



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Model code/Part number:

TM3 / 7L0115-7020

Customer: TRQSS

Car Model: SUBARU-ASCENT

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

January 21, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1071

Revision No.:

0

Page No.:

1 of 5

## PARTS:

1. Assy parts; Gray Urethane foam t=4;75mmX30mm

JIG:

1. Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

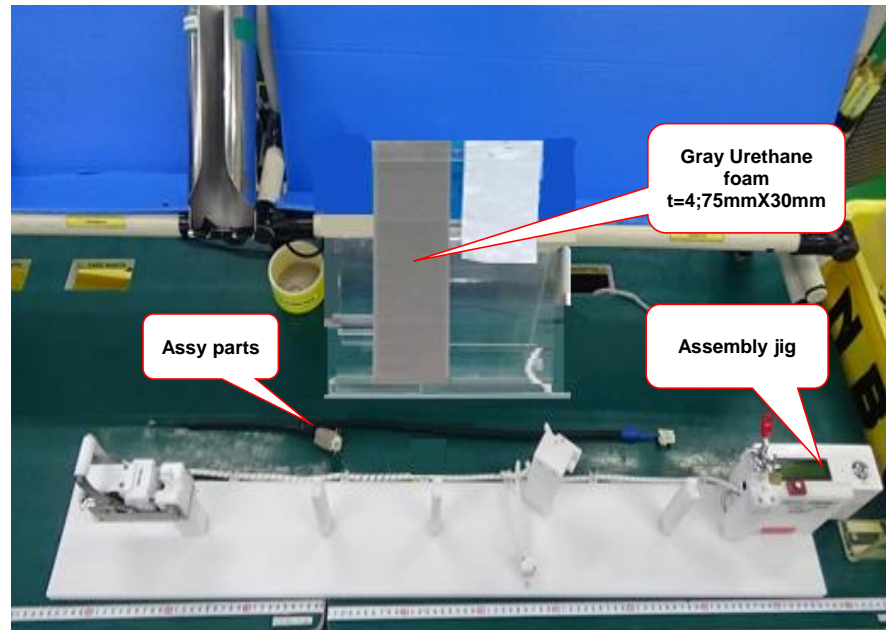
QUALITY POINTERS

1

Clamp  
Assy

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 references:**

1. Refer to WI-ENG-PDE-315A-B for Taping Assembly process

1. No missing parts/tools
2. No excess parts/tools


## Revision History

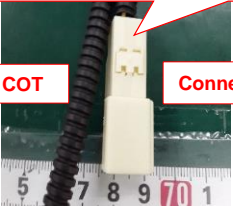
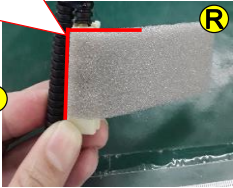

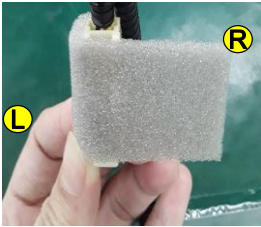
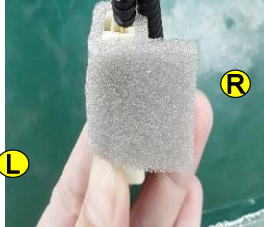

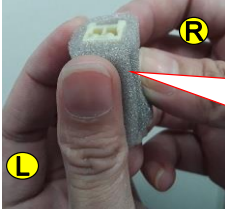
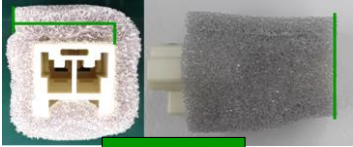
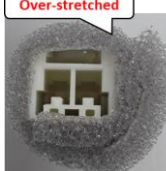
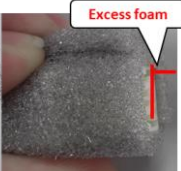
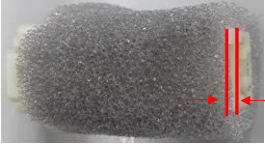
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/21/25	0	Initial issue. Separate from Taping assembly process.	D.Castillo	C. Villanueva	A. Arañes	n/a	D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 21, 2025		

