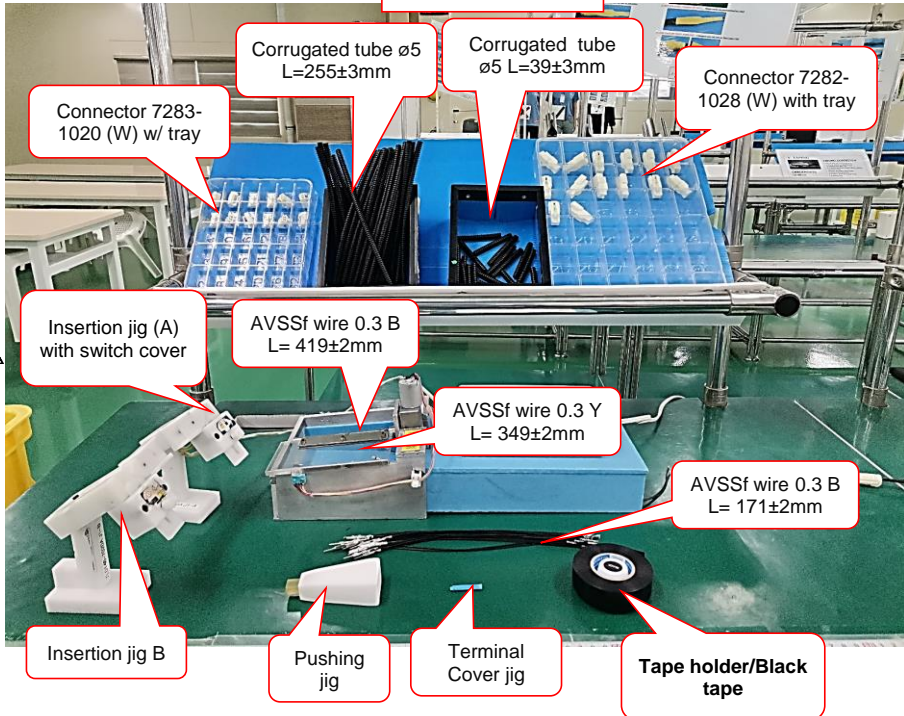
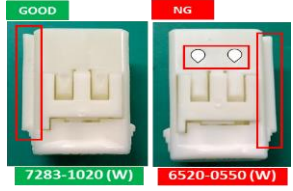
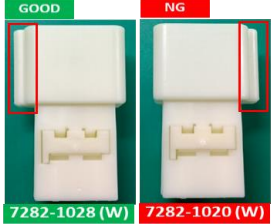




WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	October 09, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PD-724A		
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Process Name/Title:	TP1 / 7L0144-7020A		
Model code/Part number:	TP1 / 7L0144-7020A	Customer:	TRQSS
Car Model:	SUBARU-ASCENT		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. Connector 7283-1020 (W); Connector 7282-1028 (W) 2. AVSSf wire 0.3 B L= 419±2mm 3. AVSSf wire 0.3 Y L= 349±2mm 4. AVSSf wire 0.3 B L= 171±2mm 5. Corrugated tube ø5 L=255±3mm 6. Corrugated tube ø5 L=39±3mm 7. Black Tape		JIG:	1. Insertion jig with switch cover 2. Terminal Cover jig 3. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1	Tayble Lay-out		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Document references 1. Refer to WI-PRO-CNC-017 for Wire and strip length tolerance</div> <div>CONNECTOR ILLUSTRATION  7283-1020 (W) 6520-0550 (W)</div> <div>CONNECTOR ILLUSTRATION  7282-1028 (W) 7282-1020 (W)</div>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
10/09/23	1	Change purpose from Pre-launch to Masspro. Update work procedure/illustration on page 2,3,5 and 6; Additional Quality checkpoints and table lay-out	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	
09/06/23	0	Initial release	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: September 06, 2023

