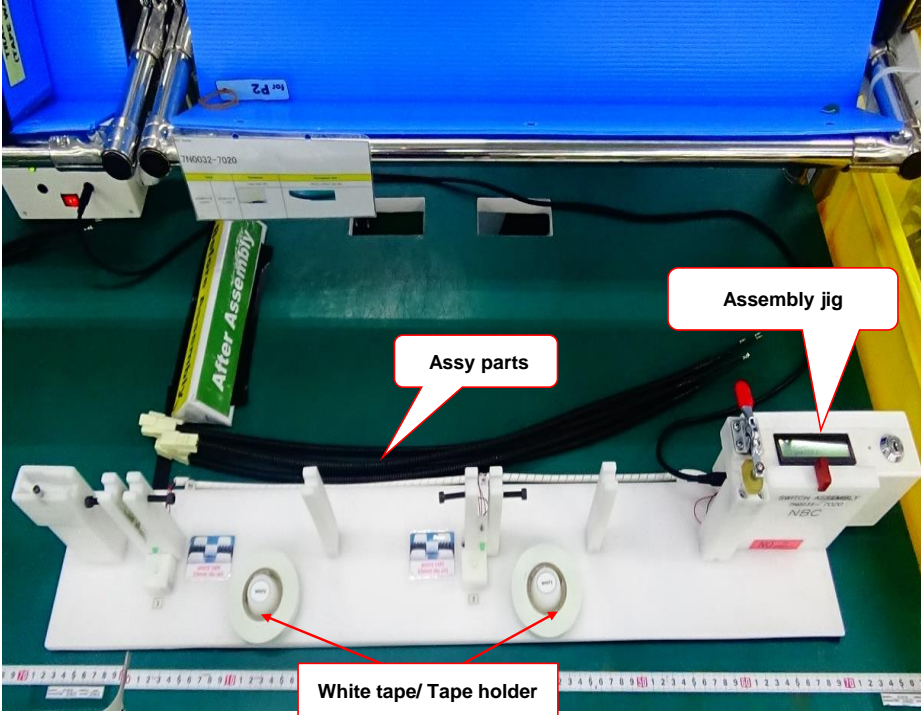


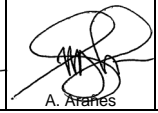
	WORK INSTRUCTION			Effectivity Date:	July 15, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: YKC / 7N0032-7020	Customer: TRJ	Car Model: SUZUKI SOLIO	Document No.:	WI-ENG-PDE-975		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	1 of 4

PARTS:		1. Assy parts; White tape [2pcs]				JIG:		1. Assembly jig											
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS											
1	Clamp Assy	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div> 				<div style="border: 1px solid 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 solid 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 solid 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-ENG-PDE-294 for Taping assembly process 1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools											
Revision History						Prepared by		Reviewed by		Approved by		Noted by							
						 D. Castillo		 C. Villanueva		 A. Arañes		n/a							
07/15/24 0 Initial issue. Separate clamp assy from Taping assembly process.														D.Castillo		C. Villanueva		A. Arañes	
Eff. Date	Rev. No	Details of Change												Revised	Reviewed	Approved	Noted	Est. Date:	July 15, 2024



WORK INSTRUCTION

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Document No.:

