

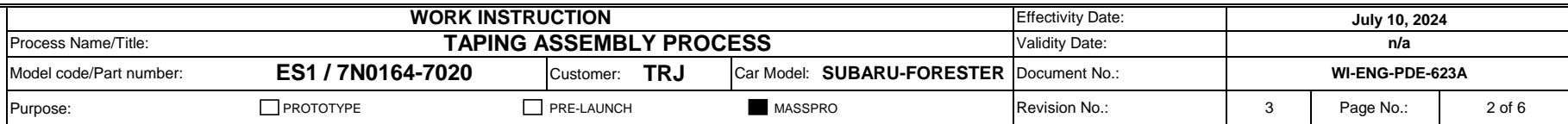
	WORK INSTRUCTION				Effectivity Date:		July 10, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: ES1 / 7N0164-7020		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.: WI-ENG-PDE-623A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 6

PARTS:		1. MR SW CP (AVSSf 0.3 L-740mm B/W-W with inserted SV tube (Vinyl) Ø5 L-38±3mm): Black tape: Connector 7C83-5524-70 (Y); Black corrugated tube (No Slit) Ø7 L=619±4mm		JIG:		1.Insertion jig 3.Measuring jig 2.Terminal cover jig 4.Lacking jig	
NO.	PROCESS NAME	3	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
1	P1			<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 References: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools		

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
07/10/24	3	Transfer Offline assembly process to Taping assembly process and transfer Taping 2 to P2 due to process improvement. Integrate connector lock to assembly jig due to jig improvement. Inclusion of car model "SUBARU-FORESTER". Update table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a					
04/05/23	2	Change taping procedure due to tape reduction project (Page 2-3).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes									
01/25/23	1	Change from Pre-launch to Masspro. Inclusion of Table lay-out (Page 1). Inclusion of measuring jig in assembly jig and quality pointers (Page 3).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 19, 2023							

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TAPING ASSEMBLY PROCESS

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ES1 / 7N0164-7020

Customer:

TRJ

Car Model:

SUBARU-FORESTER

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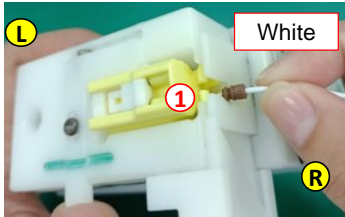
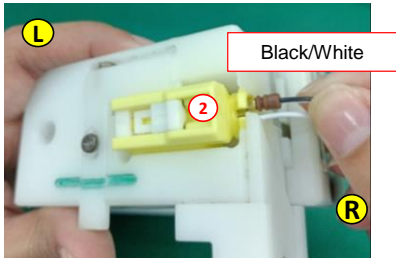
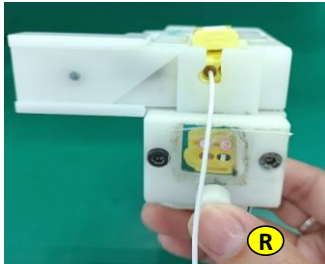

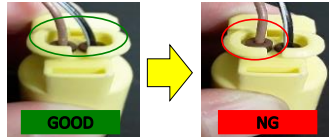
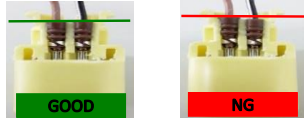
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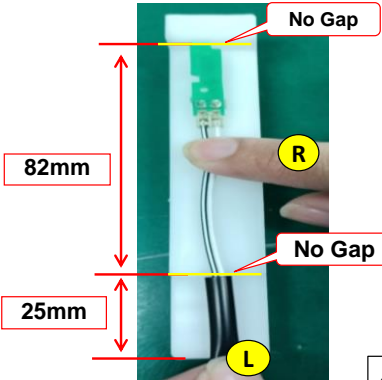
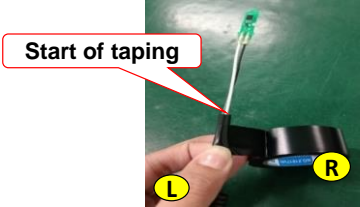
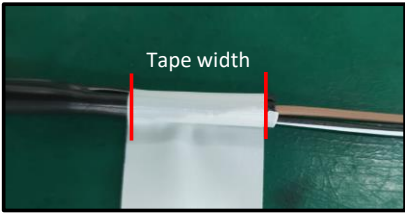
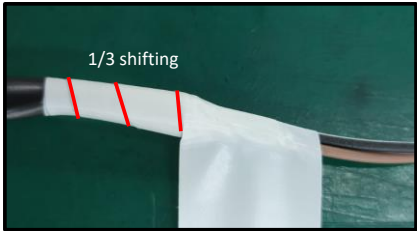



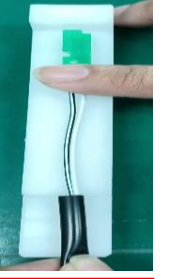
PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Wie insertion to connector 7C83-5524-70 (Y)	<div><p>Wire facing</p></div> <div><p>White</p><p>1. Get the White wire and insert to terminal slot 1 using right hand.</p></div> <div><p>Black/White</p><p>3. Get the Black/White wire and insert to terminal slot 2 using right hand.</p></div> <div><p>2. After insertion of White wire, press the button using right thumb. Slot for Black/White wire will be open.</p></div> <div><p>4. After insertion, press the insertion jig lock using left hand and then hold the wire and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</p> <p>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.</p> <p>Document References: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</p> <div><p>RUBBER SEAL CONDITION ILLUSTRATION</p><p>EMERGED RUBBER SEAL CROSS SECTIONAL VIEW</p></div>