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TP1 / 7L0144-7020A

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

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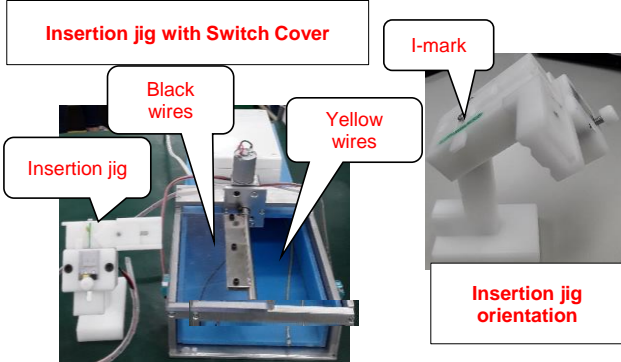
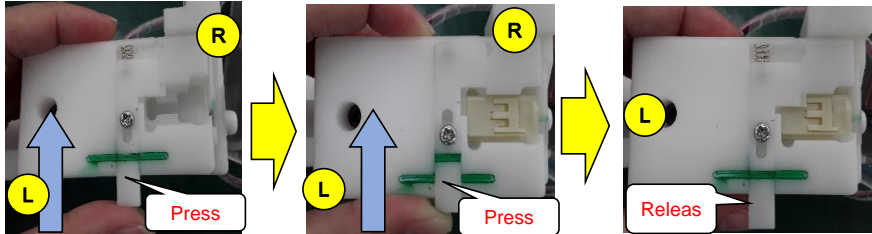
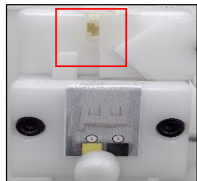

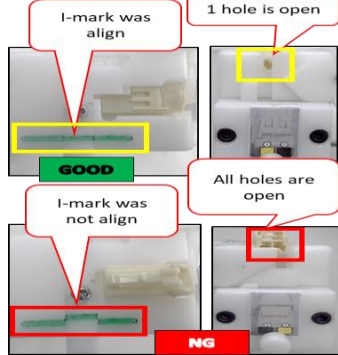

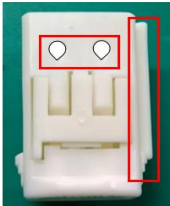
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PARTS:	1. Connector 7283-1020 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig Connector 7283-1020 (W)	<div><div><div>Insertion jig with Switch Cover</div><div></div></div><div><div></div><div><div></div><div><div>3. Check the holes/terminal slot for Y wire.</div></div></div></div><div><div>Connector Orientation</div><div></div></div></div>	N/A	<div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector. 4. No damage Connector.</div><div><div>Connector Orientation Illustration</div><div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>7283-1020 (W)</div></div><div><div>6520-0550 (W)</div></div></div></div></div>

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TP1 / 7L0144-7020A

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Validity Date:

n/a

Purpose:

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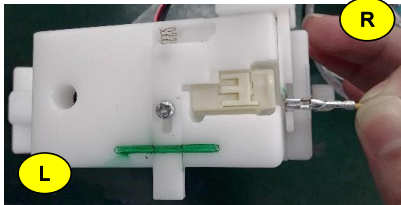
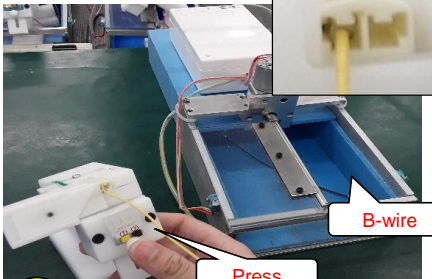
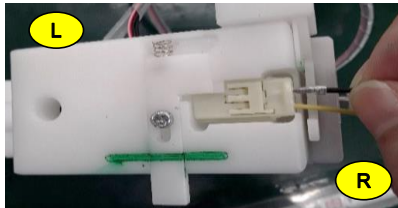
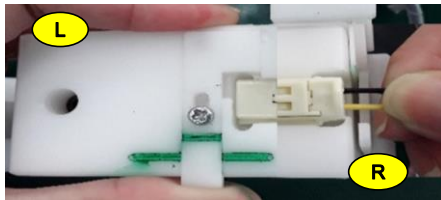
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PARTS:	1. AVSSf wire 0.3 B L= 419±2mm; AVSSf wire 0.3 Y L= 349±2mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to Connector 7283-1020 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the Yellow wire from wire holder using right hand and insert to connector.</p></div> <div><p>2. Press the button using right hand, the slot for Black wire will be opened.</p></div> <div><p>3. Get Black wire and insert to connector using right hand.</p></div> <div><p>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	N/A	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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Process Name/Title:

