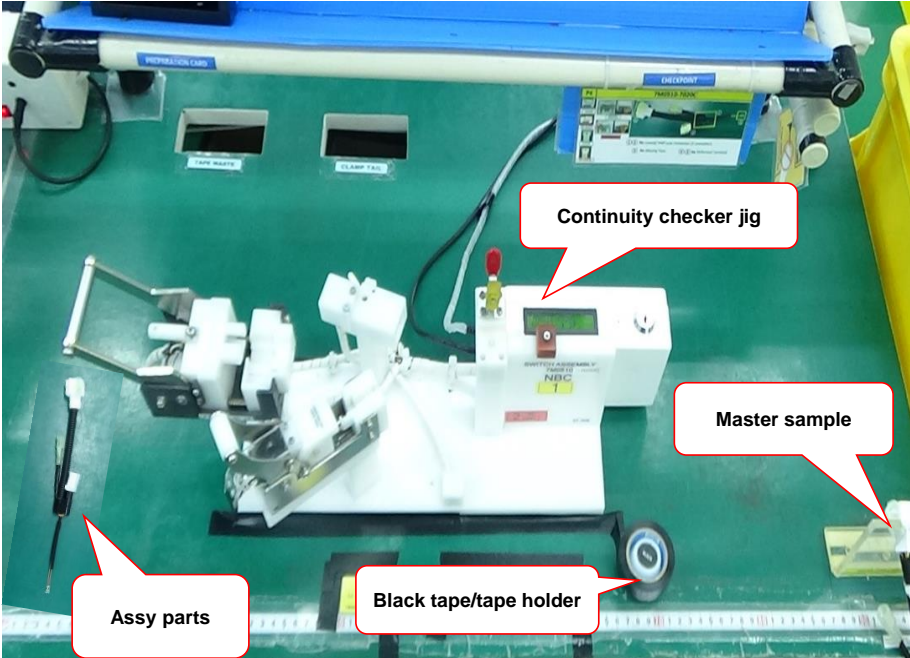
	WORK INSTRUCTION				Effectivity Date:	January 5, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: ES1 / 7M0510-7020C		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.: WI-ENG-PDE-366D	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 0		Page No.: 1	of 9

PARTS:		1. Assy parts; Black tape		JIG:	1. Continuity checker jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P4	<div>Table Lay-out</div> 		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
01/05/24	0	Initial issue. Transfer process from WI-ENG-PDE-366B to WI-ENG-PDE-366D due to Process improvement		D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted
				Est. Date:	January 5, 2024		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

ES1 / 7M0510-7020C

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

January 5, 2024

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n/a

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

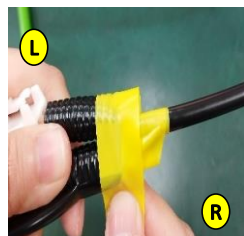
TOOLS/PPE

QUALITY POINTERS

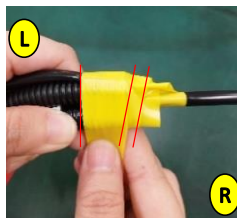
2

P4

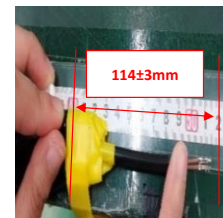
Y-Taping



1. Conduct pre-taping at the middle of combined tubes, then wind the tape to left side.



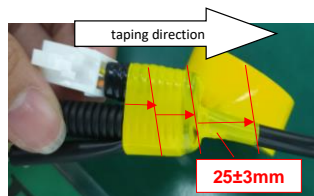
2. Shift the tape until reach the measurement **114±3mm** from end of tape to terminal then make 2 windings.



3. Confirm measurement from end of vinyl tube up to terminal pointed tip **34±2mm** using both hands.

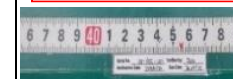


4. Wind the tape **1/3 shifting** until it reach the vinyl tube then wind the tape **2x windings** (must be 25±3mm)



Note: Do not exert excessive force during pulling & winding of tape to avoid tapered-shape on Y-Taping.

