



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 12, 2024

Process Name/Title:

Model code/Part number:

ES1 / 7N0164-7020B

Customer: TRJ

Car Model: SUBARU-FORESTER

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1168A

Revision No.:

1

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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

WORK PROCEDURE/ ILLUSTRATION

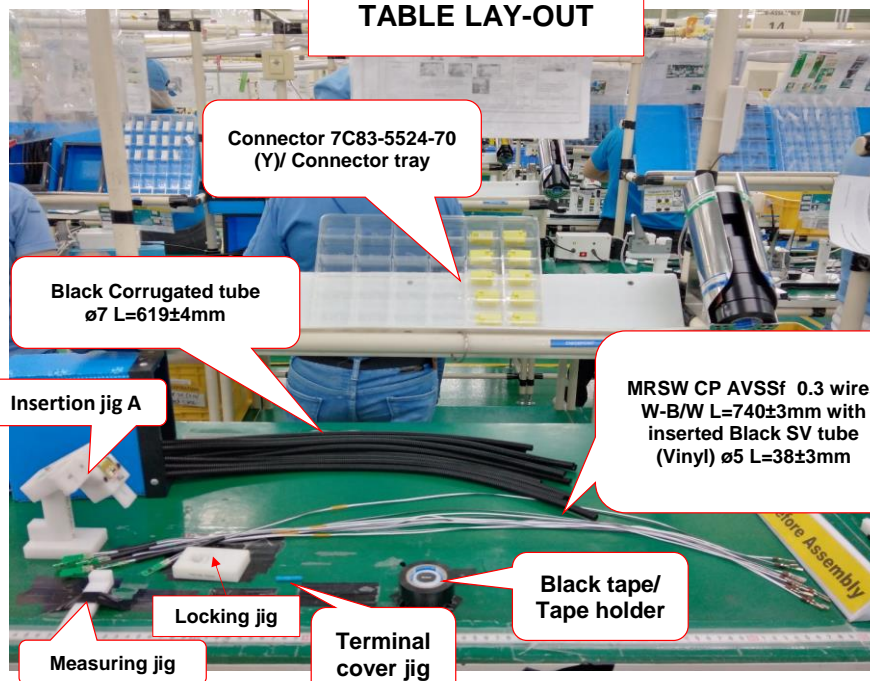
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level



For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

| Revision History | | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
|------------------|---------|--|-----------|---------------|-----------|-------|--|--|--|----------|
| 11/12/24 | 1 | Change purpose from Pre-launch to Masspro. | M. Ariola | C. Villanueva | A. Arañes | n/a |  M. Ariola |  C. Villanueva |  A. Arañes | n/a |
| 11/11/24 | 0 | Initial issue. | M. Ariola | C. Villanueva | A. Arañes | n/a | | | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | November 11, 2024 | | |

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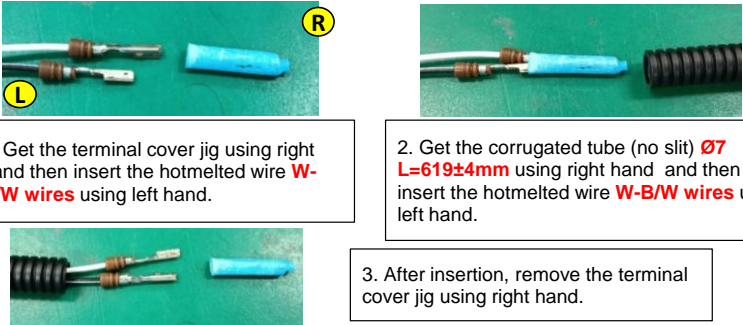

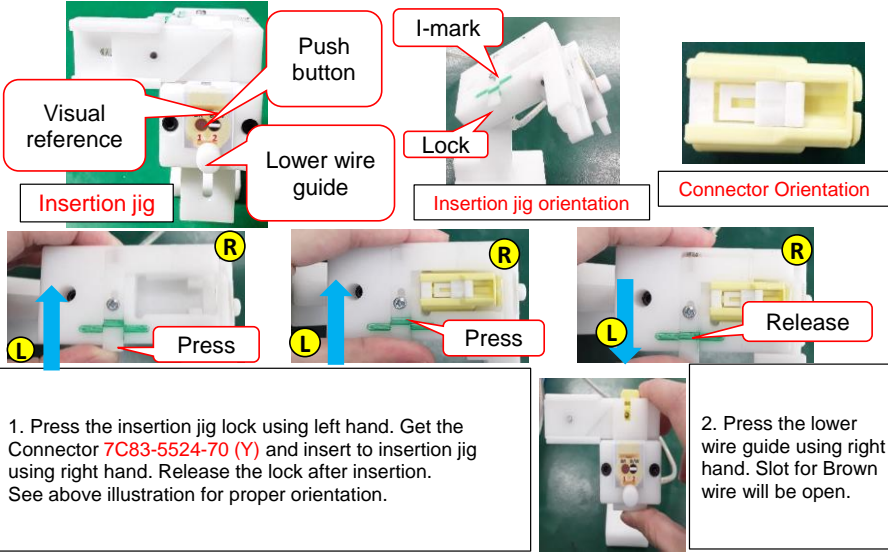
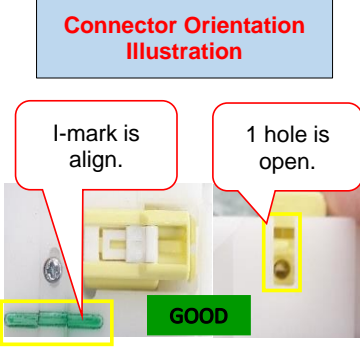
☒ MASSPRO

