

**WORK INSTRUCTION**Process Name/Title: **JOINTED WIRE TAPING PROCESS**

Effectivity Date:

**October 18, 2023**Model code/Part number: **TM3 / JOINTED WIRES** Customer: **TRQSS** Car Model: **SUBARU-ASCENT**

Validity Date:

**n/a**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

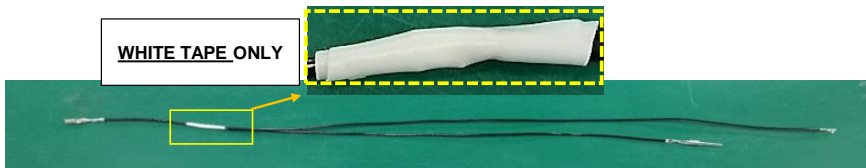

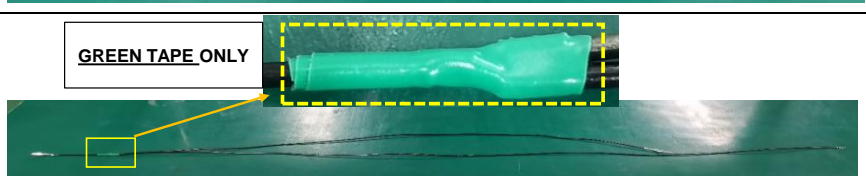
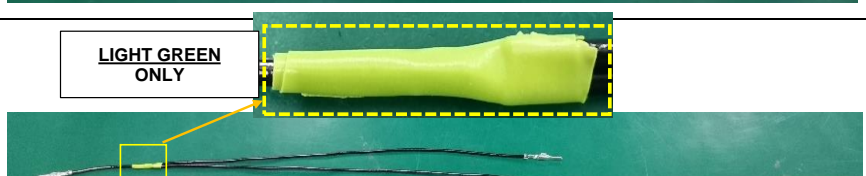
**WI-ENG-PDE-328**

Revision No.:

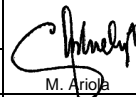
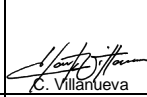

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<b>PARTS:</b>		1. 7L0112-200 <input type="checkbox"/> Jointed wires	4. 7L0115-200 <input type="checkbox"/> Jointed wires	7. White tape	10. Light Green tape	JIG:	n/a
		2. 7L0113-200 <input type="checkbox"/> Jointed wires	5. 7L0116-200 <input type="checkbox"/> Jointed wires	8. Orange tape			
		3. 7L0114-200 <input type="checkbox"/> Jointed wires	6. 7L0116-200 <input type="checkbox"/> Jointed wires	9. Green tape			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1	<div><div>1</div><div><div>WHITE TAPE ONLY</div></div></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 work place 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></div>	<div><div><b>Document references:</b> <div>1</div><div>1. Please refer to VR-ENG-PDE-002 for TM3 JOINTED WIRE TAPE MATRIX</div><div>2. Please refer to Incoming Inspection Performance of Jointed Wire; F-QAC-447 Jointed wire 7L0112-2000 F-QAC-448 Jointed wire 7L0113-2000 F-QAC-449 Jointed wire 7L0114-2000 F-QAC-450 Jointed wire 7L0115-2000 F-QAC-451 Jointed wire 7L0116-2000 F-QAC-452 Jointed wire 7L0117-2000</div></div></div>
		<div><div>1</div><div><div>ORANGE TAPE ONLY</div></div></div>					
		<div><div>1</div><div><div>GREEN TAPE ONLY</div></div></div>					
		<div><div>1</div><div><div>LIGHT GREEN TAPE ONLY</div></div></div>					

## Revision History

Revision History								Prepared by	Reviewed by	Approved by	Noted by
											n/a
10/18/23	1	Improve Work illustration page 1 and 2; Used different color of tape for each model to easily identify the models and prevent confusion during preparation of parts; Inclusion of Jointed wires for 7L0143 and 7L0145; Additional references for TM3 Jointed wire tape matrix.			M. Ariola	C. Villanueva	A. Arañes				
08/26/23	0	Initial issue.			Diane	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	August 26, 2023	

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**October 18, 2023**

Validity Date:

**n/a**Model code/Part number: **TM3 / JOINTED WIRES** Customer: **TRQSS** Car Model: **SUBARU-ASCENT**

Document No.:

**WI-ENG-PDE-726A**

Purpose:




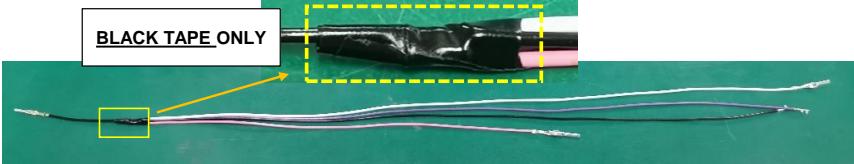


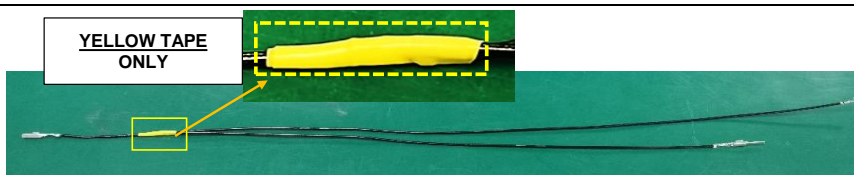

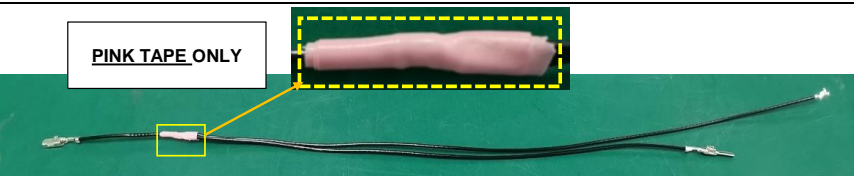
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS: 		1. 7L0117-200 <input type="checkbox"/> Jointed wires 2. 7L0143-200 <input type="checkbox"/> Jointed wires 3. 7L0145-200 <input type="checkbox"/> Jointed wires	4. Black tape 5. Yellow tape 6. Pink tape	JIG:	n/a
NO.	PROCESS NAME	 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	Jointed wire Apperance 7L0117-200 <input type="checkbox"/>	 	n/a	<b>Document references:</b>   <b>1. Please refer to VR-ENG-PDE-002 for TM3 JOINTED WIRE</b>  <b>2. Please refer to Incoming Inspection Performance of Jointed Wire;</b> F-QAC-447 Jointed wire 7L0112-2000 F-QAC-448 Jointed wire 7L0113-2000 F-QAC-449 Jointed wire 7L0114-2000 F-QAC-450 Jointed wire 7L0115-2000 F-QAC-451 Jointed wire 7L0116-2000 F-QAC-452 Jointed wire 7L0117-2000
	Jointed wire Apperance 7L0143-200 <input type="checkbox"/>	 			
	Jointed wire Apperance 7L0145-200 <input type="checkbox"/>	 			

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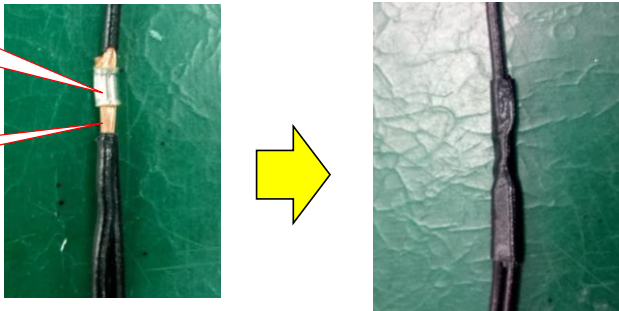
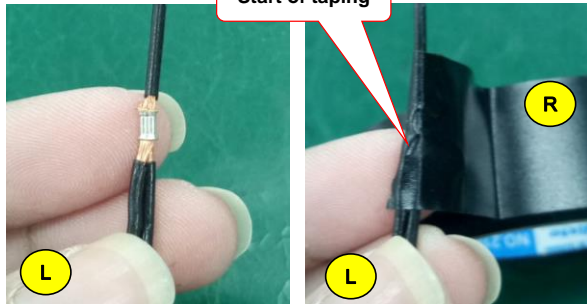
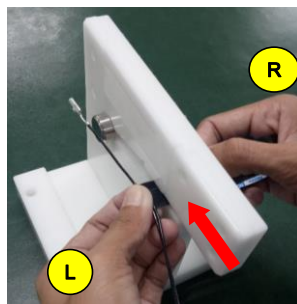
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Jointed wires			JIG:	1. Cutter jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Jointed Wire Taping	<div><div><div>Jointed wire</div><div>Connector Crimped</div><div>Core wire</div></div><div></div><div><div>Start of taping</div><div></div><div></div></div><div><div>1. Get <b>tape</b>, hold the jointed using left hand then start taping using right hand. Make two (2) windings (tape width).</div><div>3. Cut the tape using the provided cutter, then press the end tape.</div></div></div> <div>n/a</div> <td><div><div>1</div><div>Document references:</div><div>1. Please refer to VR-ENG-PDE-002 for TM3 JOINTED WIRE TAPE MATRIX.</div></div></td>		<div><div>1</div><div>Document references:</div><div>1. Please refer to VR-ENG-PDE-002 for TM3 JOINTED WIRE TAPE MATRIX.</div></div>	

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