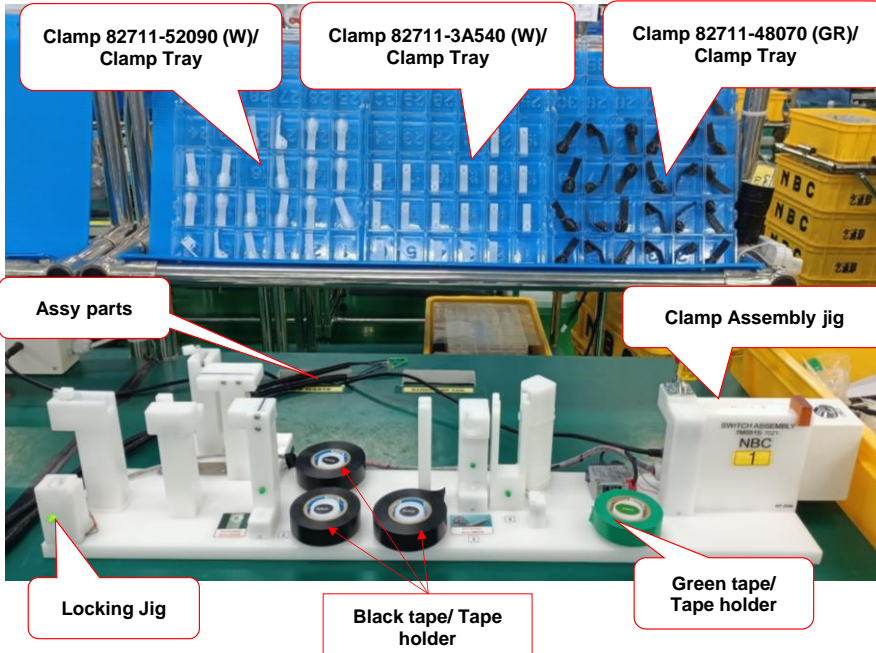
	WORK INSTRUCTION				Effectivity Date:		October 30, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ		Car Model: SUBARU		Document No.: WI-ENG-PDE-1147	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1 Page No.: 1 of 7	


PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-48070 (GR); Black tape [3pcs]; Green tape [1pc]		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div style="text-align: center;"> TABLE LAY-OUT </div> 		<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> 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>		Document references: 1. Refer to WI-ENG-PDE-770A-C for Taping assembly process 1. No missing parts/tools 2. No excess parts/tools	




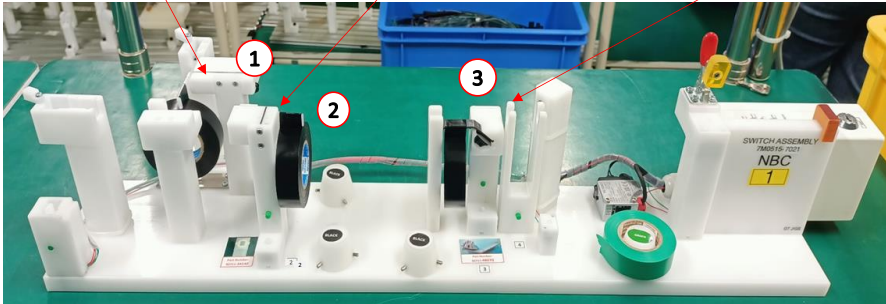
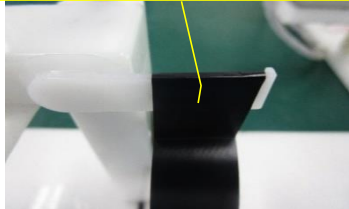


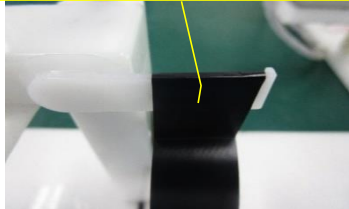


Revision History								Prepared by		Reviewed by		Approved by		Noted by	
10/30/24	1	Change from Pre-launch to Masspro.						D.Castillo	C. Villanueva	A. Arañes	n/a				
10/29/24	0	Initial issue						D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date: October 29, 2024			

