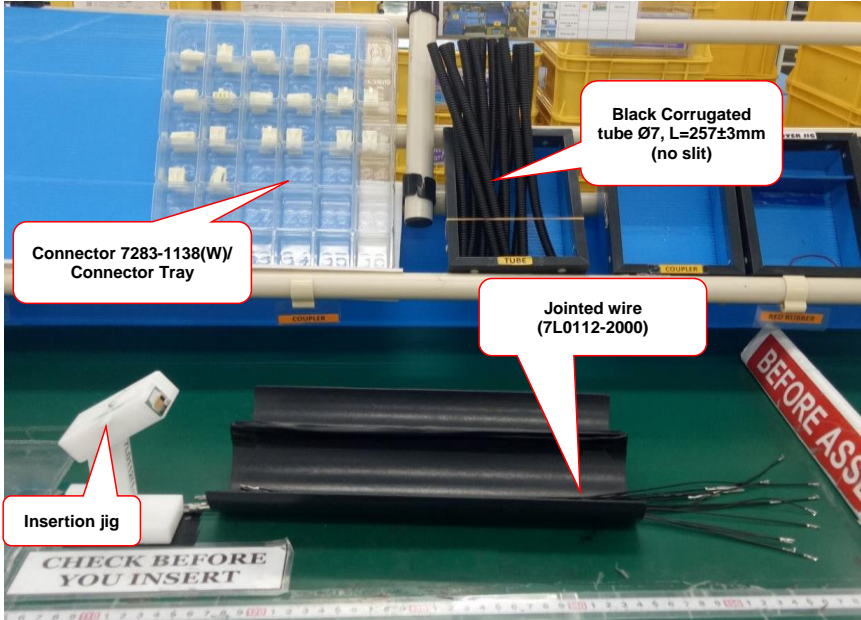
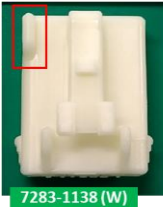
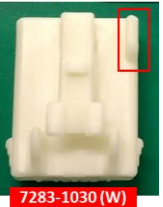
	WORK INSTRUCTION				Effectivity Date:		July 02, 2024	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: TM3 / 7L0112-7020		Customer: TRQSS		Car Model: SUBARU ASCENT	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		Revision No.:		2	Page No.: 1 of 5


PARTS:		1. Connector 7283-1138 (W); Jointed wire B-B 7L0112-2000; Black corrugated tube Ø7, L=257±3mm (no slit)				JIG:		1. Insertion jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		n/a		<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div>7283-1138 (W)</div></div> <div><div>NG</div><div>7283-1030 (W)</div></div> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

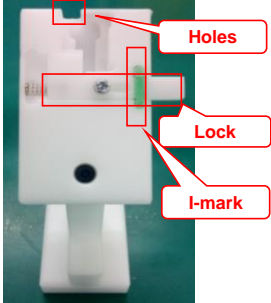



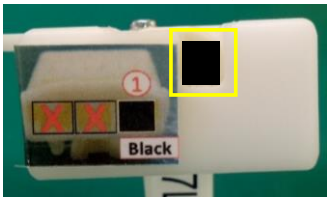
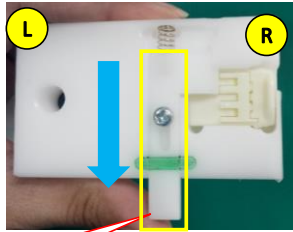
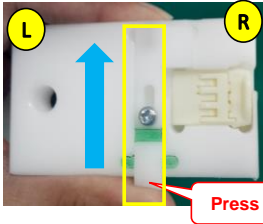
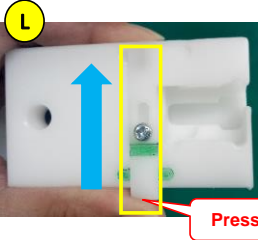
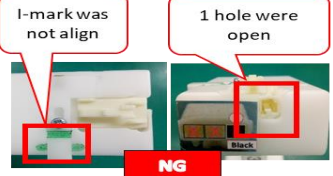
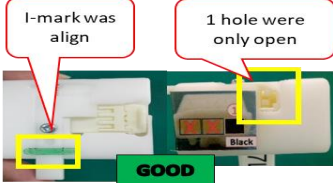


Revision History							Prepared by		Reviewed by		Approved by		Noted by	
07/02/24		2		Change process sequence and removal of terminal cover jig due to process improvement. Inclusion of car model "SUBARU ASCENT" and Measurement.			D. Castillo		C. Villanueva		A. Arañes		n/a	
10/07/22		1		Change Document name/title from Kitting Assembly Process to Offline Assembly Process. Improve quality pointers: Reminders/notes and references on page no. 1, 2 and 3 due to document improvement.			M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
08/26/21		0		Initial issue.			D. Castillo		C. Villanueva		A. Shimamura		A. Arañes	
Eff. Date		Rev. No		Details of Change			Revised		Reviewed		Approved		Noted	
											Est. Date:		August 26, 2021	

