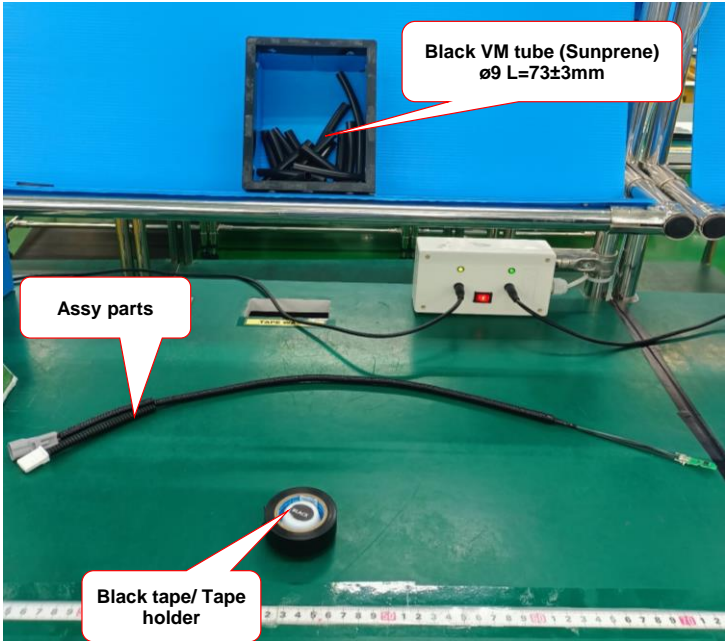


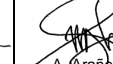
	WORK INSTRUCTION				Effectivity Date:		October 30, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ	Car Model: SUBARU	Document No.:		WI-ENG-PDE-1146C	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		1	Page No.: 1 of 7


PARTS:		1. All parts: Assy parts; Black VM tube (Sunprene) ø9 L=73±3mm; Black tape				JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P3	<div style="text-align: center;"> TABLE LAY-OUT </div> 				<div style="border: 1px solid red; padding: 5px;"> 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;"> 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>		1. No missing parts/tools 2. No excess parts/tools	




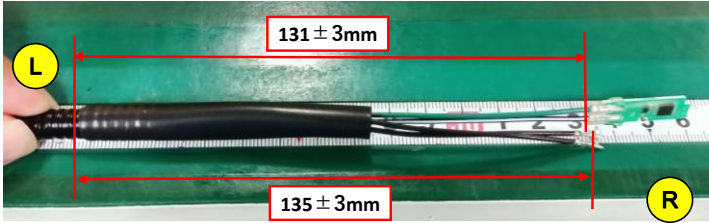

Revision History								Prepared by		Reviewed by		Approved by		Noted by			
10/30/24	1	Change from Pre-launch to Masspro.				D.Castillo	C. Villanueva	A. Arañes	n/a							n/a	
10/29/24	0	Initial issue				D.Castillo	C. Villanueva	A. Arañes	n/a								
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		October 29, 2024					

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	WORK INSTRUCTION			Effectivity Date:	October 30, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	ES1 / 7M0515-7021B	Customer:	TRJ	Car Model:	SUBARU	Document No.:	WI-ENG-PDE-1146C	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	2 of 7

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) ø9 L=73±3mm		JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P3 Wire insertion to Black VM tube (Sunprene) ø9 L=73±3mm	<div><div></div><div></div><div></div><div></div><div>4. Measure from VM tube (Sunprene) up to the edge of hotmelt 131±3mm and VM tube (Sunprene) up to terminal tip 135±3mm.</div></div> <div><div>TERMINAL COVER JIG</div></div>		1. No wrong use of parts 2. No deformed terminal		

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ES1 / 7M0515-7021B

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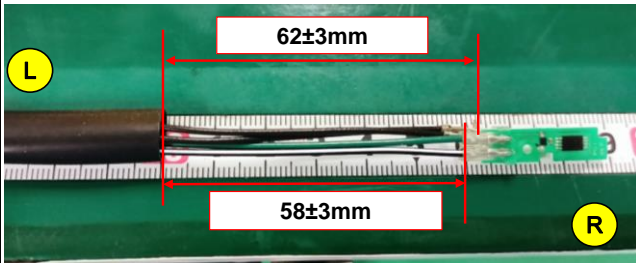

