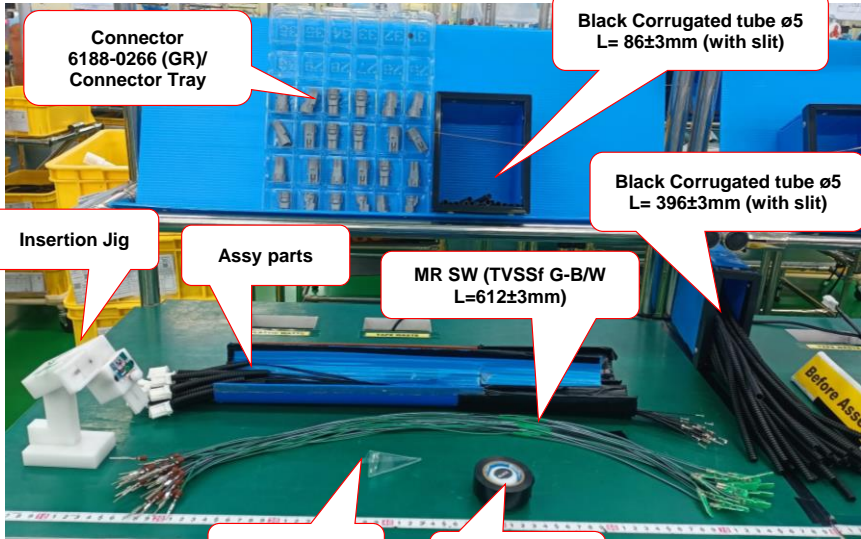



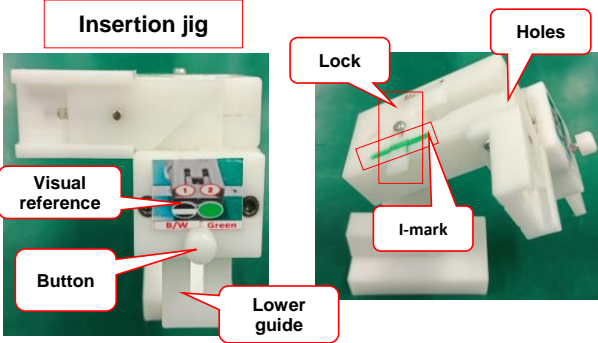

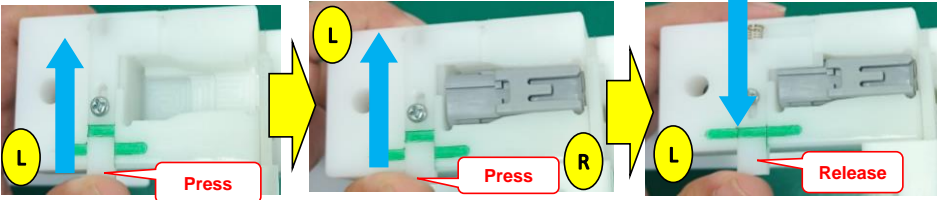
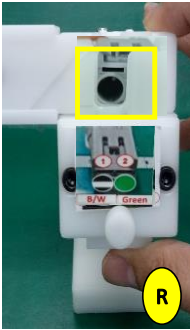
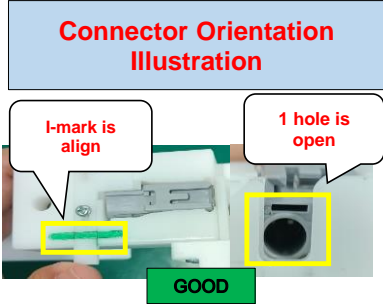
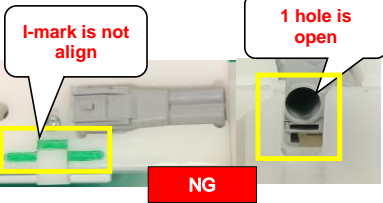
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU	Document No.:	WI-ENG-PDE-770A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 7

PARTS:		1. All parts: Assy parts; Connector 6188-0266 (GR); MR SW (TVSSf G-B/W L=612±3mm); Black corrugated tube (w/ slit) ø5 L=86±3mm; Black corrugated tube (w/ slit) ø5 L=396±3mm; Black tape		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1 Table lay-out		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.).</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document references: 1. Refer to WI-ENG-PDE-818 for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
01/26/24	1	Change from Pre-launch to Masspro. Inclusion of table lay-out. Transfer some process to Offline and Clamp assembly process. Additional Important reminders/Note/s in Half wrap taping due to customer claim countermeasure. Change COT tube length from L=88±3mm to L=86±3mm and L=394±3mm to L=396±3mm (with slit) due to encountered maximum dimension in harness.				D.Castillo	C. Villanueva	A. Arañes	n/a
12/01/23	0	Initial issue				D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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	WORK INSTRUCTION				Effectivity Date:	January 26, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU	Document No.:	WI-ENG-PDE-770A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 7


PARTS:	1. Connector 6188-0266 (GR)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector setting to insertion jig 6188-0266 (GR)	<div><div></div><div></div><div></div><div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the Connector 6188-0266 (GR) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p></div><div><p>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be open.</p></div></div></div>			n/a	<div><div></div><div></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p></div></div>		


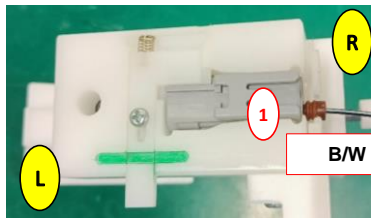
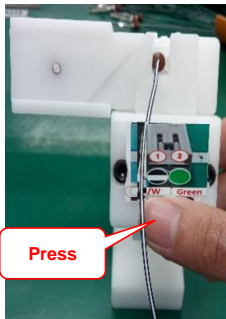
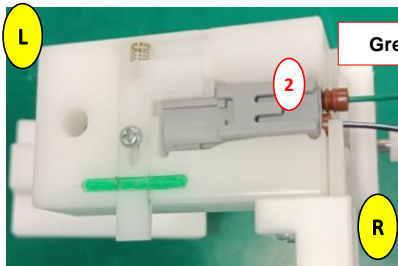
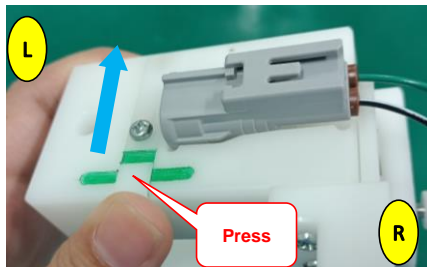

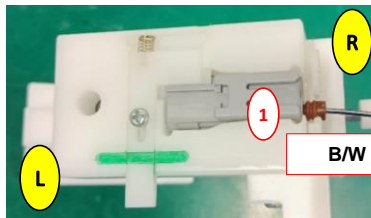
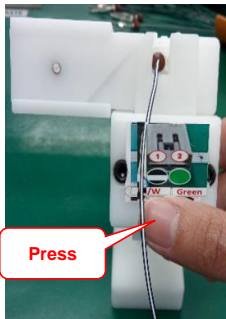
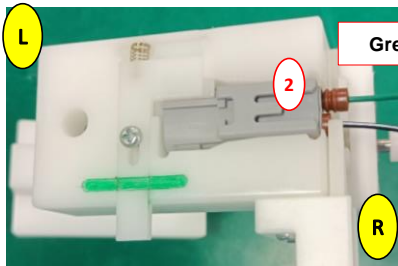
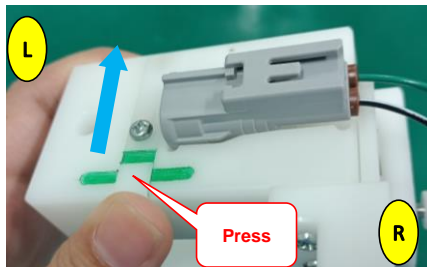

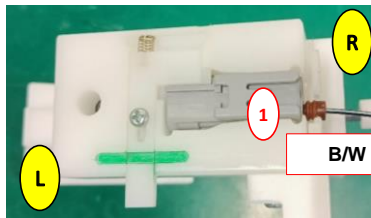
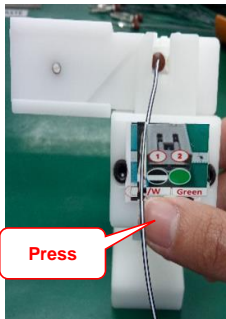
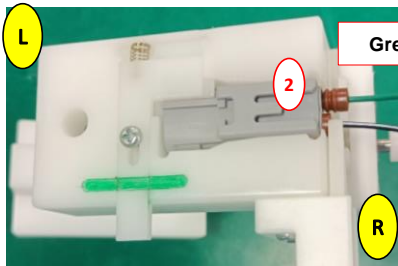
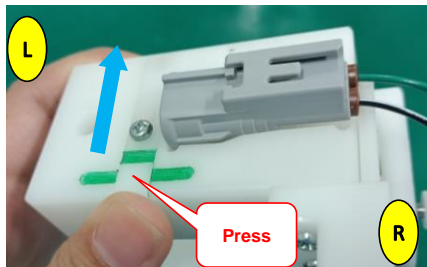

