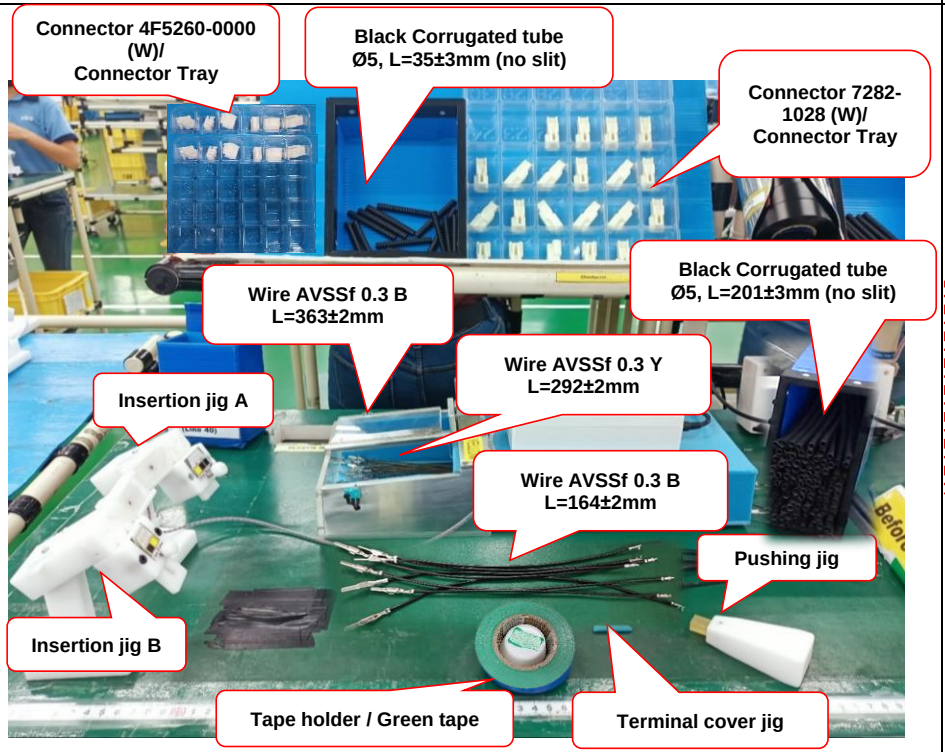
	WORK INSTRUCTION			Effectivity Date:	September 29, 2023	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: TP1 / 7L0088-7023B	Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 10

PARTS:	1. Connector 4F5260-0000(W); Connector 7282-1028 (W) 2. AVSSf 0.3 B L=363±2mm 3. AVSSf 0.3 Y L=292±2mm 4. AVSSf 0.3 B L=164±2mm 5. Black Corrugated tube (no slit) B L=35±2mm 6. Black Corrugated tube (no slit) B L=201±2mm 7. Green Tape	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out		**Safety Instruction** Be sure to wear prescribed 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.	1. No deformed terminal 2. No wrong usage of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
09/29/23	1	Change from pre-launch to mass pro and inclusion of table lay-out.	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes
09/02/23	0	Initial Release	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
A.Hernandez	C. Villanueva	A. Arañes	n/a
Est. Date:	September 02, 2023		

