



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 21, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

ES1 / 7M0509-7020C

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Document No.:

WI-ENG-PDE-357A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

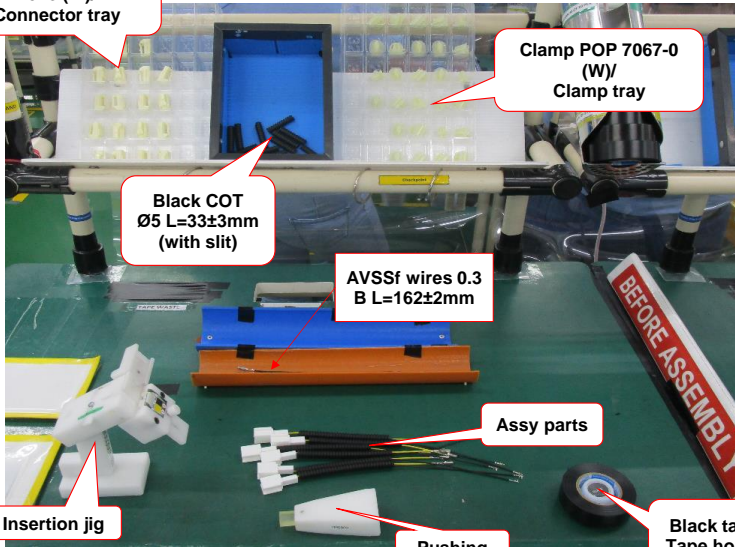
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PARTS:

1. Assy parts: Connector 7283-1028 (W); AVSSf wires 0.3 B L=162±2mm; Clamp POP 7067-0 (W); Black COT Ø5 L=33±3mm (with slit)

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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 workplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	Important reminders/Note/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Please refer to WI-ENG-PDE-375 for Offline Assembly Process 1. No missing parts/tools 2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by


Noted by

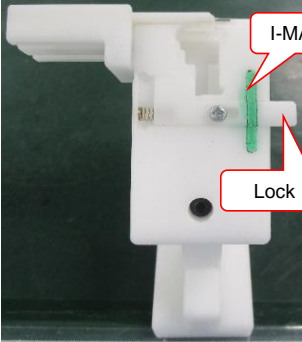
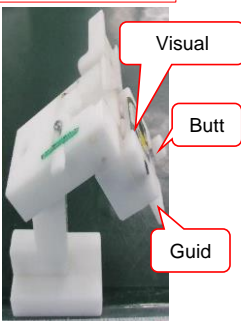
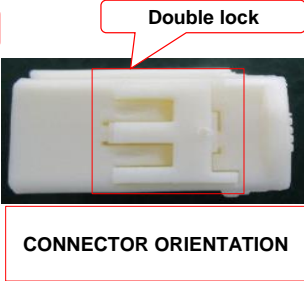
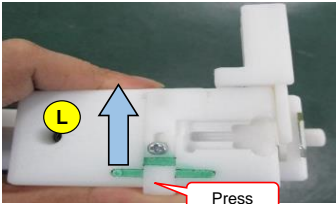
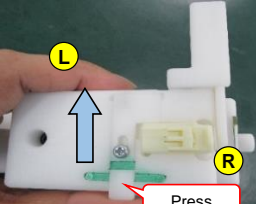
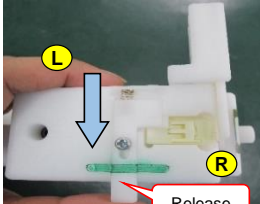
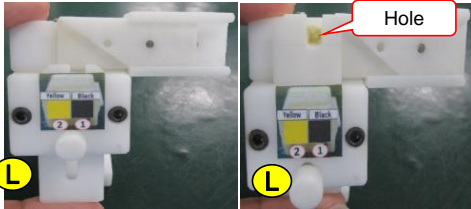
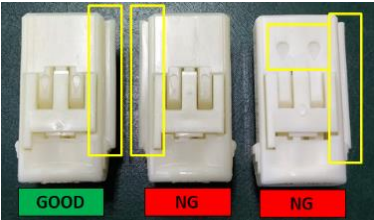
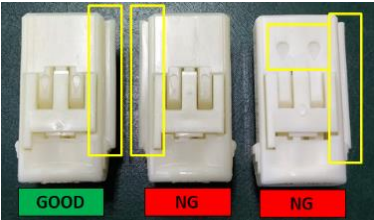
09/21/24	3	Change location of spot taping as countermeasure to customer claim. Inclusion of car model "SUBARU-FORESTER". Improved Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a				
02/25/23	2	Improve quality pointers and notes in process no.1 and 3 as document improvement. Additional process in: Process no.3, procedure 5 - pushing of wires as countermeasure for encountered terminal backing out. Addition of " Must have slightly movement of after insertion. Inclusion of Quality checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
11/25/21	1	Change from Pre-launch to masspro. Transfer insertion process from Connector to COT to Kitting (Refer to WI-ENG-PDE-375). Provide jig: Insertion and pushing jig. Improve illustration. Inclusion of Clip attachment process. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 21, 2021		