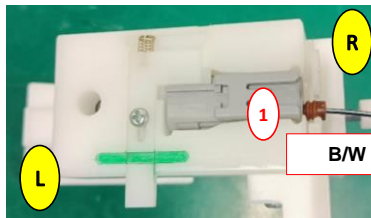
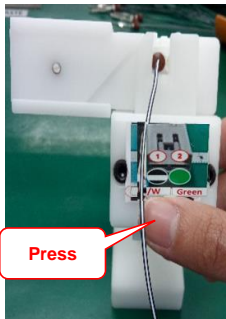
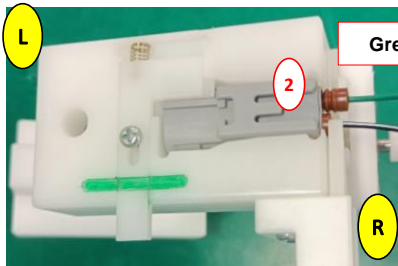
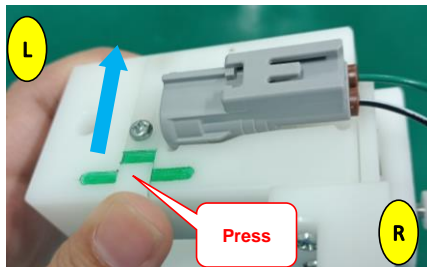

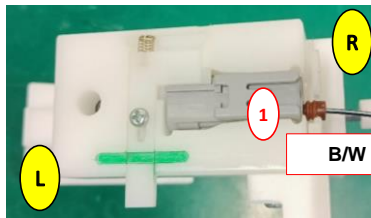
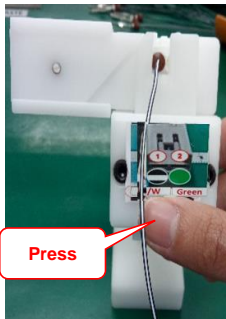
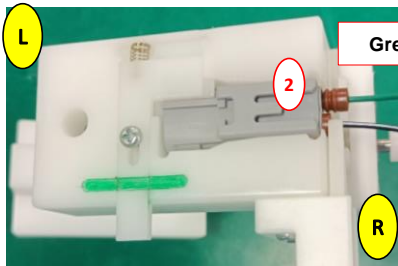
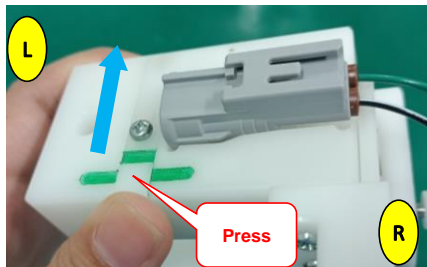

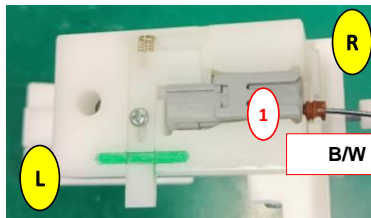
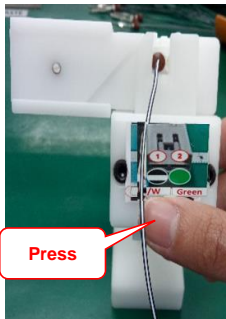
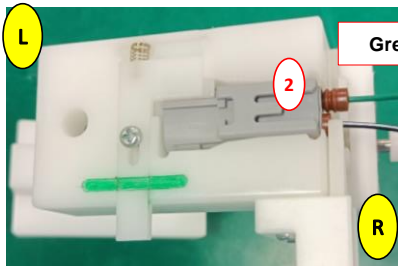
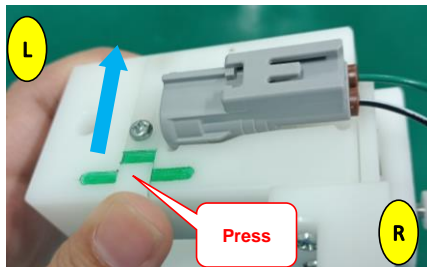

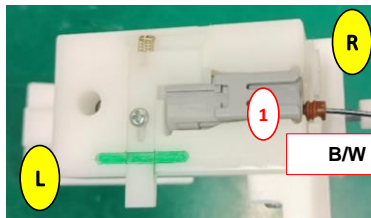
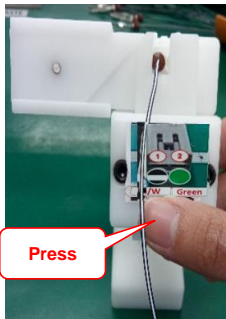
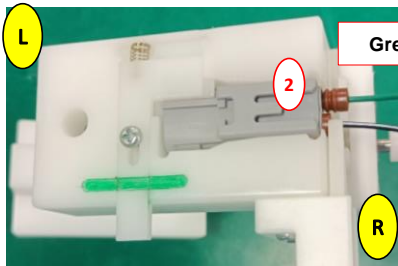
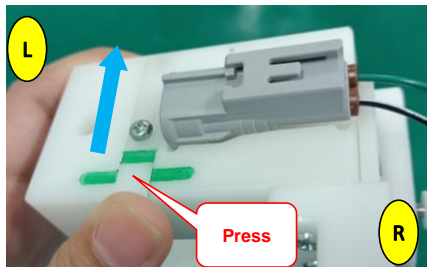

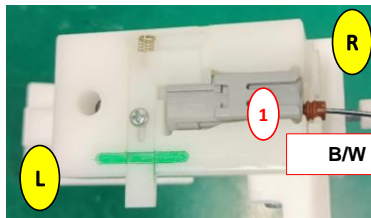
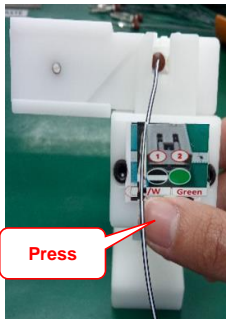
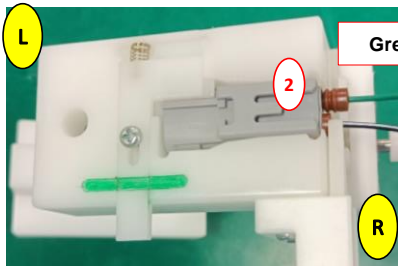
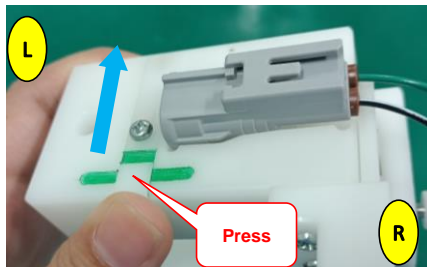

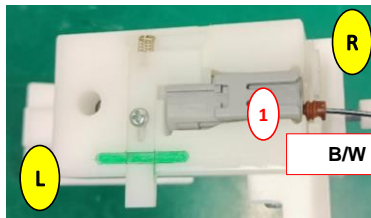
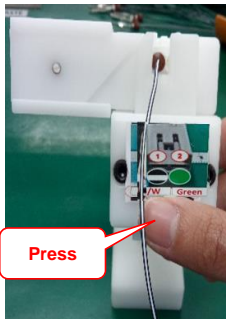
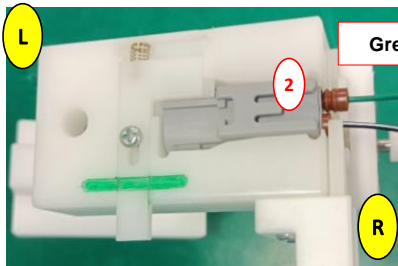
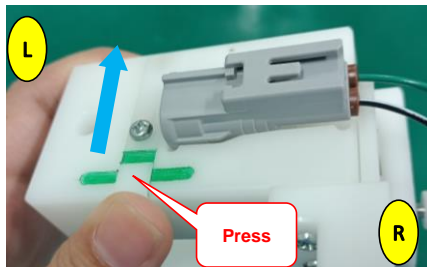