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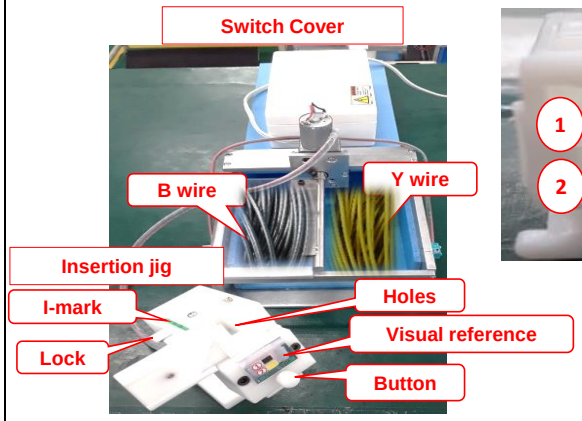
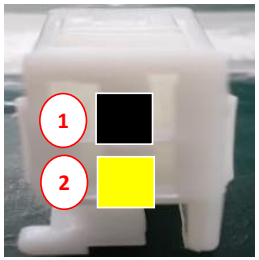
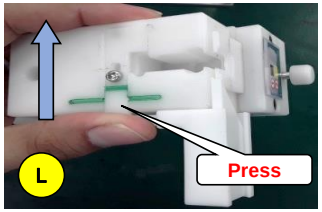
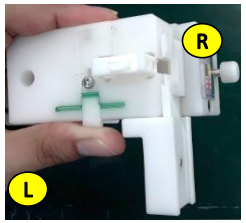
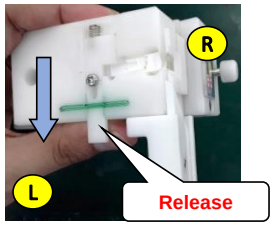
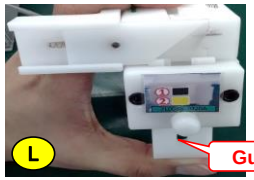
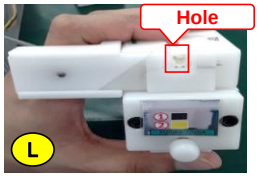
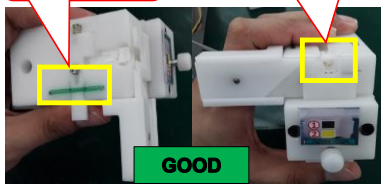
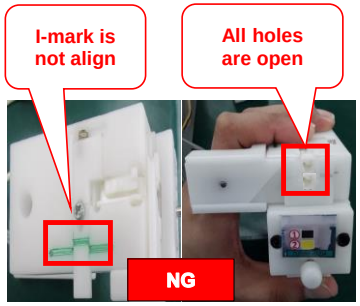
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	TP1 / 7L0088-7023B	Customer: TRQSS / Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 2 of 10

PARTS:	1. Connector 4F5260-0000 (W)	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector setting to insertion jig 4F5260-0000 (W)	  CONNECTOR ORIENTATION    1. Press the lock of insertion jig using left thumb. 2. Insert the connector **4F5260-0000 (W)** into jig using right hand and release the lock.   3. Push the guide using left hand. The slot for **B wire** will be opened.	N/A	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector **Connector Orientation Illustration**  

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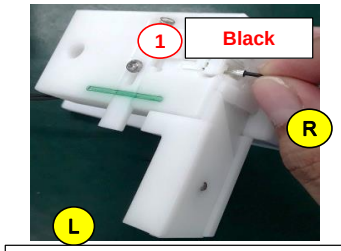
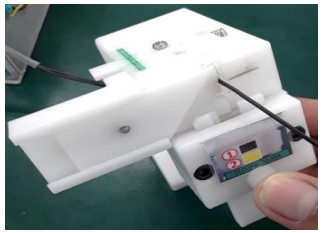
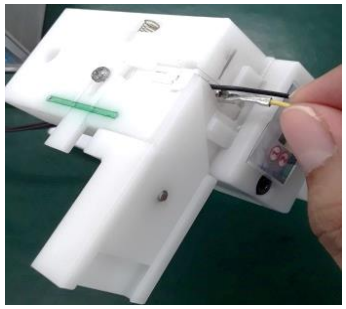
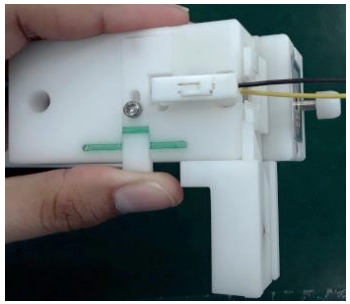
	WORK INSTRUCTION			Effectivity Date:	September 29, 2023	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: TP1 / 7L0088-7023B	Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 3 of 10

PARTS:	1. AVSSf 0.3 B L=363±2mm; Y L=292±2mm			JIG:	1. Insertion jig 2. Locking jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	n/a	Wire insertion to connector 4F5260-0000 (W)	 Wire facing  1. Get the **B wire** then insert to terminal slot **1** using right hand.  2. After insertion of **B wire** press the button using right hand. The slot for **Y wire** will be opened.  3. Get the **Y wire** then insert to terminal slot **2** using right hand.  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.	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Notes:*** *1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.* *Don not exert extra force.* *2. Please hold the wire near terminal.* ***Document references:*** *1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.* *2. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.*

