



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 04, 2024

Model code/Part number:

TM3

/

7L0145-7020A

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Document No.:

WI-ENG-PDE-945

Purpose:

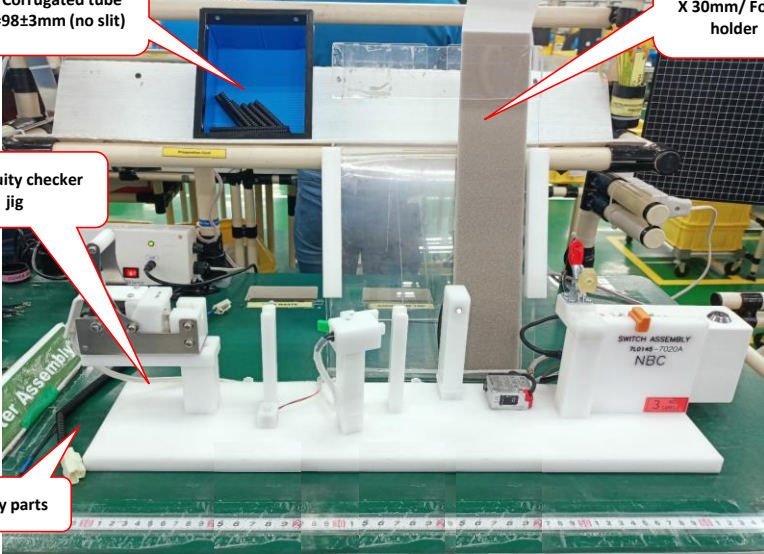
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts; Gray Urethane foam t=4; 75mm X 30mm)				JIG:		1. Continuity checker jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Clamp assy	<div>Table Lay-out</div>  <div>Black Corrugated tube Ø5, L=98±3mm (no slit)</div> <div>Continuity checker jig</div> <div>Assy parts</div> <div>Gray Urethane foam t=4; 75mm X 30mm/ Foam holder</div>				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-714A-C</b> for Taping assembly process</div> <div>1. No deformed terminal 2. No wrong usage of parts</div>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/04/24	0	Initial issue. Separate Urethane foam manual attachment and Continuity checking from Taping assembly process.				D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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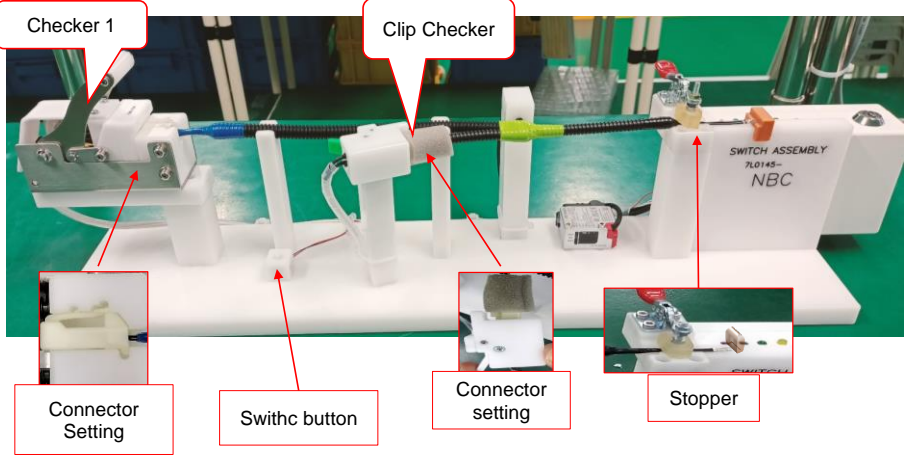
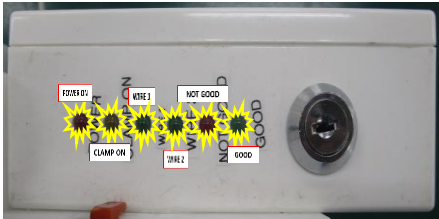

PARTS:		1. Gray Urethane foam t=4; 75mm X 30mm 2. Assy parts	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<p>Urethane foam manual attachment to connector</p> <p>Step 1: Identify the right facing to attached the foam</p> <p>Step 2: Get the Urethane foam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

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<b>PARTS:</b>	1. Assy parts		JIG:	1. Assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Clamp assy  Assembly (Continuity checking)	<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>7283-1138 (W)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>7282-1028 (W)</b> to <b>Clip checker</b> then lock. Last, set the <b>B-B wires</b> to the stopper jig then pull down the toggle clamp.</p><p>2. Check if all <b>LED</b> light for <b>Power ON</b>, <b>Wire1 &amp; Wire2</b> was <b>ON</b>. If encounter abnormality or hearing <b>NG</b> buzzer, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process.</p><p>3. Press the switch button using right hand. <b>GO</b> buzzer will be heard.</p><p>4. Conduct <b>POINT CHECKING</b> before removing the harness from the jig.</p></div> <div></div>	n/a	<div></div> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Make sure no gap between the terminal and stopper.</b></p>

