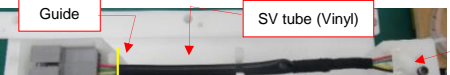
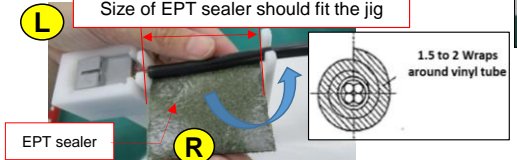
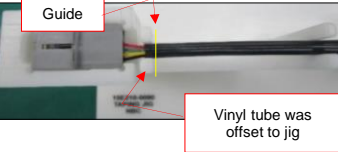
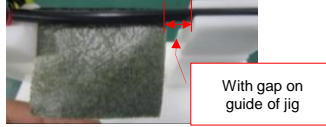





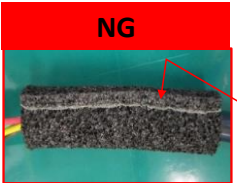



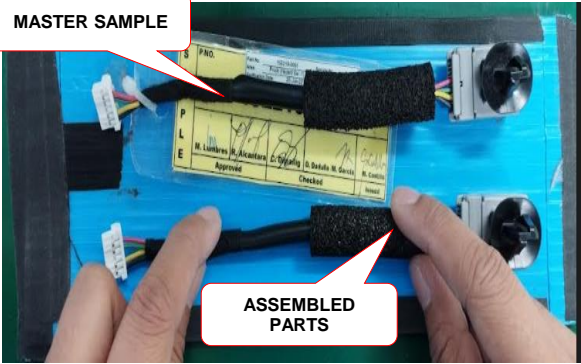
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: November 06, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: GC7 / 15E210-0091		Customer: TRP	Car Model: SUBARU-LEGACY	Document No.: WI-ENG-PDE-107C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 5 Page No.: 1 of 3			

PARTS: 1. EPT Sealer No.686 60x52x3 2. Assy parts		JIG: 1. EPT sealer attachment jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P3 Foam attachment <div style="border: 1px solid black; padding: 5px; display: inline-block;"> 6 MEDIUM </div>	<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;">  <p>1. Set the harness to attachment jig and lock the Receiver base lock. Make sure vinyl tube was not offset to jig.</p> </div> <div style="width: 50%; text-align: center;"> <div style="background-color: red; color: white; padding: 5px; font-weight: bold;">NO GOOD SETTING OF HARNESS TO JIG</div> </div> <div style="width: 50%;">  <p>2. Get the EPT sealer and attach it initially at the bottom part of the vinyl tube. (See illustration). Slowly wrap the EPT sealer on the vinyl tube in a clockwise direction. Make 1.5 to 2 wraps around the vinyl tube. <i>Note: Do not stretch or pull the EPT sealer</i></p> </div> <div style="width: 50%; text-align: center;"> <div style="background-color: red; color: white; padding: 5px; font-weight: bold;">NO GOOD ATTACHMENT OF EPT SEALER</div> </div> <div style="width: 50%;">  </div> <div style="width: 50%;">  </div> </div> <p>3. After attachment of EPT sealer, make 5 times slowly pushing from left to right using left thumb.</p> <div style="display: flex; justify-content: space-around;">      </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		<div style="background-color: red; color: white; text-align: center; padding: 5px; font-weight: bold;">NG</div>  <p>Peel-off EPT sealer</p>	<p>Document reference/s:</p> <p>1. Please refer to WI-ENG-PDE-108 for Continuity test.</p> <p>2. Please refer to WI-ENG-PDE-130 for End Tape Process.</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
11/06/24	5	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Inclusion of CAR MODEL "SUBARU-LEGACY". Update measurement.	D.Castillo	C. Villanueva	A. Arañes	n/a			
10/27/22	4	Improve Quality pointers; Reminders/Note and references on page no.1 and 2; Improve Work procedure/illustration on process no. 2 due to process improvement.	M. Ariola	C. Villanueva	A. Shimamura	A. Arañes			
07/01/21	3	Remove validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 03, 2019	

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	WORK INSTRUCTION			Effectivity Date:	November 06, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: GC7 / 15E210-0091		Customer: TRP	Car Model: SUBARU-LEGACY	Document No.: WI-ENG-PDE-107C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	2 of 3

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P3 Visual inspection/ By two's inspection	<div> <div>1. Check the double lock, terminal condition and presence of clamp.</div> <div>2. Check the EPT sealer attachment.</div> <div>3. Check the taping condition.</div> <div>4. Check the presence of terminal claw on connector holes.</div> <div>5. Compare to Master sample by tapping.</div> </div> <div>  <p>ACTUAL PRODUCT</p> </div> <div>  <p>MASTER SAMPLE</p> </div> <div>  <p>MASTER SAMPLE</p> <p>ASSEMBLED PARTS</p> </div>		<p>1. No skip checking during inspection</p> <p>Document reference/s:</p> <p>1. Please refer to WI-ENG-PDE-108 for Continuity test.</p> <p>2. Please refer to WI-ENG-PDE-130 for End Tape Process.</p>	

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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.:

WI-ENG-PDE-107C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

5

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div>6</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Measurement	<div>MEASURING TAPE</div> <div></div> <div><div><div>A-A</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>

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