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	ES1 / 7M0509-7020C	Customer:	TRJ	Car Model:	SUBARU-FORESTER	Document No.:	WI-ENG-PDE-357A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	2 of 7			


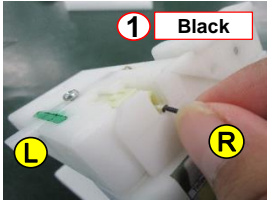
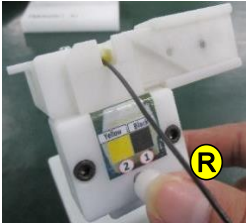
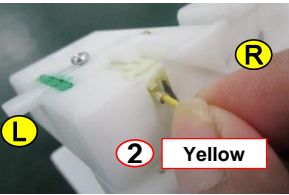
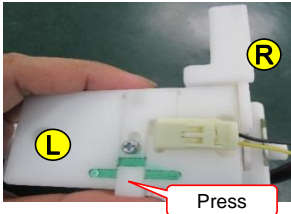
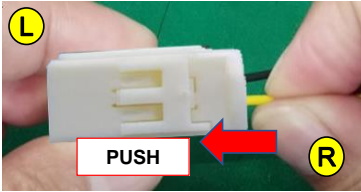
PARTS:		1. Connector 7283-1028 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector setting to insertion jig 7283-1028 (W)	<div><div><p>Insertion jig</p><p>I-MARK</p><p>Lock</p></div><div><p>Visual</p><p>Butt</p><p>Guid</p></div><div><p>Double lock</p><p>CONNECTOR ORIENTATION</p></div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the connector 7283-1028 (W) into jig using right hand then release the lock. <i>Note: Follow the connector orientation. Cannot insert the inverted connector</i></p></div><div><p>Hole</p></div><div><p>3. Push the lower guide using left thumb, the slot for Black wire will be opened.</p></div></div> <td colspan="2"><div><p>CONNECTOR ILLUSTRATION</p><p>GOOD NG NG</p></div><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></td>		<div><p>CONNECTOR ILLUSTRATION</p><p>GOOD NG NG</p></div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>		

