



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

November 19, 2024

Process Name/Title:

Model code/Part number:

ES1 / 7N0165-7020C

Customer: TRJ

Car Model: SUBARU-FORESTER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1164A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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## PARTS:

1. All parts: Connector 7C83-5524-70 (Y); MRSW CP AVSSf 0.3 wires W-B/W L=765±3mm with inserted Black SV tube (Vinyl) ø5 L=38±3mm; Black Corrugated tube ø7 L=644±6mm; Black tape

JIG:

1. Locking jig 3. Insertion jig  
2. Terminal cover jig 4. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

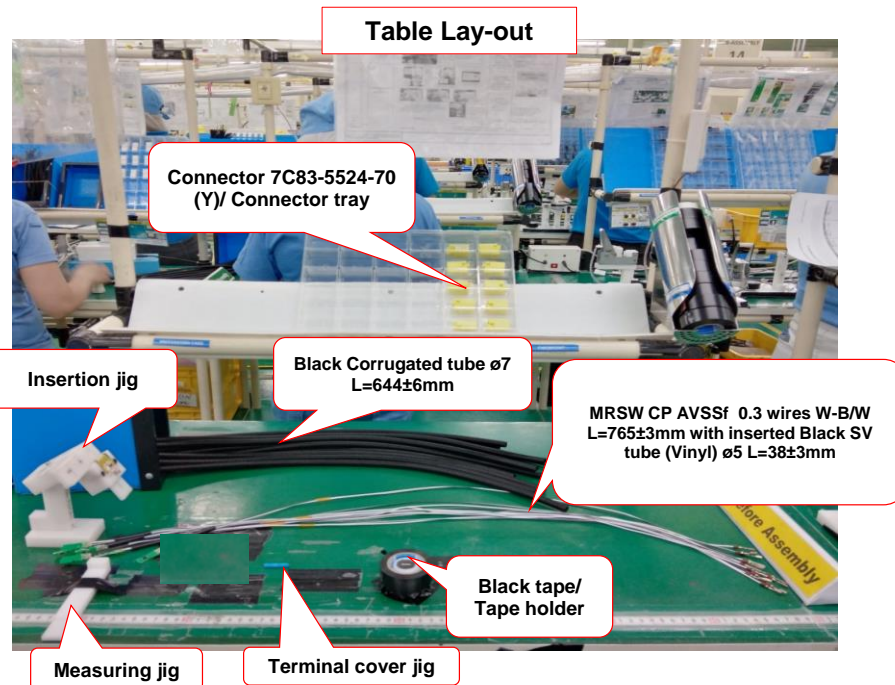
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

**Housekeeping**

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

**Document references:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Refer to WI-PRO-KIT-006 Wire Taping with Vinyl Tube

1. No missing parts/tools
2. No excess parts/tools

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

11/19/24 1 Change pre-launch to mass pro.

A.Hernandez C. Villanueva A. Arañes n/a

11/18/24 0 Initial issue.

A.Hernandez C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

November 18, 2024

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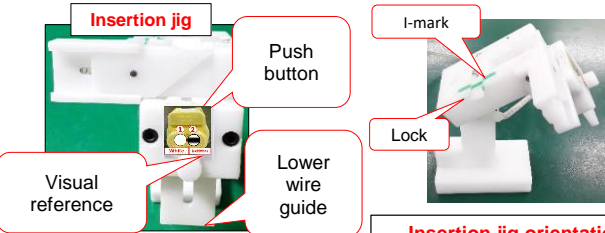

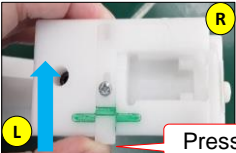
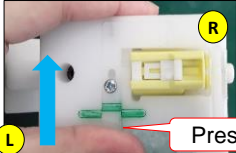
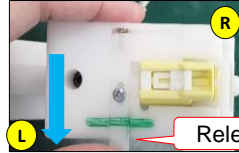