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	WORK INSTRUCTION			Effectivity Date:	October 30, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ	Car Model: SUBARU	Document No.: WI-ENG-PDE-1147		
	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. Clamp 82711-52090 (W) 2. Clamp 82711-3A540 (W) 3. Clamp 82711-48070 (GR) 4. Black tape [3pcs] 5. Green tape [1pc]			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div><div> 82711-52090 (W)</div><div> 82711-3A540 (W)</div><div> 82711-48070 (GR)</div><div></div><div>1. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.</div><div>2. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 2 using both hands.</div><div>3. Get 1pc of clamp 82711-48070 (GR) using right hand and set to clamp location 3 using both hands.</div><div>4. Initially attach Black tape to clamp location 1, 2 and 3 using both hands.</div></div> <td>n/a</td> <td><p>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><div>One wind for under tape</div><div></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-52090 (W)</div></div><div><div>NG</div><div> 82711-12A80 (W)</div></div></div></td>		n/a	<p>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <div>One wind for under tape</div> <div></div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-52090 (W)</div></div><div><div>NG</div><div> 82711-12A80 (W)</div></div></div>

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TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-1147

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

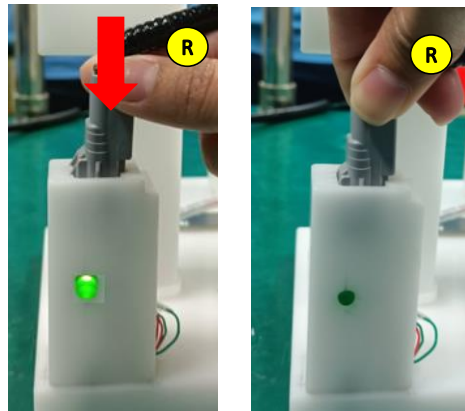
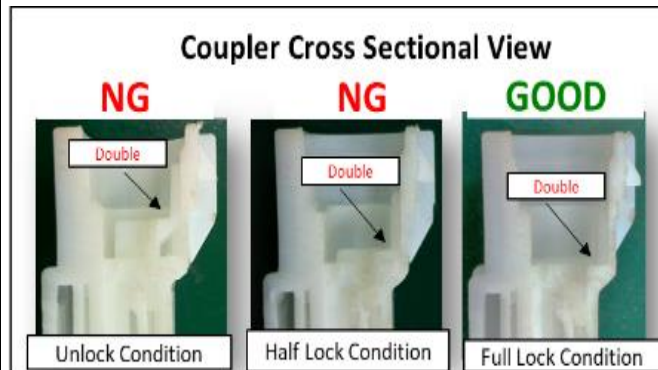



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PARTS:		1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div></div><div>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</div></div> <div><div></div><div> </div></div>		<div>LOCKING JIG</div> 	<div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</div>

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	Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ	Car Model: SUBARU	Document No.: WI-ENG-PDE-1147		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	4 of 7

PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
4	Clamp Assy	<div>Clamp Assembly</div> <div><div>CONNECTOR SETTING</div><div><div>RECEIVER BASE 2</div><div>1</div><div>2</div><div>3</div><div>4</div><div>LOCKING JIG</div><div>RECEIVER BASE 1</div><div>Y-TAPING SETTING</div><div>CONNECTOR SETTING</div><div>STOPPER</div></div><div><p>1. Put the assy into jig. (See above picture for the correct setting). First, set the connector 6188-0266 (GR) to Receiver base 1. Second, set the connector 6098-3810 (W) to receiver base 2 continue to set the harness in jig. Last, set the hotmelted and B wires together within stopper then press by toggle clamp. Continue if the sequence light of location 1 was on.</p><p>2. Checked if all LED light for POWER ON and CLAMP ON was ON. IF encountered problem, STOP and immediately CALL the attention of leader. WAIT for further instruction nad continue the process.</p></div></div> <div><div>Important reminders/Note/s:</div><div><p>1. Make sure no gap between terminal and stopper jig</p><p>2. Make 2-3 windings for Clamp taping</p></div><div><p>1. No wrong use of parts</p><p>2. No wrong use of tape</p><p>3. No damaged clamp</p><p>4. No wrong clamp position</p></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div><div>82711-52090(W)</div></div><div>NG</div><div><div>82711-12A80(W)</div></div></div></div></div>					

