
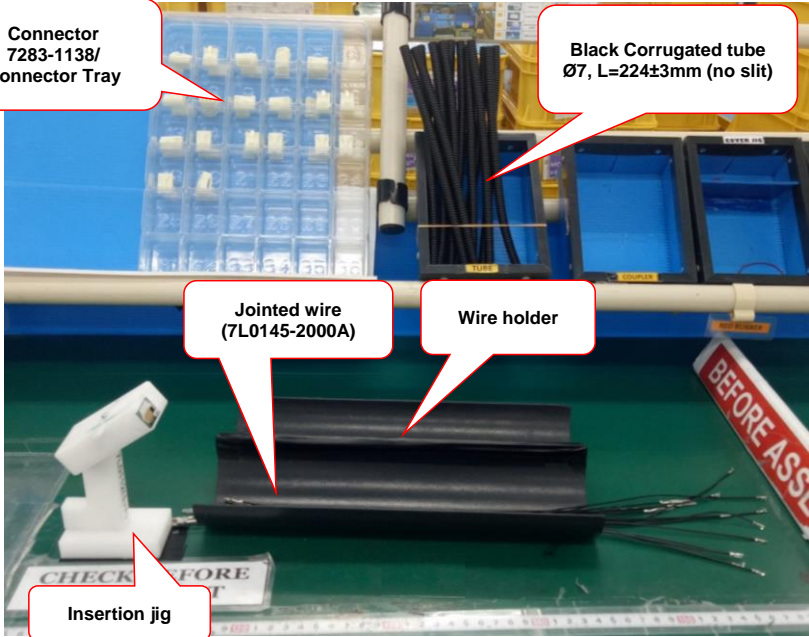
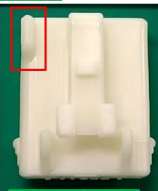
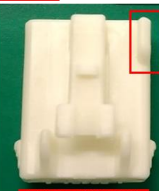





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|  | WORK INSTRUCTION | | | | Effectivity Date: | | July 04, 2024 | |
| | Process Name/Title: OFFLINE ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: TM3 / 7L0145-7020A | | Customer: TRQSS | | Car Model: SUBARU-ASCENT | | Document No.: WI-ENG-PDE-713 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | | 2 | Page No.: 1 of 5 |

| | | | | | | | | | |
|---------------|---------------------|---|--|--|--|--|--|---|--|
| PARTS: | | 1. All parts; Connector 7283-1138 (W); Jointed wire B-B 7L0145-2000A; Black corrugated tube Ø7, L=224±3mm (no slit) | | | | JIG: | | 1. Insertion jig | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | | TOOLS/PPE | | QUALITY POINTERS | |
| 1 | Offline | <div style="text-align: center;"> TABLE LAY-OUT </div>  | | | | <div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div> | | <div style="text-align: center;"> CONNECTOR ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; font-weight: bold; padding: 2px;">GOOD</div>  <div style="background-color: green; color: white; font-weight: bold; padding: 2px;">7283-1138 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; font-weight: bold; padding: 2px;">NG</div>  <div style="background-color: red; color: white; font-weight: bold; padding: 2px;">7283-1030 (W)</div> </div> </div> | |

| Revision History | | | | | | | | Prepared by | Reviewed by | Approved by | Noted by | | |
|------------------|---------|---|--|--|--|------------|--------------|--------------|-------------|--|--|--|-----|
| 07/04/24 | 2 | Change process sequence due to removal of cover jig. Inclusion of Measurement and improved Visual inspection/Quality checkpoints. | | | | D.Castillo | C.Villanueva | A. Arañes | n/a |  D. Castillo |  C. Villanueva |  A. Arañes | n/a |
| 08/26/23 | 1 | Change Pre-launch to Masspro. Additional Table lay-out and provision of insertion jig. | | | | D.Castillo | J.Loterte | C.Villanueva | A. Arañes | | | | |
| 07/24/23 | 0 | Initial issue. | | | | D.Castillo | J.Loterte | C.Villanueva | A. Arañes | | | | |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted | Est. Date: | July 24, 2023 | | |

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**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 04, 2024

