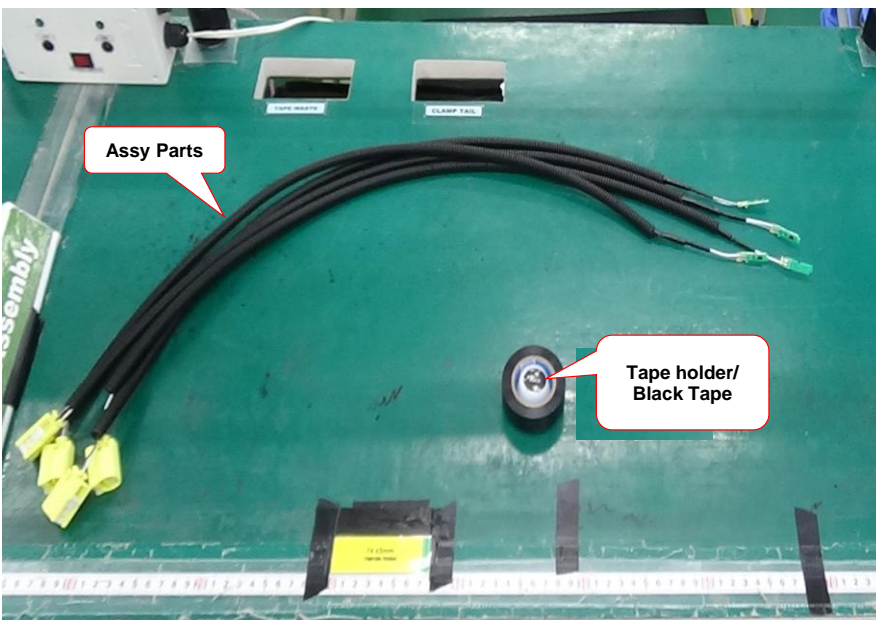

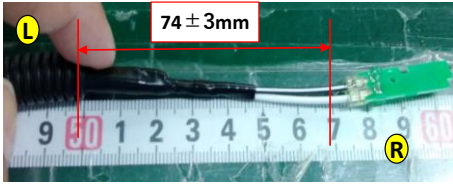
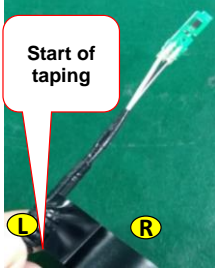
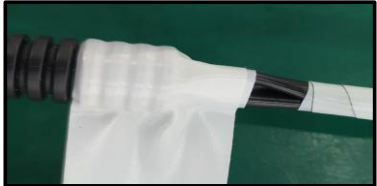

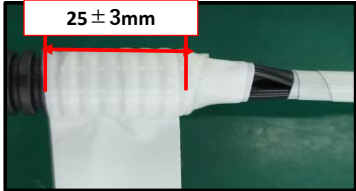

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: June 11, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: ES1 / 7N0165-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.: WI-ENG-PDE-620B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.: 1	of 7

PARTS: 1. Assy Parts ; Black tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P2 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">Table Lay-out</div>  </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>
Revision History		Prepared by: [Signature] D. Castillo Reviewed by: [Signature] C. Villanueva Approved by: [Signature] A. Arañes Noted by: n/a	
06/11/24	3	Separate Clamp setting and Clamp assembly to Clamp assembly process. Transfer Taping 2 from WI-ENG-PDE-620A due to process improvement. Update Table lay-out and Quality checkpoints.	
04/06/23	2	Change taping procedure due to tape reduction project (Page 3-4).	
01/25/23	1	Change document purpose from Pre-launch to masspro. Additional table layout.	
Eff. Date	Rev. No	Details of Change	Est. Date: January 19, 2023

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: ES1 / 7N0165-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-620B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	2 of 7

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
2	P2 Taping 2 Black COT (no slit) to Black SV tube (Vinyl) near PCB	<div><p>1. Measure from end of COT up to end of PCB 74±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>TAPING PROCEDURE</p><div><p>3. 1 wind pre-tape in the middle of COT and SV tube (Sunprene)</p></div><div><p>4. Shift the tape 1x shifting going to COT must be tape width</p></div><div><p>5. Conduct 1 wind before shifting</p></div></div> <div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <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>				

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Customer:

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Document No.:

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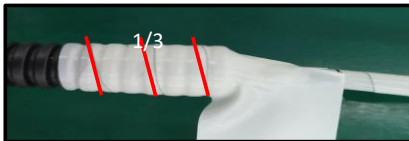

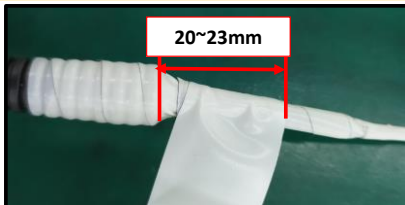

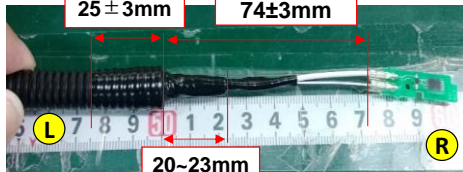


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black COT (no slit) to Black SV tube (Vinyl) near PCB (Continuation)	<div> 6. Shift the tape <u>1/3 shifting</u> going to VT see above illustration for proper shifting <i>note: 1/3 shifting must be within the COT</i></div> <div> 7. Shift the tape <u>1x shifting</u> until reach the tape width</div> <div> 8. Conduct <u>2x windings</u> before end of tape</div> <div> 9. Conduct <u>3x</u> pressing at the end of tape to prevent peel off</div> <div> 10. After taping, check the taping condition and measurement.</div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <div>NG TAPING ILLUSTRATION</div>  <div>Exceed 24mm consider as NG dimesion</div>

