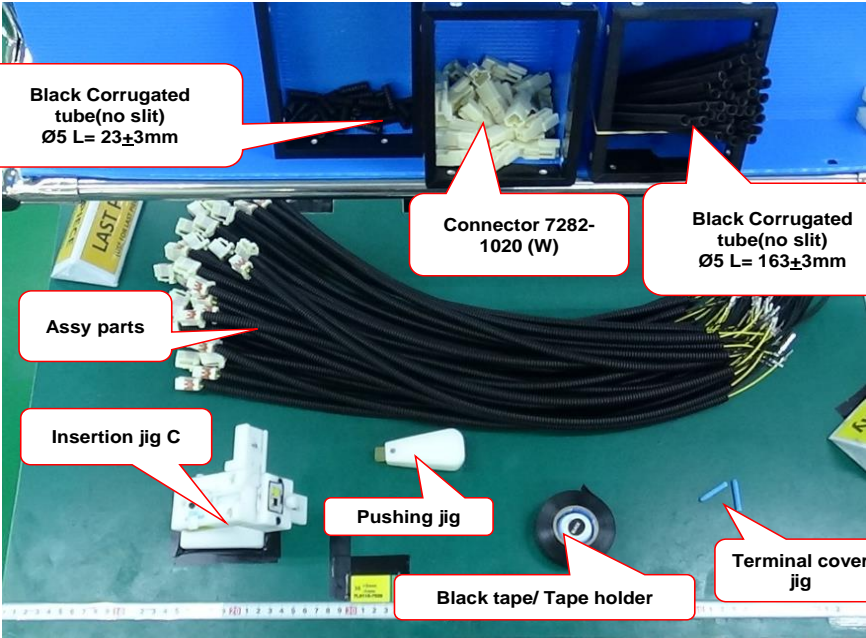

	<b>WORK INSTRUCTION</b>				Effectivity Date:	January 21, 2025		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>TM3 / 7L0115-7020</b>		Customer: <b>TRQSS</b>	Car Model: <b>SUBARU-ASCENT</b>	Document No.:	<b>WI-ENG-PDE-315A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.:	1 of 7	

PARTS:		1. Black Corrugated tube(no slit) Ø5 L= 23+3mm; Connector 7282-1020 (W); Black Corrugated tube(no slit) Ø5 L= 163+3mm; Black tape			JIG:	1. Insertion 2. Pushing jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P1	<div> <div>TABLE LAY-OUT</div>  </div>			<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document references:</b> 1. Refer to WI-ENG-PDE-346 Offline Assembly process	