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| PARTS: | | 1. Assy parts 2. Black corrugated tube (No Slit) Ø7 L=619±4mm 3. Connector 7C83-5524-70 (Y) | JIG: | 1. Insertion jig 2. Terminal cover jig |
|--------|---|--|--|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 2 | Wire insertion to Corrugated tube Ø7 L=619±4mm (no slit) |  <p>1. Get the terminal cover jig using right hand then insert the hotmelted wire W-B/W wires using left hand.</p> <p>2. Get the corrugated tube (no slit) Ø7 L=619±4mm using right hand and then insert the hotmelted wire W-B/W wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> | TERMINAL COVER JIG  | 1. No wrong use of parts 2. No deformed terminal |
| 3 | P1 Connector setting to insertion jig 7C83-5524-70 (Y) |  <p>1. Press the insertion jig lock using left hand. Get the Connector 7C83-5524-70 (Y) and insert to insertion jig using right hand. Release the lock after insertion. See above illustration for proper orientation.</p> <p>2. Press the lower wire guide using right hand. Slot for Brown wire will be open.</p> | n/a | Connector Orientation Illustration  <p>I-mark is align. 1 hole is open.</p> <p>GOOD</p> <p>1. No wrong orientation of connector</p> |

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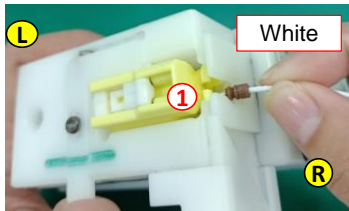
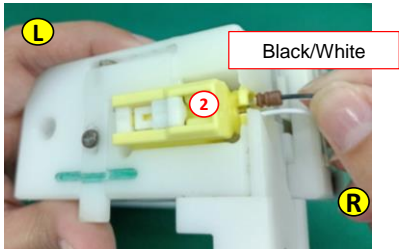
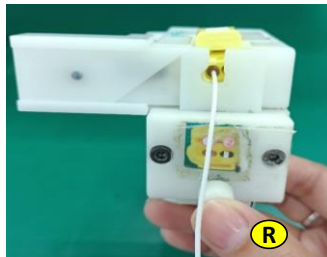

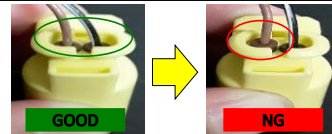
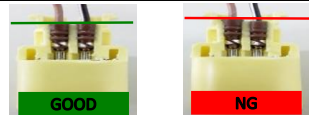
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| PARTS: | | 1. Assy parts | | JIG: | 1. Insertion jig |
|--------|--|--|--|-----------|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P1 Wire insertion to Connector 7C83-5524-70 (Y) | <div><p>Wire 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>GOOD NG</p></div> <div><p>EMERGED RUBBER SEAL CROSS SECTIONAL VIEW</p><p>GOOD NG</p></div> |

