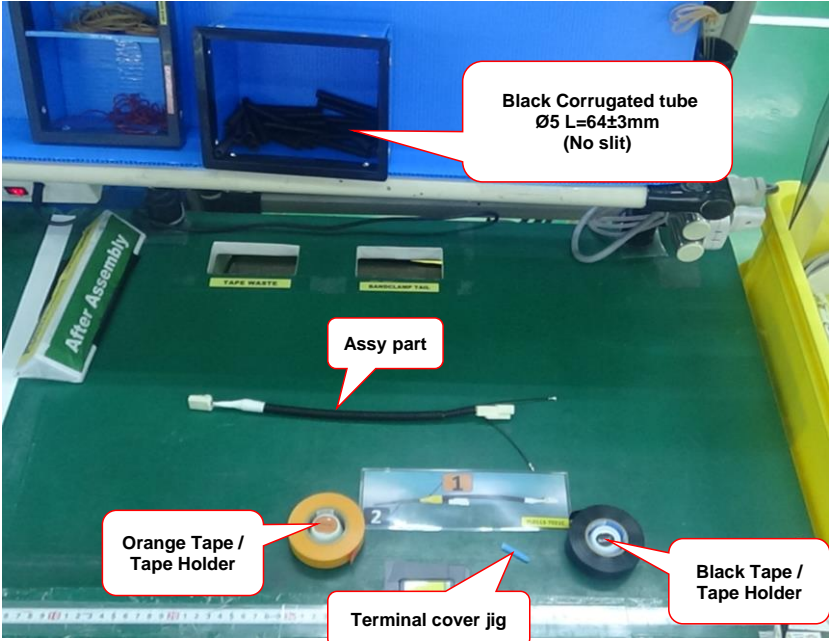
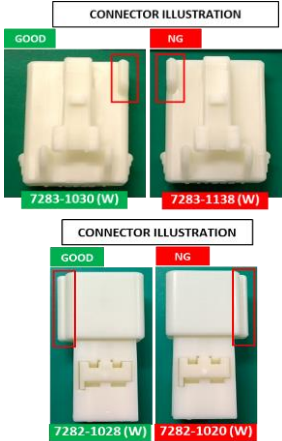


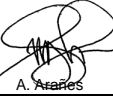
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	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: TM3 / 7L0113-7021C		Customer: TRQSS		Car Model: SUBARU-ASCENT	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-708B		Revision No.: 2		Page No.: 1 of 6	

PARTS:		1. Assy parts; Black Corrugated tube Ø5 L=64±3mm; Black tape; Orange tape				JIG:		n/a	
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>1. No missing parts/tools. 2. No missing parts/tools.</div> <div>CONNECTOR ILLUSTRATION</div> 	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
07/08/24	2	Separate urethane foam attachment and assembly to Clamp assembly process. Transfer Spot taping from P1 and change process sequence due to process improvement. Change spot taping color from White to Orange. Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
09/23/23	1	Excluded process from WI-ENG-PDE-708 due to New process distribution. Change purpose from Pre-launch to masspro. Inclusion of Table lay-out. Update Work procedure/illustration on page no.6				M. Ariola	J.Loterte	C. Villanueva	A. Arañes				
08/18/23	0	Initial issue.				M. Ariola	J.Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 18, 2023		

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 22, 2024**

Model code/Part number:

**TM3****/ 7L0113-7021C**

Customer:

**TRQSS**

Car Model:

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Document No.:

**WI-ENG-PDE-708B**

Purpose:


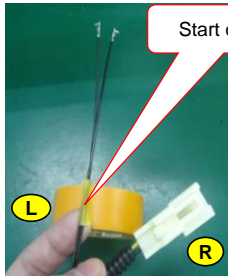
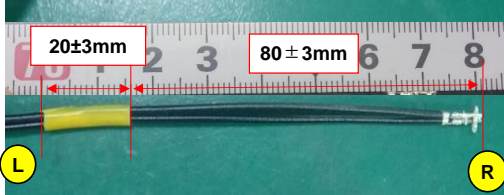




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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Page No.:

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=64±3mm 3. Orange tape		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div><div>2</div><div>Spot taping</div></div>	<div><div><div>100 ± 3mm</div><div></div><div>1. Hold wires using left hand, measure the wire up to terminal tip <b>100±3mm</b>.</div></div><div><div><div>Start of taping</div><div></div><div>2. Get the <b>Orange tape</b>, conduct <b>2x windings</b> of tape then cut using both hand.</div></div><div><div><div>20±3mm</div><div>80 ± 3mm</div><div></div><div>3. After taping, check the measurement and taping condition.</div></div></div></div></div>		n/a	<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. Please use calibrated/verified measuring tape when getting the measurement. 2. Use <u>ORANGE TAPE</u> only.</div>
3	<div><div>P2</div><div>Wire insertion to Black Corrugated tube Ø5 L=64±3mm</div></div>	<div><div><div></div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>B and B jointed wires</b> using left hand.</div></div><div><div></div><div>2. Get the corrugated tube (no slit) Ø5 L=64±3mm using right hand then insert the <b>B and B jointed wires</b> using left hand.</div></div><div><div></div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div>		<div>TERMINAL COVER 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>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

TM3

/ 7L0113-7021C

Customer:

TRQSS

Car Model:

SUBARU- ASCENT

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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### PARTS:

1. Assy parts
2. Orange tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

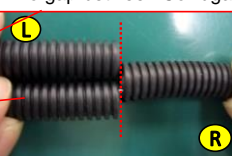
4

P2

Y-taping

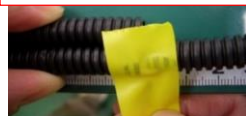


No gap between Corrugated tubes



1. Fix the corrugated tube.

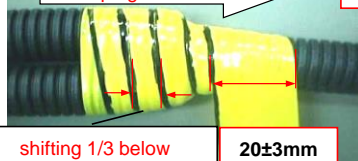
Note: Do not exert excessive force during pulling & winding of tape



2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , measurement from end of connector up to end of tape must be **52±3mm**.

taping direction

20±3mm

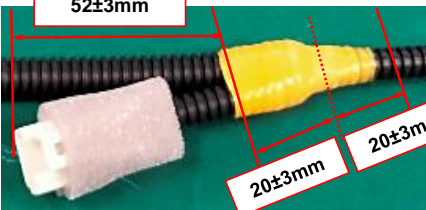


shifting 1/3 below

20±3mm

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

52±3mm



20±3mm

20±3mm

4. Wind the tape backward 1/2 shifting.

taping direction

Tape shifting 1/2 below

5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

MEASURING TAPE



Important reminders/Note/s:

1. Used **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **ORANGE TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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TM3

/ 7L0113-7021C

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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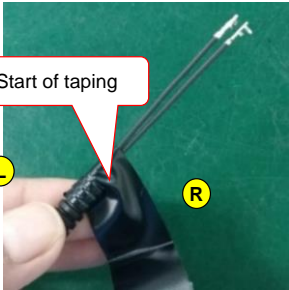
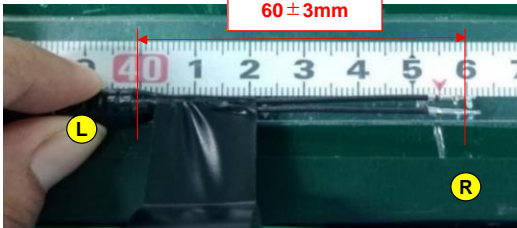

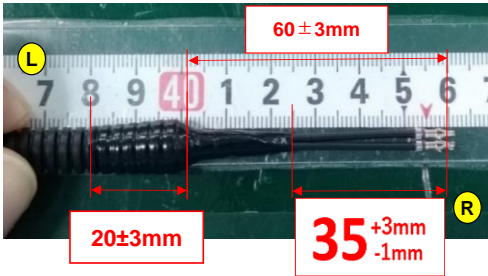

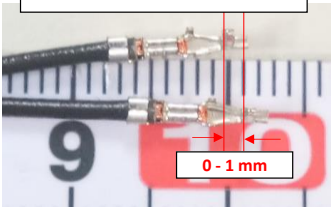
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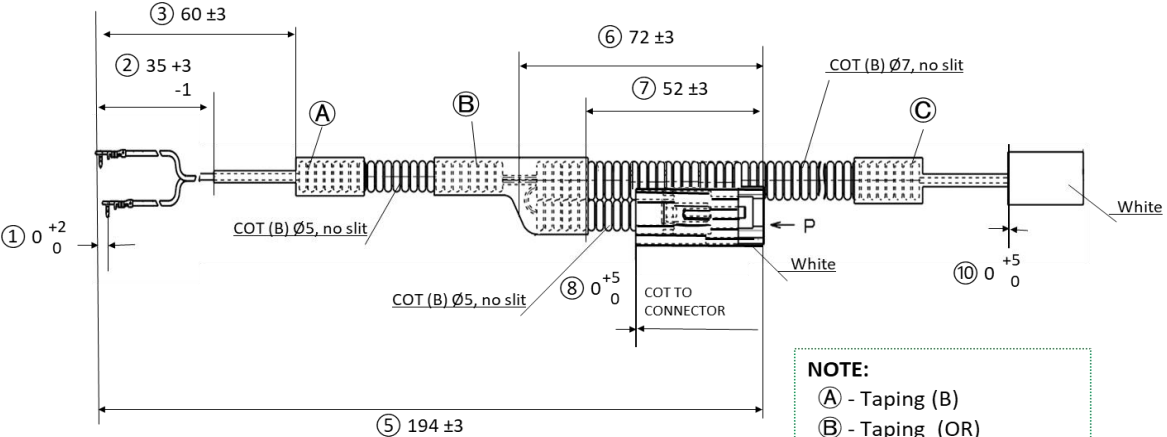

PARTS:	1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2  Taping 2 COT to wire near terminal	<div><p>Start of taping</p></div> <div><p>60 ± 3mm</p></div> <div><p>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p></div> <div><p>35 +3mm -1mm</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip <b>60±3mm</b> then continue the taping process using both hands.</p></div> <div><p>20 ± 3mm 60 ± 3mm 35 +3mm -1mm</p></div> <div><p>3. Confirm measurement of <b>35+3/-1mm</b> from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div>MEASURING TAPE</div> 	<p>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</p> <p><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></p> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 22, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>TM3 / 7L0113-7021C</b>		Customer: <b>TRQSS</b>	Car Model: <b>SUBARU- ASCENT</b>	Document No.:	<b>WI-ENG-PDE-708B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	5 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>2</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
6	P2	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (B) B - Taping (OR) C - Taping (W)</div>	<div>MEASURING TAPE</div> 	<div><b>Important reminders and note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. For Hatsumono, Nakamono and Owarimono.</b>  <b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b></div> <div>1. No wrong dimension</div>		

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**6 of 6****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7L0113-7021C**

**1** No Missing Spot Tape  
( Must be Orange Tape )

**2** **3** No Missing / Wrong use  
of tape ( Orange Tape )

**4** No Deformed  
Terminal

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