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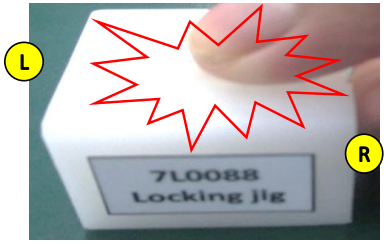
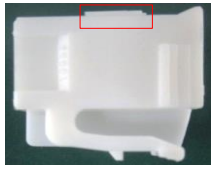
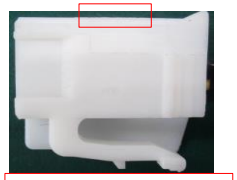
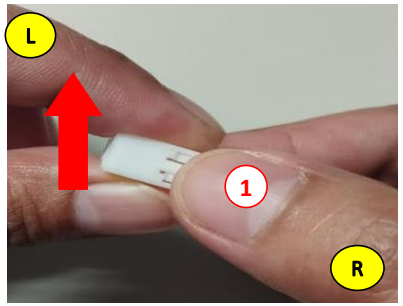
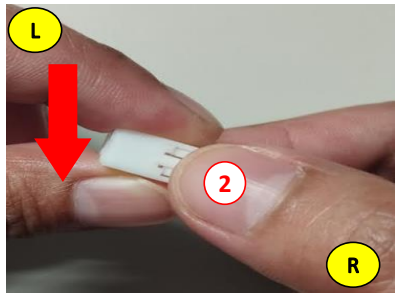
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 — Page No.: 4 of 10

PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	Connector Lock	  BEFORE PRESSING  AFTER PRESSING 1. Put the connector into locking jig using right hand then press **2x** using both hands.   2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.	LOCKING JIG 	1. Use the provided locking jig per model 2. No unlock/half-locked connector ***Important reminders/Notes:*** *1. Manual locking may cause damaged connector lock.*

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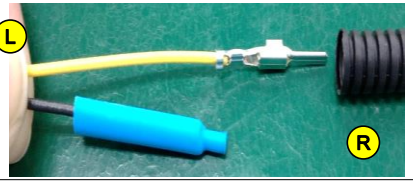
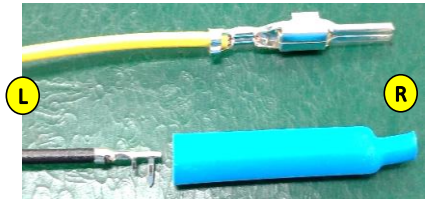
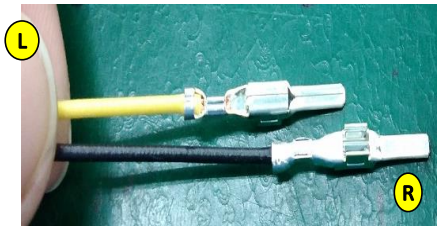
	Model code/Part number: TP1 / 7L0088-7023B	Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 10

PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=201±3mm 3. Black Corrugated tube (no slit) Ø5 L=35±3mm 4. AVSSf 0.3 B L=164±2mm	JIG:	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Wire insertion to Black Corrugated tube (no slit) Ø5 L=201±3mm	 1. Get the terminal cover jig and insert to **B wire** using right hand.  2. Get the Corrugated tube (no slit) **Ø5 L=201±3mm** using right hand and insert the wires using left hand.  3. Remove the terminal cover jig using right hand after insertion.	**TERMINAL COVER JIG** 	1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Black Corrugated tube (no slit) Ø5 L=35±3mm	 1. Get the **B wire L=164±1mm** using right hand then combine to Y wire. 2. Get the corrugated tube (no slit) **Ø5 L=35±3mm** using right hand then insert the **B-Y wires** using left hand.	N/A	1. No wrong use of parts 2. No deformed terminal ***Document references:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.***

