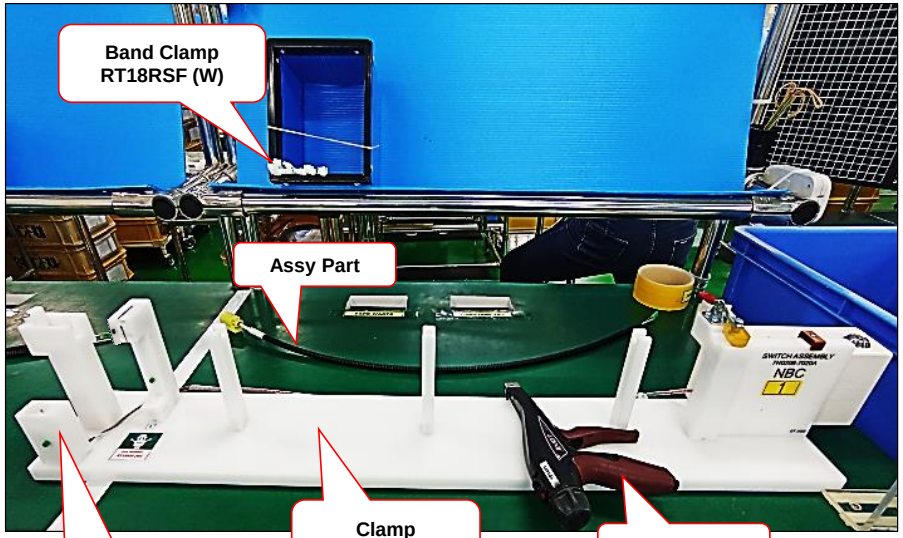
	WORK INSTRUCTION			Effectivity Date:	November 20, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: NB8 / 7N0208-7020Aa	Customer: TRJ	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-1109		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.:	1 of 6

PARTS:	1. Assy part 2. Band Clamp RT18RSF (W)	JIG:	1. Clamp Assembly Jig 2. Bando Gun

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	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 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.	1.No excess/lacking parts/tools ***Document reference/s:*** ***1. Please check the clamp first before assembly to avoid wrong use of tape.***

Revision History							Prepared by	Reviewed by	Approved by	Noted by
11/20/24	1	Change pre-launch to mass pro.	A.Hernandez	C. Villanueva	A. Arañes	n/a				
10/08/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 08, 2024		

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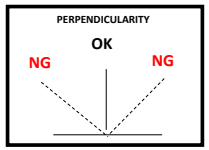
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 6

PARTS:	1. Assy Parts 2. Band Clamp RT18RSF (W)	JIG:	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	 RT18RSF (W) 1. Get 1 pc of Band clamp **RT18RSF (W)** using right hand and set in to clamp **location 1** using both hands. **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4** BANDO GUN POSITION ON CLAMP LOCATION 1 NG GOOD BANDO GUN ALIGNMENT  PERPENDICULARITY OK NG NG Fixed setting of band clamp cutter: 1.5		1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp BANDO GUN ***Important reminders/Note/s:*** *1. Make sure no gap between the terminal and stopper jig.* *use of tape and missing tape.* *2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.* For: ø5 - 1~2, ø7 - 3~4

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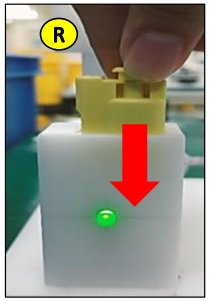
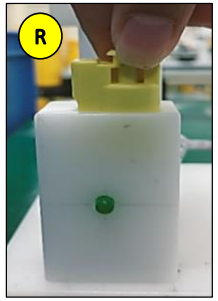
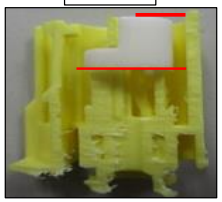
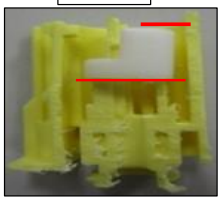
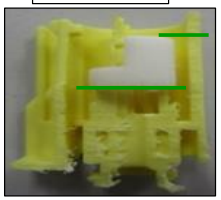
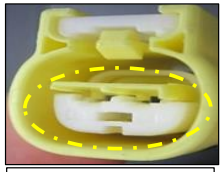
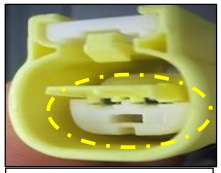
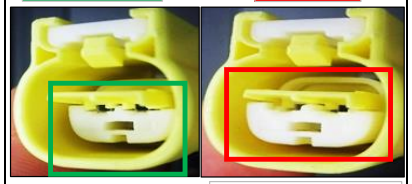
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 1	Page No.: 3 of 6

PARTS:	1. Assy Part	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Connector Lock	  1. Put the connector into locking jig using right hand then press **2x** to lock using both hands. Check the lock if properly locked. **CROSS SECTIONAL VIEW** NG  **Unlock** NG  **Half-locked** GOOD  **Fully locked**  **Before Pressing**  **After Pressing**		1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged connector 4. No skip of locking process ***Important reminders/Notes:*** *1. Manual locking may cause damaged connector lock.* *2. Do not exert extra force. It may cause damaged of connector.* **GOOD** **NG**  **LOCK** **UNLOCK/ HALF-LOCK** ***Document references:*** ***1. Refer to GL-PRO-ASY-017 for the verification of connector lock.***

