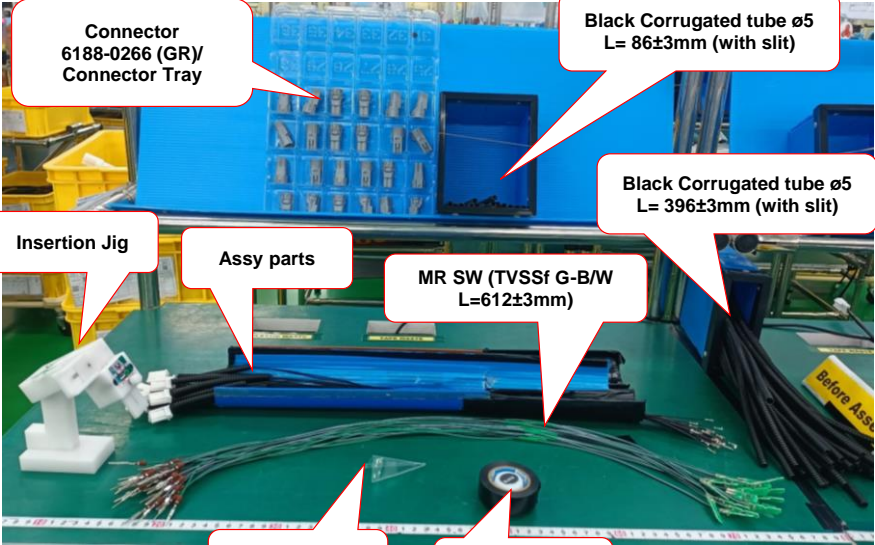
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS			Effectivity Date:	October 30, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	ES1 / 7M0515-7021B	Customer:	TRJ	Car Model:	SUBARU	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:	WI-ENG-PDE-1146A		
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PARTS:		1. All parts: Assy parts; Connector 6188-0266 (GR); MR SW (TVSSf G-B/W L=612±3mm); Black corrugated tube (w/ slit) ø5 L=86±3mm; Black corrugated tube (w/ slit) ø5 L=396±3mm; Black tape		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P1	Table lay-out		<div>TABLE LAY-OUT</div> 	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Document references: 1. Refer to WI-ENG-PDE-1145 for Offline assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/30/24	1	Change from Pre-launch to Masspro.				D.Castillo	C. Villanueva	A. Arañes	n/a
10/29/24	0	Initial issue				D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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ES1 / 7M0515-7021B

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TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-1146A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

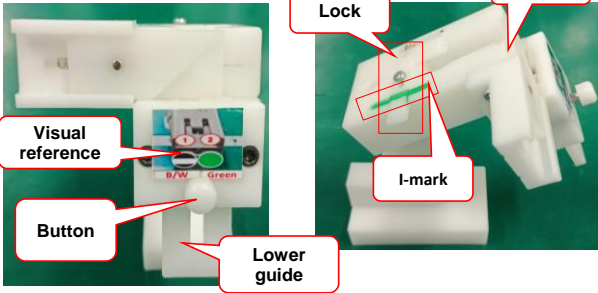

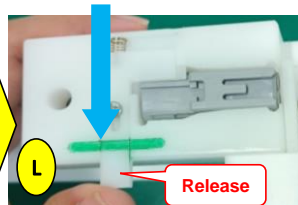
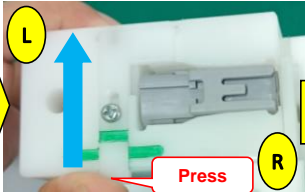
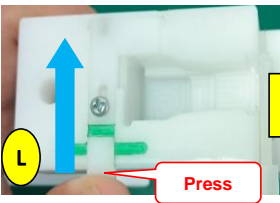
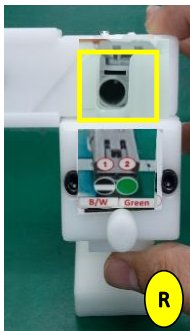
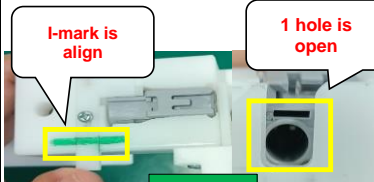
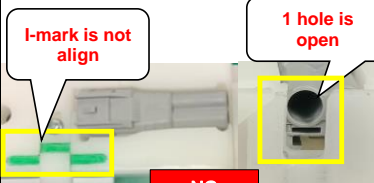
☒ MASSPRO