Measuring tape



Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

Document reference/s:

1. Refer to **WI-ENG-PDE-588** for **TAPE AND TUBE END STANDARD TOLERANCE**


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


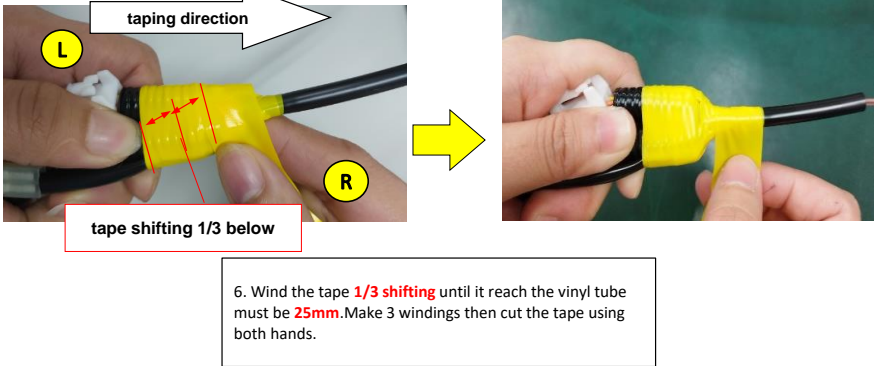
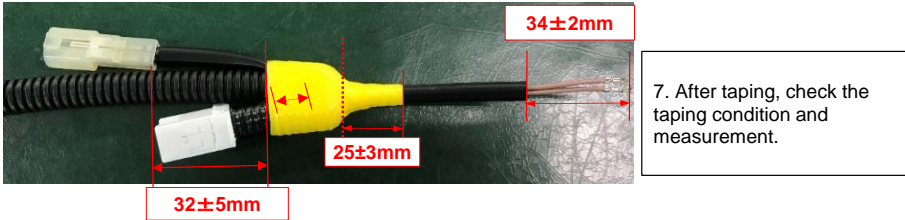



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 9

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Y-Taping (Continuation)	<div></div> <div></div> <div></div>		<div>Measuring tape</div>	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement</p> <p>Document reference/s:</p> <p>1. Refer to WI-ENG-PDE-588 for TAPE AND TUBE END STANDARD TOLERANCE</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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Purpose:

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☐ PRE-LAUNCH

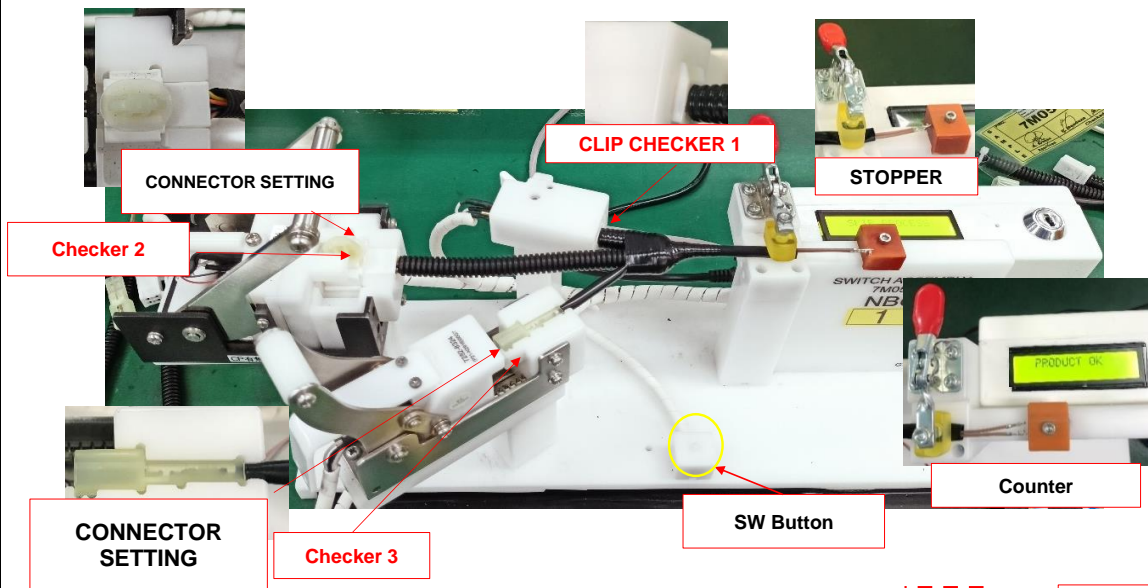

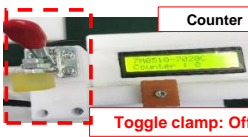


☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Continuity checker jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P4	Continuity Test	<div><div></div><div><p>1. Get the assy parts and set to tester jig using both hands. First, set the connector 4F5450-0000 (W) to Clip Checker 1 then lock. Second, set the connector 7186-8849 (W) to Checker 2 then pull the checker fixture for continuity checking. Third, set the connector 7282-8324 (W) to Checker 3 then pull the checker fixture for continuity checking. Last, set the BR-BR wires together within the stopper jig then press by toggle clamp. (See above picture for correct setting).</p><p>2. Check if all LED light for Wire1,Wire2 & BR-BR Wires was ON. If encounter abnormality or hearing NG buzzer, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></div><div><p>Counter</p><p>Counter</p><p>Toggle clamp: Off</p><p>Counter</p><p>Toggle clamp: On</p></div></div>	<div><p>STOPPER</p></div> <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Make sure no gap in between the terminal and stopper2. Counter will be the basis of quantity of harness per box. Only LEADER are allowed to reset the counter. <ol style="list-style-type: none">1. No wrong insertion2. No wrong orientation of connector

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Document No.:

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Purpose:

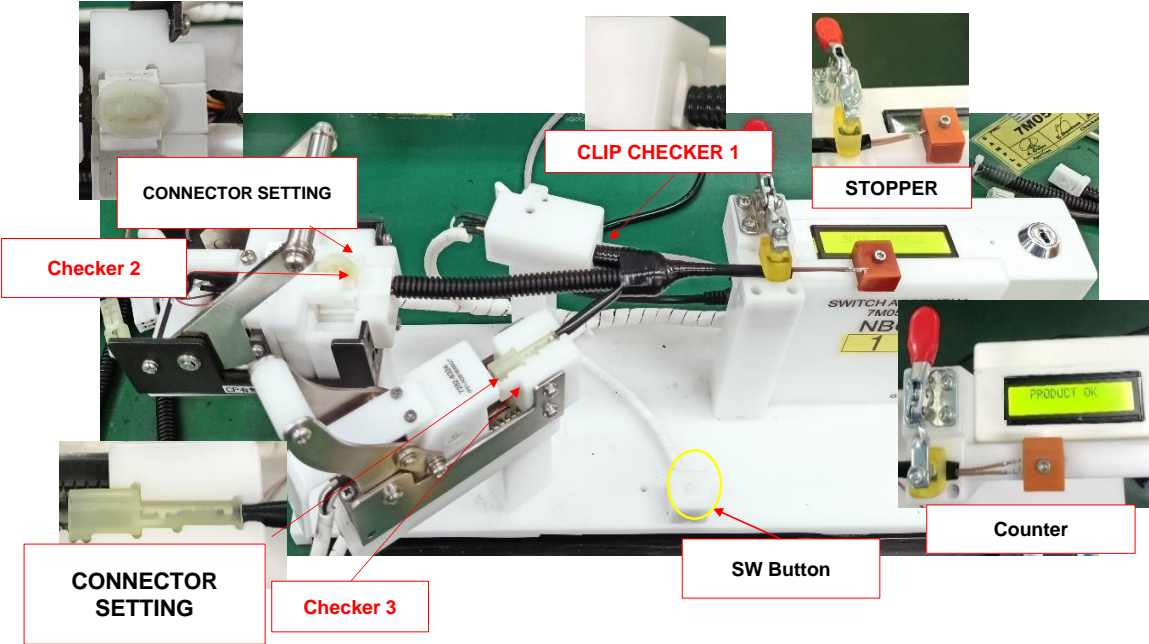
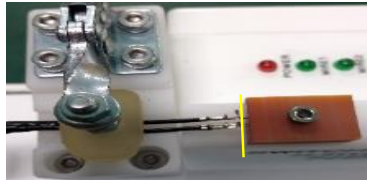
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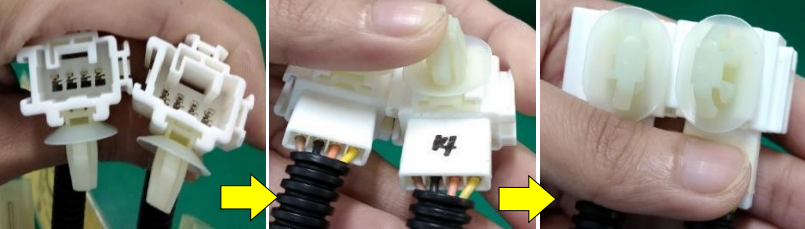


PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P4 Continuity Test (Continuation)	<div><div>3. Press the SW button using right hand for continuity checking. GO sound will be heard.</div><div>4. Conduct POINT CHECKING before removing the harness from jig.</div><div>5. For the removal of harness from the jig, First, remove the BR-BR wires to toggle clamp. Second, remove the connectors to checker 3, Checker 2 and last is Checker 1.</div></div>	<div><div>STOPPER</div><p>Important reminders/Note/s:</p><p>1. Make sure no gap in between the terminal and stopper.</p><p>2. Counter will be the basis of quantity of harness per box. Only LEADER are allowed to reset the counter.</p><p>1. No wrong insertion 2. No wrong orientation of connector</p></div>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	6 of 9


PARTS:	n/a			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
5	P4	<div><div><p>ACTUAL PRODUCT</p></div><div><p>Assembled parts</p></div><div><p>Master sample</p></div><div><p>1. Conduct alignment of harness (Master sample vs. assembled parts) using both hands.</p></div><div><p>2. Check the terminal, insertion and presence of clamp attachment.</p></div><div><p>3. Check the condition of connector lock and insertion.</p></div></div> <div><p>MASTER SAMPLE</p><p>1. No skip checking during inspection</p></div>					

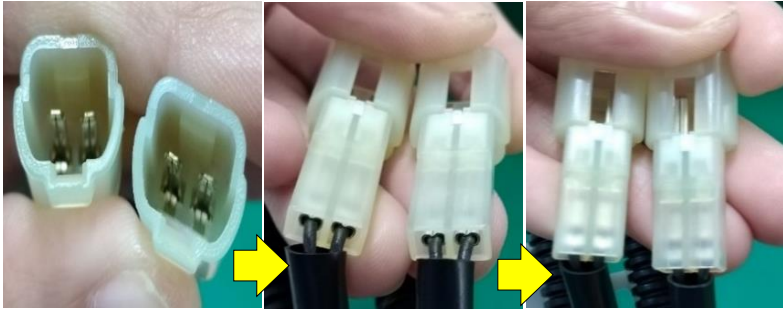



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:

PARTS:		n/a		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
5	P4 Visual/By Two's Inspection (Continuation)	<div><div>4. Check the terminal, insertion and condition of connector lock.</div><div>5. Check the Y-Taping condition.</div><div>6. Check the terminal appearance. Must be no deformed terminal.</div></div>				<div><div>MASTER SAMPLE</div></div> <div>1. No skip checking during inspection</div>	