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TP1 / 7L0144-7020A

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TRQSS

Car Model: SUBARU-ASCENT

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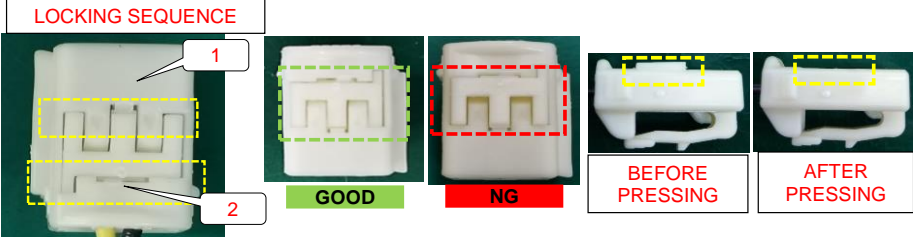

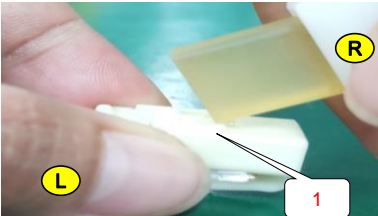
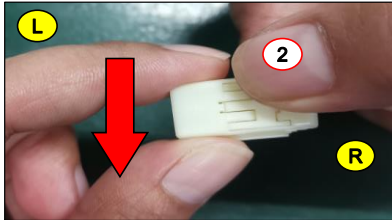
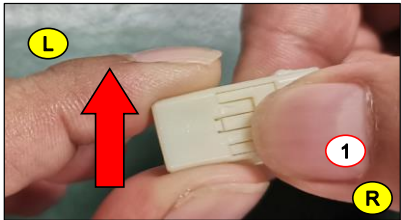
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PARTS:	1. Assy parts			JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Connector Lock	<div><div>LOCKING SEQUENCE</div><div></div><div></div><div><div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part. <i>(Position of pushing jig during locking must be slant.)</i></div></div><div></div><div>2.Ensure that the connector is in locked condition by touching the connector lock based on the sequence illustrated.</div></div>		N/A	<div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged conector lock.</div> <div>2. Position of Pushing jig must be slanted.</div> <div>1. Use provided jig tool per model to avoid damaged conector lock</div> <div>2. No unlocked/half-locked connector</div> <div>3. No damage connector</div>

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PARTS:		1. Assy parts 2. Corrugated tube Ø5 L=255±3mm 3. Corrugated tube Ø5 L=39±3mm		4. AVSSf wire 0.3 B L= 171±2mm	JIG:	1. Terminal Cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5		Wire insertion to Black Corrugated tube (no slit) Ø5 L=255±3mm	<div><p>1. Get the terminal cover jig and insert to B wire using right hand.</p></div> <div><p>2. Get the Corrugated tube (no slit) Ø5 L=255±3mm using right hand and insert the wires using left hand.</p></div> <div><p>3. Remove the terminal cover jig using right hand after insertion.f</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal
6	P1	Wire insertion to Black Corrugated tube (no slit) Ø5 L=39±3mm	<div><p>1. Get the B wire L=171±1mm using right hand then combine to Y wire.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L=39±3mm using right hand then insert the B-Y wires using left hand.</p></div>		N/A	1. No wrong use of parts 2. No deformed terminal Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.