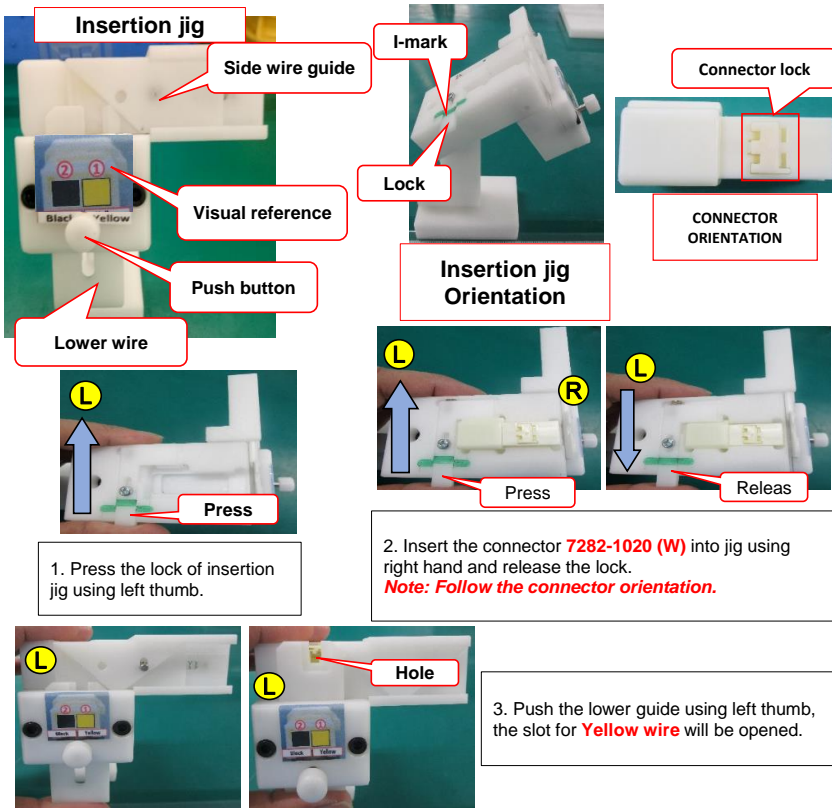
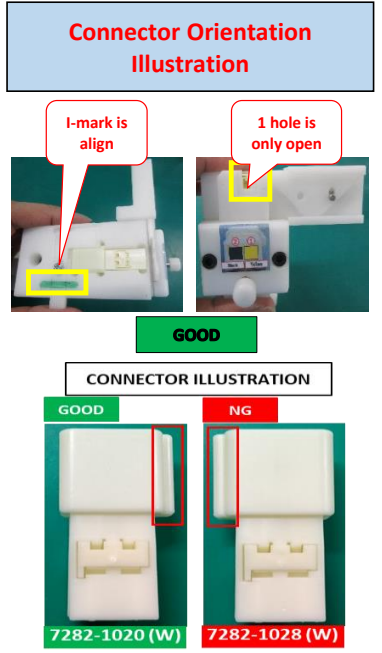
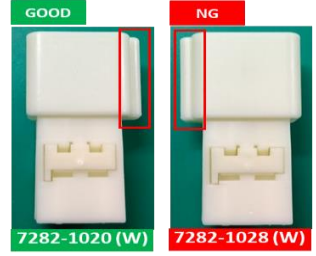
Revision History								Prepared by	Reviewed by	Approved by	Noted by
01/21/25	4	Transfer some process to Offline assembly process. Process sequence change process 6 and 7. Transfer Y-taping and Taping 2 to P2. Separate assembly jig to Clamp assembly jig. Inclusion of Measurement. Improved Table lay-out and Visual inspection/Quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a		
02/10/23	3	Work instruction improvement: Change MP from 2MP to 1MP. Update table lay-out and include batching. Inclusion of Quality check point (Page 16).				D. Castillo	J. Loterte	C. Villanueva	A. Arañes		
10/14/22	2	Improve quality pointers: References in process no.1,4,5,9,10 and 11 due to document improvement. Work procedure/illustration in process no.5 and 9 - connector lock.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 03, 2021

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	Process Name/Title:				Document No.:	WI-ENG-PDE-315A	
	Model code/Part number:	TM3 / 7L0115-7020	Customer:	TRQSS	Car Model:	SUBARU-ASCENT	
Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	4	Page No.: 2 of 7

PARTS:	1. Black Corrugated tube $\phi 5$ L=23 $\pm$ 3mm (no slit) 2. Connector 7282-1020 (W)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Corrugated tube $\phi 5$ L=23 $\pm$ 3mm (no slit)	 <div> <p>1. Get the corrugated tube <math>\phi 5</math> L=23<math>\pm</math>3mm using right hand then insert the <b>Yellow and black jointed wire</b> using left hand.</p> </div>		n/a	1. No deformed terminal 2. No wrong use of parts
3	P1 Connector setting to Insertion jig 7282-1020 (W)	<div>  <div> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector <b>7282-1020 (W)</b> into jig using right hand and release the lock.  <i>Note: Follow the connector orientation.</i></p> <p>3. Push the lower guide using left thumb, the slot for <b>Yellow wire</b> will be opened.</p> </div> </div>		n/a	<div> <p><b>Connector Orientation Illustration</b></p>  <p><b>CONNECTOR ILLUSTRATION</b></p>  <p>7282-1020 (W) 7282-1028 (W)</p> </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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Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

January 21, 2025

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n/a

Model code/Part number:

**TM3 / 7L0115-7020**

Customer:

**TRQSS**

Car Model:

**SUBARU-ASCENT**

Document No.:

**WI-ENG-PDE-315A**

Purpose:



