



## WORK INSTRUCTION

Effectivity Date:

November 12, 2024

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

ES1 / 7N0164-7020B

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Document No.:

WI-ENG-PDE-1169

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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## PARTS:

1. Assy parts: Gray tape (10mm)

JIG:

1. Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

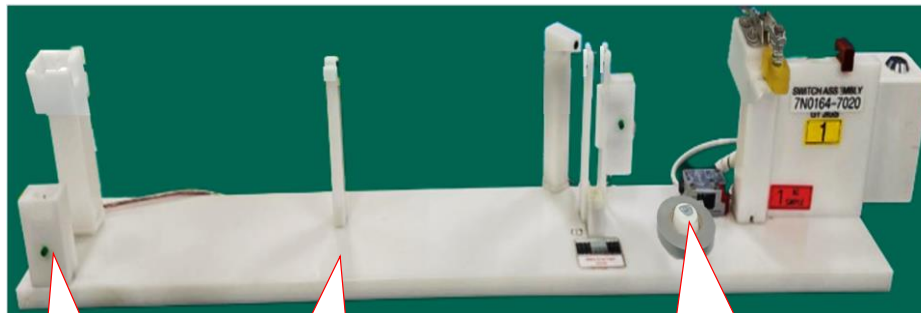
## QUALITY POINTERS

1

CLAMP  
ASSY

Table Lay-out

## TABLE LAY-OUT



Locking jig

Assembly jig

Tape holder/ Gray tape  
(10mm)**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 reference/s:**

1. Refer to **WI-ENG-PDE-623A-B** for Offline assembly process

1. No missing parts/tools
2. No excess parts/tools

## 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

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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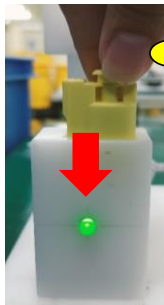

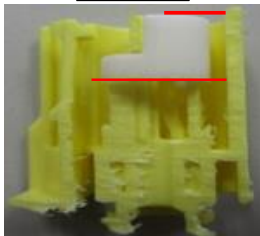
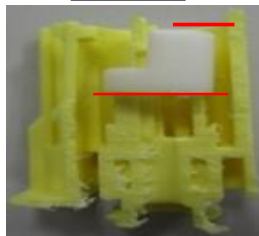
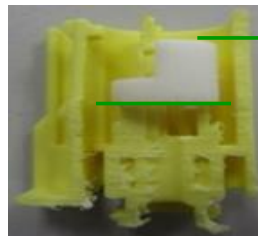
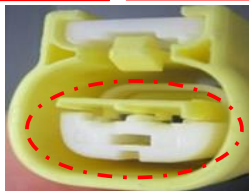
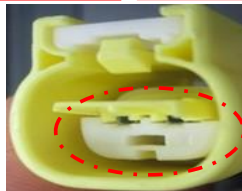

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PARTS:	1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	<div><div><div></div><div></div><div>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</div></div><div>CROSS SECTIONAL VIEW</div><div><div>NG</div><div>NG</div><div>GOOD</div></div><div></div><div>Unlock</div><div></div><div>Half-locked</div><div></div><div>Fully locked</div><div></div><div>Before Pressing</div><div></div><div>After Pressing</div></div>	<div>LOCKING JIG</div> 	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</b></p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</p>

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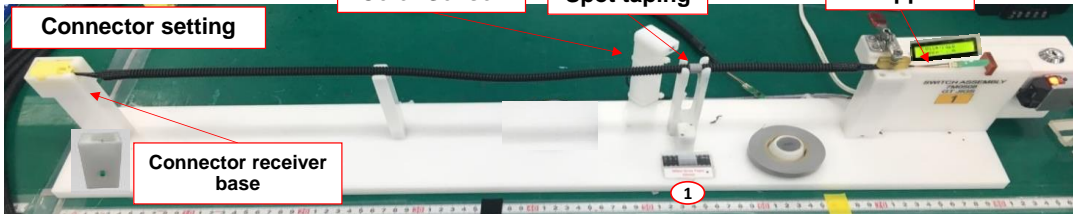










☒ MASSPRO

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PARTS:		1. Assy parts 2. Gray tape (10mm)		JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Assembly (Spot taping)	<div></div> <div>1. Get the assy parts then set into jig (<i>See above illustration</i>). First, the connector to receiver base. Last, put the PCB into stopper jig then pull the toggle clamp using both hands. Make sure the end tape of wire is within the tolerance.</div> <div>2. Check in the counter if <b>CLAMP</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</div> <div>3. Get the <b>Gray tape</b> using right hand and start spot taping on <b>location 1</b> using both hands make 3 winds. Check if the Color sensor was ON. Press the SW button. <b>GO</b> buzzer will be heard.</div> <div>4. Conduct <b>POINT CHECKING</b> after taping and before removal from jig.</div> <div></div>		<div><p><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between stopper and terminals</b></p><p>1. No wrong use of tape 2. No excess/lacking tape windings</p><div><p><b>Make sure the end tape of wire is within the tolerance.</b></p></div></div>

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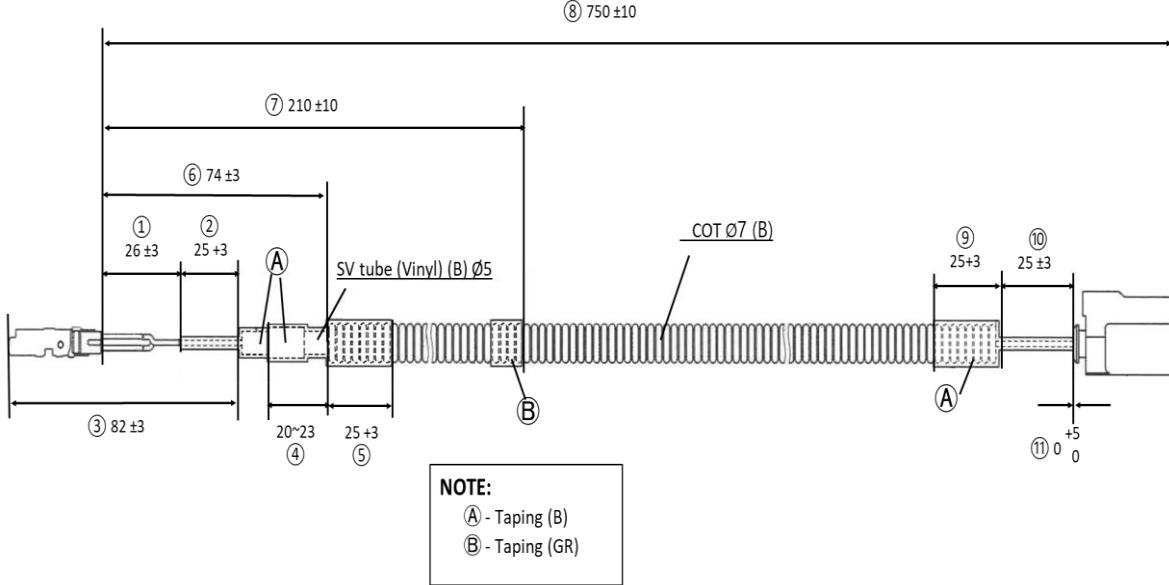
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Measurement	<div>MEASURING TAPE</div>  	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0164-7020B**

- ① No **unlock/half-locked connector**
- ② No **Missing spot tape (Gray tape)**
- ③ No **Missing Tape (COT to wire near Connector)**
- ④ No **Missing Tape (COT to wire near SV tube)**

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