



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 10, 2024

Process Name/Title:

Model code/Part number:

TM3 / 7L0116-7020

Customer:

TRQSS

Car Model: SUBARU ASCENT

Document No.:

WI-ENG-PDE-341B

Purpose:

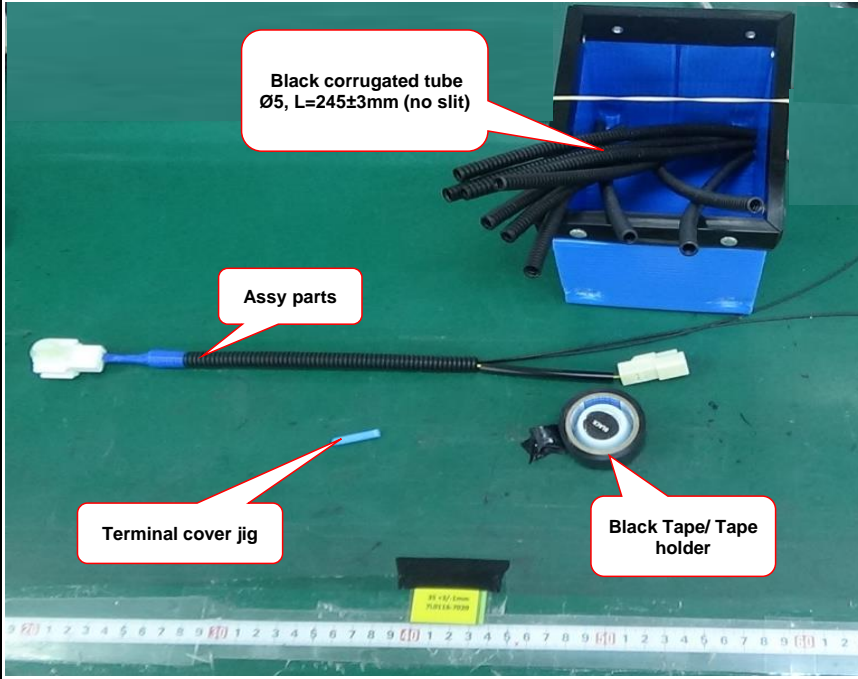



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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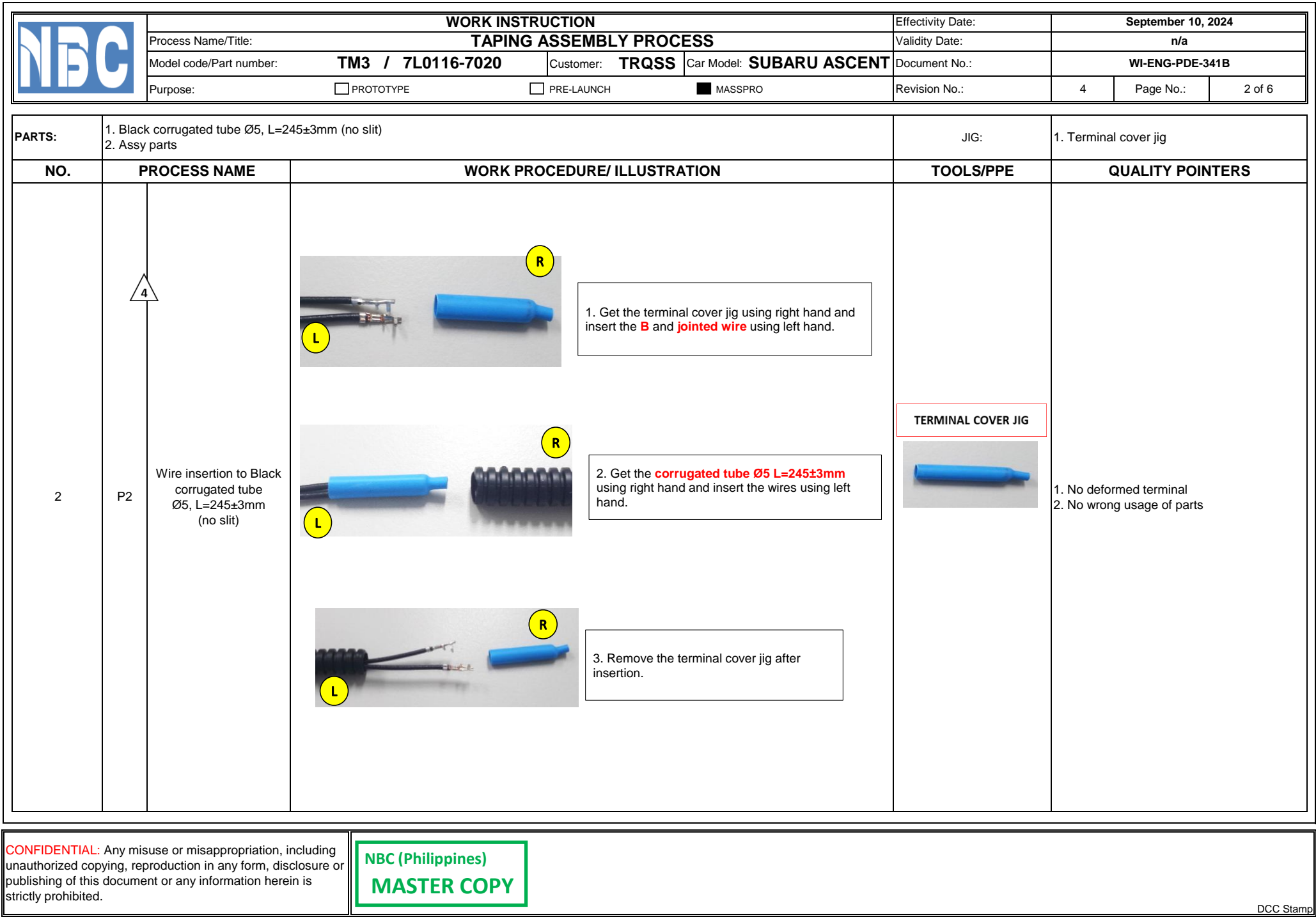
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PARTS:		1. Assy parts; Black corrugated tube Ø5, L=245±3mm (no slit); Black tape		JIG:	1. Terminal cover jig						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS						
1	P2	TABLE LAY-OUT 		<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools						
Revision History											
09/10/24	4	Separate clamp assy process and transfer wire insertion to COT and Taping 2 from P1 due to process improvement. Update work procedure of Y-taping process. Inclusion of car model "SUBARU-ASCENT". Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints.		D. Castillo	C. Villanueva	A. Arañes	n/a	Prepared by	Reviewed by	Approved by	Noted by
02/25/23	3	Inclusion of Quality Checkpoints on page no. 9.		M. Ariola	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
09/30/22	2	Additional process on page 5 (Clamp setting) due to process improvements. Improve work procedure/illustration on process no. 1,2,3,4,5,6 and 7; Quality pointers and notes on pg. 1 to 8		M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
10/15/21	1	Change from pre-launch to masspro. Add Table lay-out.		D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	October 2, 2021		

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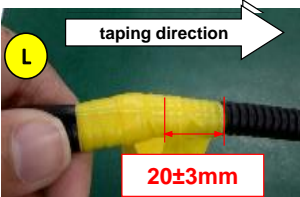
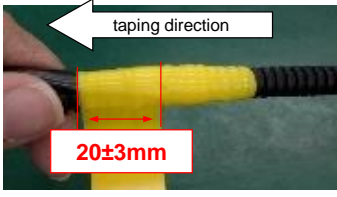