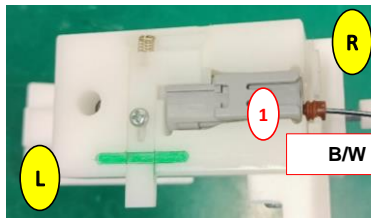
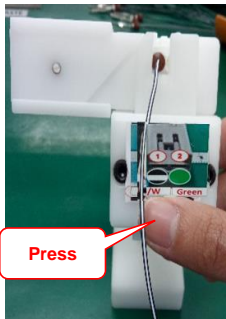
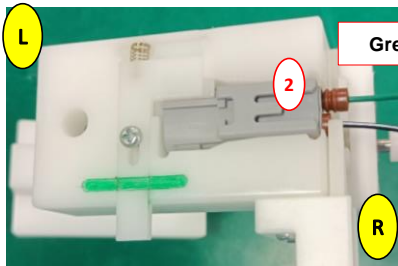
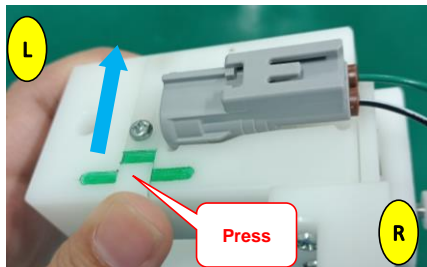

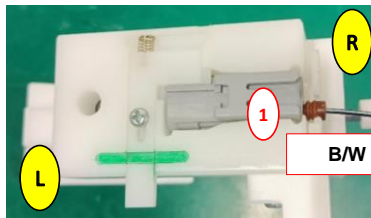
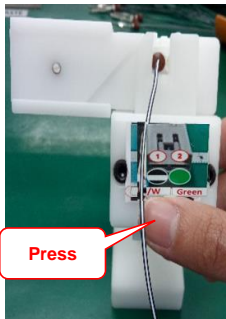
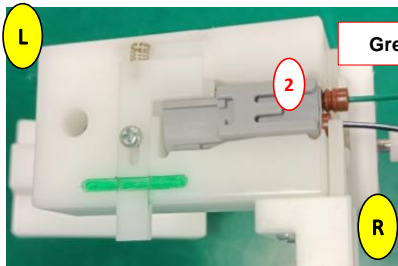
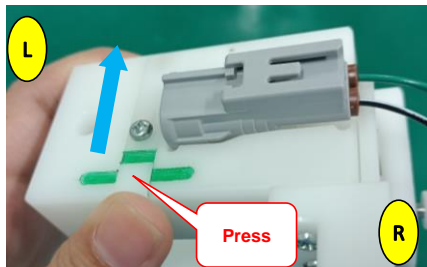

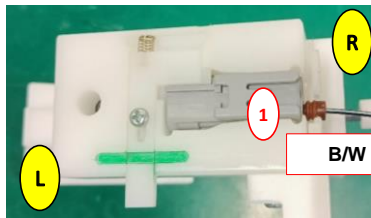
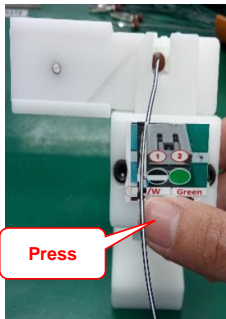
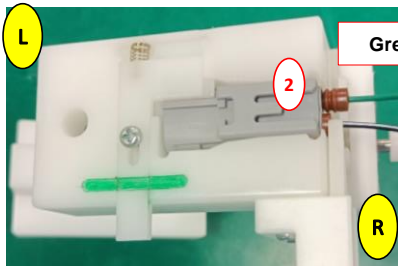
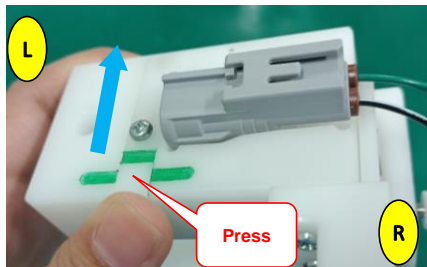

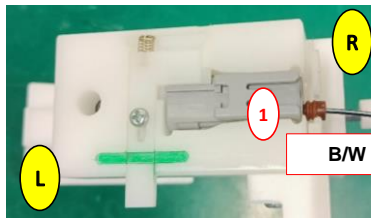
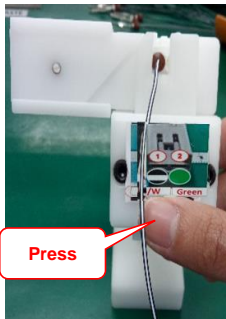
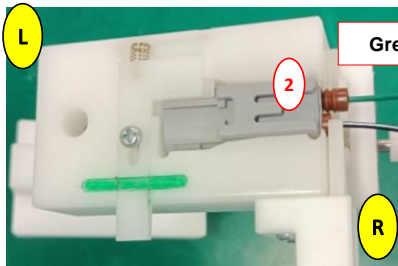
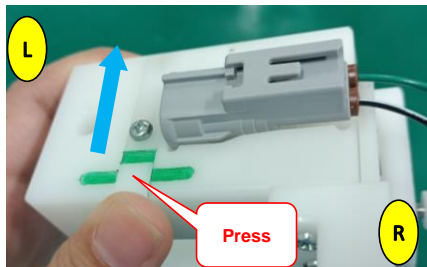

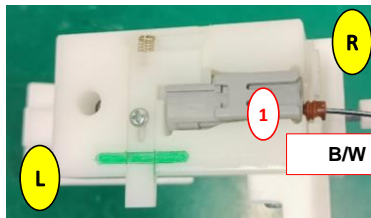
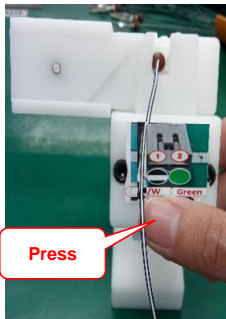
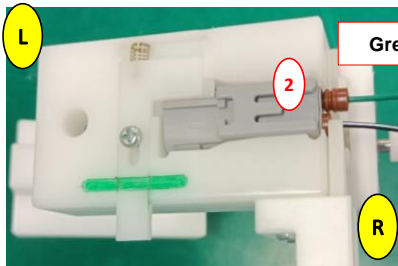
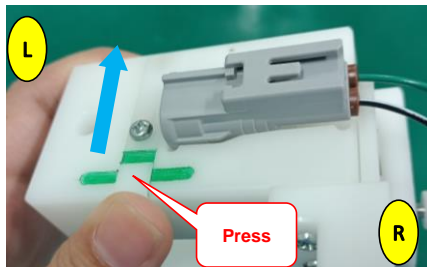

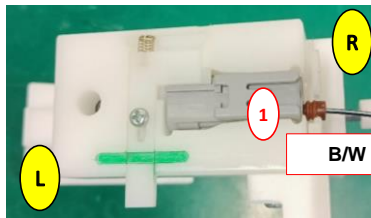
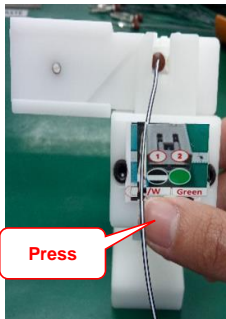
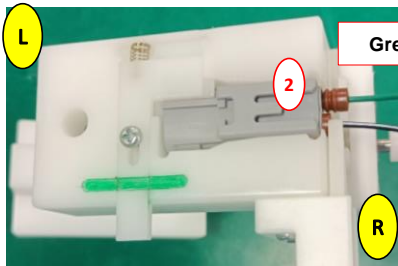
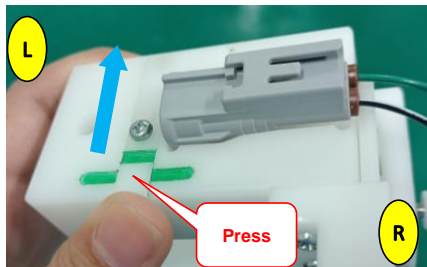