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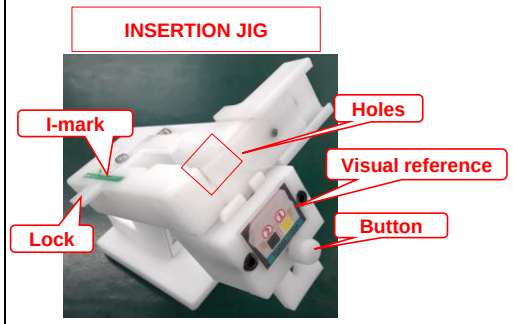
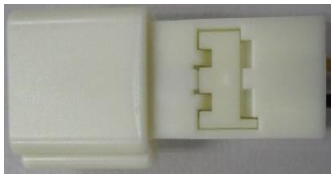
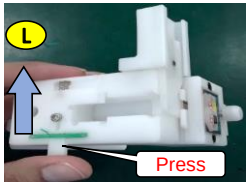
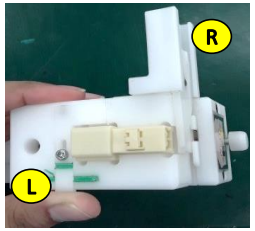
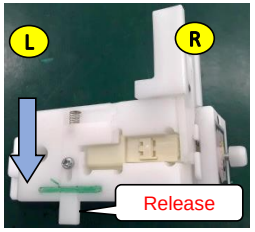
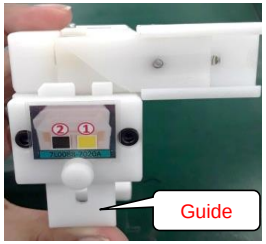
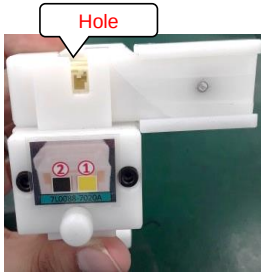
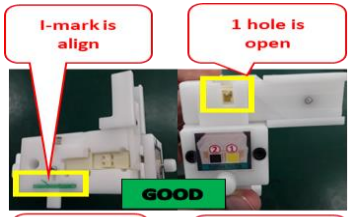
	Model code/Part number:	TP1 / 7L0088-7023B	Customer: TRQSS / Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 6 of 10

PARTS:	1. Assy parts:Connector 7282-1028 (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a	Connector setting to insertion jig 7282-1028 (W)	  CONNECTOR ORIENTATION  1. Press the lock of insertion jig using left thumb.   2. Insert the connector **7282-1028 (W)** into jig using right hand and release the lock.   3. Push the guide using left hand. The slot for **Y wire** will be opened.	N/A	**Connector Orientation Illustration**  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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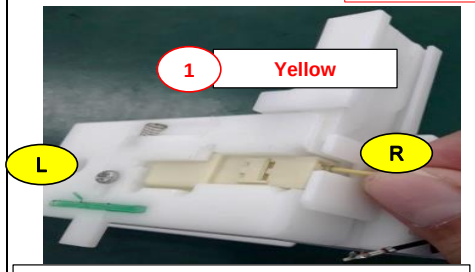
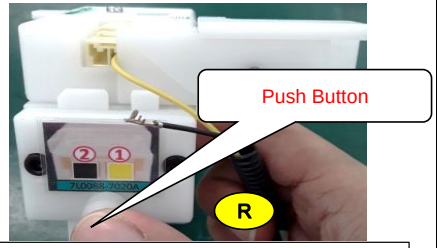
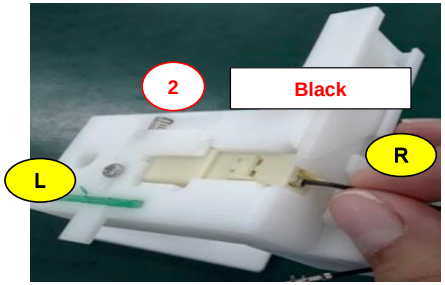
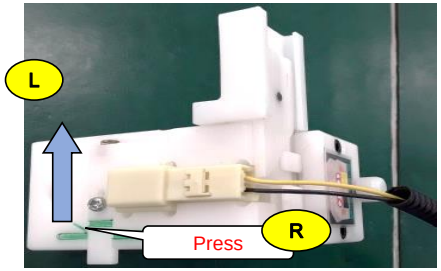
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: TP1 / 7L0088-7023B	Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 7 of 10

PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	n/a	Wire insertion to connector 7282-1028 (W)	 WIRE FACING  1. Hold the **Y wire** then insert to terminal slot **1** using right hand.  2. After insertion of **Y wire** press the button using left hand. The slot for **B wire** will be opened.  3. Hold the **B wire** then insert to terminal slot **2** using right hand.  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.	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***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.*** ***Document references:*** ***1. Refer to GL-PRO-ASSY-029 for Pull-Push procedure.***