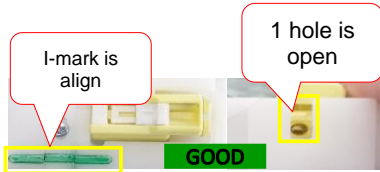
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PARTS:		1. Black Corrugated tube $\varnothing 7$ L=644 $\pm$ 6mm 2. Connector 7C83-5524-70 (Y)		3. MRSW CP AVSSf 0.3 wires W-B/W L=765 $\pm$ 3mm with inserted Black SV tube (Vinyl) $\varnothing 5$ L=38 $\pm$ 3mm		JIG:	1. Insertion jig 2. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2		Wire insertion to Black Corrugated tube $\varnothing 7$ L=644 $\pm$ 6mm (no slit)	<div><div><p>1. Get the terminal cover jig using right hand then insert to both terminals (<b>W-B/W wires</b>) using right hand.</p></div><div><p>1. Hold the corrugated tube <b><math>\varnothing 7</math> L=644<math>\pm</math>6mm</b> using left hand then get the hotmelted <b>W-B/W wires</b> and insert to COT using right hand.</p></div><div><p>3. After insertion, remove the cover jig using right hand.</p></div></div>			<div>TERMINAL COVER JIG</div> 	<p><b>Document references:</b></p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No wrong usage of parts 2. No damaged rubber seal</p>
3		Connector setting to insertion jig 7C83-5524-70 (Y)	<div><div><p>Insertion jig orientation</p></div><div><p>Connector Orientation</p></div><div><p>Press</p><p>Press</p><p>Release</p></div><div><p>1. Press the insertion jig lock using left hand. Get the Connector <b>7C83-5524-70 (Y)</b> and insert to insertion jig using right hand. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p><p>2. Press the lower wire guide using right hand. Slot for <b>White wire</b> will be opened.</p></div></div>			n/a	<p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p> <div>Connector Orientation Illustration</div> <div></div>

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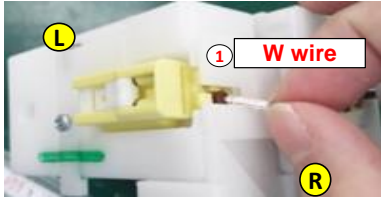

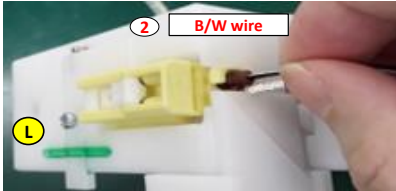
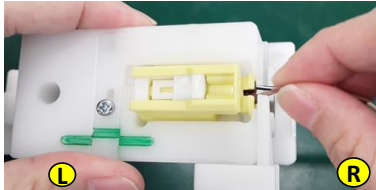




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PARTS:	1. Assy parts ; Connector 7C83-5524-70 (Y)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1  Wire insertion to connector 7C83-5524-70 (Y)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand. Get the <b>White wire</b> then insert to terminal slot <b>1</b> using right hand.</div></div> <div><div>2. Press the button using right thumb. The slot for <b>Black/White wire</b> will be opened.</div></div> <div><div>3. Get the <b>Black/White wire</b> then insert to terminal slot <b>2</b> using right hand.</div></div> <div><div>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.</div></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</p> <div><p><b>EMERGED RUBBER SEAL CROSS SECTIONAL VIEW</b></p><div><div>Not fully inserted rubber seal</div></div><p><b>RUBBER SEAL CONDITION ILLUSTRATION</b></p><div></div></div>

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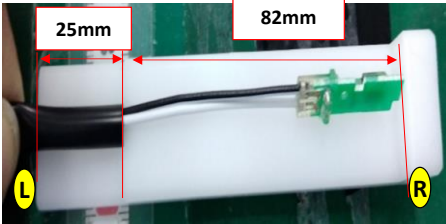
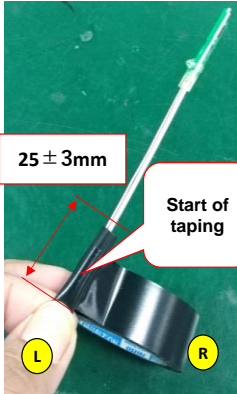
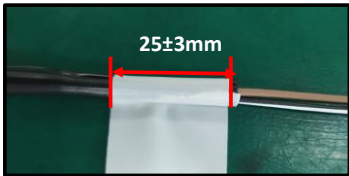
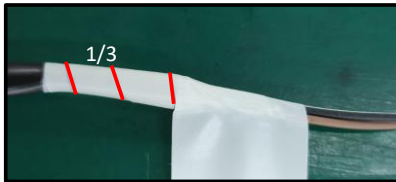