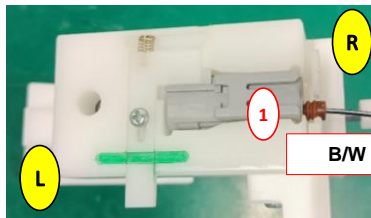
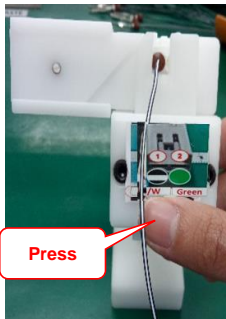
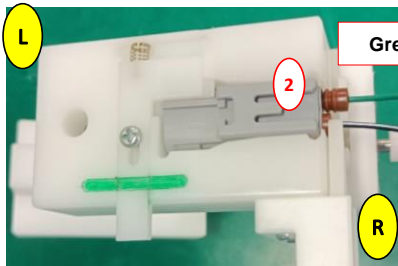
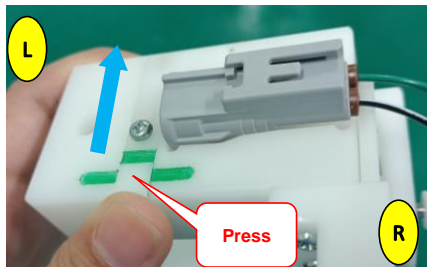

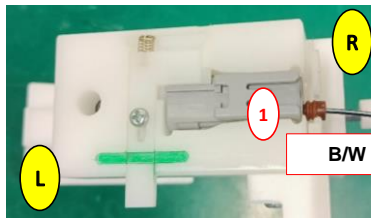
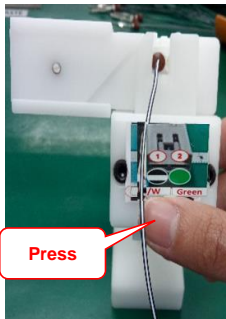
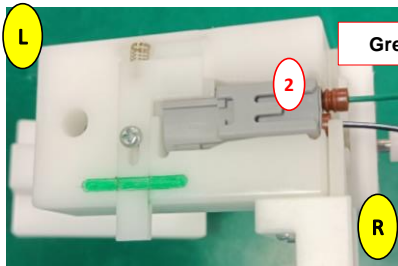
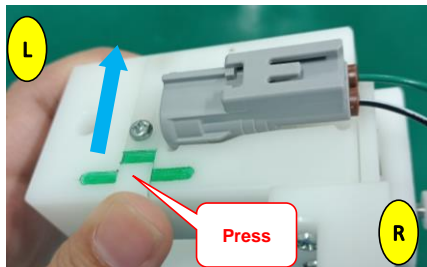

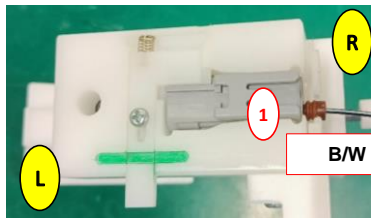
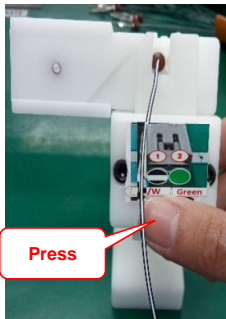
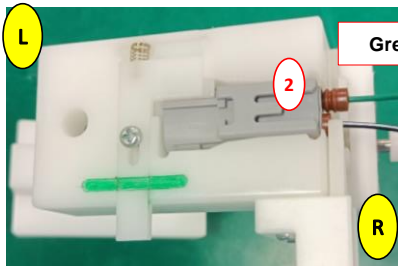
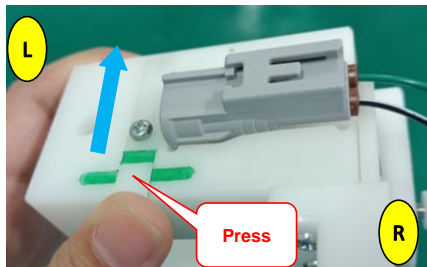

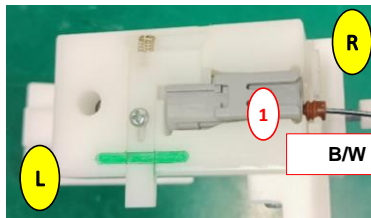
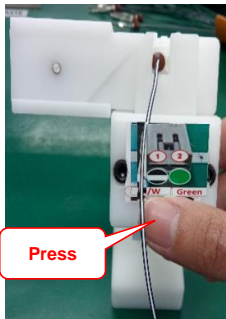
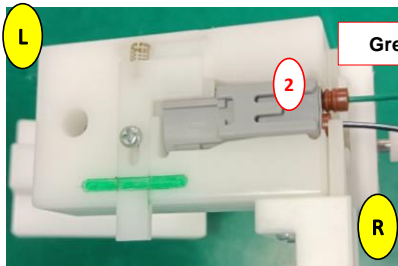
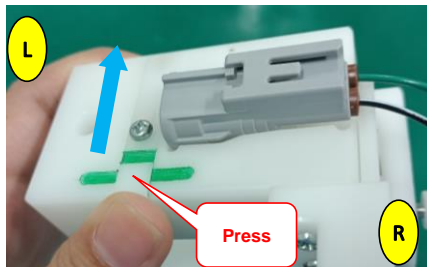

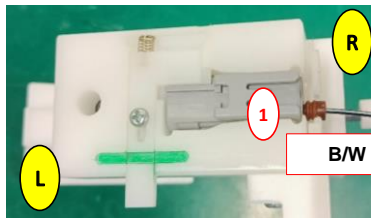
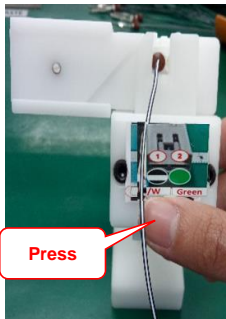
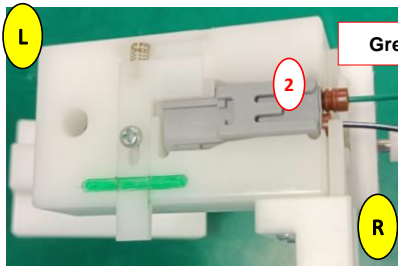
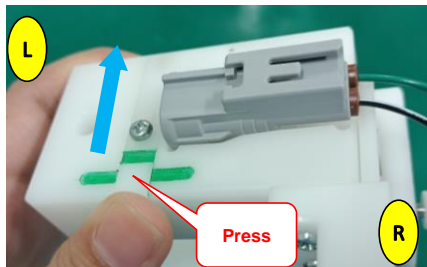

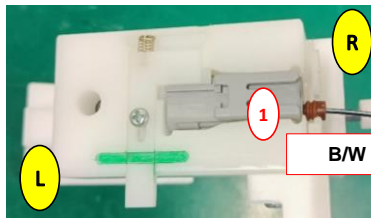
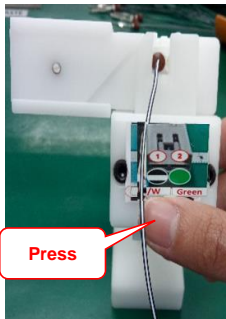
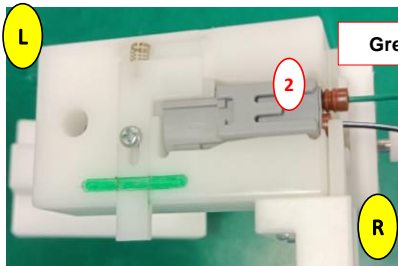
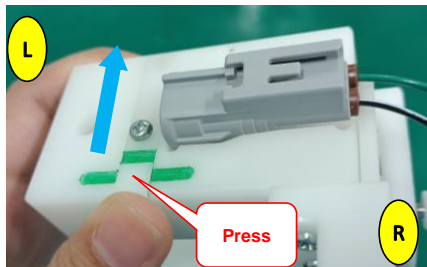

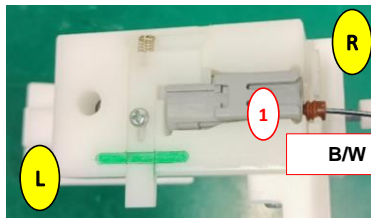
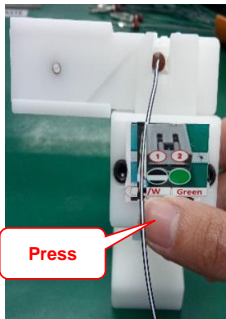
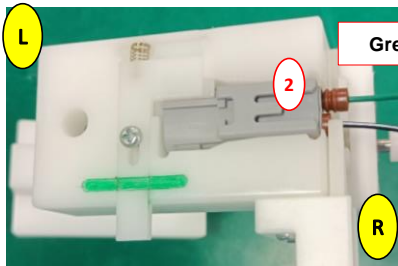
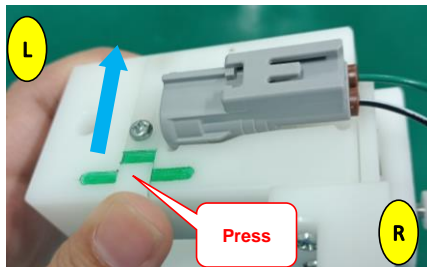