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Customer:

TRJ

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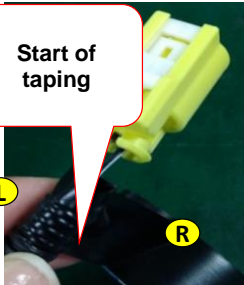
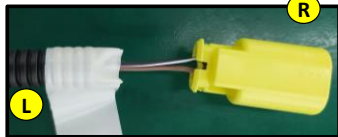
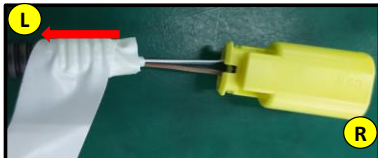
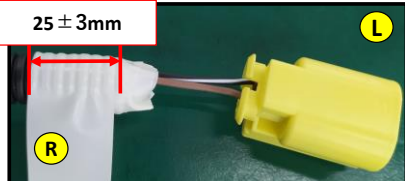
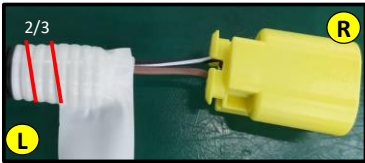
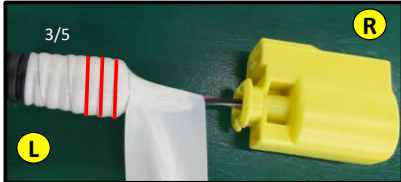

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 3 COT to wire near connector	<div><div><div>Start of taping</div></div><div><div>1. Hold the Corrugated tube using left hand, get the Black tape using right hand then start taping procedure using both hands. <i>(Please refer below for taping procedure)</i></div><div><div>TAPING PROCEDURES</div><div><div>2. 2 winds pre-tape in the middle of COT and wires</div></div></div><div><div><div>3. Shift the tape 1x shifting going to COT must be tape width</div></div><div><div><div>25 ± 3mm</div><div>4. Conduct 1 wind before shifting</div></div></div><div><div><div>5. Shift the tape 2/3 shifting upward <i>refer to above illustration for shifting direction</i></div></div><div><div><div>6. Shift the tape 3/5 shifting upward <i>note: 3/5 shifting must be within the cot</i></div></div></div></div></div></div></div>		<div><div>MEASURING TAPE</div></div>	<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE</div> <div>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</div>

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TRJ

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WI-ENG-PDE-620B

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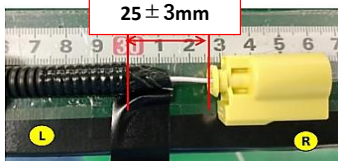
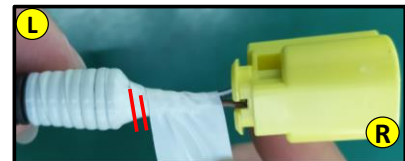
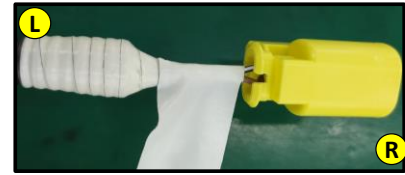
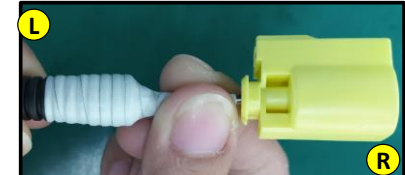
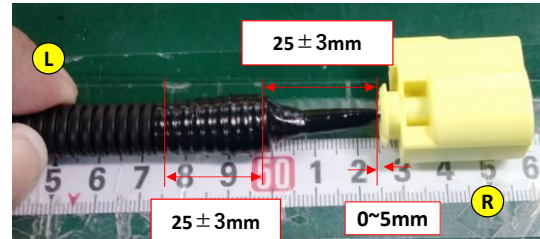

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 COT to wire near connector (Continuation)	<div><p>7. Shift the tape <u>1/2 shifting</u> upward until reach the 0~5mm from connector to tape</p></div> <div><p>8. Shift the tape <u>1/2 shifting</u> upward until reach the 0~5mm from connector to tape</p></div> <div><p>9. Conduct <u>2x windings</u> before end of tape</p></div> <div><p>10. Conduct <u>3x</u> pressing at the end of tape to prevent peel off</p></div> <div><p>11. After taping, check the taping condition and measurement.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Used <u>WHITE TAPE</u> to easy visualization of shifting lines, but in actual should be <u>BLACK TAPE</u> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

n/a

Model code/Part number:

ES1 / 7N0165-7020A

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Document No.:

WI-ENG-PDE-620B

Purpose:

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PARTS:		1. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P2	Measurement	<div>MEASURING TAPE</div> <div></div> <div></div> <div>NOTE: A - Taping (B)</div>		<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>	1. No wrong dimension

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PARTS:

1. Assy parts

JIG:

n/a



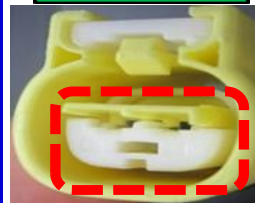
VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

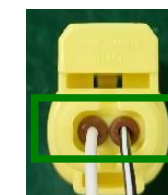
7N0165-7020A



GOOD



NG



GOOD



NO GOOD

1

No **Unlock/ Half Lock**

Check the **CONNECTOR LOCK** if properly locked.

2

No **Wrong Insert**

3

No **Terminal Backing out**

4

No **Missing Parts**

5

No **Missing tape (SV tube (Vinyl) to Wire ; COT to SV tube (Vinyl) ; COT to wire near connector**

6

No **Damaged PCB**

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