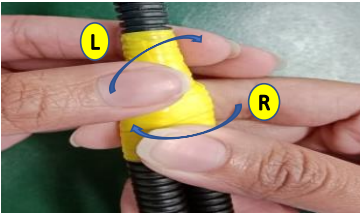
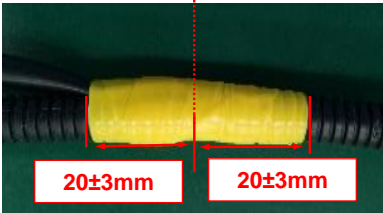
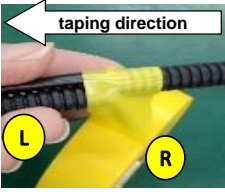
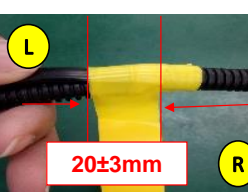
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape	JIG:	N/A
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Y-Taping	<div><div>NO GAP BETWEEN TUBES</div><div><div>1. Fix the 3 tubes (SV tube and COT).</div></div><div><div><div>3. Winding the tape 1/3 shifting going to the right side until reach the other side of tube. Make 2 windings, width must be 25±3mm</div></div><div><div><div>4. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 23±2mm.</div></div></div><div><div><div>6. conduct proper pressing of end tape using left hand (top part)</div></div><div><div><div>7. conduct proper pressing of end tape using left hand (Middle part)</div></div><div><div><div>8. conduct proper pressing of end tape using left hand (bottom part)</div></div></div><div><div><div>9. Check the Measurement and condition of tape.</div></div></div></div><div><div><div>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±2mm. Note: Do not exert excessive force during pulling &amp; winding of tape.</div></div><div><div><div>5. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube. Make 3 windings, width must be 25±3mm. Then cut the tape.</div></div></div></div><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 dimension</div><div><b>Important reminders/note/s:</b> 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</div><div><b>Document reference/s:</b> 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</div></div></div></div>		

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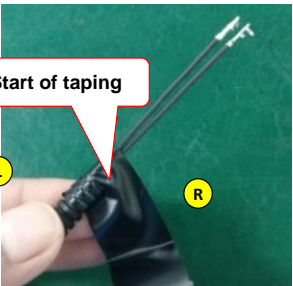
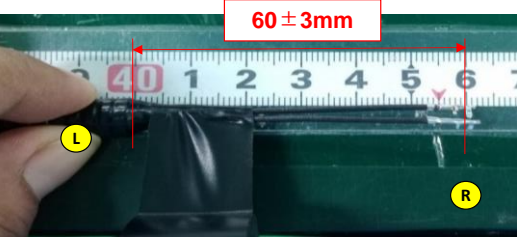