PROTOTYPE



PRE-LAUNCH




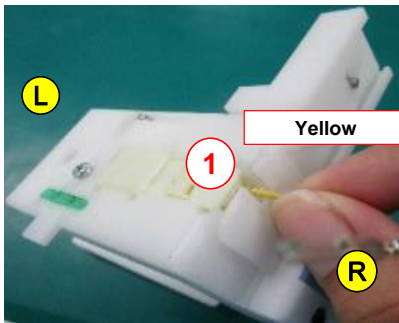
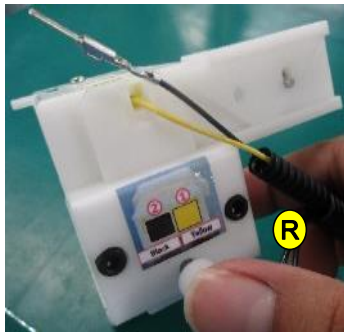
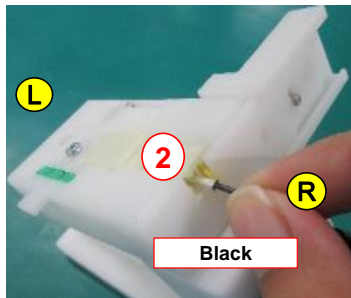
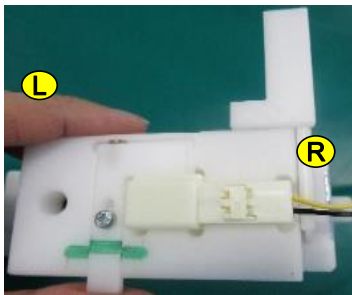
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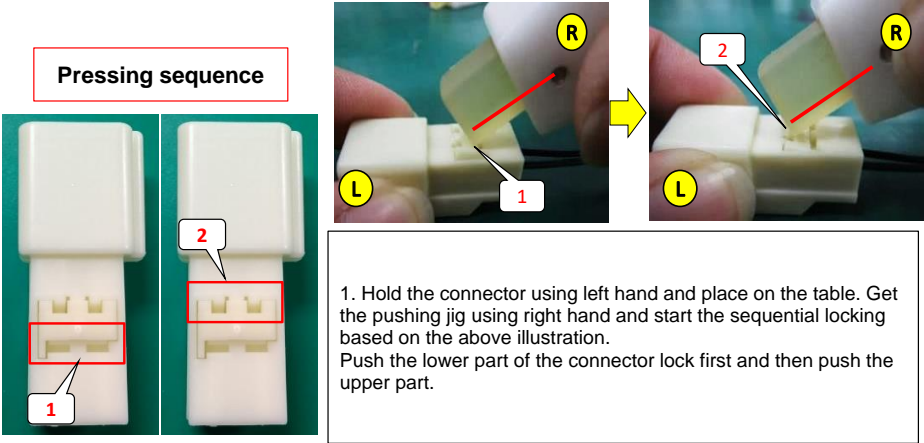
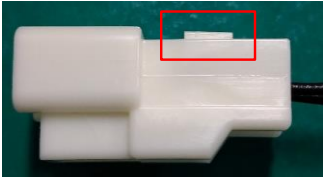
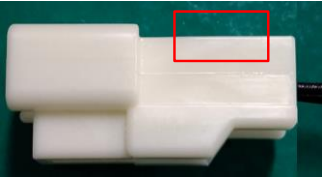
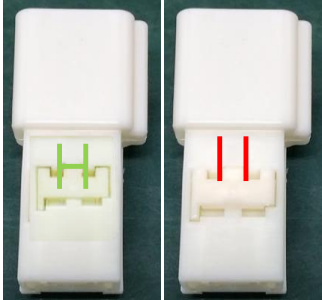
<b>PARTS:</b>		1. Assy parts	JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1 Wire insertion to connector 7282-1020 (W)	<div><p><b>TERMINAL FACING</b></p></div> <div><p>1. Insert the <b>Yellow wire</b> using right hand then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right hand, the slot for <b>Black wire</b> will be opened.</p></div> <div><p>3. Get <b>Black wire</b> using right hand then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> 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>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	TM3 / 7L0115-7020	Customer:	TRQSS	Car Model:	SUBARU-ASCENT	Document No.:	WI-ENG-PDE-315A	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:	4 of 7


PARTS:		1. Assy parts		JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P1	Connector Lock		<div>Pushing jig</div> 	<div>Pressing sequence</div>  <div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div> <div>Before pressing</div>  <div>After pressing</div>  <div>1. No unlocked/half-locked connector</div> <div>2. No damage connector</div> <div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>2. Use the provided jig tool to lock the connector.</div> <div>3. Position of pushing jig during locking must be slanted</div> <div>LOCKED CONDITION</div>  <div>GOOD</div> <div>NG</div>	

