


	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-199A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		7	Page No.: 1 of 3

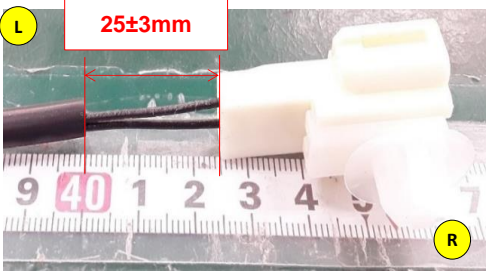

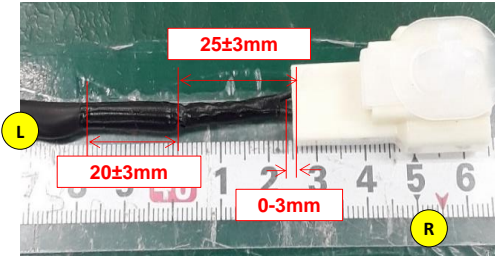

PARTS:		1. Assy parts; Black tape		JIG:		n/a	
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">7</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P1	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;">TABLE LAY-OUT</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-ENG-PDE-558 OFFLINE ASSEMBLY PROCESS . 1. No missing parts/tools 2. No excess parts/tools			

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
06/11/24	7	Transfer Taping 2 to P2 (WI-ENG-PDE-199B). Update table lay-out and visual inspection/quality checkpoints. Inclusion of car model "SUBARU-FORESTER".	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes					
04/28/23	6	Inclusion of quality checkpoints.	M.Catapan g	C.Villanueva	A. Arañes	n/a									
11/04/22	5	Improve notes/references and quality pointers in process 1, 2 and 3 as document improvement.	M.Catapan g	J.Loterte	C.Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:		July 16, 2018						

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	Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-199A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	2 of 3

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P1 Taping 1 Black SV tube (Vinyl) to wire near connector	<div><div>1. Hold the SV tube (Vinyl) using left hand then measure from end of tube up to edge of connector 25±3mm using both hands.</div></div> <div><div>2. Get the Black tape using right hand then start taping process using both hands.</div></div> <div><div>3. After taping, check the measurement and taping condition.</div></div>		<div>Measuring tape</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension	

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TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Validity Date:

n/a

Model code/Part number:

ES1 / 7M0503-7020ACustomer: **TRJ**Car Model: **SUBARU-FORESTER**

Document No.:

WI-ENG-PDE-199A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

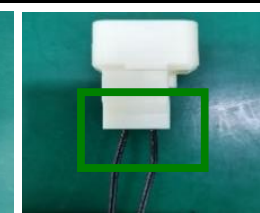
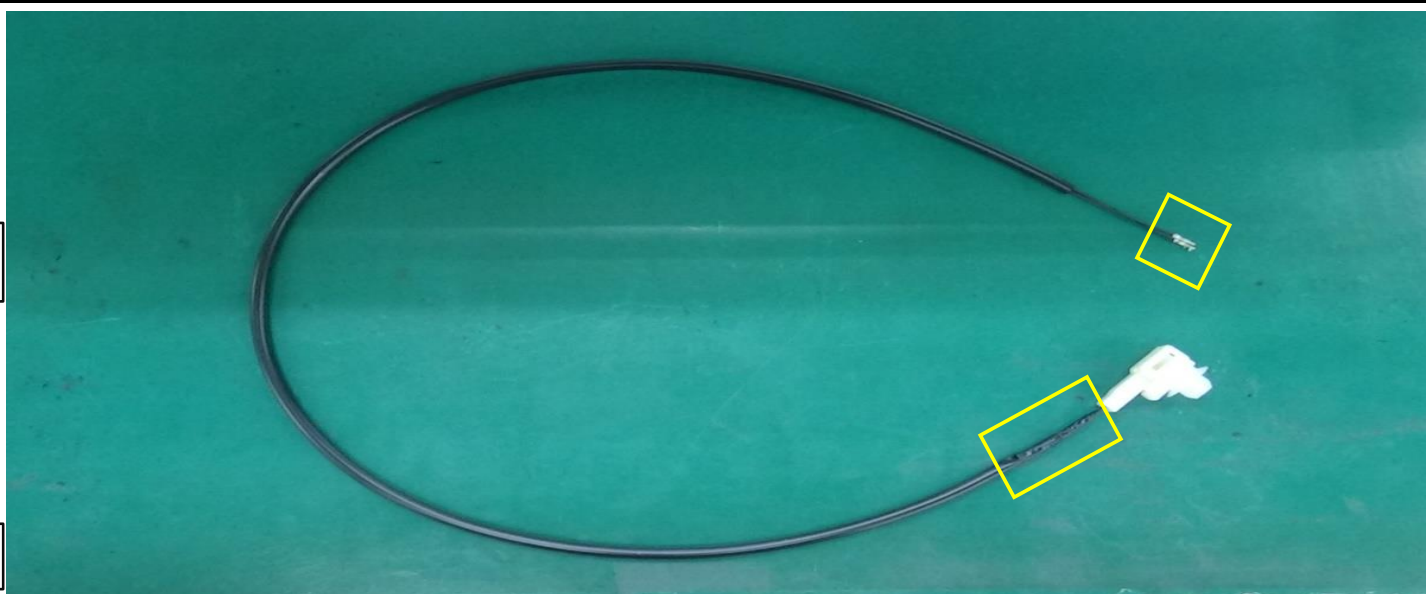
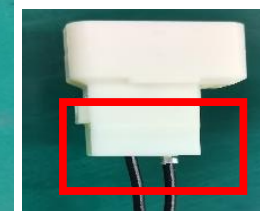
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0503-7020A****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/Halflock Connector****2** No **Missing Tape****3** No **Terminal Backing Out****4** No **Deformed Terminal**

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