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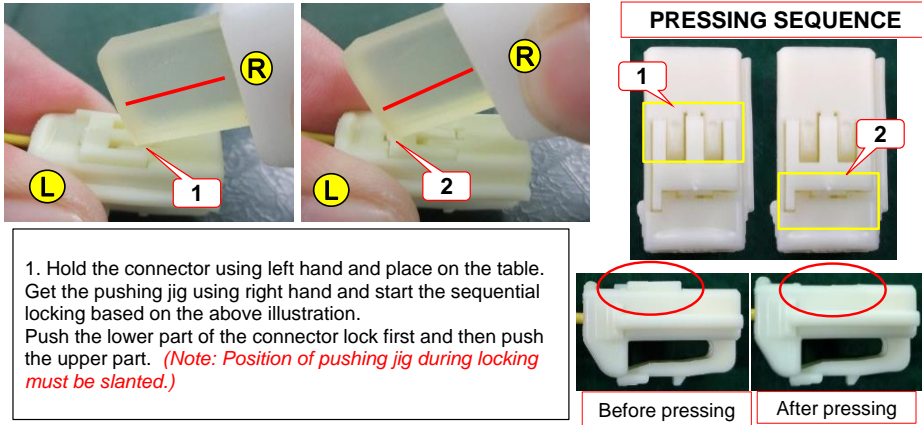
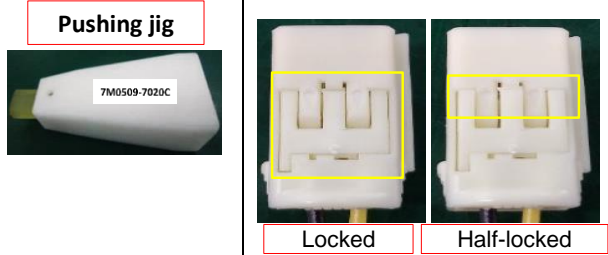
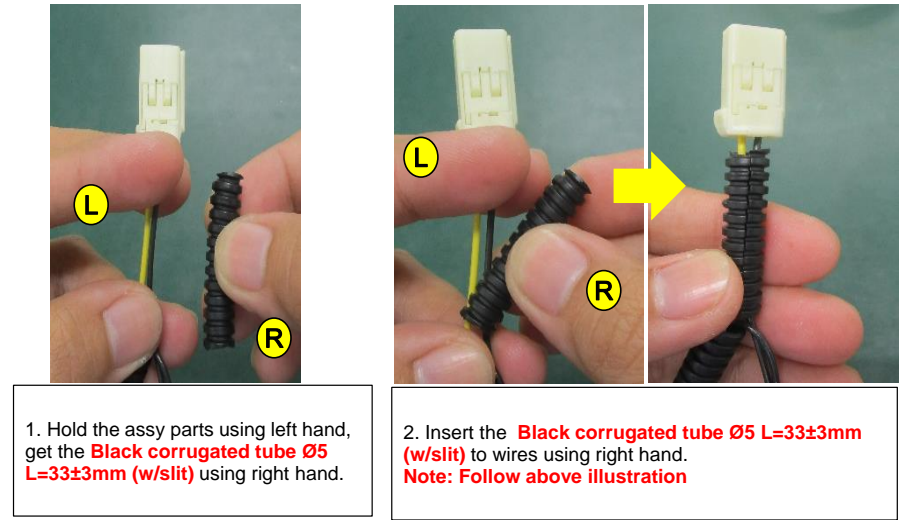
PARTS:	1. Assy parts 2. AVSSf wires 0.3 B L=162±2mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 7283-1028 (W)	<div>TERMINAL FACING</div> <div>1 Black L R</div> <div>2 R 2. Press the button using right hand, the slot for Yellow wire will be opened.</div> <div>2 Yellow L R</div> <div>Press L R</div> <div>PUSH L R</div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. Must have slightly movement after insertion.</div> <div>Important reminders/Note/s: 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 3. Conduct pushing of wires after removing the connector from jig 4. Pushing of wires will be one by one of every inserted wires.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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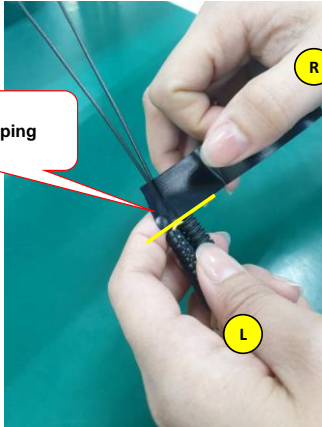
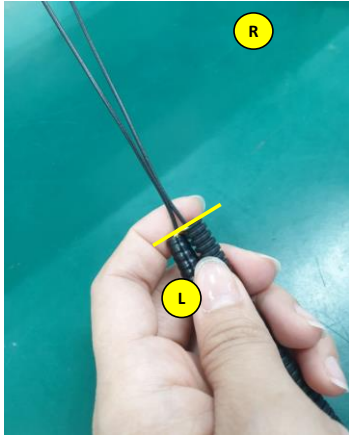
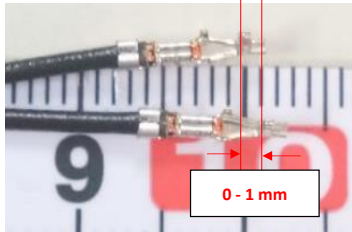
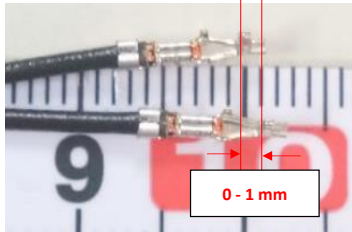
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PARTS: 1. Assy parts 2. Black corrugated tube Ø5 L=33±3mm (w/ slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
4	Connector lock	 <p>1. Hold the connector using left hand and place on the table. Get the pushing jig using right 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. <i>(Note: Position of pushing jig during locking must be slanted.)</i></p>	 <p>Pushing jig</p> <p>Locked Half-locked</p>
5	P1 Wire insertion to Black Corrugated tube Ø5 L=33±3mm (w/ slit)	 <p>1. Hold the assy parts using left hand, get the Black corrugated tube Ø5 L=33±3mm (w/slit) using right hand.</p> <p>2. Insert the Black corrugated tube Ø5 L=33±3mm (w/slit) to wires using right hand. Note: Follow above illustration</p>	<p>n/a</p> <p>1. No wrong usage of parts 2. No wires left in between the COT</p>

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1 <div>3</div> Spot tape	<div><div>1. Hold assy parts using left hand, get Black tape and position near COT then start taping using right hand. Make 2 windings of tape then cut using both hands.</div><div>2. After taping, check the measurement and taping condition.</div></div> <td>n/a</td> <td colspan="2"><div>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 position of spot tape</div><div><div>Wire alignment tolerance</div><div>0 - 1 mm</div></div></td>	n/a	<div>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 position of spot tape</div> <div><div>Wire alignment tolerance</div><div>0 - 1 mm</div></div>	