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	WORK INSTRUCTION			Effectivity Date:	July 02, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: TM3 / 7L0112-7020		Customer: TRQSS	Car Model: SUBARU ASCENT	Document No.:	WI-ENG-PDE-326	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	2 of 5


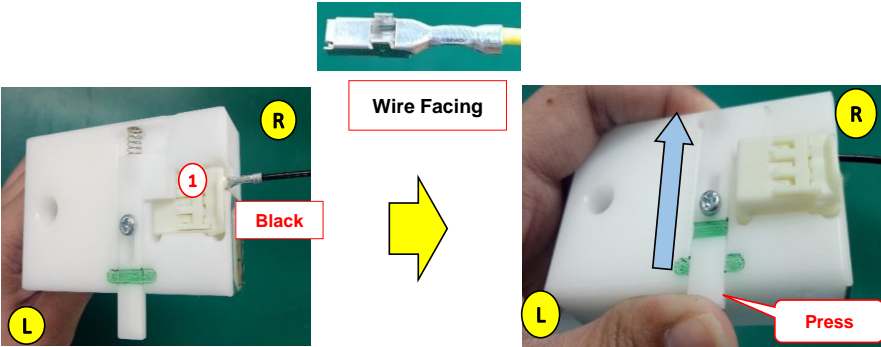
PARTS:	1. Connector 7283-1138 (W)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	n/a	<div><div>Insertion Jig</div><div>Insertion Jig Orientation</div><div>Connector lock</div><div>Connector Orientation</div><div>Connector Setting to insertion jig 7283-1138 (W)</div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 7283-1138 (W) using right hand and release the lock.</div><div>3. Check the holes/terminal slot for Jointed wire (B).</div></div>			n/a	<div>Connector Orientation Illustration</div> <div></div> <div>CONNECTOR ILLUSTRATION</div> <div></div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>		

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	Model code/Part number: TM3 / 7L0112-7020		Customer: TRQSS	Car Model: SUBARU ASCENT	Document No.:	WI-ENG-PDE-326	
	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. Jointed wire B-B 7L0112-2000 2. Black corrugated tube Ø7, L=257±3mm (no slit)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	<div>2</div> <div>Wire insertion to corrugated tube Ø7, L=257±3mm (no slit)</div>	<div></div> <div>1. Get Black Corrugated tube Ø7, L=257±3mm using left hand and insert Jointed wire (7L0112-2000)±3mm using right hand.</div>	n/a	1. No wrong usage of parts	
4	<div>n/a</div> <div>2</div> <div>Wire insertion to Connector 7283-1138 (W)</div>	<div></div> <div>1. Get Jointed wire then insert to terminal slot ① using right hand.</div> <div>2. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during inspection.</div>	

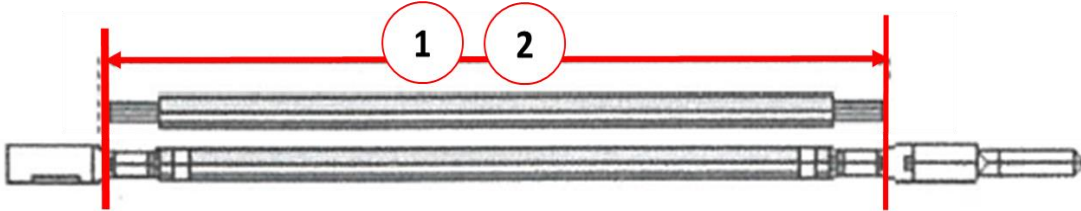
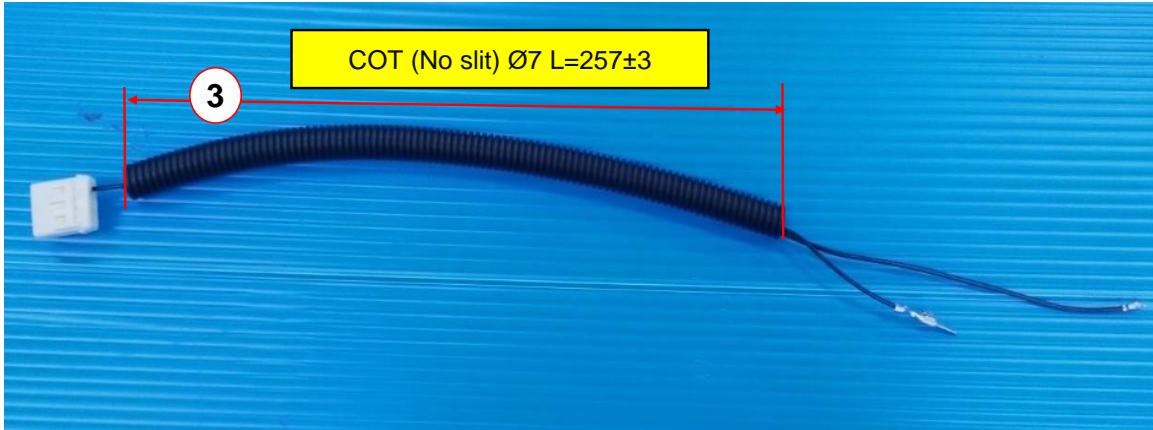