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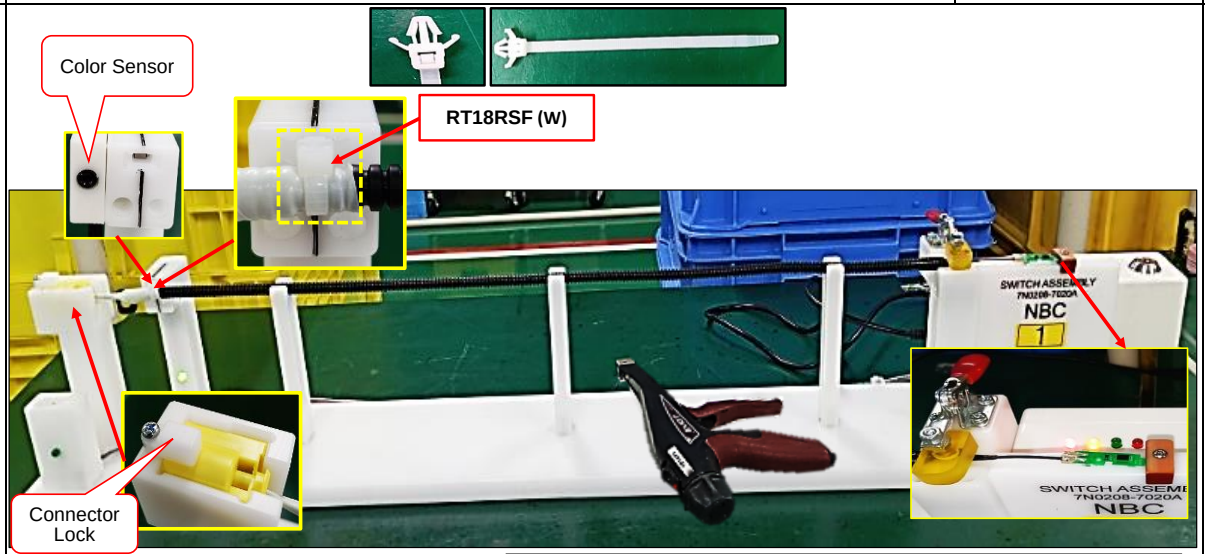
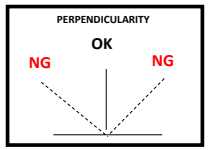
	Model code/Part number: NB8 / 7N0208-7020Aa	Customer: TRJ	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-1109
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 4 of 6

PARTS:	1. Assy Parts 2. Band Clamp RT18RSF (W)	JIG:	1. Clamp Assembly Jig 2. Bando Gun

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Clamp Assembly	  1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector **7C83-5524-70 (Y)** in **Receiver base 1**. Continue to set the harness then last, set the **W-BW wires** together within the stopper then press by **Toggle clamp**. 2. Initially tighten the band clamp **RT18RSF (W)** on **location 1** using both hands. (Note: Hold properly the band clamp using left hand while tightening) 3. Get the bando gun using right hand then cut the band clamp on **location 1.** 4. Conduct **POINT CHECKING** before removing the harness from jig. **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4** **BANDO GUN POSITION ON CLAMP LOCATION 1** **BANDO GUN ALIGNMENT**  Fixed setting of band clamp cutter: 1.5		1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts ***Important reminders/Note/s:*** *1. Make sure no gap between the terminal and stopper jig.* *use of tape and missing tape.* *2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.* For: ø5 - 1~2, ø7 - 3~4 **BANDO GUN**

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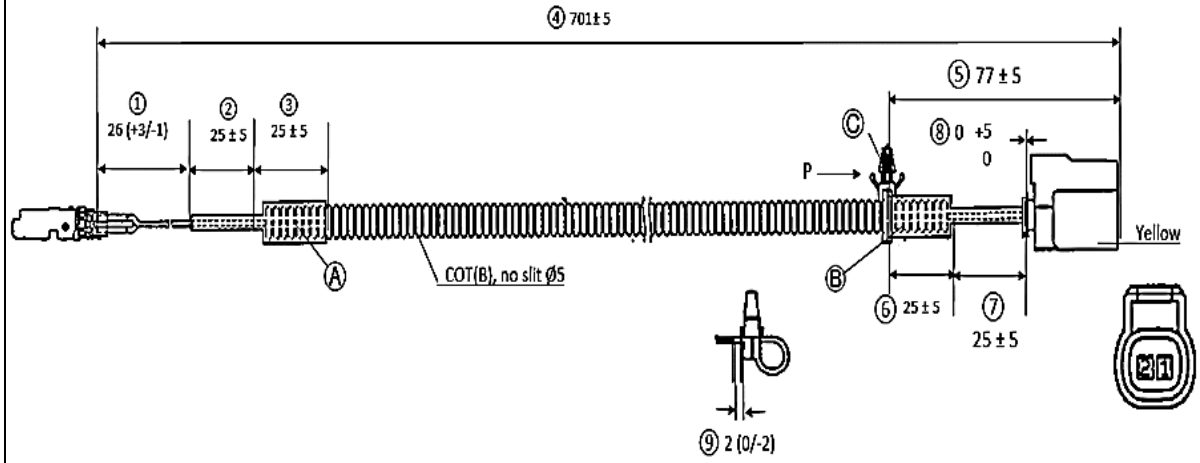
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.:	1	Page No.: 5 of 6

PARTS:	1. Assy Parts	JIG:	1. Measuring tape

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Measurement			1. No wrong dimension ***Important reminders and note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* *2. For Hatsumono, Nakamono and Owarimono.* **MEASURING TAPE** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection*

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PARTS:	n/a	JIG:	n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

CLAMP ASSY	7N0208-7020Aa

1 No Halflock/Unlock Connector

2 No Missing Tape (WHITE and BLACK)

3 No Missing Clamp (RT18RSF (W))

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