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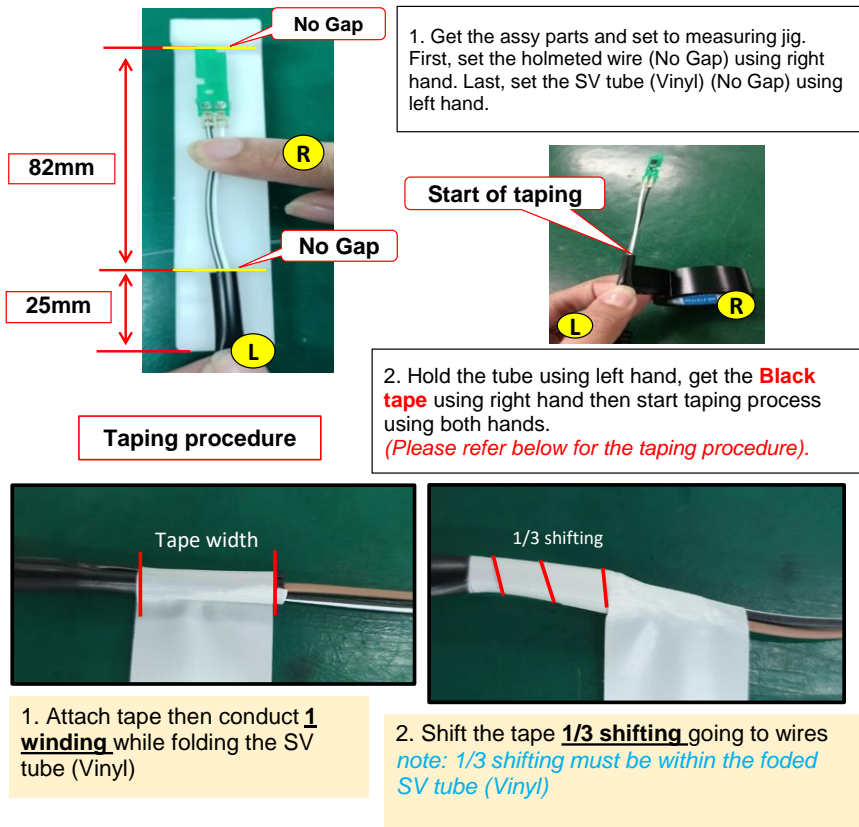



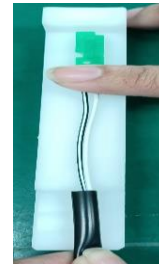
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| PARTS: | | 1. Black tape 2. Assy parts | | JIG: | 1. Measuring jig |
|--------|---|---|--|--|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P1 Taping 1 SV tube (Vinyl) to wire |  <p>1. Get the assy parts and set to measuring jig. First, set the holmated wire (No Gap) using right hand. Last, set the SV tube (Vinyl) (No Gap) using left hand.</p> <p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands. (Please refer below for the taping procedure).</p> <p>1. Attach tape then conduct 1 winding while folding the SV tube (Vinyl)</p> <p>2. Shift the tape 1/3 shifting going to wires <i>note: 1/3 shifting must be within the folded SV tube (Vinyl)</i></p> | |   | <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>  GOOD  NG <p>Position the finger in wire to avoid deformed hotmelt</p> |

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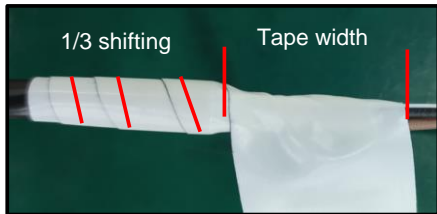
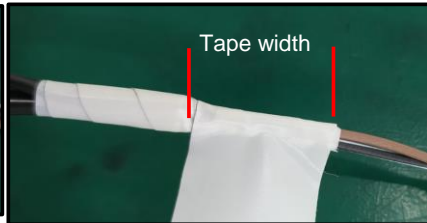
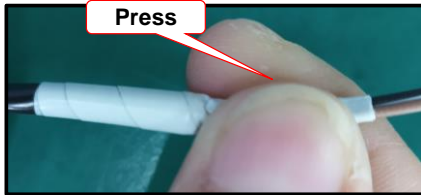
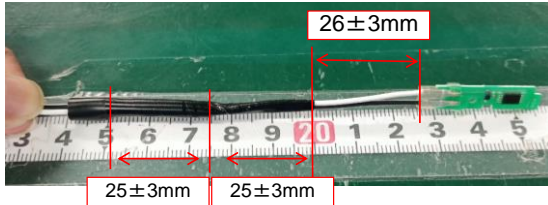




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| PARTS: | | 1. Black tape 2. Assy parts | | JIG: | 1. Measuring jig |
|--------|---|--|--|--|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P1 Taping 1 SV tube (Vinyl) to wire (Continuation) | <div><p>1/3 shifting Tape width</p></div> <div><p>3. Shift the tape 1x shifting until</p></div> <div><p>Tape width</p></div> <div><p>4. Conduct 2x windings before end of tape .</p></div> <div><p>Press</p></div> <div><p>5. Conduct 3x pressing at the end of tape to prevent peel off.</p></div> <div><p>25±3mm 25±3mm 26±3mm</p></div> <div><p>3. After taping, check the taping condition and measurement.</p></div> | | <div>MEASURING TAPE</div>  <div>MEASURING JIG</div>  | <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><p>GOOD</p></div> <div><p>NG</p></div> <p>Position the finger in wire to avoid deformed hotmelt</p> |

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PARTS:

1. Assy parts

JIG:

n/a

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

- ① No Wrong Insert
- ② No Terminal backing out
- ③ No Deformed terminal
- ④ No Missing tape (Black tape)
- ⑤ No Missing tape parts

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