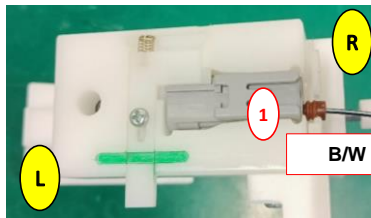
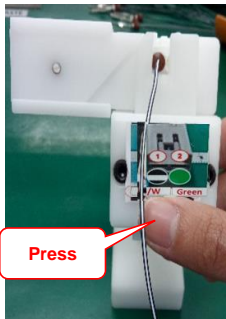
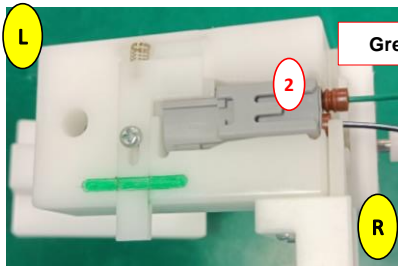
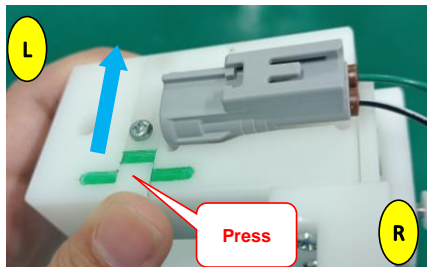

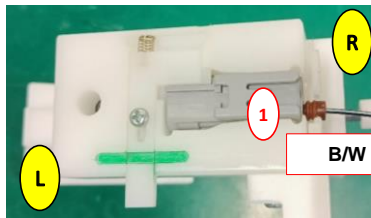
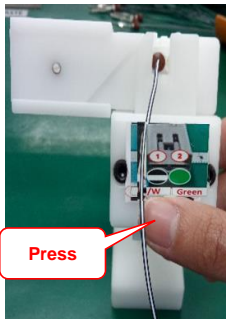
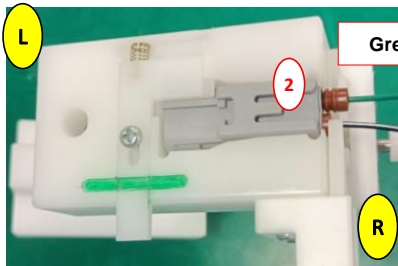
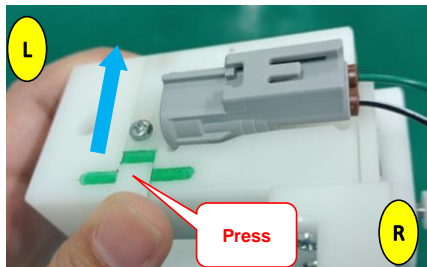

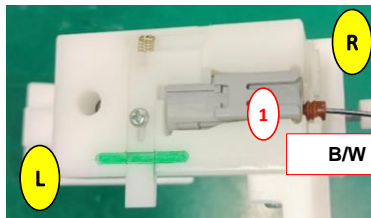
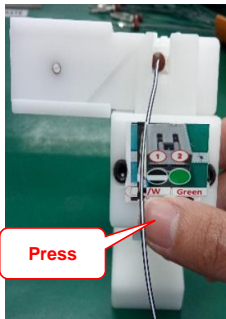
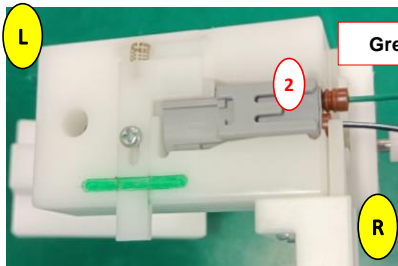
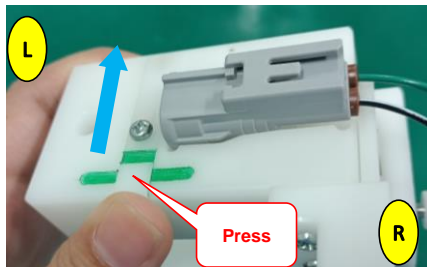

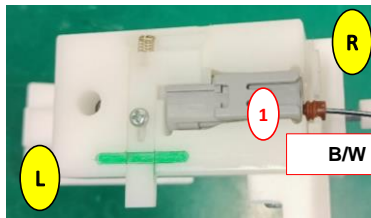
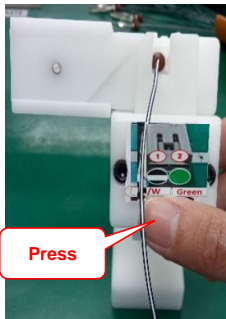
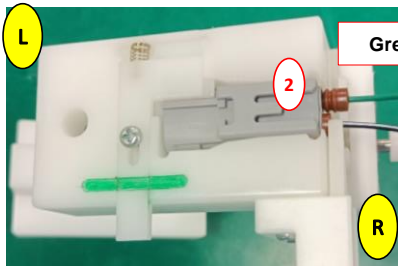
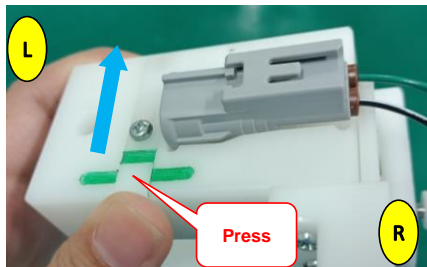

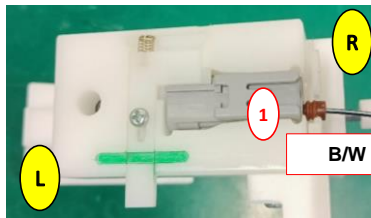
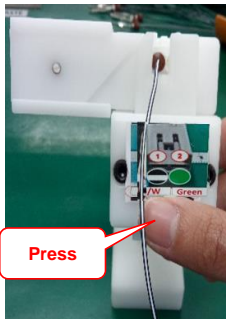
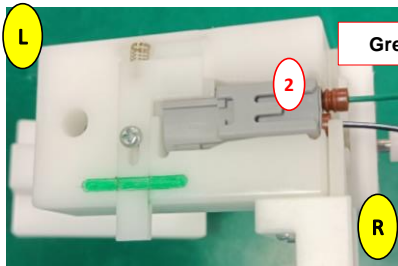
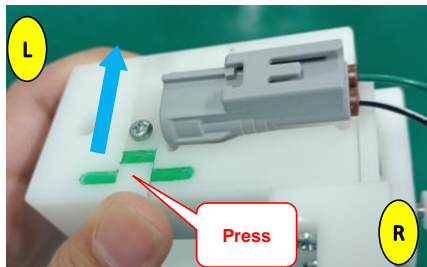

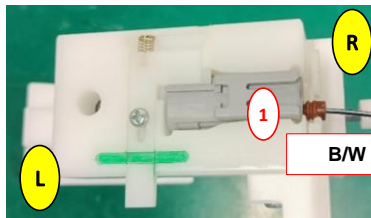
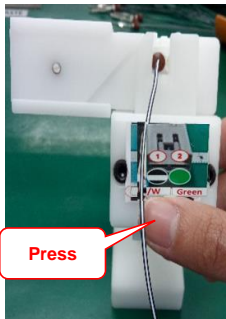
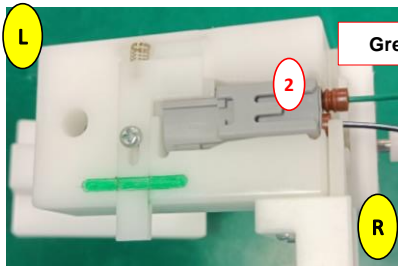
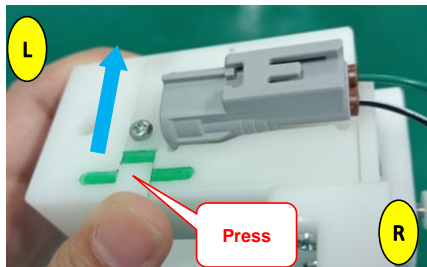

