

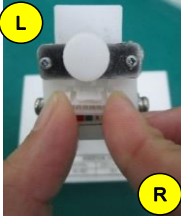
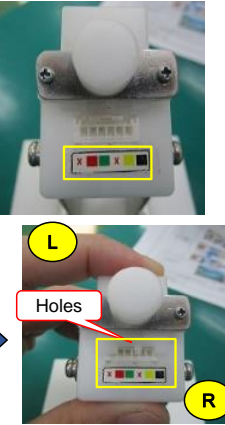



	<b>WORK INSTRUCTION</b>				Effectivity Date:	November 06, 2024			
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>GC7 / 15E210-0091</b>	Customer: <b>TRP</b>	Car Model: <b>SUBARU-LEGACY</b>	Document No.:	WI-ENG-PDE-107A		
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	6	Page No.:	1 of 6

PARTS:		1. Connector 505570-0600 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 505570-0600 (W) <div style="border: 1px solid black; padding: 5px; margin: 10px auto; width: 100px; text-align: center;">HIGH</div>	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <b>INSERTION JIG</b>   </div> <div style="text-align: center;">   <b>CONNECTOR ORIENTATION</b> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;">   <b>BEFORE PRESSING</b> </div> <div style="text-align: center;">   <b>AFTER PRESSING</b> </div> </div> <div style="margin-top: 10px;"> <p>1. Get the connector 505570-0600 and set it to jig using right hand.  <i>Note: Follow the connector orientation.</i></p> <p>2. Press the lock button using left index finger. You will notice the holes that needs to be inserted are only open.</p> </div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>          Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)       </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>          1. Maintain and always practice 5's.          2. Personal things on the workplace is prohibited. Keep it in your locker.       </div> <div style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

Revision History				Prepared by				Reviewed by		Approved by		Noted by	
11/06/24	6	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Separate Connector setting and Wire insertion process. Change from 1 piece to 3 piece flow due to process improvement. Change term from Vinyl tube to SV tube (Vinyl). Inclusion of CAR MODEL "SUBARU-LEGACY".			D.Castillo	C. Villanueva	A. Arañes	n/a					
10/27/22	5	Improve Quality pointers; Reminders/Notes and references on page no.1 to 4 due to document improvement.			M. Ariola	C. Villanueva	A. Shimamura	A. Arañes					
07/01/21	4	Remove validity date			J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				n/a	
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 03, 2019			

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

November 06, 2024

Model code/Part number:

GC7 / 15E210-0091

Customer:

TRP

Car Model:

SUBARU-LEGACY

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



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### PARTS:

1. AVSS 0.3 Black, Yellow, Green and Red L= 170±2mm

JIG:

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

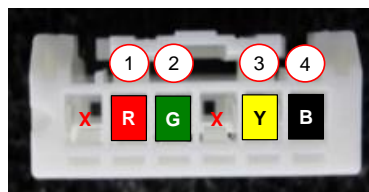
2

P1

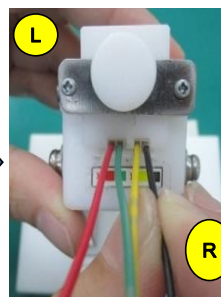
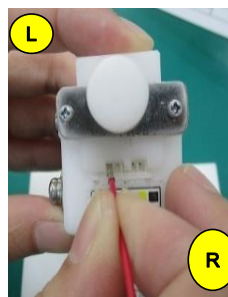
MEDIUM

Wire insertion to  
Connector  
505570-0600 (W)

#### WIRE SEQUENCE FROM LEFT TO RIGHT

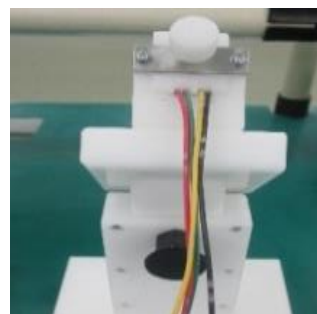
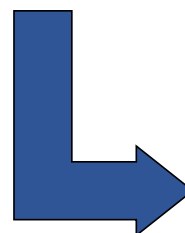


#### TERMINAL FACING



1. Get **R wire** and insert to terminal slot using right hand. Conduct pull-push-pull-push. Repeat the process for **G-Y and B wires**.