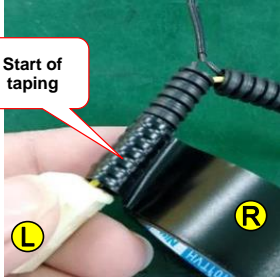
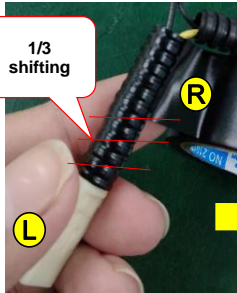
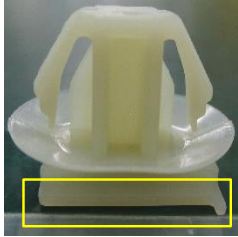
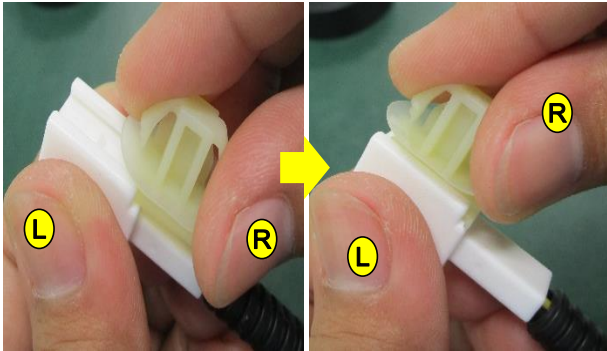
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PARTS:		1. Assy parts 2. Black tape		3. Clamp POP-7067-0 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
7	Half-wrap Taping	<div><p>Start of taping</p></div> <div><p>1/3 shifting</p></div> <div><p>1. Hold the assy parts using left hand, get the Black tape using right hand then make 2 windings of tape before shifting.</p><p>2. Make 1/3 shifting until it covers the slit of COT, make 2 windings of tape before cut.</p></div>				n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape
8	P1 Clip/clamp attachment	<div><p>CLIP ORIENTATION</p></div> <div><p>1. Hold the assy parts using left hand, get the clamp POP-7067-0 (W) using right hand then insert to connector. Note: Follow the correct orientation.</p></div>				n/a	1. No wrong usage of parts

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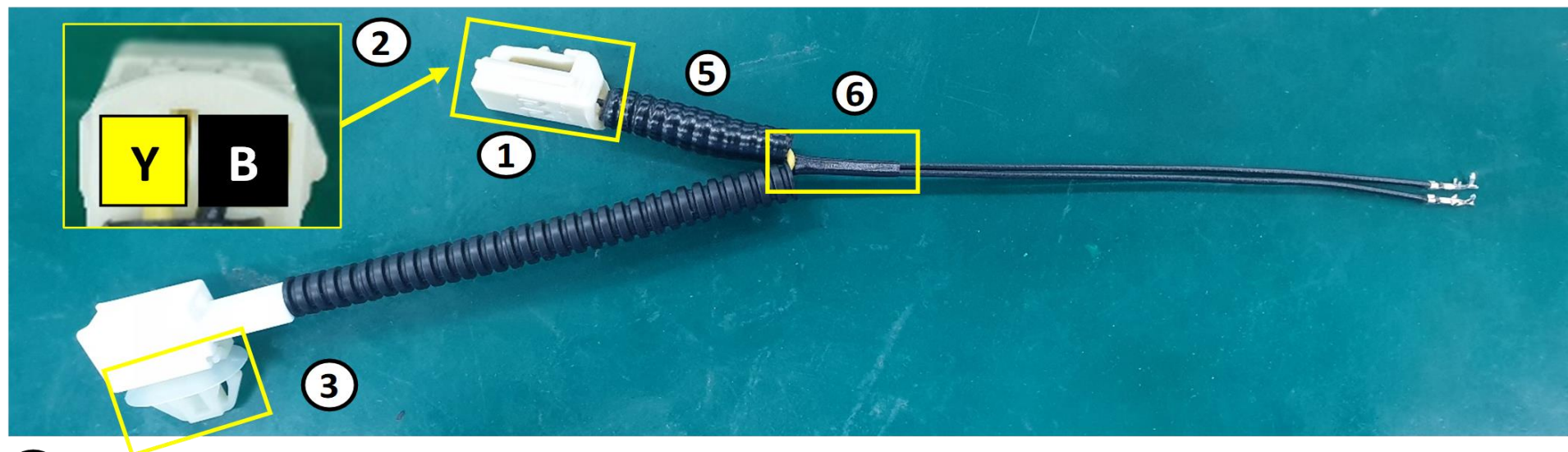
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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7M0509-7020C****1** No **Unlocked/ Half-Locked Connector****2** No **Wrong Insert****3** No **Terminal Backing Out****4** No **Missing Clip Type Clamp****5** No **Missing Tape (Half-wrap)****6** No **Missing Spot Tape/ No wrong location of Spot tape**

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