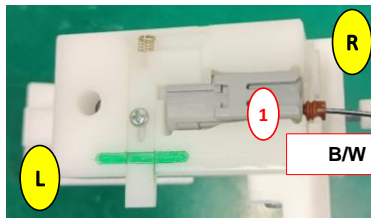
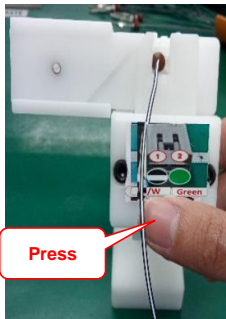
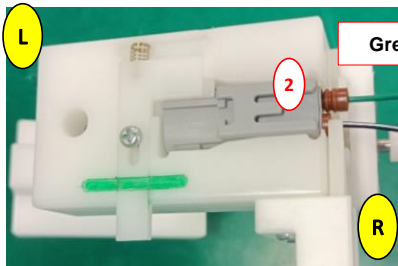
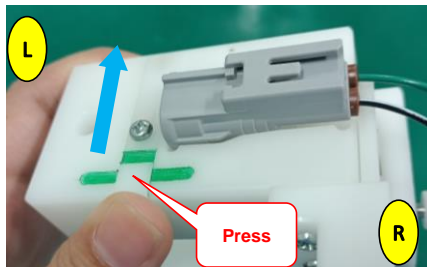

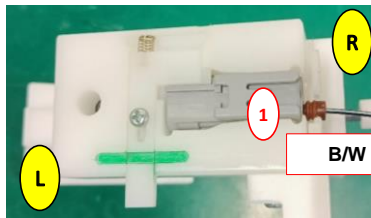
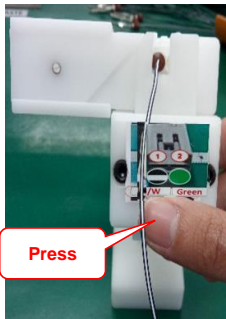
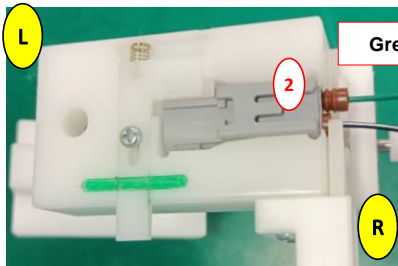
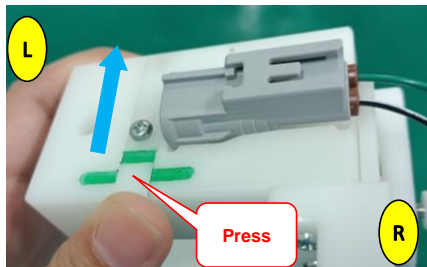

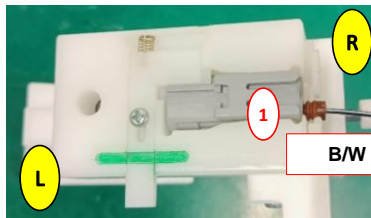
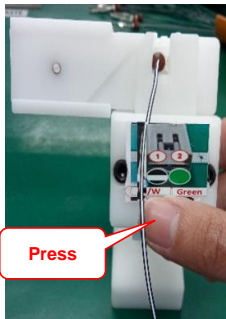
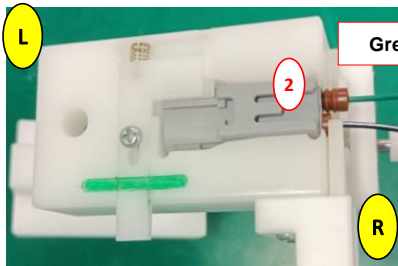
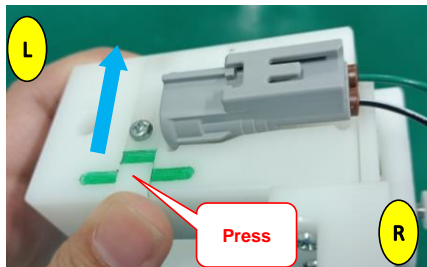

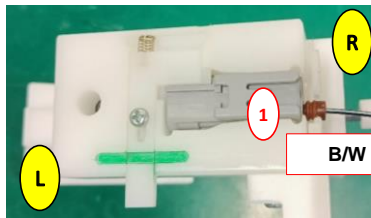
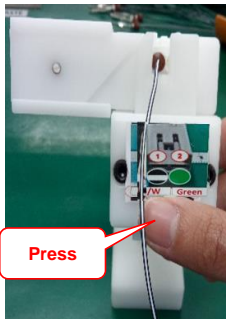
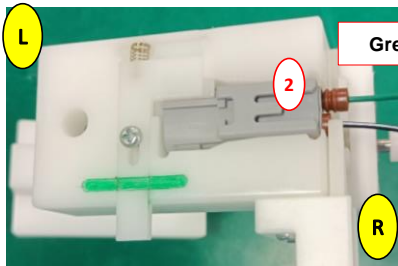
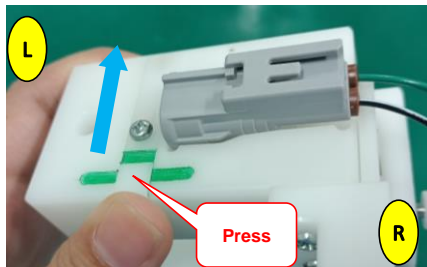

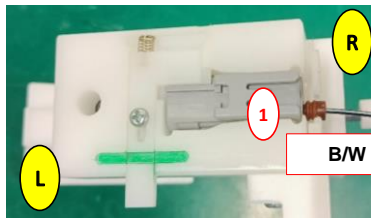
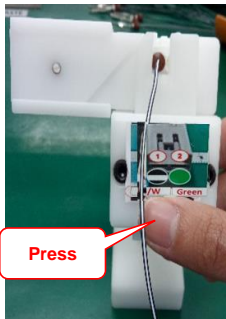
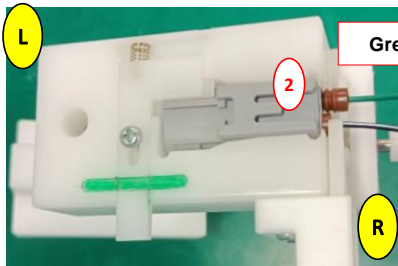
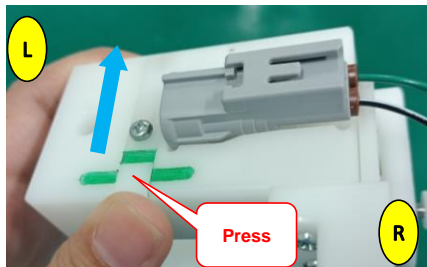

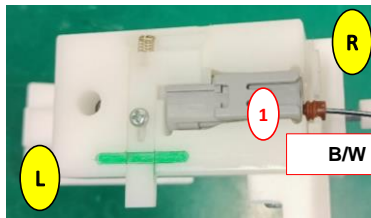
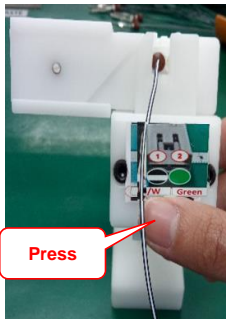
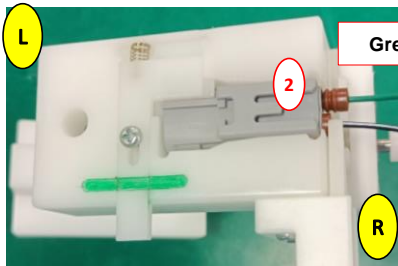
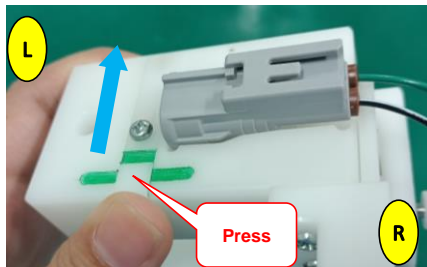

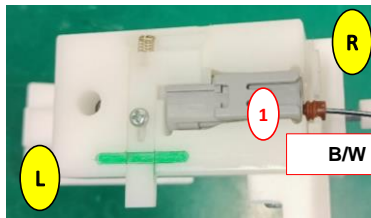
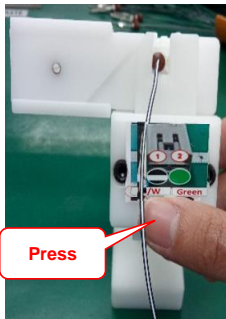
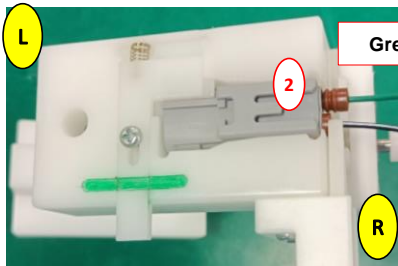
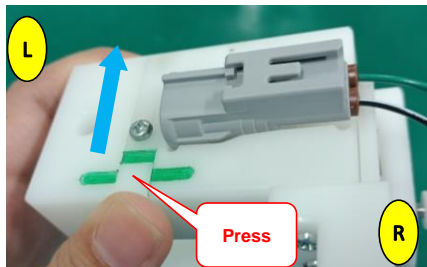