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n/a

Model code/Part number:

ES1 / 7M0515-7021B

Customer:

TRJ

Car Model:

SUBARU

Document No.:

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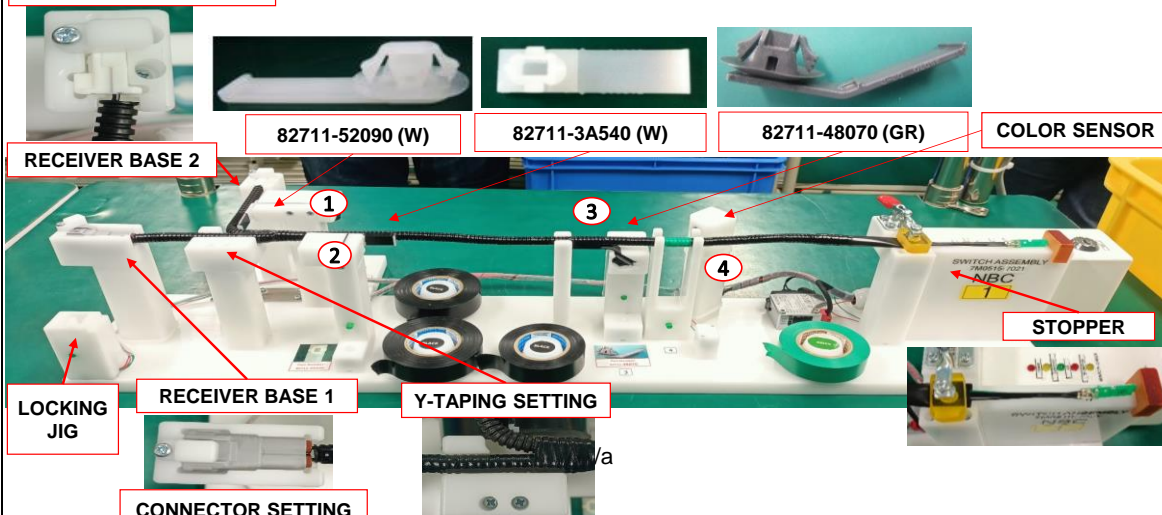



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
4	Clamp Assy	Clamp Assembly (Continuation)	<div><div>CONNECTOR SETTING</div><div></div></div>		<div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between terminal and stopper jig</div><div>2. Make 2-3 windings for Clamp taping</div></div>		
			<div><div>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Press the SW button. Continue if the sequence light of location 2 was on.</div></div>			<div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div>	
			<div><div>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Continue if the sequence light of location 3 was on.</div></div>				<div><div>7. Conduct POINT CHECKING before removing the harness from jig.</div></div>
			<div><div>5. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Continue if the sequence light of location 4 was on.</div></div>				<div><div>8. After point checking, remove the harness from toggle clamp up to clamp up to Connector receiver base 1, Connector receiver base 2 then Y-taping.</div></div>

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☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