WI-ENG-PDE-975

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

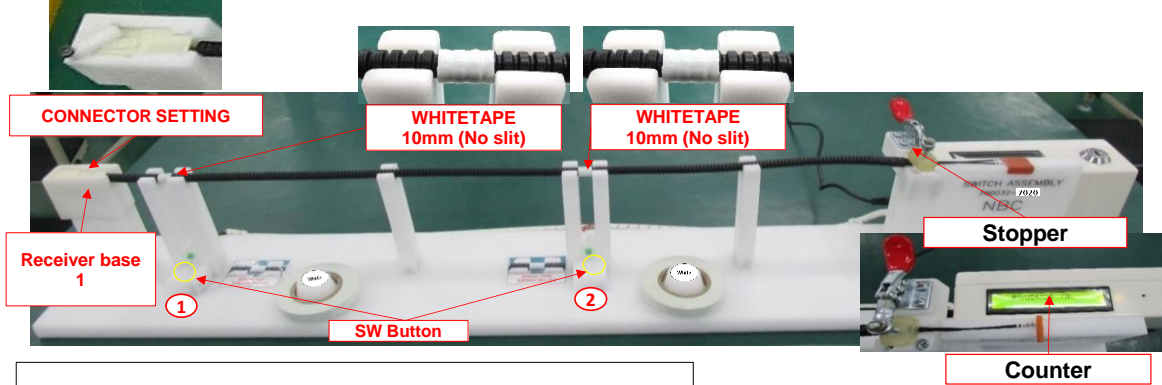

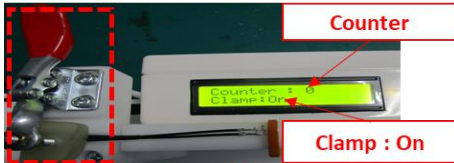

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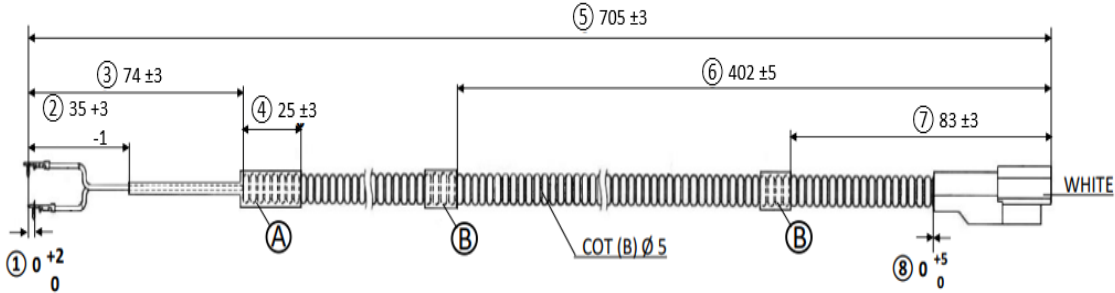
PARTS:		1. Assy parts 2. White tape 10mm (No slit) [2pcs.]		JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Assembly jig (Spot Taping)	<div></div> <div><p>1. Get the assy parts and set to taping jig using both hands. <i>(See above picture for correct setting)</i>. First, set the 7282-1020 (W) to Receiver base 1 then lock. Continue to set the harness, last set the B-B wires together within the stopper jig then press by toggle clamp. Continue if the sequence light in location 1 was ON.</p><p>2. Check if the Clamp is ON. Check if location 1 sequence light was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Get the White tape 10mm (no slit) using right hand then conduct spot taping using both hands on location 1. Make 3 windings then cut the tape. Press the SW button using right index finger. Continue if sequence light on location 2 was ON.</p><p>4. Get the White tape 10mm (no slit) using right hand then conduct spot taping using both hands on location 2. Make 3 windings then cut the tape. Press the SW button using right index finger. Go sound will be heard.</p></div> <div></div> <div><p>5. Conduct POINT CHECKING before removing the harness from jig.</p></div>			<div><p>1. No wrong insert 2. Make sure no gap between terminal and stopper jig 3. No wrong use of tape 4. No excess windings 5. No missed tape</p><p><i>Important reminders/Note/s:</i></p><p>1. <i>Make sure no gap between stopper and terminals.</i></p><p>2. <i>Counter will be the basis of quantity of harness per box. Only LEADER are allowed to reset the counter.</i></p></div> 

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: YKC / 7N0032-7020		Customer: TRJ	Car Model: SUZUKI SOLIO	Document No.: WI-ENG-PDE-975		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 4

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Clamp Assy	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (W)</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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PARTS:

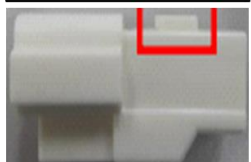
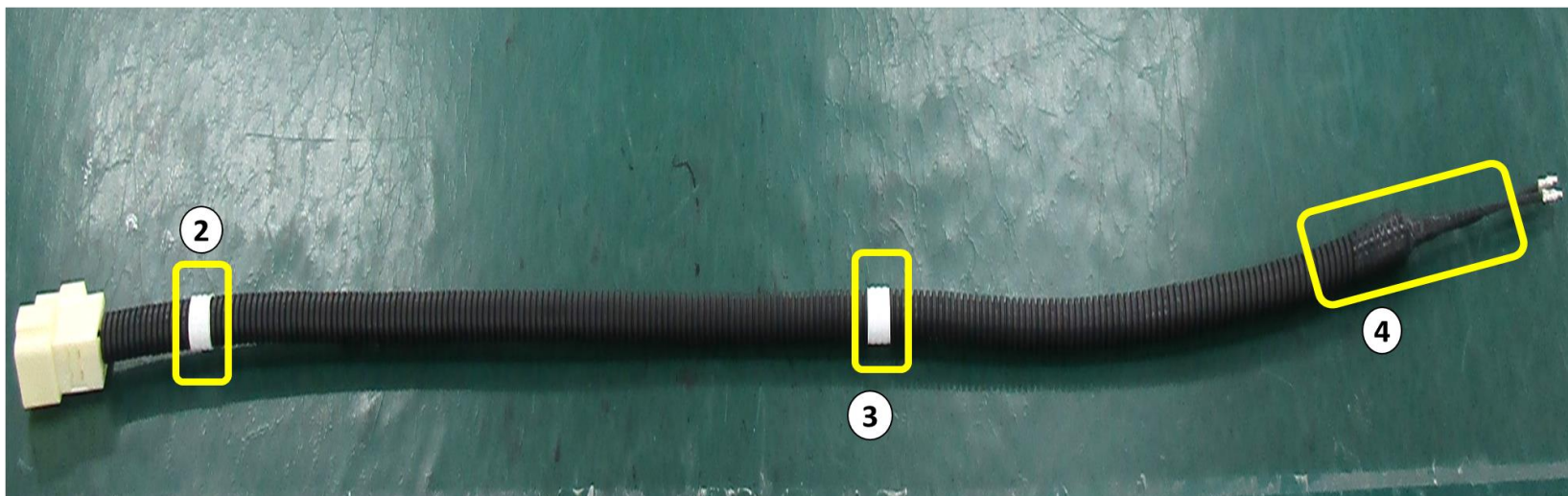
1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0032-7020**

①

**GOOD****NO GOOD**

①

No Unlocked/Halflocked Connector

②

③

No Missing Spot Tape(White Tape)

④

No Missing Tape (Black Tape)

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