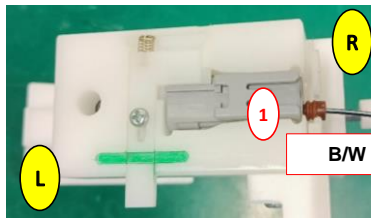
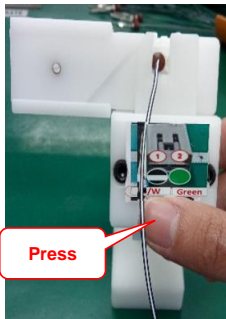
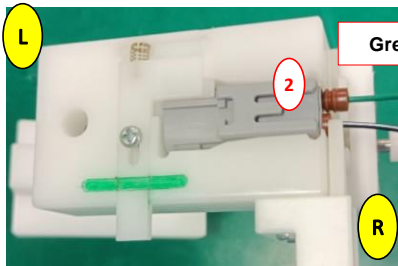
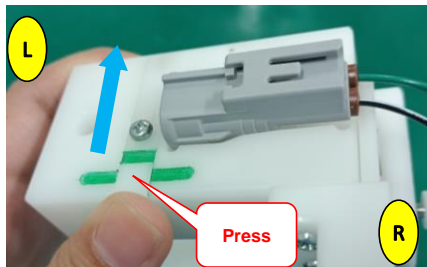

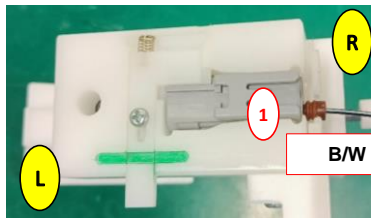
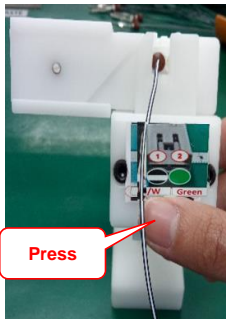
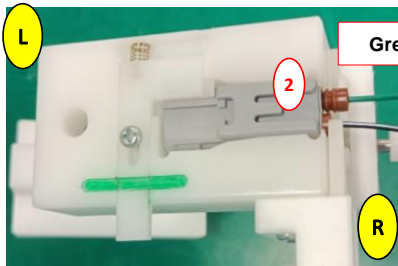
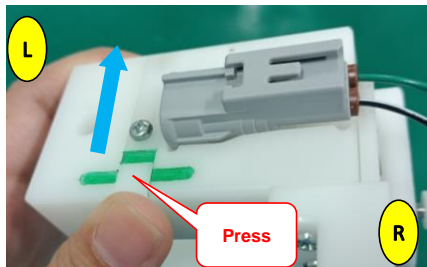

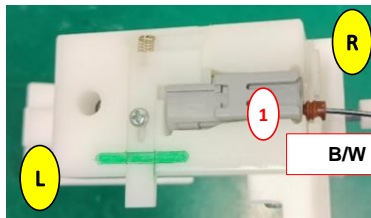
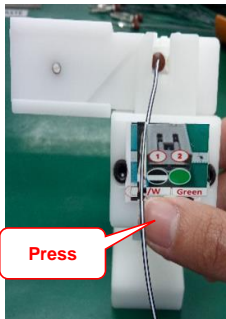
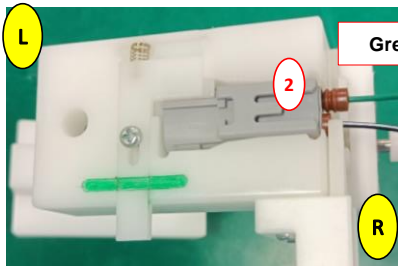
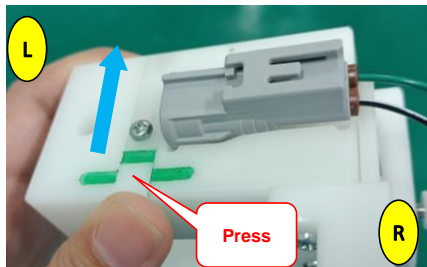

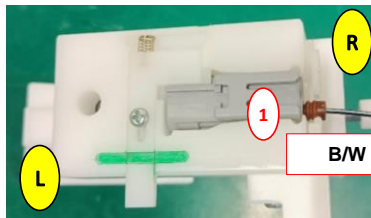
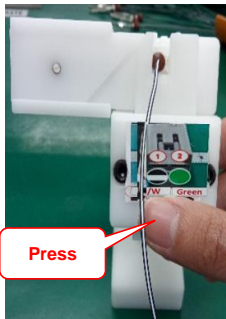
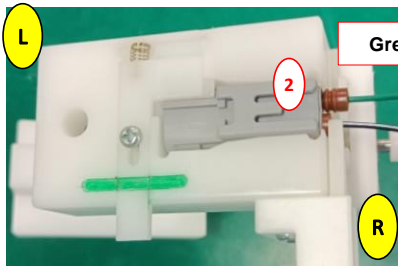
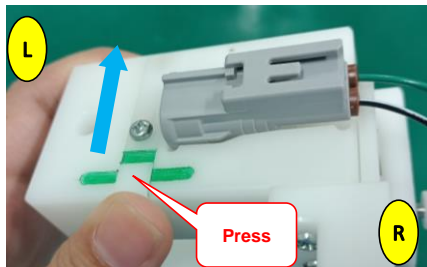

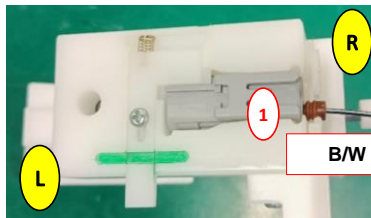
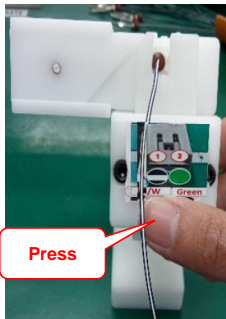
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		WORK INSTRUCTION				Effectivity Date:		January 26, 2024		
		TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU		Document No.:		WI-ENG-PDE-770A	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.:	3 of 7

PARTS:		1. MR SW CP (TVSSf G-B/W L=612±3mm)				JIG:		1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
3	P1	<div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div> <div><div><p>Wire facing</p></div><div><p>1. Get Black/White wire then insert to terminal slot 1 using right							
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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 26, 2024

Validity Date:

n/a

Model code/Part number:

ES1

/

7M0515-7021

Customer:

TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-770A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1

1. Assy parts
2. Black corrugated tube (w/ slit) $\phi 5$ L=86 \pm 3mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

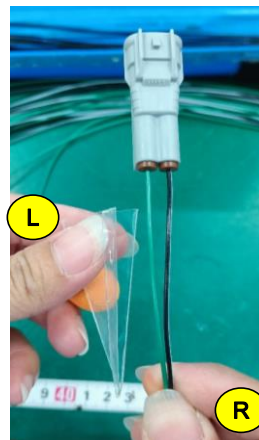
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QUALITY POINTERS

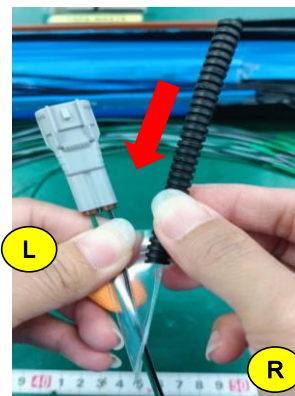
4

P1

Wire insertion to Black corrugated tube (w/ slit) $\phi 5$ L=86 \pm 3mm



1. Hold the COT adaptor using left hand then insert the wires using right hand.



2. Hold the COT adaptor with wires using left hand, get the **Black corrugated tube (w/slit) $\phi 5$ L=86 \pm 3mm** using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (**same timing**) using both hands. Make sure all wires are inserted.

