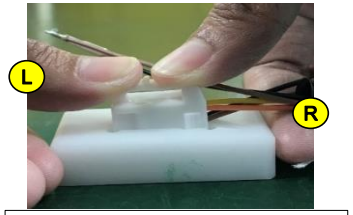
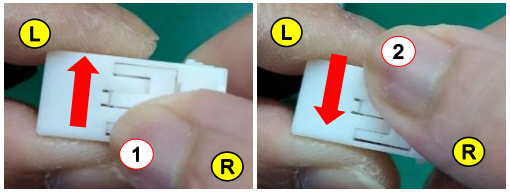
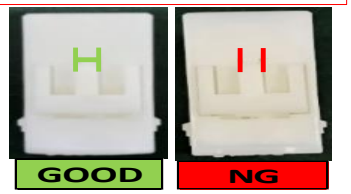
	WORK INSTRUCTION			Effectivity Date:	January 5, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-366A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	5	Page No.:	11 of 12

PARTS:	1. Assy parts			JIG:	1.Locking Jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
11	P1	Connector lock	 1. Put the connector into locking jig using both hands then press **2x.** Touch the connector lock if properly lock.  2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated. **BEFORE PRSSING** **AFTER PRESSING** 	**LOCKING JIG** 	1. No unlock/half-locked connector 2. No damaged connector lock ***Important reminders/Note/s:*** ***1. Manual locking may cause damaged connector.*** **Connector lock must be locked properly** 

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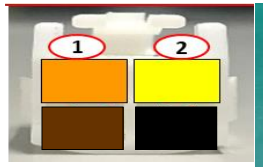
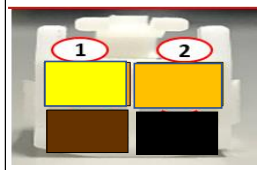
PARTS:	n/a	JIG:	n/a

5 **QUALITY CHECKPOINTS**

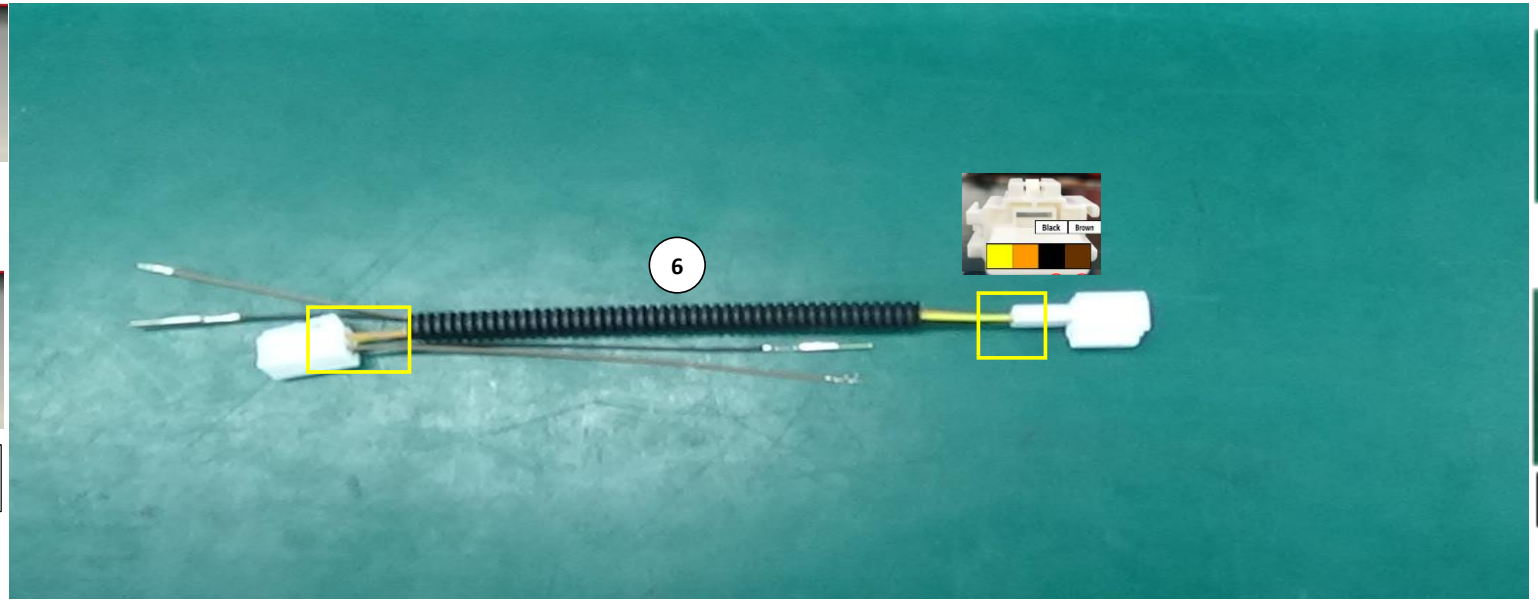
P1 7M0510-7020C



GOOD



NO GOOD



GOOD

NO GOOD

1 2 No Unlock/ Half Lock Connector (2 connector)

3 4 No Wrong Insert (2 connector)

5 No Terminal Backing Out (2 connector)

6 No Missing COT

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