

	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER		Document No.: WI-ENG-PDE-558
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.: 1 of 5


PARTS:	<div style="border: 1px solid black; padding: 2px; display: inline-block;">2</div>	1. All parts: Connector 7282-1026 (W)-((With clip clamp 82711-1E360 (W))); AVSSf 0.3 B wires L=884±3mm; Black SV tube (Vinyl) ø5 L=798±5mm	JIG:	1. Locking jig
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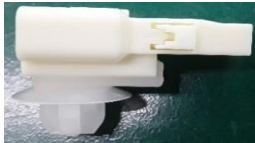
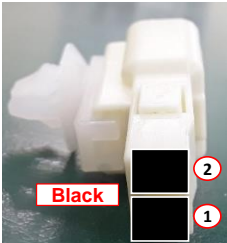
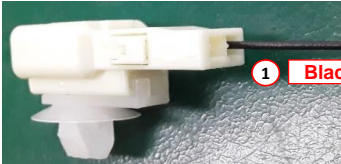
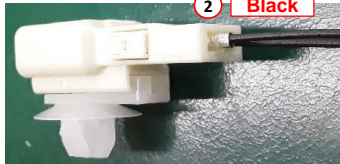
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Offline Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-PRO-KIT-008 7M0503 Clip Clamp Attachment 1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
06/11/24	2	Inclusion of Car model "SUBARU-FORESTER", Measurement and Visual inspection/Quality checkpoints. Standardize term of SV tube (Vinyl).	D.Castillo	C.Villanueva	A. Arañes	N/A				N/A					
11/04/22	1	Improve notes/references and quality pointers in process no.1,2 and 3 as document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
07/08/22	0	Initial issue. Excluded from WI-ENG-PDE-199A.	M. Catapang	C. Villanueva	A. Arañes	n/a									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 08, 2022							

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PARTS:		1. Connector 7282-1026 (W)-((With clip clamp 82711-1E360 (W)) 2. AVSSF 0.3 B wires L=884±3mm [2pcs.]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	Offline Wire insertion to connector 7282-1026 (W)	<div><p>Connector Orientation</p></div> <div><p>Visual Reference</p></div> <div><p>1. Hold the connector 7282-1026 (W) then get the 1st Black wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion. Note: Insertion must be from the bottom to top.</p></div> <div><p>2. Hold the connector 7282-1026 (W) then get the 2nd Black wire and insert to terminal slot of connector using right hand. Conduct 2x push pull after wire insertion. Note: Insertion must be from the bottom to top.</p></div>	N/A	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p>	


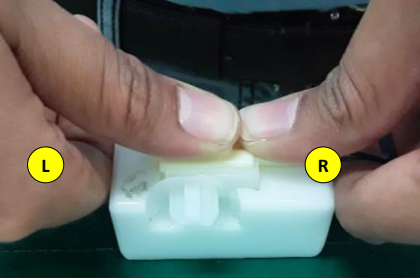
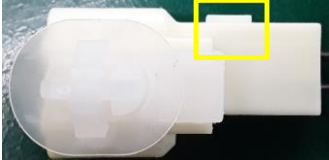
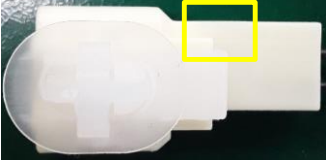



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	Process Name/Title:		Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-558	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	3 of 5	


PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=798±5mm			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	Connector lock	<div><div><div>L</div><div>R</div></div><div>Put the connector into locking jig using right hand then press 2x using both hands. Check by touching the connector lock if properly lock.</div></div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div>			<div><div>LOCKING JIG</div></div>	<div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided jig per connector 2. No unlock/half-locked connector</div>		
4	Offline  Black SV tube (Vinyl) ø5 L=798±5mm	<div><div><div>L</div><div>R</div></div><div>1. Get the SV tube (Vinyl) ø5 L=798±5mm using right hand. Insert the 2 Black wires using left hand.</div></div>			N/A	1. No wrong use of parts		

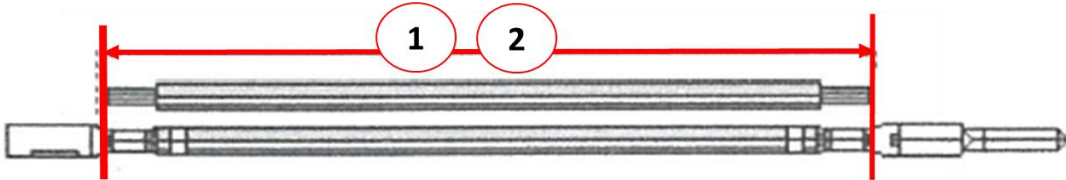
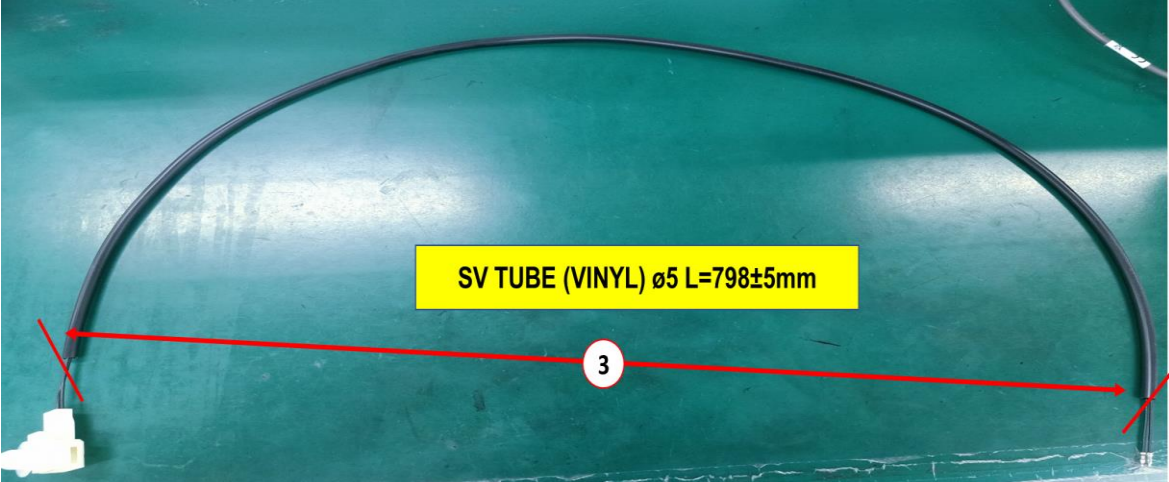

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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	4 of 5

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline Measurement	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>  	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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n/a

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ES1 / 7M0503-7020A

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Document No.:

WI-ENG-PDE-558

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

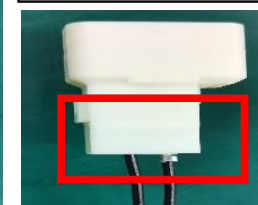
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0503-7020A****GOOD****NO GOOD****2****GOOD****NO GOOD**

1 No Unlocked/Halflocked Connector

2 No Missing clip clamp

3 No Terminal Backing Out

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