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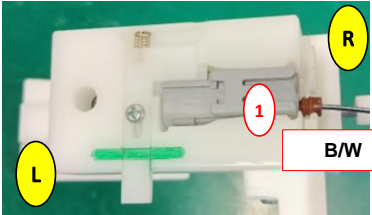
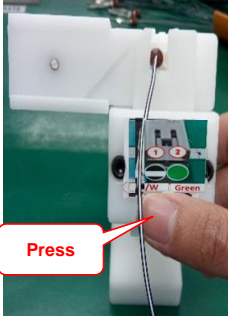
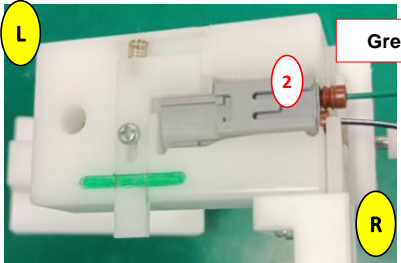
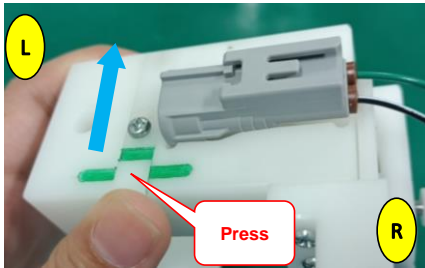
PARTS:	1. Connector 6188-0266 (GR)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6188-0266 (GR)	<div><div><div>Insertion jig</div><div></div></div><div><div>Connector orientation</div><div></div></div><div><div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div></div></div><div><div>2. Insert the Connector 6188-0266 (GR) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></div></div><div><div>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be open.</div></div></div></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div></div></div>

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ	Car Model: SUBARU	Document No.: WI-ENG-PDE-1146A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 7

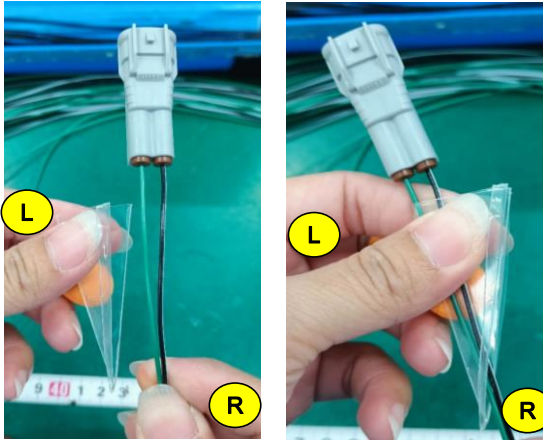
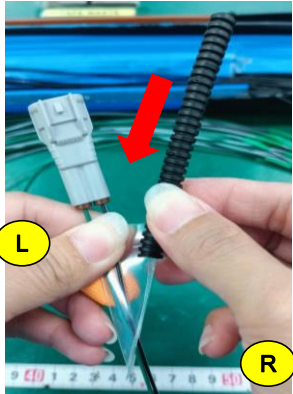

PARTS:	1. MR SW CP (TVSSf G-B/W L=612±3mm)			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6188-0266 (GR)	<div><p>Terminal facing</p></div> <div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div> <div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Insertion of wire must be inserted.</p> <p>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance.</p> <p>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p>

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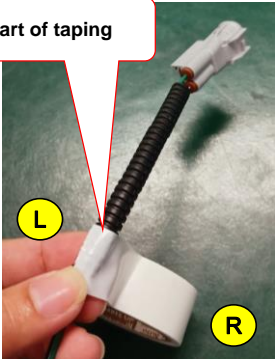
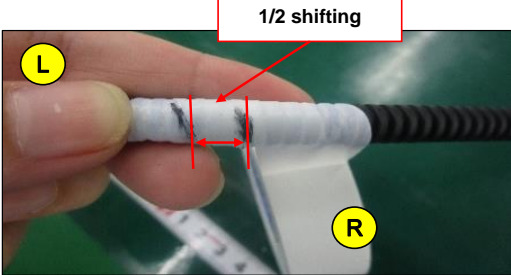
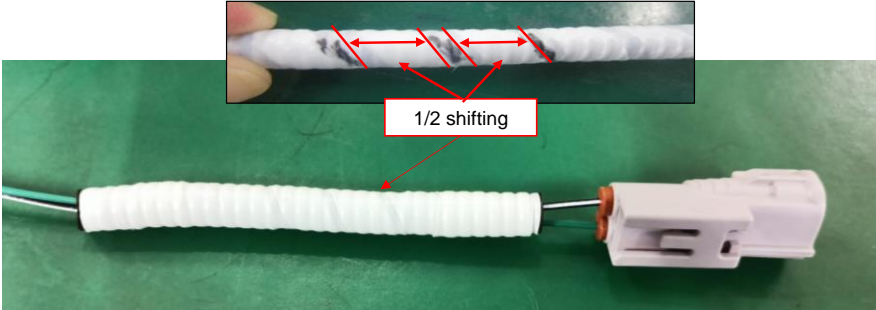