COT ADAPTOR



1. No wrong use of parts
2. No wires left between COT with slit

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Effectivity Date:

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ES1

/

7M0515-7021

Customer:

TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-770A

Purpose:

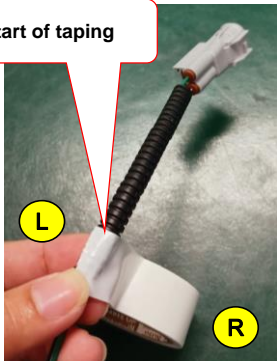
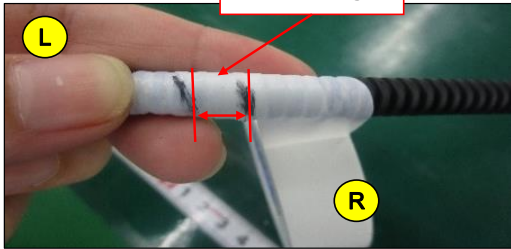
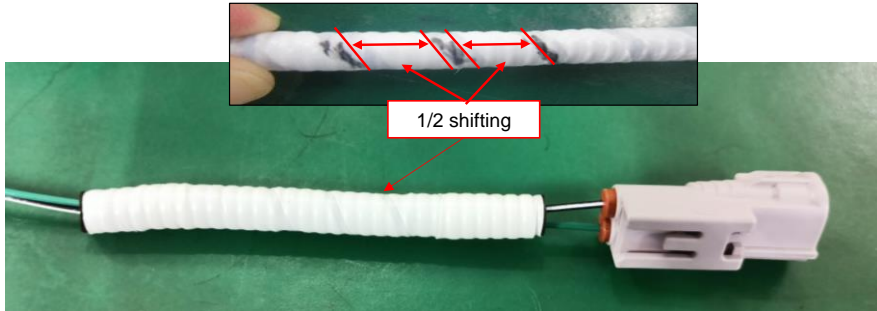

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


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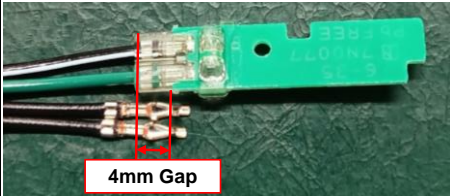



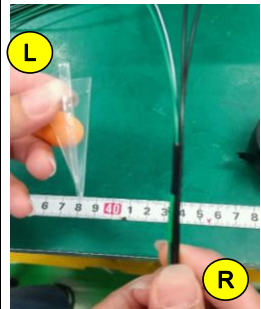
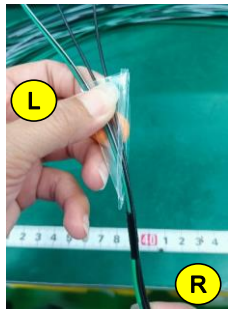
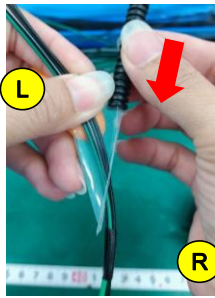

PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Half-wrap Taping 1	<div><div><div>Start of taping</div><div></div></div><div><div>1/2 shifting</div><div></div><div>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 winds and then cut the tape.</div></div><div><div></div><div>1/2 shifting</div><div>3. Check the taping condition.</div></div></div> <div><div>MEASURING TAPE</div><div></div></div>		<div><div>1</div><div>Important reminders/Note/s 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used <u>WHITE TAPE</u> to easily visualize the tape shifting, but actual should be <u>BLACK TAPE</u>. 3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</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</div></div>	

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	WORK INSTRUCTION				Effectivity Date:	January 26, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU	Document No.:	WI-ENG-PDE-770A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	6 of 7

PARTS: 1. Assy parts 2. Black tape [1pc]	<div style="display: flex; align-items: center;"> <div style="border: 1px solid black; padding: 2px; margin-right: 5px;">1</div> 3. Black corrugated tube (w/slit) ø5 L=396±3mm </div>			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Spot taping	<div style="display: flex;">   </div> <div style="display: flex; margin-top: 10px;"> <div style="flex: 1;"> 1. Fix the hotmelted wire and terminal pointed tip using both hands (4mm gap). </div> <div style="flex: 1;"> 2. Hold the wires using left hand, get the Black tape using right hand then make 2 windings of tape using both hands. <i>Note: Position of spot taping must be right beside Green tape.</i> </div> </div> <div style="display: flex; margin-top: 10px;">  <div style="flex: 1; margin-left: 10px;"> 3. Check the taping condition and terminal alignment. </div> </div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape
7	<div style="display: flex; align-items: center;"> <div style="border: 1px solid black; padding: 2px; margin-right: 5px;">1</div> Wire insertion to Black corrugated tube (w/ slit) ø5 L=396±3mm </div>	<div style="display: flex;">    </div> <div style="display: flex; margin-top: 10px;"> <div style="flex: 1;"> 1. Hold the COT adaptor using left hand then insert the wires using right hand. </div> <div style="flex: 1;"> 2. Hold the COT adaptor with wires using left hand, get the Black corrugated tube (w/slit) ø5 L=396±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted. </div> </div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">COT ADAPTOR</div> 	1. No wrong use of parts 2. No wires left between COT with slit

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7M0515-7021

Customer: TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-770A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

n/a

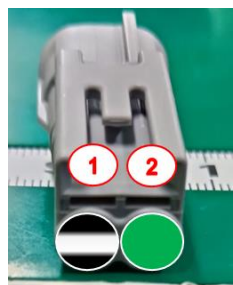
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n/a

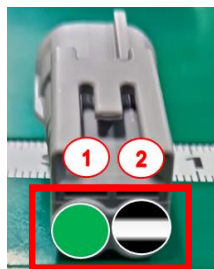
QUALITY CHECKPOINTS

P1

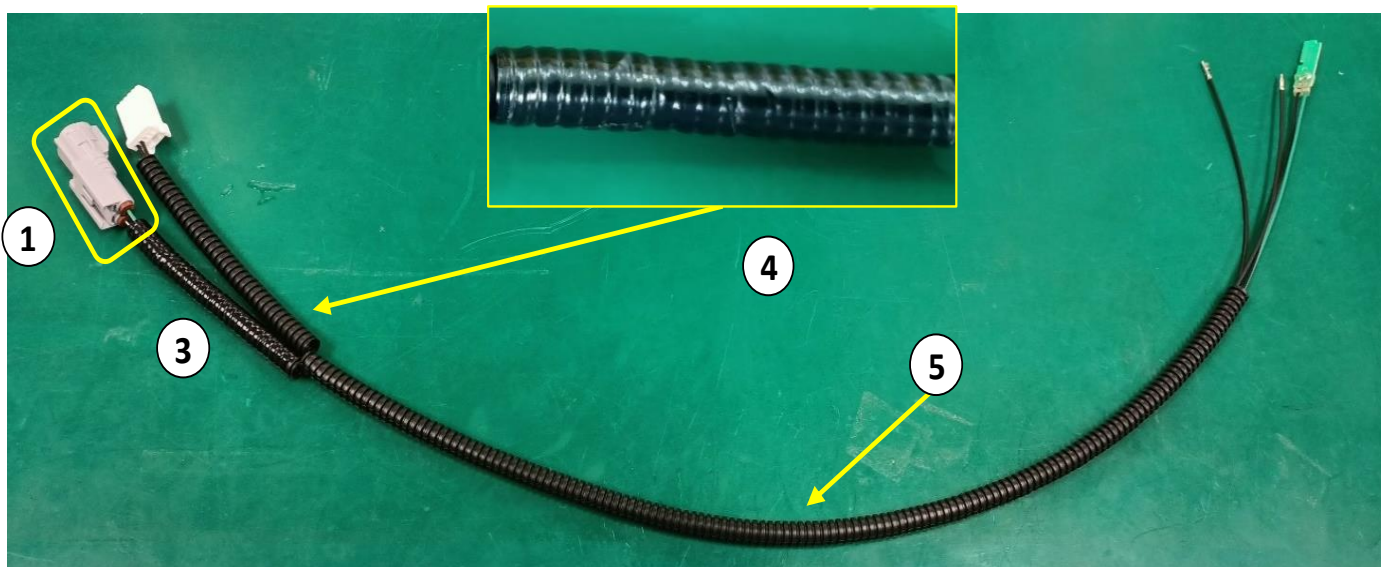
7M0515-7021



GOOD



NO GOOD



1 No WRONG INSERT

2 No TERMINAL BACKING OUT

3 No MISSING TAPE

4 CHECK HALF WRAP TAPING

5 No MISSING COT



GOOD



NO GOOD

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