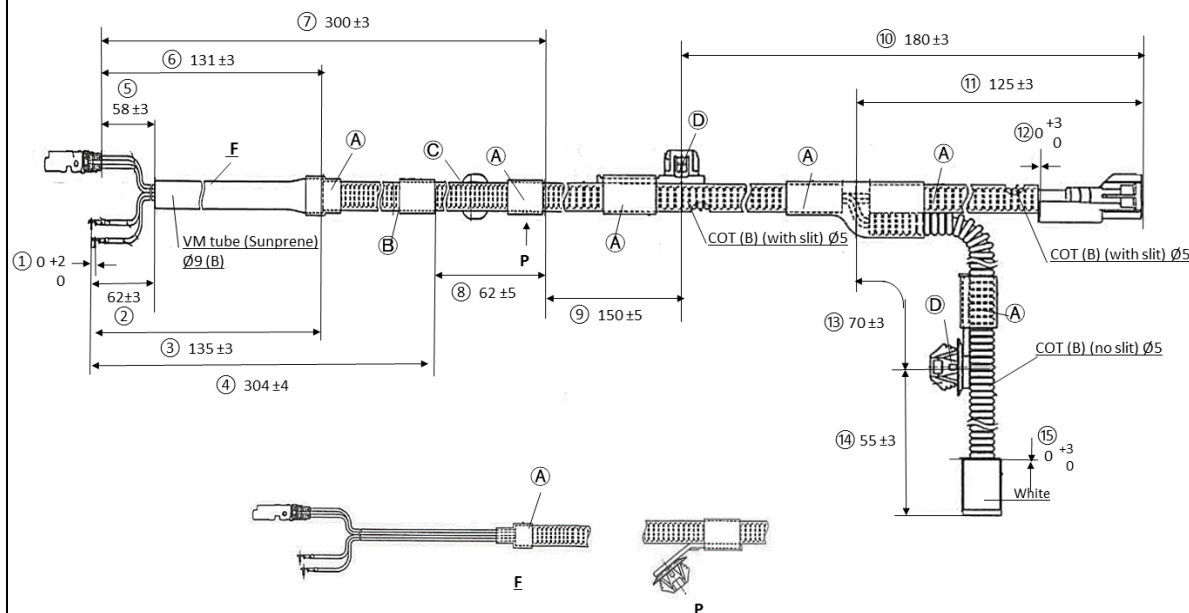
TOOLS/PPE

QUALITY POINTERS

5

Clamp Assy

Measurement



MEASURING TAPE



Important reminders and note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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**WORK INSTRUCTION**Process Name/Title: **CLAMP ASSEMBLY PROCESS**

Effectivity Date:

October 30, 2024Model code/Part number: **ES1 / 7M0515-7021B**Customer: **TRJ**Car Model: **SUBARU**

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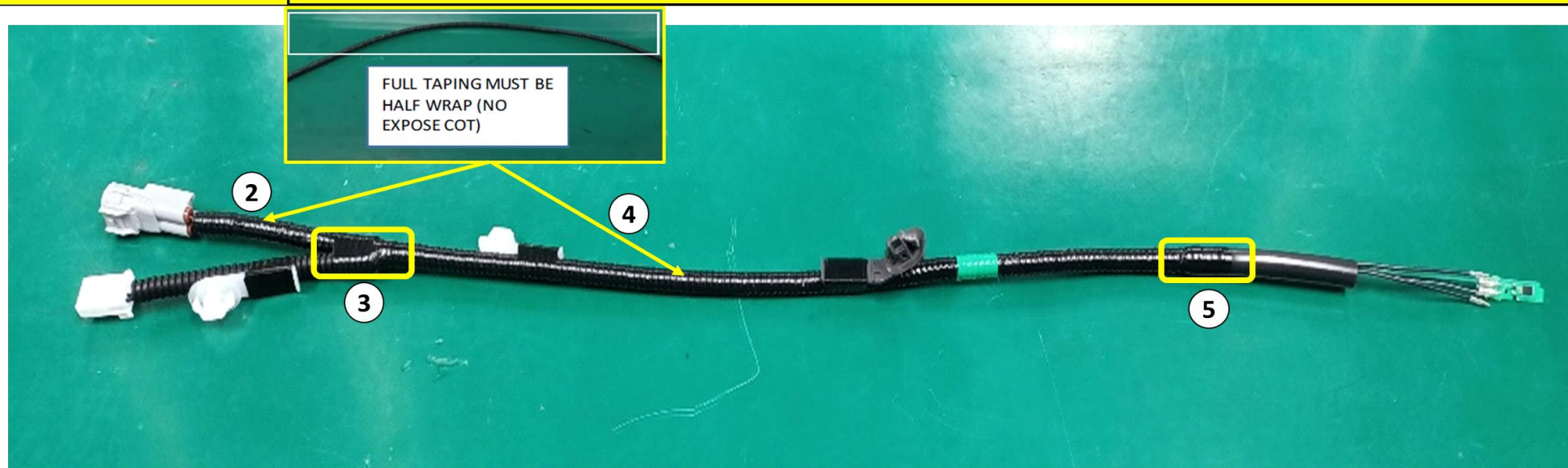
Page No.:

7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0515-7021B****① No Wrong facing of clamp****② ③ ④ ⑤ No Missing Tape (Black tape)**

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