| | | | | | WORK II | NSTRUCTION | | | | | Effec | tivity Date: | | | January 26, 20 | 24 |
|-----------|----|-------------------|--------------------------------|-------------------------|------------------|---|---------------|------------|------------------------------------|----------------------|-----------|---|--|-----------------------------|---|-----------|
| | | | Process Name/Title: | | CLA | MP ASSEMBLY | PROCES | SS | | | Valid | ity Date: | | | n/a | |
| | -1 | | Model code/Part number: | ES1 / | 7M0515-7 | 021 Customer: | TRJ C | Car Model: | SL | JBARU | Docu | ment No.: | | | WI-ENG-PDE-8 | 17 |
| | | | Purpose: | PROTOTYPE | | PRE-LAUNCH | • | MASSE | PRO | | Revis | sion No.: | | 0 | Page No.: | 1 of 9 |
| PARTS: | | 1. Assy | parts; Clamp 82711-52090 | 0 (W); Clamp 82711-3. | A540 (W); Clam | p 82711-48070 (GR); I | Black tape [3 | 3pcs]; Gre | een tape [1 | pc] | | JIG: | 1 | n/a | | |
| NO | Э. | F | ROCESS NAME | | WOR | K PROCEDURE/ IL | LUSTRAT | TION | | | | TOOLS/PPE | | C | QUALITY POIN | TERS |
| 1 | | CLAM P ASSY | Table lay-out | Clamp 82711-52 Clamp Tr | 2090 (W)/ | TABLE LA Clamp 82711-3A540 Clamp Tray Black tape/ Tape holder | Y-OUT | Clam | p 82711-44 Clamp T lamp Asserting | I B C 233 embly jig | f pi (glo | Alert level and trouble any trouble, info | on eat learning and the communitation in | Docume 1. Refer t Taping as | ent references: o WI-ENG-PDE-7 ssembly process ing parts/tools ss parts/tools | 70A-C for |
| | | | | | Revision History | у | | | | | | Prepared by | Revi | iewed by | Approved by | Noted by |
| | | | | | | | | | | | | | | | | |
| 01/26/24 | 0 | Initial iss | ue. Separate process from WI-E | NG-PDE-770 Taping asset | mbly process. | | | D.Castillo | C. Villanueva | A. Arañes | n/a | D. Castillo | Jour Comp |) form | Arcino | n/a |
| Eff. Date | | | | Details of Cha | | | | Revised | Reviewed | Approved | Noted | Est. Date: | | 26, 2024 | / Addites | ıva |



| | | | | WORK INST | RUCTION | | | | Effectivity Date: | $\overline{}$ | January 26, 20 | 124 |
|--------|-------------------|---|---|---|-------------------------------------|-----------------|--------------|-------------------|-------------------|---|---|------------------------|
| | | Process Name/Title: | | | ASSEMBLY F | PROCESS | | | Validity Date: | + | n/a | <u></u> |
| | | Model code/Part number: | ES1 / | 7M0515-7021 | | TRJ Car M | lodel: | SUBARU | Document No.: | | WI-ENG-PDE-8 | 317 |
| | | Purpose: | PROTOTYPE | | PRE-LAUNCH | | MASSPRO | | Revision No.: | 0 | Page No.: | 2 of 9 |
| PARTS: | 2. Clan | np 82711-52090 (W) np 82711-3A540 (W) np 82711-48070 (GR) | | | 4. Black tape [3 5. Green tape [| Bpcs] | | | JIG: | 1. Clamp a | ssembly jig | |
| NO. | | PROCESS NAME | | WORK PF | ROCEDURE/ ILL | USTRATION | 1 | | TOOLS/PPE | (| QUALITY POIN | TERS |
| 2 | CLAM P ASSY | Clamp Setting | 1. Get 1pc. of clamp 2. Get 1pc of clamp 3. Get 1pc of clamp 4. Initially attach Black | 82711-52090 (W) us 82711-3A540 (W) us 82711-48070 (GR) us | sing right hand and | set to clamp lo | ocation 2 us | using both hands. | n/a | 1. Pleas before s wrong t 1. No wron 2. No wron 3. No dama 4. No wron | g use of parts g use of tape aged clamp g clamp position one side tape under the side | mp first y to avoid |