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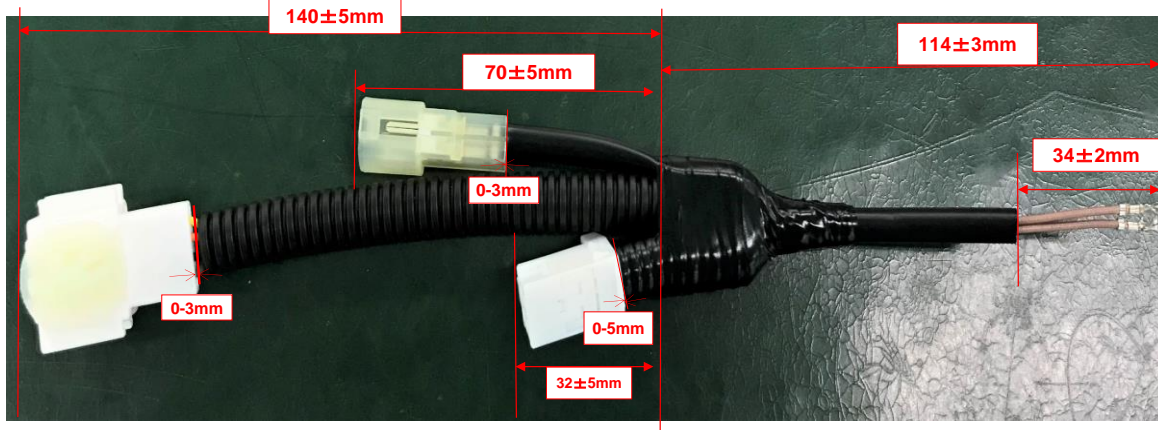
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P4	Measurement	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. FOR HATSUMONO AND OWARIMONO.</p> <p>1. No wrong dimension</p>

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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS

P4

7M0510-7020C



GOOD



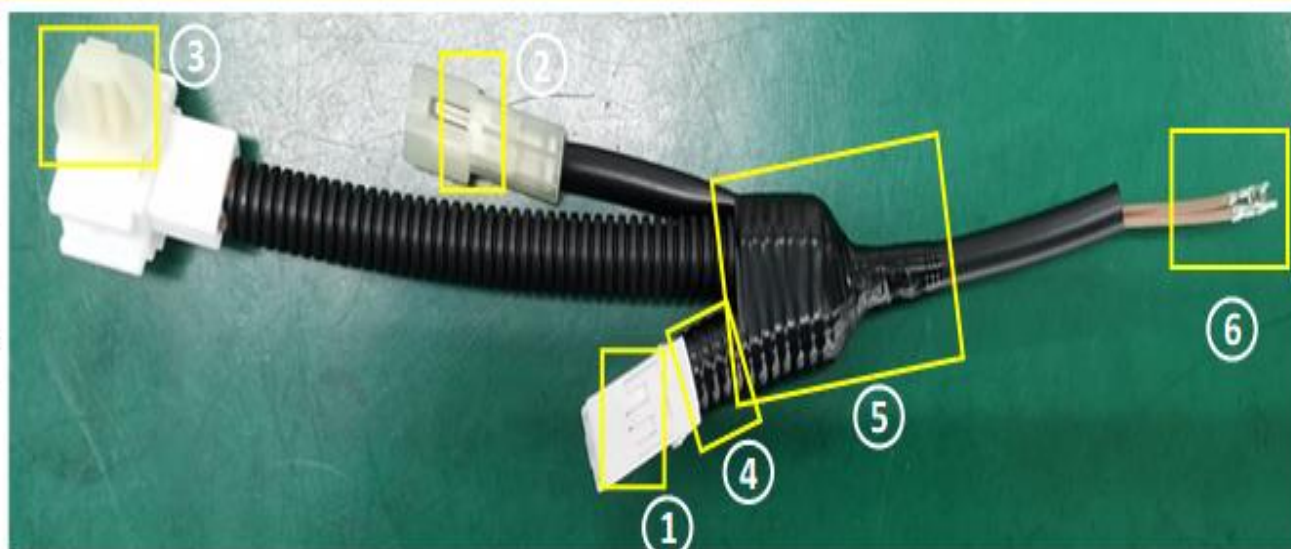
NO GOOD



GOOD



NO GOOD



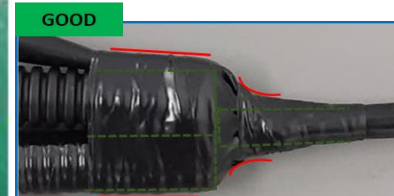
① ② No Unlock/ Half Lock Connector
(2 connector)

③ No Missing Clip Type Clamp

④ ⑤ No Missing Tape

⑦ No Deformed Terminal

⑥ No Tapered-shape
on Y-Taping



GOOD

Normal Appearance of Y-Taping



NG

Appearance of Y-Taping was Tapered-Shape
(Cone-shape)

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