



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 04, 2024

Model code/Part number:

TM3 / 7L0145-7020A

Customer: TRQSS

Car Model: SUBARU-ASCENT

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-714C

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. Assy parts; Black tape; Light green tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

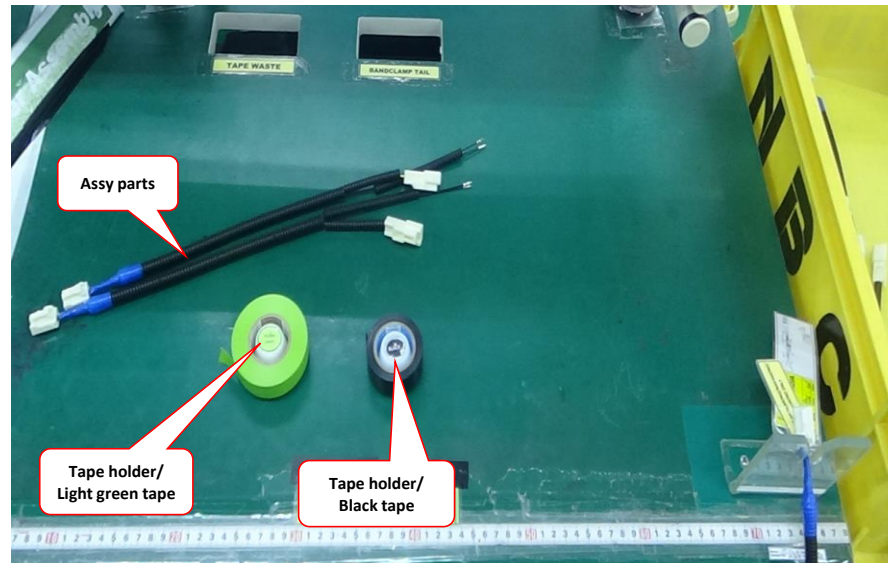
QUALITY POINTERS

1

P3

Table lay-out

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the work place is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No deformed terminal
2. No wrong usage of parts

Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/04/24 0 Initial issue.

D.Castillo

C.Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 04, 2024

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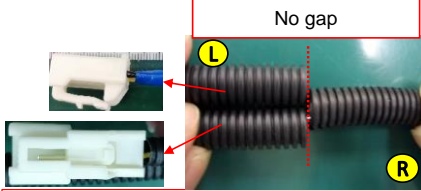

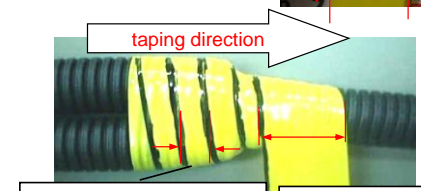
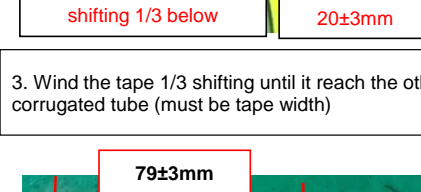

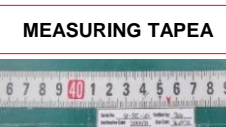
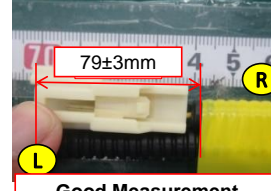
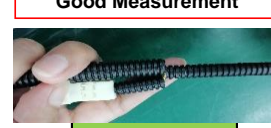
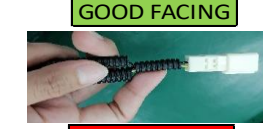
WI-ENG-PDE-714C

Revision No.:

0

Page No.:

2 of 5

PARTS:		1. Light green tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3	Y-Taping	<div><div></div><div><p>1. Fix the corrugated tube.</p></div></div> <div><div><p>Note: Do not exert excessive force during pulling & winding of tape</p></div><div></div><div></div><div><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, measurement from end of connector up to end of tape must be 79±3mm.</p></div><div><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p></div><div></div><div><p>4. Wind the tape backward 1/2 shifting.</p></div><div></div><div><p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div></div> <div><div></div><div>MEASURING TAPEA</div></div> <div><div></div><div>Good Measurement</div><div></div><div>GOOD FACING</div><div></div><div>NG FACING</div><div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. Used Yellow tape for easy visualization of shifting lines, but actual should be <u>LIGHT GREEN</u>.</p><p>1.No flip out tape 2.No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between COT 6. No exposed wire</p></div></div>		