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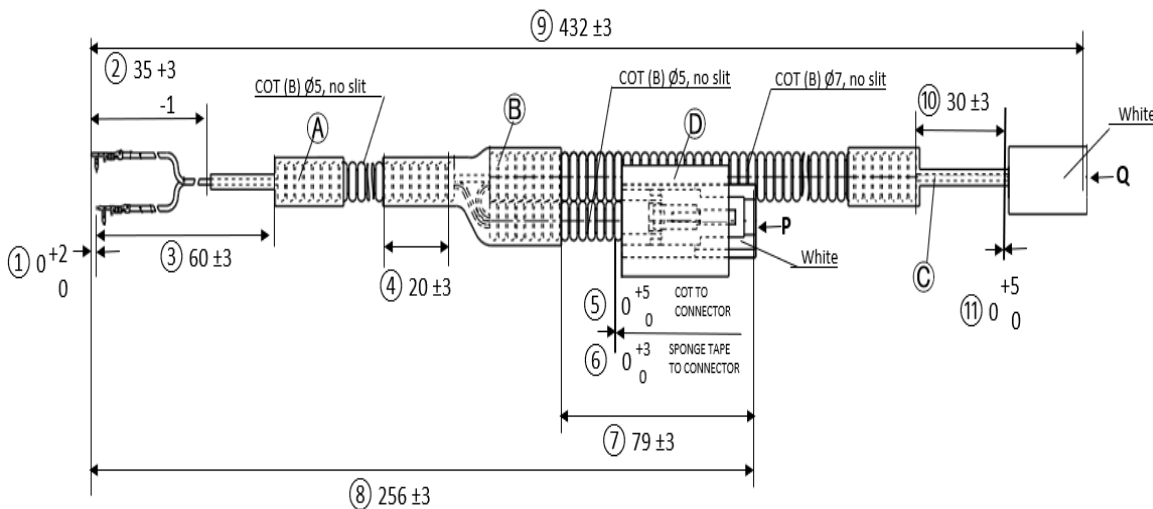

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp assy	Measurement	<div><div>MEASURING TAPE</div></div>  <div><b>NOTE:</b> (A) - Taping (B) (B) - Taping (LG) (C) - Taping (L) (D) - Sponge Tape (GR)</div>	<div><div>MEASURING TAPE</div></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 <i>WI-PRO-ASY-056</i> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b></div>	1. No wrong dimension

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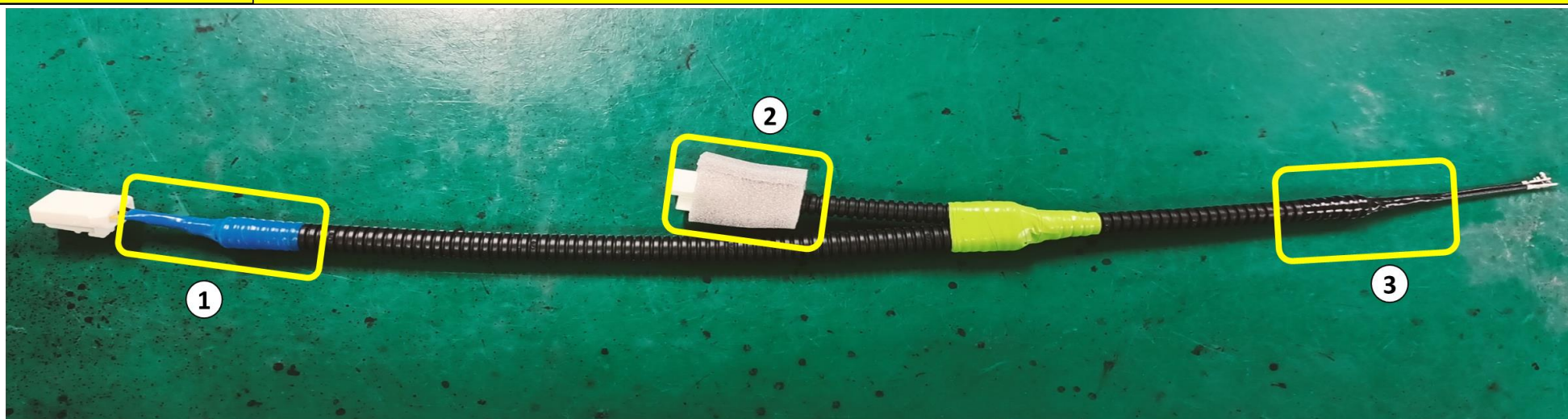
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0145-7020A****1****No Missing Tape  
(Blue Tape)****2****No Missing  
Urethane Foam****3****No Missing Tape  
(Black Tape)**

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