| | | | | WORK INST | RUCTION | | | | Effectivity Date: | | January 26, 20 | 24 |
|--------|---------------|-------------------------|---------------------------|-----------------|------------|----------------|----------------|-------------------------|-------------------|--|--|-------------|
| | | Process Name/Title: | | CLAMP | ASSEMBI | Y PROCES | S | | Validity Date: | | n/a | |
| | | Model code/Part number: | ES1 / | 7M0515-7021 | Customer: | TRJ Ca | r Model: | SUBARU | Document No.: | | WI-ENG-PDE-8 | 17 |
| | | Purpose: | PROTOTYPE | | PRE-LAUNCH | J | MASSPRO | | Revision No.: | 0 | Page No.: | 3 of 9 |
| PARTS: | 1. Assy | | | | | | | | | 1. Locking | | |
| NO. | F | ROCESS NAME | | WORK PF | ROCEDURE | ILLUSTRATI | ON | | TOOLS/PPE | (| QUALITY POIN | TERS |
| 3 | Clamp Assy | Connector Lock | NG Double Unlock Conditio | Coupler Cross S | | Check the lock | if properly lo | Before lock After lock | 4. | 1. MANU, DAMAGE 1. Use the 2. No unlo | Int reminders/NAL LOCKING MAYED CONNECTOR. provided locking jick/half-locked control of locking process | g per model |

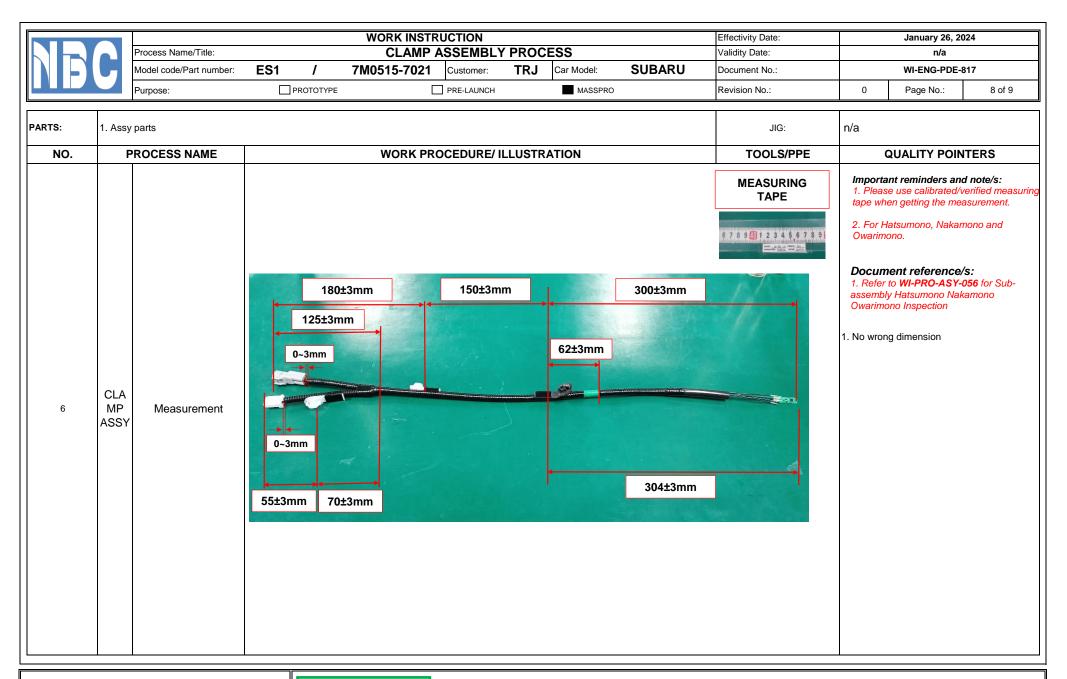
| | | | | WORK INSTR | | | Effectivity Date: | | January 26, 20 | 24 |
|--------|-------------------|-------------------------|---|---|---|--|---|---|---|---------------|
| | | Process Name/Title: | | | ASSEMBLY PROC | | Validity Date: | | n/a | |
| | | Model code/Part number: | ES1 / | 7M0515-7021 | Customer: TRJ | Car Model: SUBARU | Document No.: | | WI-ENG-PDE-8 | 17 |
| | | Purpose: | PROTOTYPE | | PRE-LAUNCH | MASSPRO | Revision No.: | 0 | Page No.: | 4 of 9 |
| PARTS: | 1. Assy | parts | | | | | JIG: | 1. Clamp a | assembly jig | |
| NO. | F | ROCESS NAME | | WORK PR | OCEDURE/ ILLUSTR | ATION | TOOLS/PPE | (| QUALITY POIN | TERS |
| 4 | CLAM P ASSY | Clamp Assembly | CONNE 1. Put the assy into setting). First, set ti | 82711-52090 1 EIVER BASE 1 ECTOR SETTING ijig. (See above pictule the connector 6188-02 | Y-TAPING SETTING Wire for the correct 166 (GR) to Receiver | 2. Checked if all LED light for P | COLOR SENSOR STOPPER STOPPER OWER ON and CLAMP | Impo 1. Mai termin 1. No wron 2. No wron 3. No dam | ortant reminderske sure no gap be hal and stopper jig og use of parts og use of tape aged clamp og clamp position | s/Note/s: |
| | | | 2 continue to set the wires together with | t the connector 6098- e harness in jig. Last, in stopper then press lence light of location | 3810 (W) to receiver base set the hotmelted and B by toggle clamp. 1 was on. | ON was ON. IF encountered proimmediately CALL the attention further instruction nad continue | of leader. WAIT for | 82711-52 | 090 (W) 827 | 711-12A80 (W) |