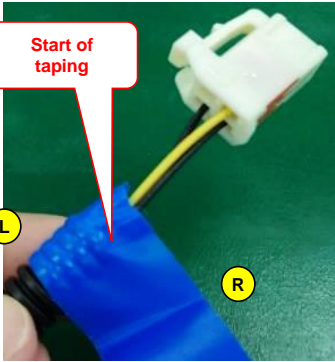
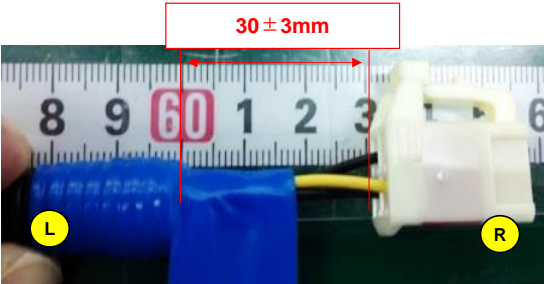
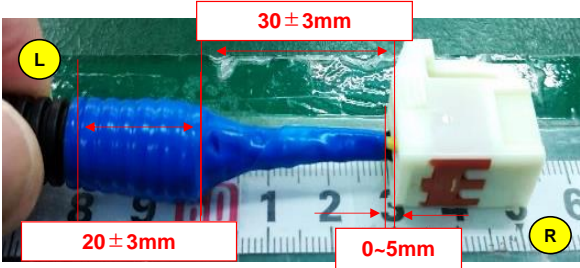

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<b>PARTS:</b>	1. Assy parts 2. Blue tape			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
6	P1 Taping 1 Black corrugated tube to wire near connector	<div><p>Start of taping</p></div> <div><p>30 ± 3mm</p></div> <div><p>1. Hold the COT using left hand, get the <b>Blue tape</b> using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of COT up to edge of connector <b>30±3mm</b> then continue the taping process using both hands.</p></div> <div><p>20 ± 3mm      0~5mm</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p><b>Measuring tape</b></p></div>	<p><b>Important reminders/Note/s:</b></p> <p><b>1. Use BLUE TAPE only</b></p> <p><b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to WI-PRO-COM-001A for Taping procedure</b></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 7. No insufficient tape</p>			

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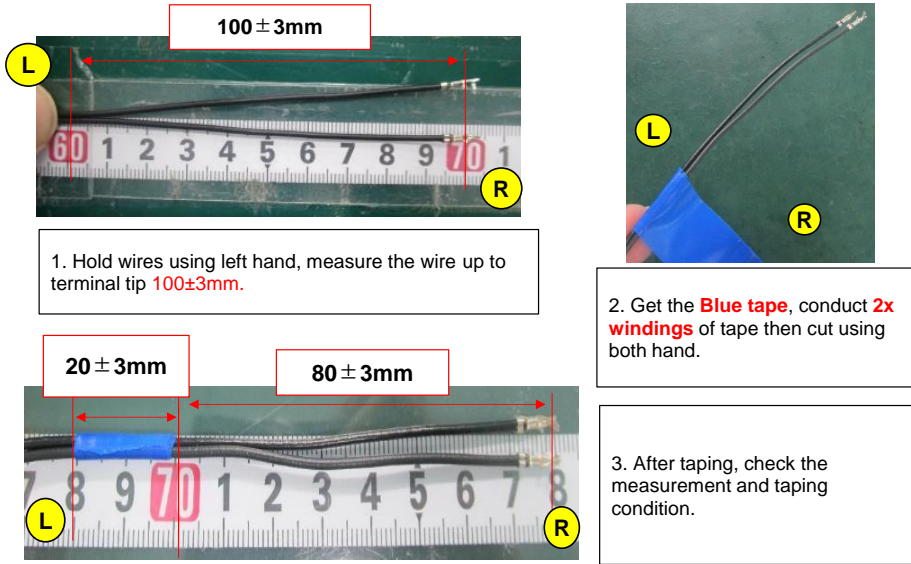
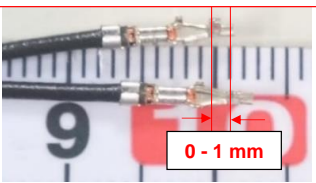
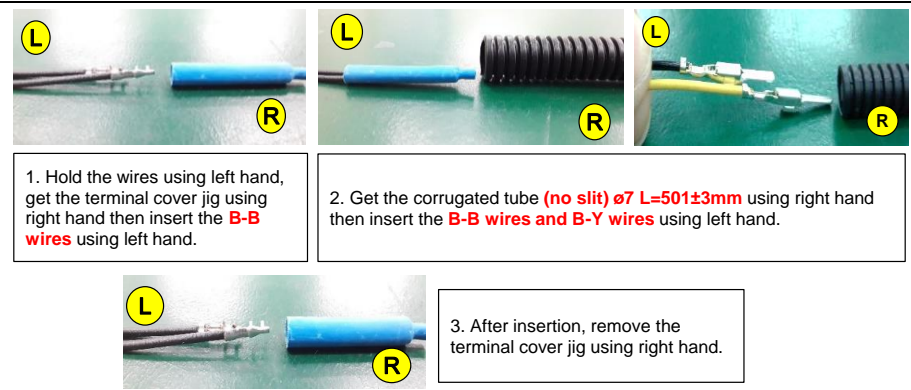