Model code/Part number:

TM3 / 7L0145-7020ACustomer: **TRQSS**Car Model: **SUBARU-ASCENT**

Document No.:

WI-ENG-PDE-713

Purpose:

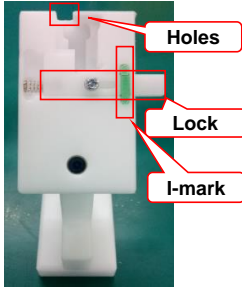
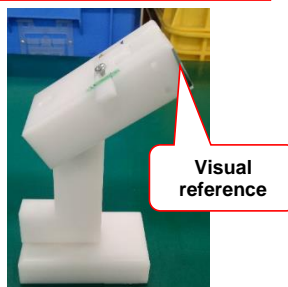
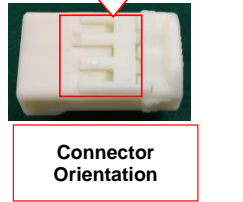
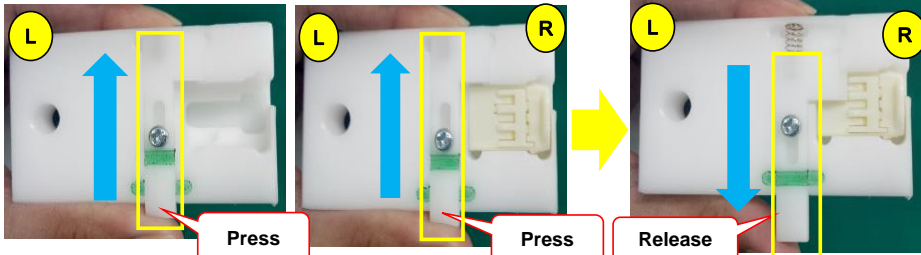
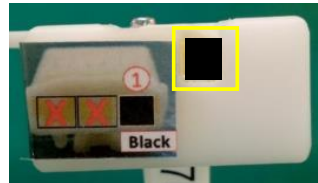
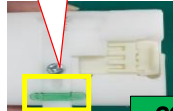



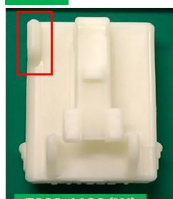
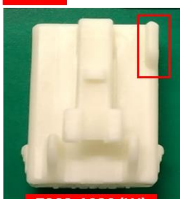
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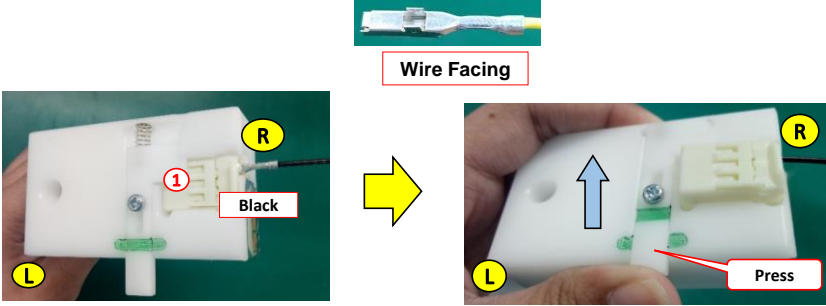
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|--------|--|--|--|-----------|--|
| PARTS: | | 1. Connector 7283-1138 (W) | | JIG: | 1. Insertion jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | Offline Connector Setting to insertion jig 7283-1138(W) | <div><div><div>Insertion Jig</div></div><div><div>Insertion Jig Orientation</div></div><div><div>Connector lock</div></div></div> <div><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 using left hand. Note: Follow the connector orientation.</div></div><div><div></div><div>3. Check the holes/terminal slot for Jointed wire (B).</div></div></div> | | n/a | <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole were only open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>1 hole were open</div><div>NG</div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>7283-1138 (W)</div></div><div><div>NG</div><div>7283-1030 (W)</div></div></div></div> |