| | | | | WORK INSTRUCTION | | | | Effectivity Date: | | January 26, 20 | 24 |
|--------|-------------------|----------------------------------|---|--|------------|------------|-----------------------|---|---|---|-------------|
| | | Process Name/Title: | | CLAMP ASSEMB | LY PROC | ESS | | Validity Date: | | n/a | |
| | | Model code/Part number: | ES1 / | 7M0515-7021 Customer | TRJ | Car Model: | SUBARU | Document No.: | | WI-ENG-PDE-8 | 17 |
| | | Purpose: | PROTOTYPE | PRE-LAUNG | СН | MASSPR | 80 | Revision No.: | 0 | Page No.: | 5 of 9 |
| PARTS: | 1. Assy | parts | | | | | | JIG: | 1. Clamp a | assembly jig | |
| NO. | F | PROCESS NAME | | WORK PROCEDURI | =/ ILLUSTR | ATION | | TOOLS/PPE | (| QUALITY POIN | TERS |
| 4 | CLAM P ASSY | Clamp Assembly (Continuation) | CONNE 3. Hold the tape on c windings of tape the | 82711-52090 (W) 1 2 EIVER BASE 1 Y-TAPIN Ilamp location 1, make 3 en cut the tape using both hands. Continue if the sequence light | 82711-3A | 540 (W) | ON PERSONAL PROPERTY. | COLOR SENSOR STOPPER 6. Get the Green tape and attach to location 4, make 3 | Impo 1. Mal termin 1. No wron 2. No wron 3. No dam. | ortant reminder ke sure no gap be hal and stopper jit ng use of parts ng use of tape aged clamp ng clamp position | s/Note/s: |
| | | | windings of tape the | lamp location 2, make 3 on cut the tape using both e sequence light of location 3 | | | | windings of tape then cut the tape using both hands. Press the SW button. Go sound will be heard. | 82711-520 | 090 (W) 8271 | L-12A80 (W) |
| | | | windings of tape the | lamp location 3, make 3 on cut the tape using both hands. ence light of location 4 was on. | | | | 7. Conduct POINT CHECKING before removing the harness from jig. | | | |