*Note: Follow wire sequence based on visual reference attached to jig.*



N/A

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deform terminal
5. No wrong terminal facing

#### Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.


#### Document reference/s:


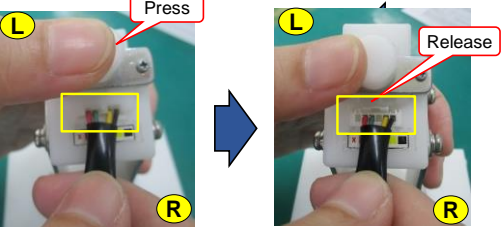

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>November 06, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>GC7 / 15E210-0091</b>		Customer: <b>TRP</b>	Car Model: <b>SUBARU-LEGACY</b>	Document No.:	<b>WI-ENG-PDE-107A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	3 of 6

<b>PARTS:</b>		1. Assy parts 2. Black SV tube (Vinyl) ø6 L=112±3mm		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	P1 <div>6 MEDIUM</div> Wire insertion to Black SV tube (Vinyl) ø6 L=112±3mm	<div><p>1. Get the SV tube (Vinyl) ø6 L=112±3mm using right hand. Insert the wires on the tube using left hand.</p></div> <div><p>2. Press the unlock button using left thumb to release the lock. Then slowly remove the harness from jig.</p></div> <div><p>3. Check the wire insertion.</p></div>		n/a	1. No wrong use of parts 2. Terminal claw must be seen in connector holes

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**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**November 06, 2024**

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**GC7 / 15E210-0091**Customer: **TRP**Car Model: **SUBARU-LEGACY**

Validity Date:

n/a

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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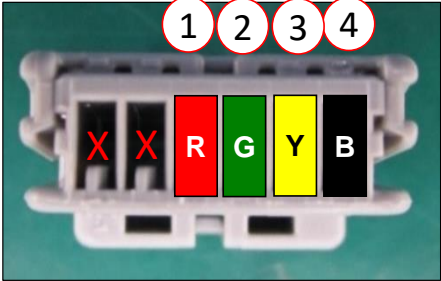

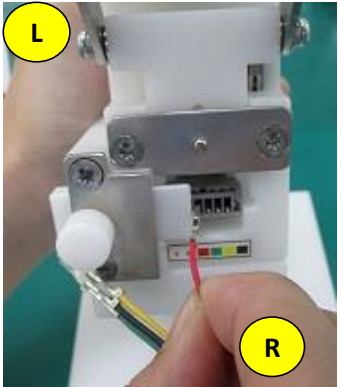
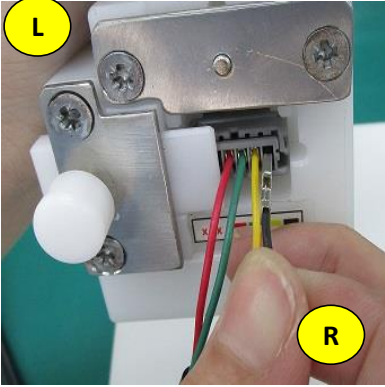
PARTS:		1. Connector 7282-5978-40 (GR)		JIG:	1. Insertion jig with locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 <div><div>6</div><div>HIGH</div></div> <div>Connector setting to insertion jig 7282-5978-40 (GR)</div>	<div><div>Insertion/locking Jig</div><div><div><div>Jig lock</div><div>Locking mechanism</div><div>Visual reference</div><div>Slider</div><div>Adjustable stand lock</div><div>Push button</div></div><div><div>Connector orientation</div><div><div>Connector lock</div></div></div><div><div><div><div>L</div><div>R</div></div><div>1. Get the connector using right hand and insert to jig.</div></div><div><div><div>Press</div><div>R</div></div><div>2. Press the slider using right thumb after insertion.</div></div></div></div></div> <div><div><div>Pressure gauge standard setting 0.15~0.25MPa</div></div></div>		<div><div>Important reminder/Note/s:</div><div>1. Always make sure to open and close the air pressure before and after use.</div><div>2. Perform the daily equipment inspection check before and end of shift</div><div><div>Document reference/s</div><div>1. Refer to F-PRO-ASY-029 for daily equipment inspection checksheet.</div></div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div>	