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PARTS:		1. Connector 7282-1028 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><div><div><div><div>Insertion jig</div><div>Side wire</div><div>Visual reference</div><div>Push button</div><div>Lower wire</div></div><div><div>I-mark</div><div>Insertion jig Orientation</div></div><div><div>Connector lock</div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Release</div></div></div><div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>2. Insert the connector 7282-1028 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div></div><div><div><div>3. Push the lower guide using left thumb, the slot for Yellow wire will be opened.</div></div></div></div></div></div></div></div>		N/A	<div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div><div><div><div>Connector Orientation Illustration</div><div><div><div>I-mark was align</div><div>1 hole is open</div></div><div><div><div>I-mark was not align</div><div>All holes are open</div></div></div><div><div><div>GOOD</div><div>NG</div></div></div></div><div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>NG</div></div><div><div><div>7282-1028 (W)</div><div>7282-1020 (W)</div></div></div></div></div></div></div></div></div>

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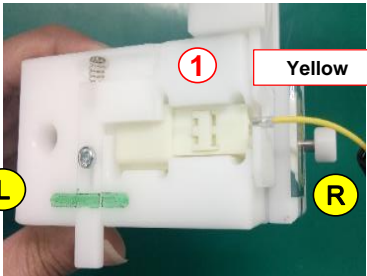

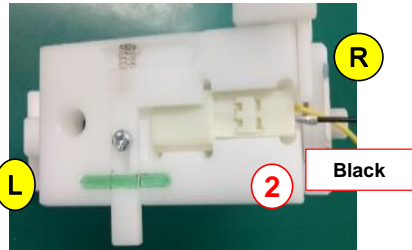
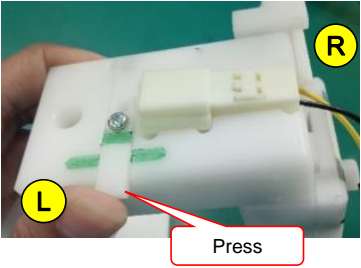
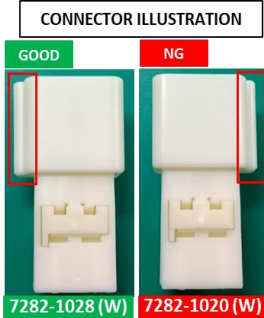
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PARTS:		1. Assy parts 2. Connector 7282-1028 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 7282-1028 (W)	<div>WIRE FACING</div> <div><p>1. Insert the Yellow wire using right hand then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right hand, the slot for Black wire will be opened.</p></div> <div><p>3. Get Black wire using right hand then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>		N/A	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminder's/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <div><p>CONNECTOR ILLUSTRATION</p><p>GOOD NG</p><p>7282-1028 (W) 7282-1020 (W)</p></div>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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TP1 / 7L0144-7020A

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Car Model:

SUBARU-ASCENT

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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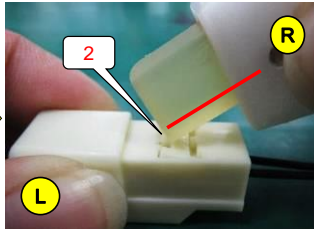
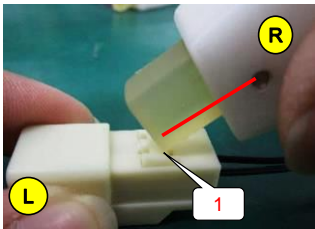
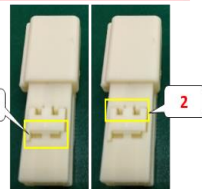
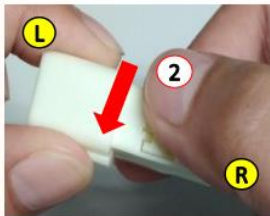
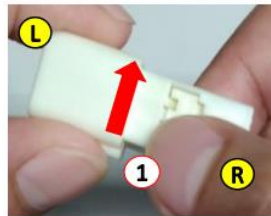