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|  | WORK INSTRUCTION | | | | Effectivity Date: | | July 04, 2024 | |
| | Process Name/Title: OFFLINE ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: TM3 / 7L0145-7020A | | Customer: TRQSS | Car Model: SUBARU-ASCENT | Document No.: | | WI-ENG-PDE-713 | |
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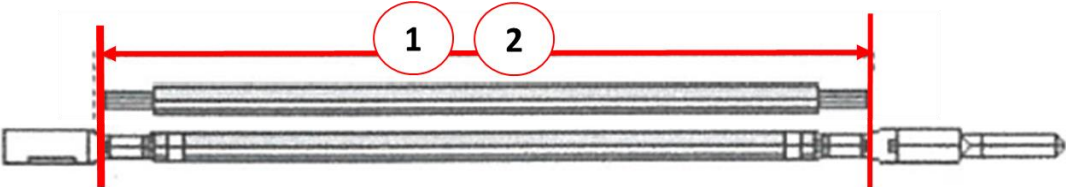
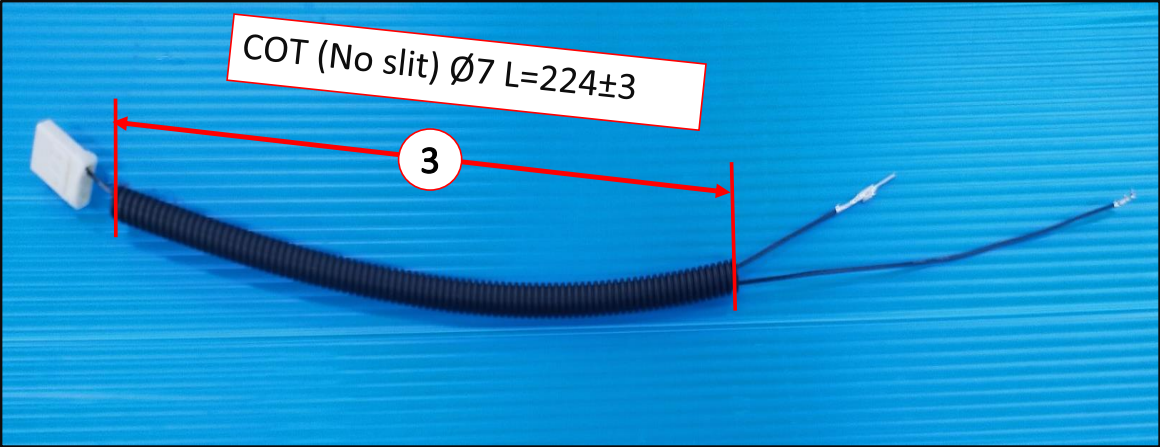

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|---------------|--|---|------------------|---|-----------------------|
| PARTS: | 1. Black corrugated tube Ø7, L=224±3mm (no slit) 2. Jointed wire B-B 7L0145-2000A | | | JIG: | 1. Terminal cover jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS | |
| 3 | Wire insertion to Corrugated tube Ø7, L=224±3mm (no slit) |  <div>1. Get black corrugated tube Ø7, L=224±3mm using left hand then insert Jointed wire (7L0145-2000A) using right hand.</div> | n/a | 1. No deformed terminal 2. No wrong usage of parts | |
| 4 | Offline Wire insertion to Connector 7283-1138(W) |  <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 | 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. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure. | |

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| | | | | | |
|---------------|---------------------|---|--|--|---|
| PARTS: | 1. Assy parts | | | JIG: | 1. Insertion jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | Offline Measurement | <div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> | | <div>MEASURING TAPE</div> <div></div> | <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div> |

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**WORK INSTRUCTION**

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OFFLINE ASSEMBLY PROCESS

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TM3**/ 7L0145-7020A**

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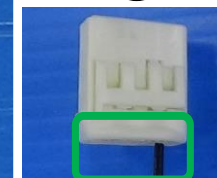
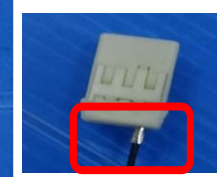
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0145-7020A****1****GOOD****NO GOOD****2****1****No Lock connector****2****No Wrong insert****3****GOOD****NO GOOD****3****No Terminal Backing Out****4****No Deformed terminal****4**

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