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp

	<b>WORK INSTRUCTION</b>			Effectivity Date:	January 21, 2025		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>TM3 / 7L0115-7020</b>		Customer: <b>TRQSS</b>	Car Model: <b>SUBARU-ASCENT</b>	Document No.:	<b>WI-ENG-PDE-1071</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 5

<b>PARTS:</b>		1. Assy parts 2. Gray Urethane foam t=4; 75mm X 30mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	Clamp Assy  Urethane foam attachment	<div>Step 1: Identify the right facing to attached the foam</div> <div></div> <div>Connector</div> <div>Step 2: Get the Urethane foam and begin the attachment. Note: Foam and connector must be align</div> <div></div> <div>Step 3: Attached the foam in all sides of the connector. Note: Follow the attachment sequence based on the illustration</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div>Step 4: Press the Urethane foam side by side after attachment.</div>		<div>DO NOT STRETCH THE URETHANE FOAM</div> <div></div> <div>GOOD</div> <div></div> <div>Over-stretched</div> <div></div> <div>Excess foam</div> <div>NG</div> <div>1. No damaged Urethane foam 2. No missing Urethane foam 3. No stretched Urethane foam</div> <div></div> <div>0-3mm tolerance from Urethane foam to Connector</div>	

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

**CLAMP ASSEMBLY PROCESS**

Effectivity Date:

January 21, 2025

Validity Date:

n/a

Model code/Part number:

**TM3 / 7L0115-7020**

Customer:

**TRQSS**

Car Model:

**SUBARU-ASCENT**

Document No.:

**WI-ENG-PDE-1071**

Purpose:



PROTOTYPE



PRE-LAUNCH



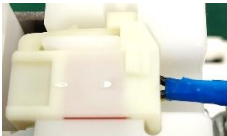

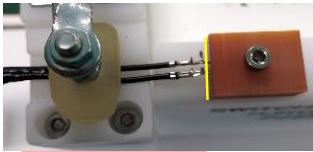
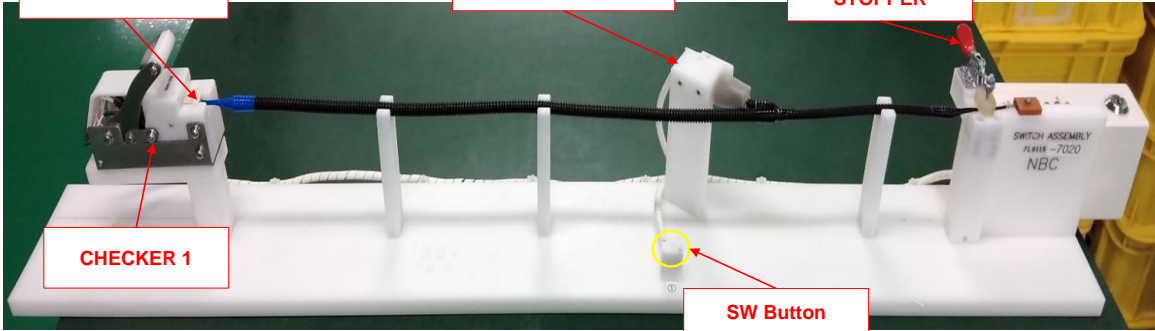

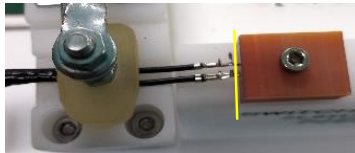
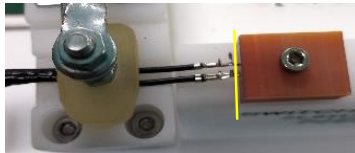
MASSPRO

Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Assy parts		JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Continuity test			
		<div><div> CONNECTOR SETTING</div><div> CLIP CHECKER 1</div><div> STOPPER</div><div> CHECKER 1 SW Button STOPPER</div></div> <div><div><p>1. Get the assy parts and set to tester jig using both hands. <i>(See above picture for correct setting)</i>. First set the connector <b>6249-1252(W)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>7282-1020 (W)</b> to <b>Clip checker 1</b> then lock. Last, set the <b>B-B wires</b> to together within the stopper jig then press by toggle clamp.</p><p>2. Check in the counter if <b>Wire 1</b> and <b>Wire 2</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</p></div><div></div><div><p>3. Press the <b>SW</b> button using right index finger for continuity checking. <b>Go</b> sound will be heard.</p><p>4. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</p><p>5. After point checking, remove the harness. Start from toggle clamp up to Checker 1 then Clip checker 1.</p></div></div> <td><div> STOPPER</div><div><p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p></div></td>		<div> STOPPER</div> <div><p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p></div>	

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

**CLAMP ASSEMBLY PROCESS**

Effectivity Date:

January 21, 2025

Model code/Part number:

**TM3 / 7L0115-7020**

Customer:

**TRQSS**

Car Model:

**SUBARU-ASCENT**

Document No.:

**WI-ENG-PDE-1071**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

4 of 5

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy  Measurement	<div><div>⑥ 775 ±3</div><div><div><div>NOTE:</div><div>① - Taping (B)</div><div>② - Taping (L)</div><div>*Unit of measurement is in millimeter (mm)</div></div></div></div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



**WORK INSTRUCTION**

Process Name/Title:

**CLAMP ASSEMBLY PROCESS**

Effectivity Date:

January 21, 2025

Validity Date:

n/a

Model code/Part number:

**TM3 / 7L0115-7020**

Customer:

**TRQSS**

Car Model:

**SUBARU-ASCENT**

Document No.:

**WI-ENG-PDE-1071**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

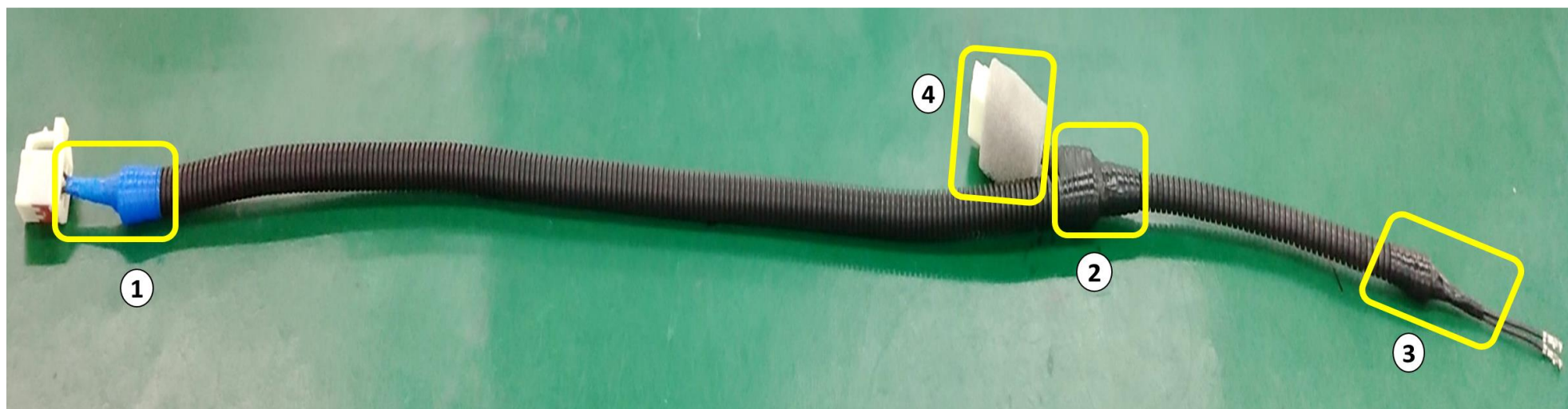
5 of 5

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0115-7020**

**1 No Missing Tape  
(Blue Tape)**

**2 3 No Missing Tape  
(Black Tape)**

**4 No Missing Urethane  
Foam**

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)  
MASTER COPY**

DCC Stamp