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	6 of 7

<b>PARTS:</b> 1. Assy parts 2. Black Corrugated tube (no slit) $\phi 7$ L=501 $\pm$ 3mm	<b>JIG:</b> 1. Locking jig 2. Terminal cover jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Spot Taping			<b>Important reminders/Note/s:</b> <b>1. Use BLUE TAPE only</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  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 7. No insufficient tape  <div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>Wire alignment tolerance</b>   </div>
8	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L=501 $\pm$ 3mm		<div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>TERMINAL COVER JIG</b>   </div>	1. No wrong usage of parts 2. No deformed terminal tip

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PROTOTYPE



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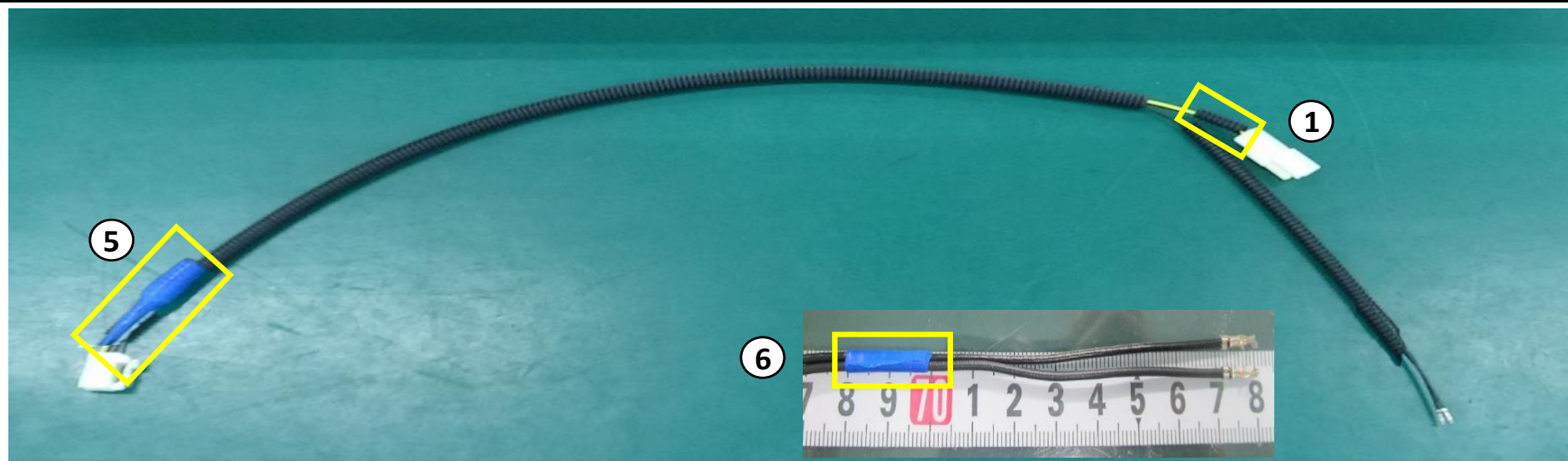
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7L0115-7020****① No Unlocked/Half-locked connector****④ No Terminal backing out****② No Wrong Insert****⑤ ⑥ No Missing Tape  
No Wrong use of tape (Blue tape)****③ No Deformed terminal**

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