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	WORK INSTRUCTION			Effectivity Date:	July 02, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: TM3 / 7L0112-7020		Customer: TRQSS	Car Model: SUBARU ASCENT	Document No.:	WI-ENG-PDE-326	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	4 of 5

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	Offline Measurement	<p>Note:</p> <ol style="list-style-type: none"> Measurement point: End of core wire to the end of core wire Terminal is reference only.  	<div>Measuring tape</div> 	<p>Important reminders and note/s:</p> <ol style="list-style-type: none"> Please use calibrated/verified measuring tape when getting the measurement. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none"> Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection. <p>1. No wrong usage of parts</p>	

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**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Model code/Part number:

TM3 / 7L0112-7020

Customer:

TRQSS

Car Model:

SUBARU ASCENT

Document No.:

WI-ENG-PDE-326

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

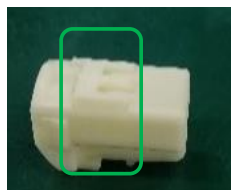
1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0112-7020**

1

**GOOD****NO GOOD**

2



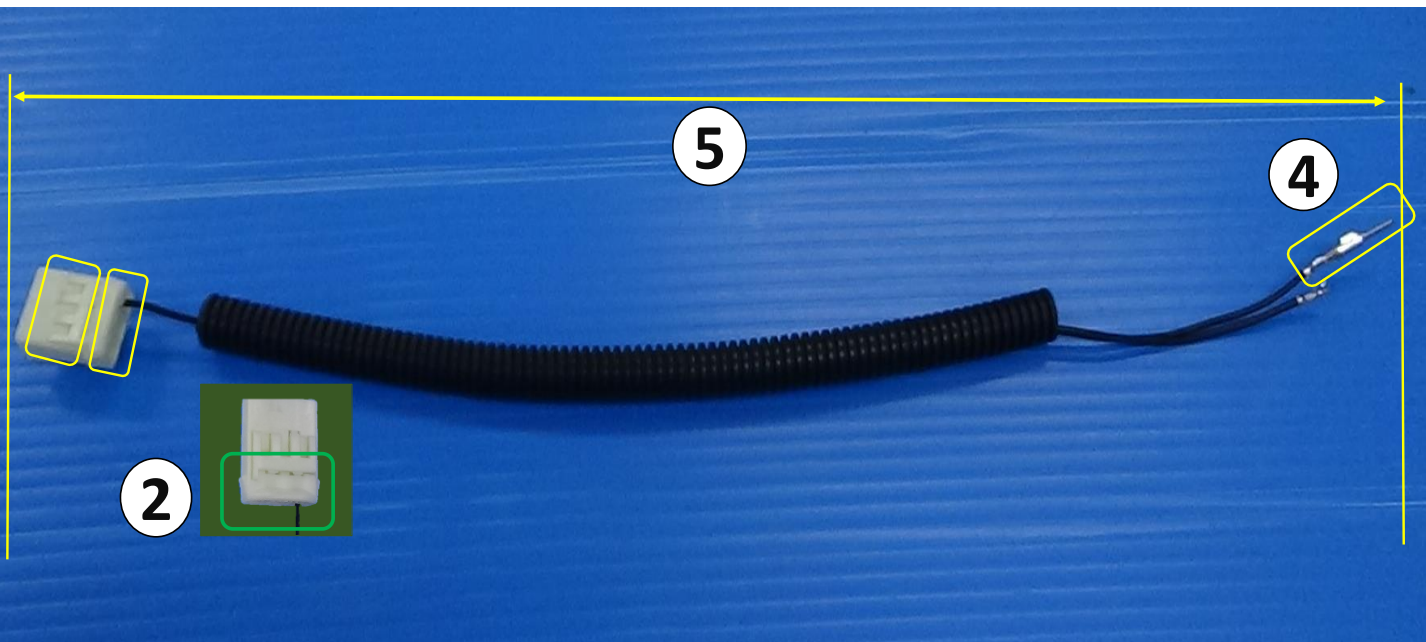
1

No Lock connector

2

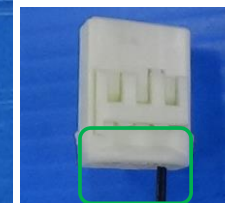
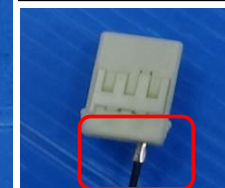
No Wrong insert

5



4

3

**GOOD****NO GOOD**

3

No Terminal Backing Out

4

No Deformed terminal

5

Check the Alignment

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