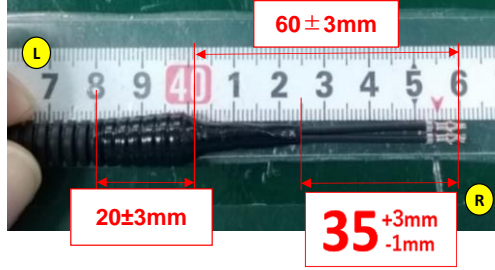

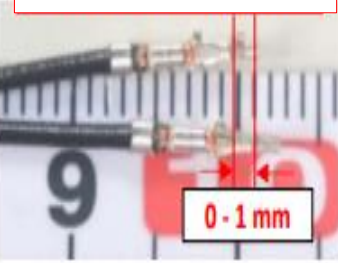
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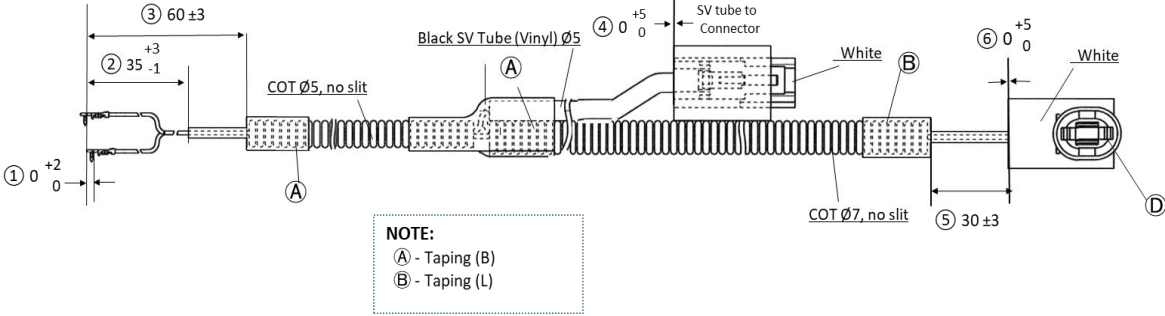
PARTS:	1. Assy parts 2. Black tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Taping 2 Corrugated tube to wire near terminal	<div data-bbox="548 375 1467 1332"><p>Start of taping</p><p>60 ± 3mm</p><p>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p><p>2. Measure from end of COT up to terminal pointed tip <b>60±3mm</b> then continue the taping process using both hands.</p><p>35 +3mm -1mm</p><p>3. Confirm measurement of <b>35 (+3/-1mm)</b> from end of tape up to terminal pointed tip then continue the taping process using both hands.</p><p>60 ± 3mm</p><p>20 ± 3mm</p><p>35 +3mm -1mm</p><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div data-bbox="1489 686 1713 845"><p>Measuring tape</p></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> <p><b>Important reminders/note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-588</b> for Tape and Tube end standard tolerance. 2. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p> <div data-bbox="1758 949 2094 1276"><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 5 of 6

PARTS:		1. Assy parts		JIG:	N/A
NO.	PROCESS NAME	<div>4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P2	Measurement	<div>MEASURING TAPE</div>  	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>	

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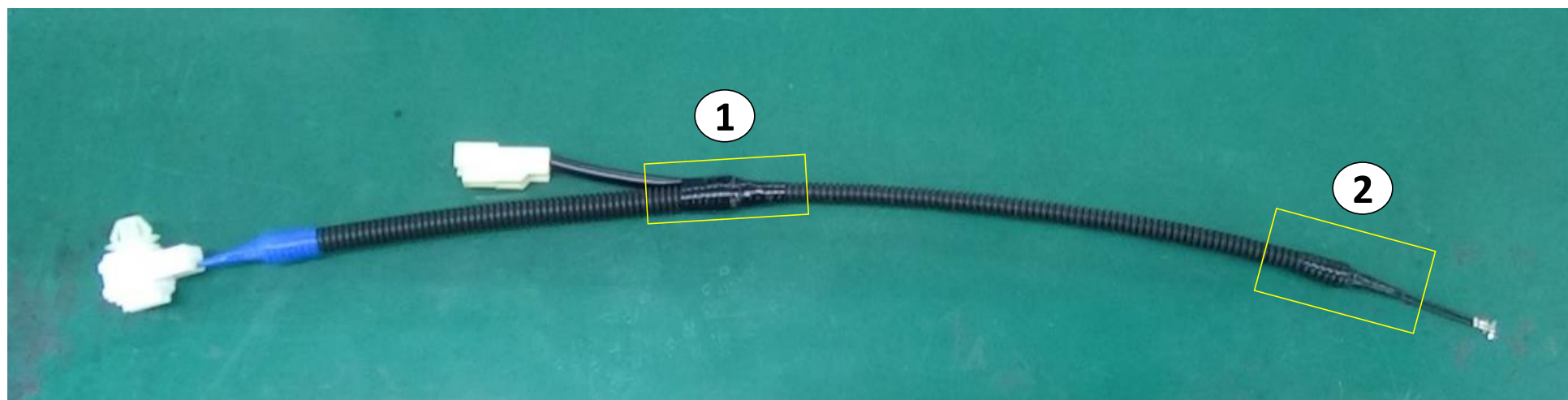
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**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7L0116-7020****1****2****No Missing tape**

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