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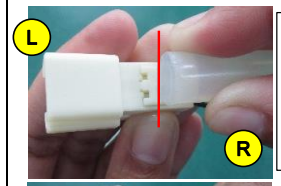
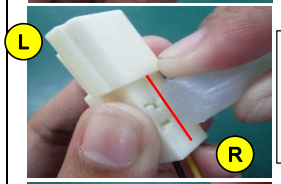
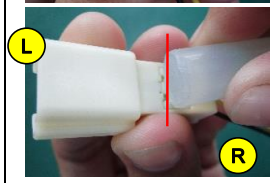
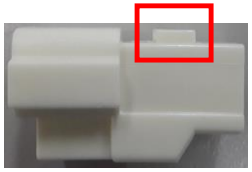
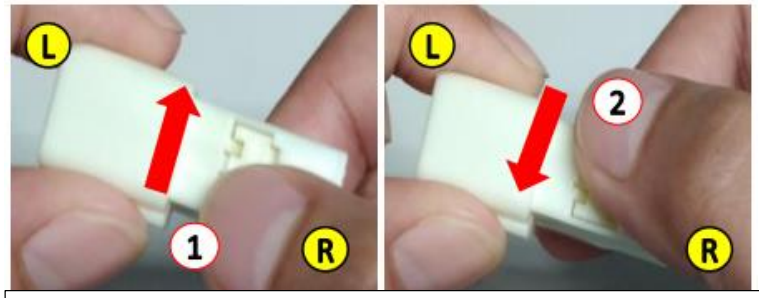
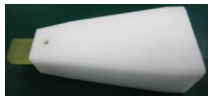
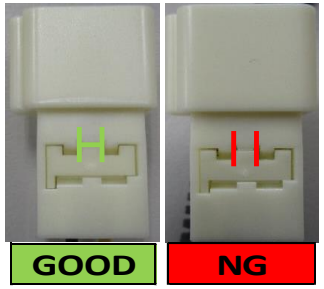
	Model code/Part number:	TP1 / 7L0088-7023B	Customer: TRQSS / Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-723A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 — Page No.: 8 of 10

PARTS:	1. Assy parts	JIG:	1. Pushing jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	n/a	Connector lock	 1. Get the Gluestick using right hand and hold the connector using left hand and then push down the lower part of the connector lock using gluestick.  2. Push down the upper center part of the connector lock using gluestick.  3. Push down the upper part as a whole to properly lock the connector.  BEFORE PRESSING AFTER PRESSING  2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.	PUSHING JIG 	1. No unlock/half-locked connector *Important reminders/notes:* *1. Manual locking may cause damaged connector lock.* *2. Position of glue stick must be slanted.* LOCK CONDITION 

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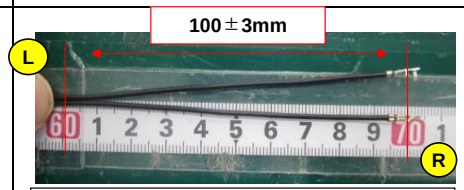
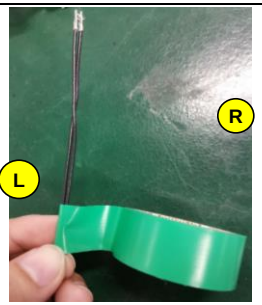
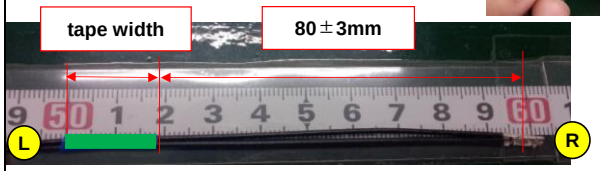
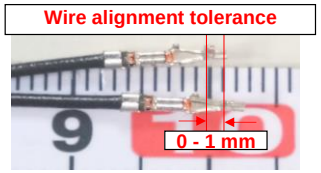
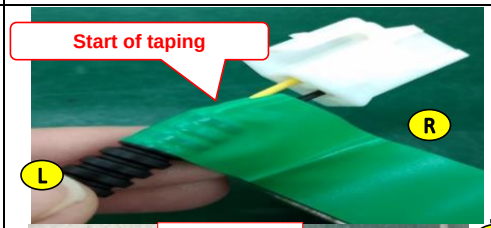
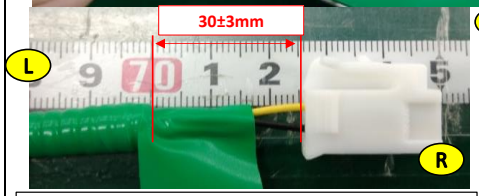
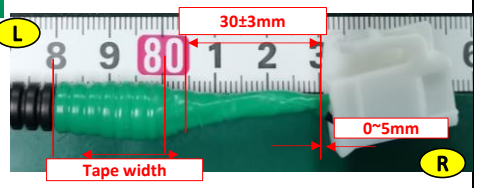
PARTS:	1. Assy parts 2. Green tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	n/a	Spot Taping	 1. Hold wires using left hand, measure the wire upd to terminal tip 100±3mm.  2. Get the **Green tape**, conduct 2x windings of tape then cut using both hand.  3. After taping, check the measurement and taping condition.	N/A	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape ***Important reminders/Note/s:*** *1.Use **GREEN TAPE** only.* *2. Please use calibrated/verified measuring tape when getting the measurement.* 
10		Taping 1 COT to wire near connector	 1. Hold the COT using left hand and start taping using right hand.  2. Measure from COT up to the end of connector **30±3mm** using both hands then continue the taping process.  3. After taping, check the dimension and taping condition.	MEASURING TAPE 	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape ***Important reminders/Note/s:*** *1.Use **GREEN TAPE** only.* *2. Please use calibrated/verified measuring tape when getting the measurement.*