| | | | WO | ORK INSTRUCTION | | Effectivity Date: | | January 26, 20 | 24 |
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| | | Process Name/Title: | | CLAMP ASSEMBLY PROC | CESS | Validity Date: | | n/a | |
| | | Model code/Part number: | ES1 / 7M05 | 15-7021 Customer: TRJ | Car Model: SUBARU | Document No.: | | WI-ENG-PDE-8 | 17 |
| | | Purpose: | PROTOTYPE | PRE-LAUNCH | MASSPRO | Revision No.: | 0 | Page No.: | 6 of 9 |
| PARTS: | 1. Assy | parts | | | | JIG: | n/a | | |
| | | er sample | | | | | | | |
| NO. | P | ROCESS NAME | \ | WORK PROCEDURE/ ILLUSTF | RATION | TOOLS/PPE | , | QUALITY POIN | TERS |
| 5 | CLAM P ASSY | Visual/By Two's Inspection | Assembled parts 1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands. | Master sample 3. Check the presence of clamp condition. | p attachment, taping condition, c | 2. Check the connector lock condition, insertion and terminal. | - Contract of the Contract of | MASTER SAME | |



| | | | | WORK INSTRUCTION | | | | Effectivity Date: | $\overline{}$ | January 26, 2 | 024 |
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| | | Process Name/Title: | | CLAMP ASSEMB | LY PROCES | SS | | Validity Date: | _ | n/a | |
| | | Model code/Part number: | ES1 / | 7M0515-7021 Customer: | | ar Model: | SUBARU | Document No.: | | WI-ENG-PDE-8 | :17 |
| | | Purpose: | PROTOTYPE | PRE-LAUNCI | | MASSPRO | | Revision No.: | 0 | Page No.: | 7 of 9 |
| | | | | | | | | | | | |
| PARTS: | 1. Assy 2. Mast | parts er sample | | | | | | JIG: | n/a | | |
| NO. | F | ROCESS NAME | | WORK PROCEDURE | / ILLUSTRAT | ION | | TOOLS/PPE | (| QUALITY POIN | TERS |
| 5 | CLAM P ASSY | Visual/By Two's Inspection (Continuation) | 4. Check the Taping COT. Conduct sligh | g condition of Half-wrap, Y-taping thy bending to avoid overlook of many than the second state of the second state of the second | g and VM tube thissing tape. | | Check the Hotmelted pearance. | ACTUAL PRODUCT and terminal | 2. No wron 3. No dama | master same | MPLE |





| | WORK INSTRUCTION | | Effectivity Date: | Janu | ary 26, 2024 |
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| Process Name/Title: | CLAMP ASSEMBLY PROC | | Validity Date: | | n/a |
| Model code/Part number: ES1 / | 7M0515-7021 Customer: TRJ | Car Model: SUBARU | Document No.: | WI-E | NG-PDE-817 |
| Purpose: Prototyp | PE PRE-LAUNCH | MASSPRO | Revision No.: | 0 Page | No.: 9 of |
| | | | | | · |
| TS: n/a | | | JIG: | n/a | |
| | QUALITY CHE | CKPOINTS | | I . | |
| | | | | | |
| | | | | | |
| | 70.00 | NE4E 7004 | | | |
| CLAMP ASSY | | 0515-7021 | | | |
| N P-A | | | | | |
| | 8) | | No. of the last of | NATION AND ADDRESS OF THE PARTY | |
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| IO COOP NO COOP | | | | | AT A S |
| NO GOOD NO GOOD | | S. Harris and Called Black | | | NO GOOD |
| No Unlock/ Halflocked Conne | ector 4 No Missing ta | ane | (7) No N | lissing clamp | (3pcs) |
| 1) NO UMOCK/ Hamocked Come | •••• | • | _ | | • |
| 2 No Wrong Insert | (5) No Wrong us | e of tape (Green ta | ape) (8) Chec | k Half-wrap | taping |
| Z) NO Wrong misert | | | | | |
| 3 No Terminal Backing Out | | pot tape | (9) NO D | eformed Te | rminai |
| J remma backing out | (Green tape) | | | Hotmelted | |
| | | | | | |
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