

	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.: WI-ENG-PDE-199B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	8 Page No.: 1 of 4

PARTS:		1. Assy parts; Black tape		JIG:		n/a								
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">8</div>	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS									
1	P2	Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; text-align: center;">TABLE LAY-OUT</div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-ENG-PDE-558 OFFLINE ASSEMBLY PROCESS .									
Revision History				Prepared by		Reviewed by		Approved by		Noted by				
06/11/24		8	Transer Taping 2 from P1 (WI-ENG-PDE-199A). Separate Clamp setting and clamp assembly to Clamp assembly process. Update table lay-out and visual inspection/quality checkpoints.. Inclusion of car model "SUBARU-FORESTER"				D.Castillo		C.Villanueva		A. Arañes		n/a	
01/26/23		7	Improvement: Change clamp sequence (Page 2-4). Inclusion of Quality pointers.				D.Castillo		J.Loterte		C.Villanueva		A. Arañes	
11/04/22		6	Improve notes/references and quality pointers in process 2, 3, 4, 5 and 6 as document improvement. Work procedure illustration in process no.5 - visual/by two's inspection.				M.Catapang		J.Loterte		C.Villanueva		A. Arañes	
Eff. Date		Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		July 16, 2018	

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SUBARU-FORESTER

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Purpose:

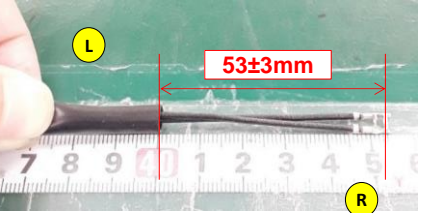
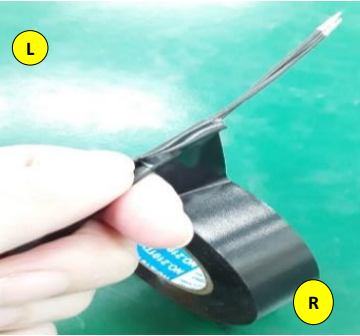
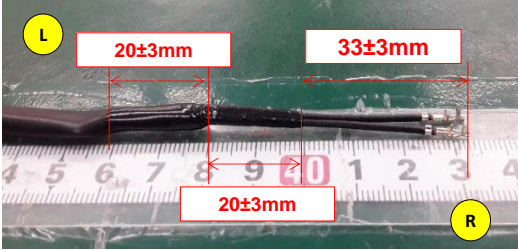

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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 SV tube (Vinyl) to wire near terminal	<div><p>1. Hold the SV tube (Vinyl) using left hand. Measure from end of vinyl tube up to terminal pointed tip 53±3mm using both hands.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand. Get Black tape using right hand and taping process using both hands.</p></div> <div><p>3. After taping, check the measurement from end tape up to terminal pointed tip 33±3mm using both hands.</p></div>	<div>Measuring tape</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <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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PARTS:

1. Assy parts

JIG:

n/a

NO.**PROCESS NAME**

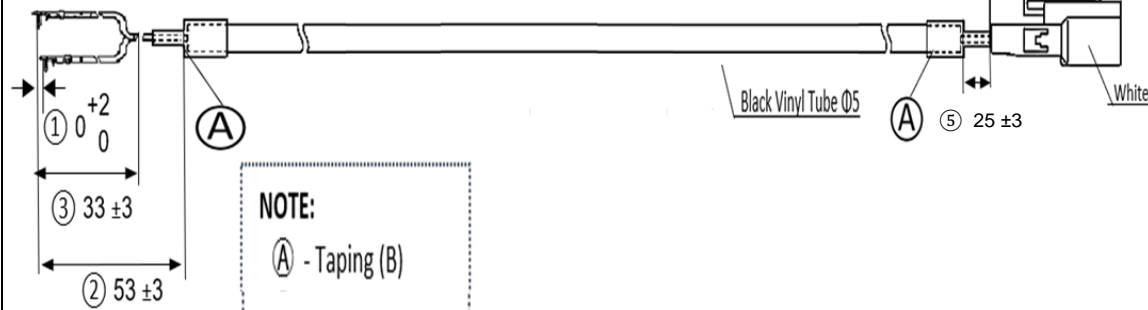
8

WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

3

P2

Measurement

**MEASURING TAPE****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

1. No wrong dimension

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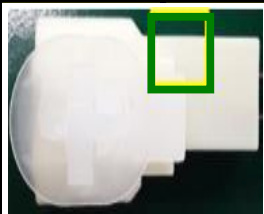
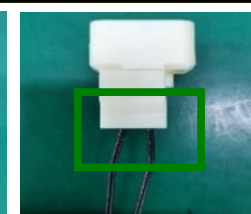
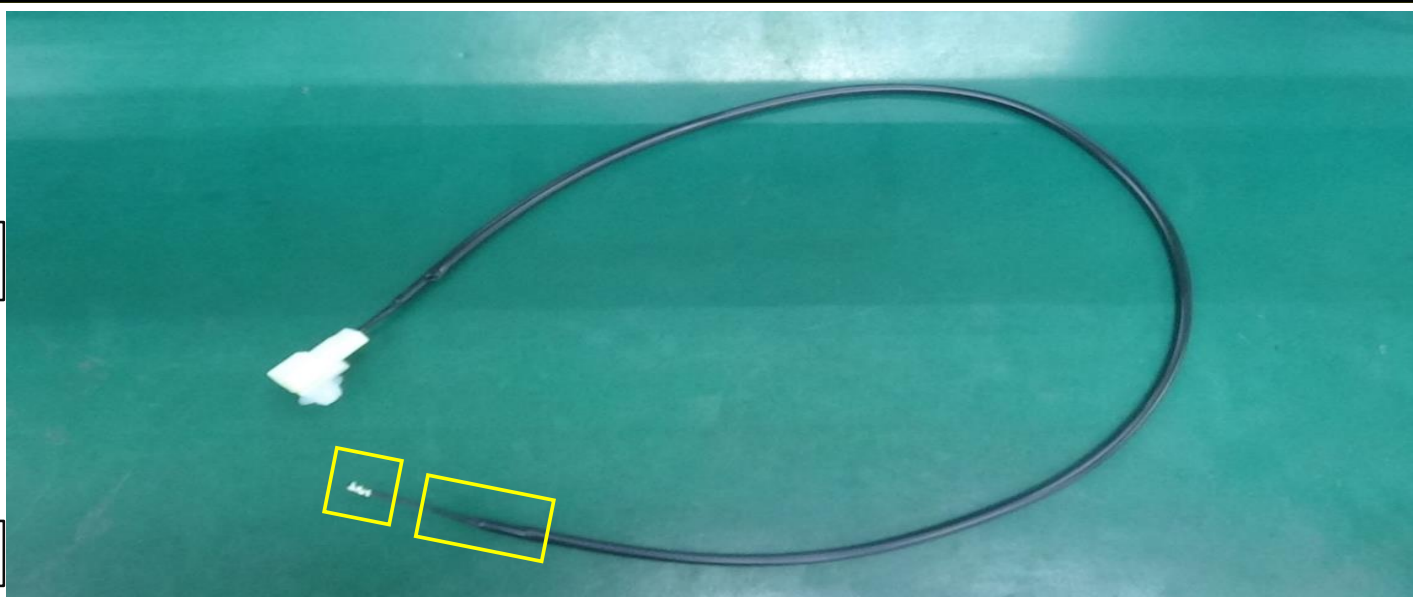
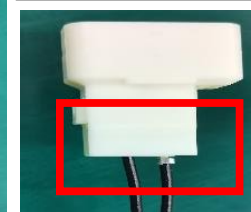
PARTS:

1. Assy parts

JIG:

n/a

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VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****7M0503-7020A****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/Halflock Connector****2** No **Missing Tape****3** No **Terminal Backing Out****4** No **Deformed Terminal**

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