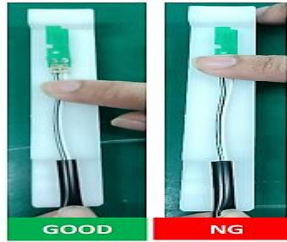
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black SV tube (Vinyl) to wire near PCB	<div><p>1. Conduct measurement on measuring jig by placing the assy parts on guide dimension. (See illustration)</p></div> <div><p>2. Hold the tube using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</p></div> <div><p><b>TAPING PROCEDURES</b></p><div><p>3. Attach tape then conduct <b>1 winding</b> while folding the SV tube (Vinyl)</p></div><div><p>4. Shift the tape <b>1/3 shifting</b> going to wires <i>note: 1/3 shifting must be within the foded SV tube (VINYL)</i></p></div></div>		<div><p><b>MEASURING TAPE</b></p></div> <div><p><b>MEASURING JIG</b></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> <b>1. Used <u>WHITE TAPE</u> to easy visualization of shifting lines, but in actual should be <u>BLACK TAPE</u></b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>3. First dimension will be conducted using measuring jig</b></p> <div><p><b>GOOD</b>      <b>NG</b></p></div> <p><b>Position the finger in wire to avoid deformed hotmelt</b></p>

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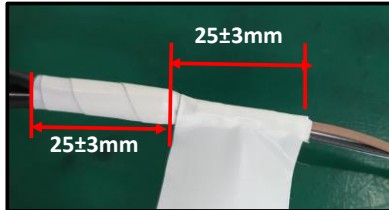

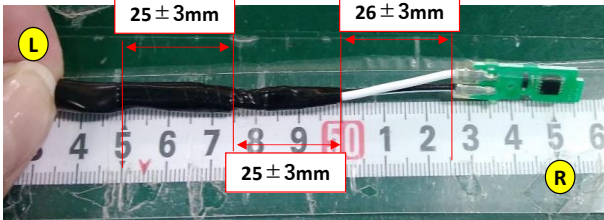


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PARTS:		1. Assy parts 2. Black tape		JIG:	1.Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black SV tube (Vinyl) to wire near PCB (Continuation)	<div><p>5. Conduct <u>1</u> wind</p></div> <div><p>6. Conduct <u>2x</u> windings</p></div> <div><p>7. Conduct <u>3x</u> pressing at the end</p></div> <div><p>8. After taping, check the taping condition and measurement.</p></div>		<div><p>MEASURING TAPE</p></div> <div><p>MEASURING JIG</p></div>	<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Used <b>WHITE TAPE</b> to easy visualization of shifting lines, but in actual should be <b>BLACK TAPE</b></li><li>2. Please use calibrated/verified measuring tape when getting the measurement.</li><li>3. First dimension will be conducted using measuring jig</li></ol> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol>

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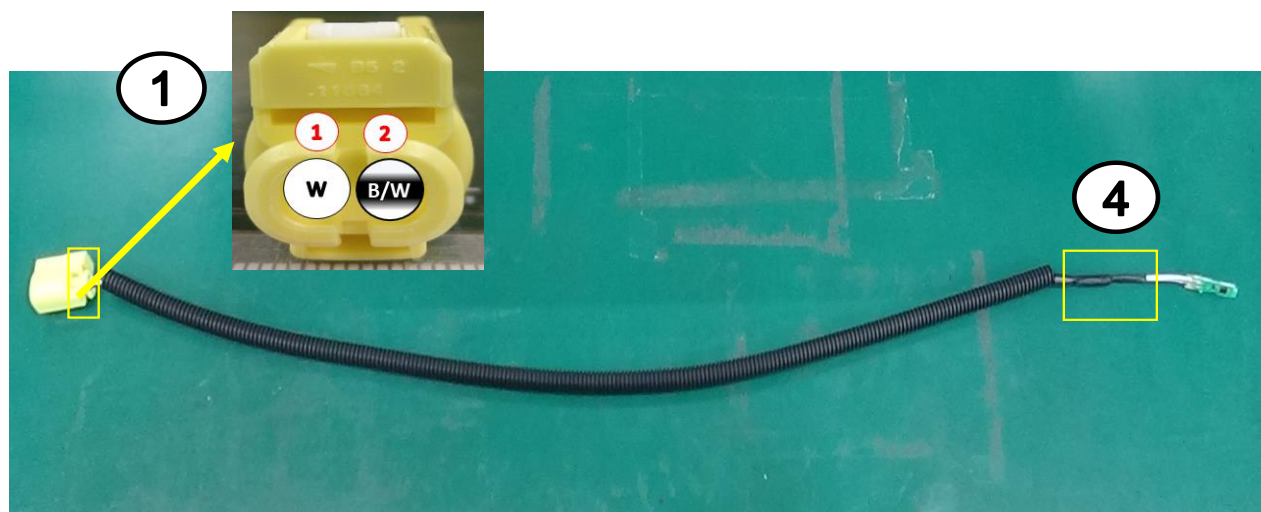
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7N0165-7020C**

- ① No Wrong Insert
- ② No Terminal backing out
- ③ No Deformed terminal
- ④ No Missing tape (Black tape)
- ⑤ No Missing tape parts

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