PARTS:		1. Assy parts 2. Black corrugated tube (w/ slit) ø5 L=86±3mm		JIG:	1. COT adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><p>1. Hold the COT adaptor using left hand then insert the wires using right hand.</p></div> <div><p>2. Hold the COT adaptor with wires using left hand, get the Black corrugated tube (w/slit) ø5 L=86±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p></div>		<div>COT ADAPTOR</div> 	1. No wrong use of parts 2. No wires left between COT with slit

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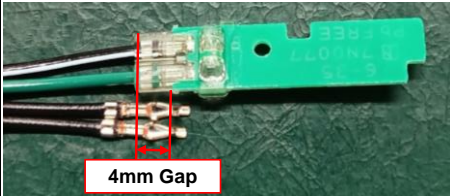



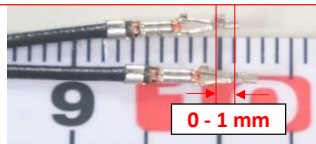
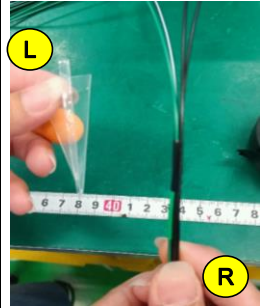
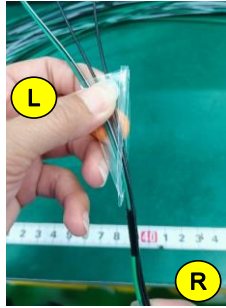
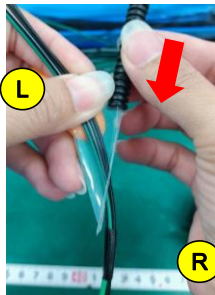

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P1 Half-wrap Taping 1	<div><div>Start of taping</div><div>1. Hold the corrugated tube using left hand and begin taping using right hand.</div></div> <div><div>1/2 shifting</div><div>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 winds and then cut the tape.</div></div> <div><div>3. Check the taping condition.</div></div>		<div>MEASURING TAPE</div> 	Important reminders/Note/s 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used <u>WHITE TAPE</u> to easily visualize the tape shifting, but actual should be <u>BLACK TAPE</u> . 3. Internal tolerance for halfwrap taping shifting should be 0~14mm only. 1. No flip-out tape 2. No peel-off tape 3. No loose/tight tape 4. No missing tape 5. No wrong use of tape 6. No exposed COT between tape windings	


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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:	1. Assy parts 2. Black tape 3. Black corrugated tube (w/slit) ø5 L=396±3mm				JIG:	1. COT adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	Spot taping	<div>   </div> <div> <p>1. Fix the hotmelted wire and terminal pointed tip using both hands (4mm gap).</p> <p>2. Hold the wires using left hand, get the Black tape using right hand then make 2 windings of tape using both hands. Note: Position of spot taping must be right beside Green tape.</p> </div> <div>  <p>3. Check the taping condition and terminal alignment.</p> </div>			<div>  </div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"> No flip-out tape No peel-off tape No loose tape No missing tape No wrong dimension No wrong use of tape <div> <p>Wire alignment tolerance</p>  </div>
7	Wire insertion to Black corrugated tube (w/ slit) ø5 L=396±3mm	<div>    </div> <div> <p>1. Hold the COT adaptor using left hand then insert the wires using right hand.</p> <p>2. Hold the COT adaptor with wires using left hand, get the Black corrugated tube (w/slit) ø5 L=396±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p> </div>			<div>  </div>	<ol style="list-style-type: none"> No wrong use of parts No wires left between COT with slit

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7M0515-7021B



①

No Wrong Insert

②

No Terminal backing out

③

No Deformed terminal

④

No Missing COT

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