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	Model code/Part number: <b>GC7 / 15E210-0091</b>		Customer: <b>TRP</b>	Car Model: <b>SUBARU-LEGACY</b>	Document No.:	<b>WI-ENG-PDE-107A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	5 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig with locking jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
5	<div><div>6</div><div>MEDIUM</div><div>Wire Insertion to Connector 7282-5978-40 (GR)</div></div>	<div><div>WIRE SEQUENCE FROM LEFT TO RIGHT</div><div></div><div></div><div>TERMINAL FACING</div><div></div><div></div><div>1. Get the <b>R wire</b> and insert to terminal slot using right hand. Conduct pull-push-pul-push. Repeat the process for <b>G-Y and B wires</b>. <i>Note: Follow wire sequence based on visual reference attached on jig.</i></div></div>			n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong terminal facing</div> <div><b>Important reminders/Note/s:</b>  1. <b>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b> 2. <b>Please hold the wire near terminal during insertion.</b> 3. <b>Insertion of wire must be from left to right.</b></div> <div><b>Document reference/s:</b>  1. <b>Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b> 2. <b>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>		


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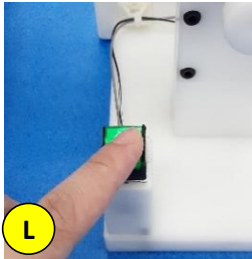
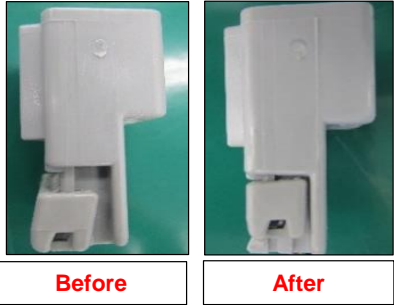
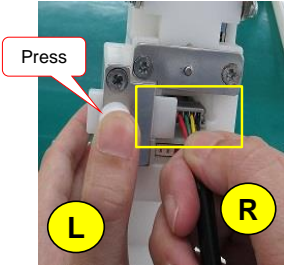
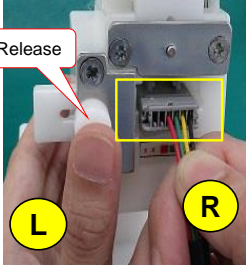
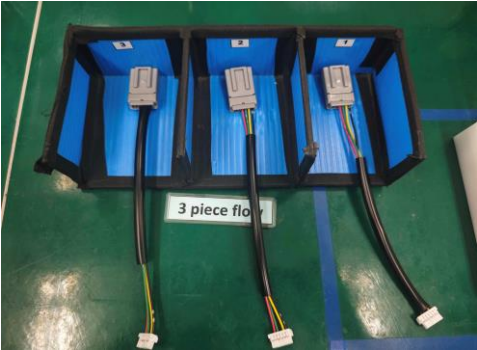
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<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig with locking jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
6	<div><div>6</div><div>LOW</div></div> Connector lock	<div><div><div>1. Press the SW button using left finger to lock the connector.</div></div><div><div>Before</div><div>After</div></div><div><div><div>Press</div></div><div><div>Release</div></div><div>2. Press the unlock button to release the lock using left thumb. Then slowly remove the harness from jig. Check the lock if properly pressed.</div></div></div>			n/a	<b>Important reminders/Note/s:</b>  <i>1. Refer to VR-QAD-QAC-004 for Damage/Scratch on Connector Limit.</i>  1. No unlock/half-locked connector 2. No skipped process	
7	<div><div>6</div></div> Pass WIP to P2	<div><div>3 piece flow</div></div> <div>1. Put WIP to WIP holder.</div>			n/a	<b>Important reminders/Note/s:</b>  <i>1. Three (3) Piece flow</i>  1. No WIP overflow	

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