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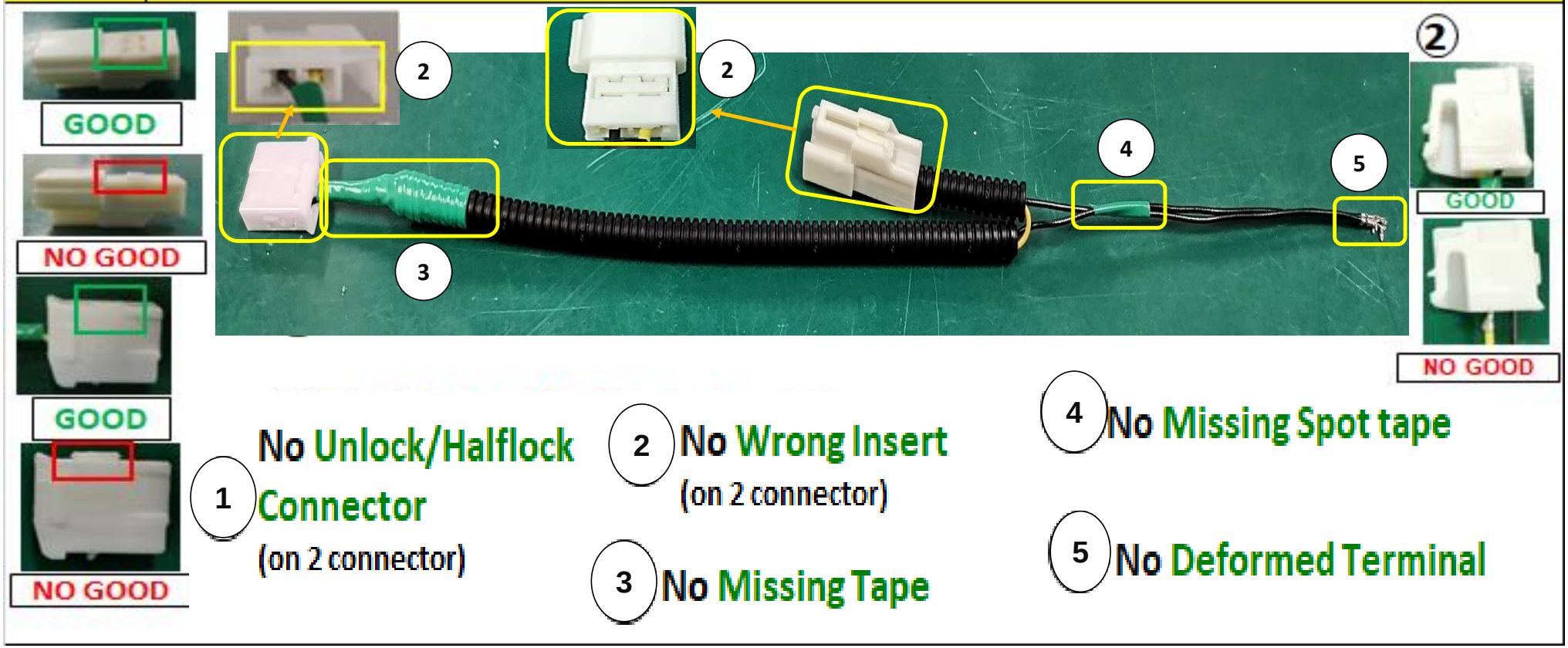
PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

P1 **7L0088-7023B**



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