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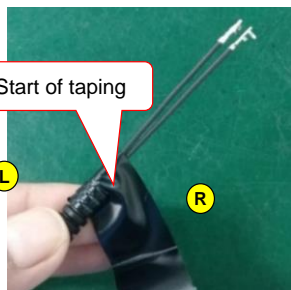
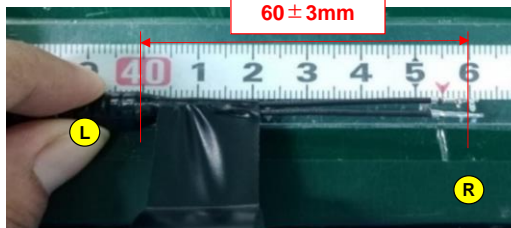

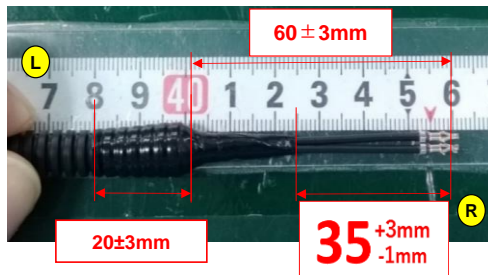

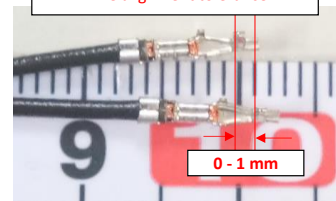
WI-ENG-PDE-714C

Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	<div><div><p>Start of taping</p></div><div><p>60 ± 3mm</p></div><div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div><div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div><div><p>35 +3mm -1mm</p></div><div><p>3. Confirm measurement of 35+3/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div><div><p>60 ± 3mm 20±3mm 35 +3mm -1mm</p></div><div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div></div> <div><div>MEASURING TAPEA</div></div> <div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p></div> <div><p><i>Important reminders/Note/s:</i></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><div><div>Wire alignment tolerance</div><p>0 - 1 mm</p></div></div>			

Important reminders/Note/s:

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

Wire alignment tolerance

0 - 1 mm

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4 of 5

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Measurement	<div><p>NOTE:</p><ul style="list-style-type: none">Ⓐ - Taping (B)Ⓑ - Taping (LG)Ⓒ - Taping (L)<p>for item number ② Dimension tolerance is different from the master drawing due to internal change only.</p></div>	<div>MEASURING TAPE</div>	<p>Important reminders and note/s:</p> <ul style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ul style="list-style-type: none">1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p>

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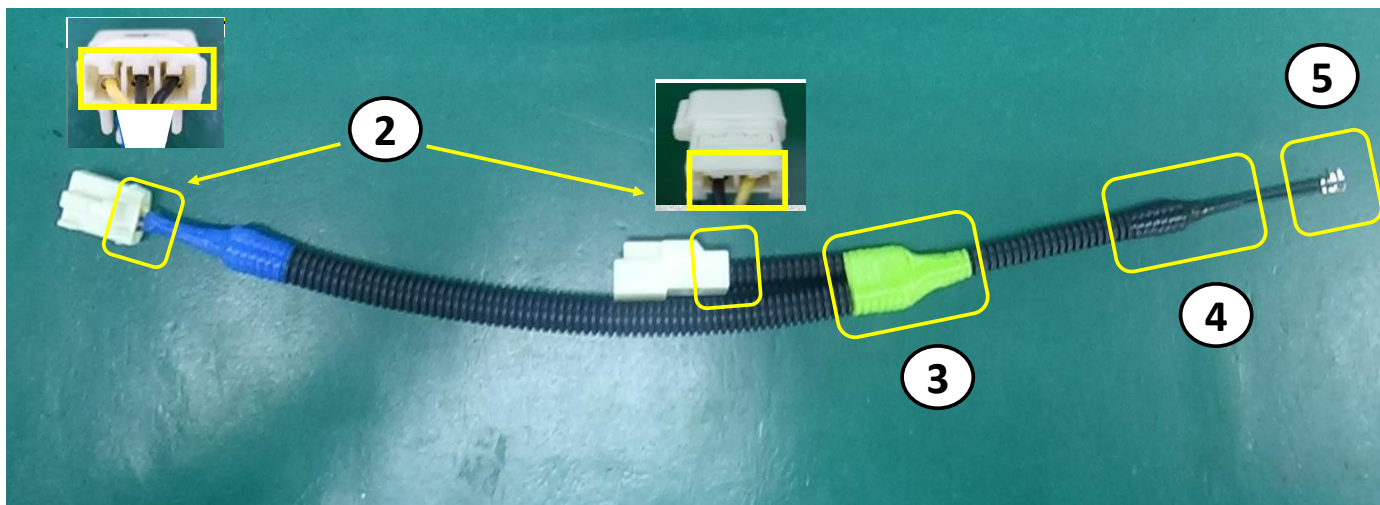
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P3****7L0145-7020A****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlocked/Halflocked Connector****2** No **Wrong Insert****3** No **Missing / Wrong used of Tape (Light green Tape)****4** No **Missing Tape****5** No **Deformed Terminal****GOOD****NO GOOD**

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