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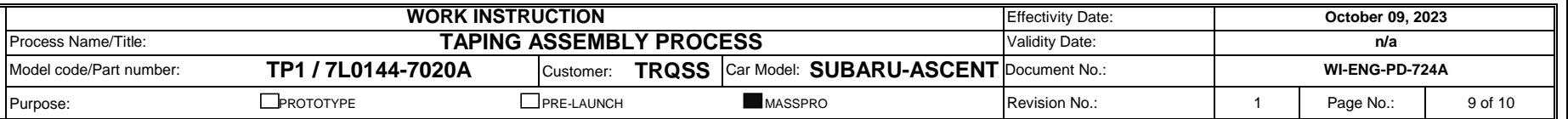
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PARTS:		1. Assy parts 2. Connector 7282-1028 (W)		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Connector Lock	<div><div>Pressing Sequence</div></div> <div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</div> <div></div> <div>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div> <div><div>Before pressing</div></div> <div><div>After pressing</div></div>		<div>PUSHING JIG</div> 	<div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock.</div> <div>2. Use provided jig tool per model to avoid damaged lock.</div> <div>3. Position of pushing jig during locking must be slanted.</div> <div>LOCK CONDITION</div> <div></div> <div>GOOD</div> <div>NG</div> <div>1. No unlocked/half-locked connector 2. No damage connector.</div>

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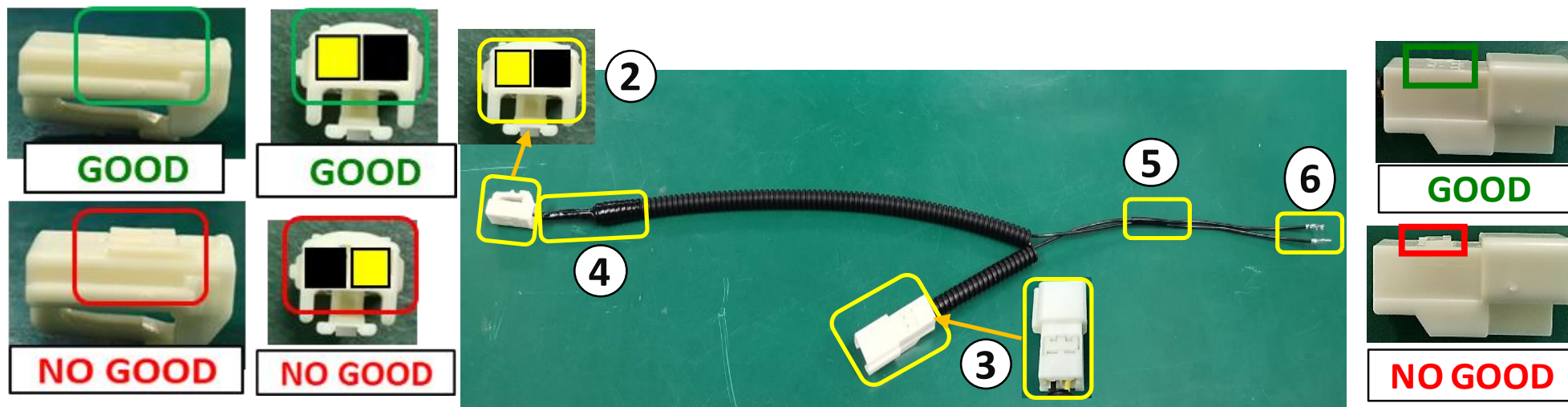
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PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7L0144-7020A**

1 No **Unlock/Halflock Connector**
(on 2 connector)

2 **3** No **Wrong Insert** (on 2 connector)

4 No **Missing Tape**

5 No **Missing Spot tape**

6 No **Deformed Terminal**

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