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	WORK INSTRUCTION			Effectivity Date:	July 10, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: ES1 / 7N0164-7020		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-623A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	4 of 6

PARTS: 1. Black tape 2. Assy parts				JIG: 1. Measuring jig	
NO. 5	PROCESS NAME P1 Taping 1 SV tube (Vinyl) to wire	WORK PROCEDURE/ ILLUSTRATION <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>Taping procedure</p> </div> <div style="border: 1px solid black; padding: 5px; width: 200px;"> <p>1. Get the assy parts and set to measuring jig. First, set the holmeted wire (No Gap) using right hand. Last, set the SV tube (Vinyl) (No Gap) using left hand.</p> </div> <div style="text-align: center;">  <p>Start of taping</p> </div> <div style="border: 1px solid black; padding: 5px; width: 200px;"> <p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands. <i>(Please refer below for the taping procedure).</i></p> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>Tape width</p> </div> <div style="text-align: center;">  <p>1/3 shifting</p> </div> </div> <div style="display: flex; justify-content: space-around;"> <div style="background-color: #fff9c4; padding: 5px; width: 150px;"> <p>1. Attach tape then conduct 1 winding while folding the SV tube (Vinyl)</p> </div> <div style="background-color: #fff9c4; padding: 5px; width: 150px;"> <p>2. Shift the tape 1/3 shifting going to wires <i>note: 1/3 shifting must be within the foded SV tube (Vinyl)</i></p> </div> </div> </div>		TOOLS/PPE <div style="display: flex; flex-direction: column; align-items: center;"> <div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> MEASURING TAPE  </div> <div style="border: 1px solid black; padding: 5px;"> MEASURING JIG  </div> </div>	QUALITY POINTERS <div style="margin-top: 20px;"> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. USED WHITE TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL TAPE SHOULD BE BLACK TAPE.</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p>GOOD</p> </div> <div style="text-align: center;">  <p>NG</p> </div> </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px; text-align: center;"> <p>Position the finger in wire to avoid deformed hotmelt</p> </div> </div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

ES1 / 7N0164-7020

Customer: TRJ

Car Model: SUBARU-FORESTER

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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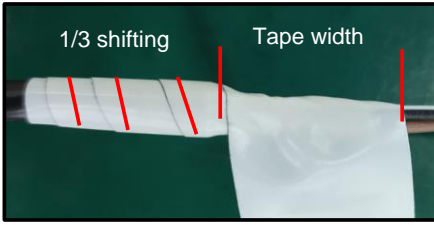
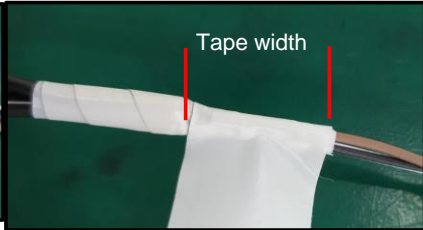
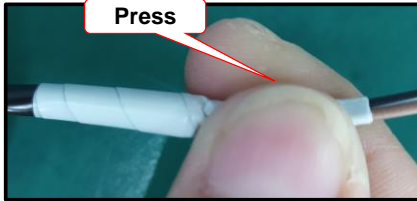
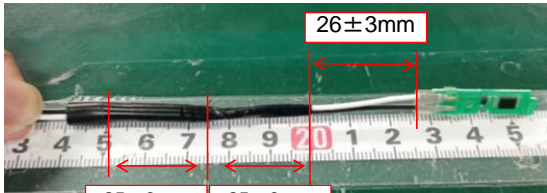




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PARTS:		1. Black tape 2. Assy parts		JIG:	1.Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 1 SV tube (Vinyl) to wire (Continuation)	<div><div><div><div><div>1/3 shifting</div><div>Tape width</div></div><div></div></div><div><div><div>Tape width</div></div><div></div></div></div><div><div>3. Shift the tape 1x shifting until reach the tape width.</div><div>4. Conduct 2x windings before end of tape .</div><div><div><div>Press</div><div></div></div><div>5. Conduct 3x pressing at the end of tape to prevent peel off.</div></div><div><div><div><div><div>25±3mm</div><div>25±3mm</div><div>26±3mm</div></div><div></div></div><div>3. After taping, check the taping condition and measurement.</div></div></div></div></div>		<div>MEASURING TAPE</div> <div></div> <div>MEASURING JIG</div> <div></div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div><div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. USED WHITE TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL TAPE SHOULD BE BLACK TAPE.</div><div><div><div><div></div><div>GOOD</div></div><div><div></div><div>NG</div></div></div><div>Position the finger in wire to avoid deformed hotmelt</div></div></div>

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**WORK INSTRUCTION**

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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0164-7020**

2

**GOOD****NO GOOD**

1

No Wrong Insert

3

No Missing Tape

2

No Terminal Backing Out

4

No Missing Parts

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