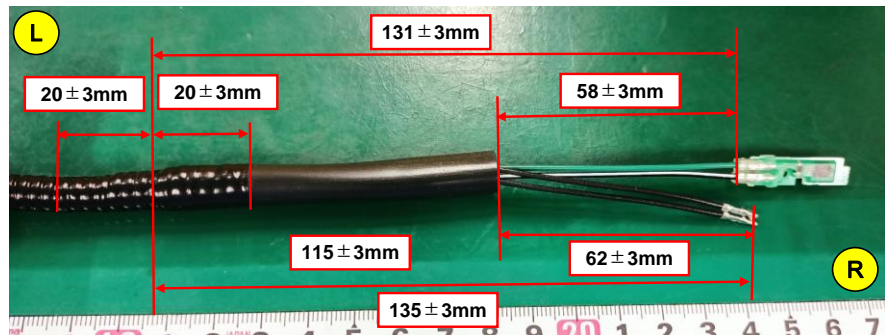

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 Taping 2 COT to VM tube (Sunprene)	<div><div><p>1. Measure from end of the VM tube (Sunprene) up to the edge of hotmelt 58±3mm and VM tube (Sunprene) up to terminal tip 62±3mm.</p></div><div><p>2. Hold the assy parts using left hand and start taping using right hands.</p></div><div><p>3. After taping, check the dimension, terminal appearance and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references:</p><p>1. Refer to WI-PRO-ASY-001 for Taping process</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></div>			

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Validity Date:

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Model code/Part number:

ES1 / 7M0515-7021B

Customer:

TRJ

Car Model:

SUBARU

Document No.:

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Purpose:




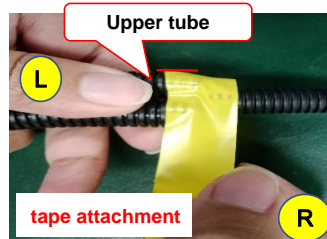

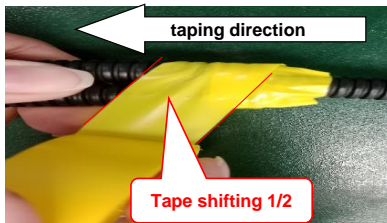
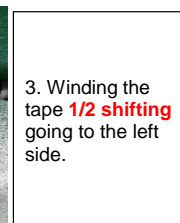
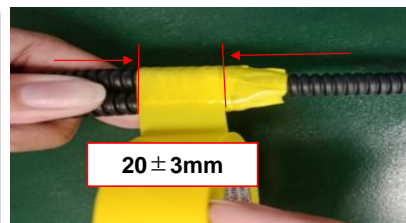
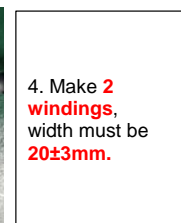
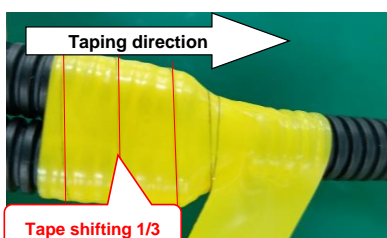
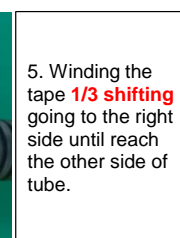
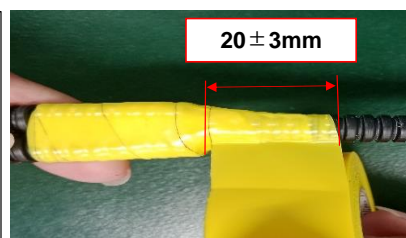
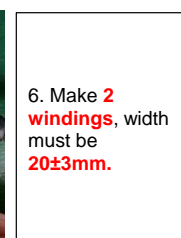
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Y-taping	<div><div></div><div></div><div></div><div>1. Fix the 3 corrugated tube. Note: Follow the COT orientation.</div></div> <div><div></div><div></div><div>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</div></div> <div><div></div><div></div><div>3. Winding the tape 1/2 shifting going to the left side.</div></div> <div><div></div><div></div><div>4. Make 2 windings, width must be 20±3mm.</div></div> <div><div></div><div></div><div>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</div></div> <div><div></div><div></div><div>6. Make 2 windings, width must be 20±3mm.</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>	

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 30, 2024

Validity Date:

n/a

Model code/Part number:

ES1 / 7M0515-7021B

Customer:

TRJ

Car Model:

SUBARU

Document No.:

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Purpose:

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☐ PRE-LAUNCH

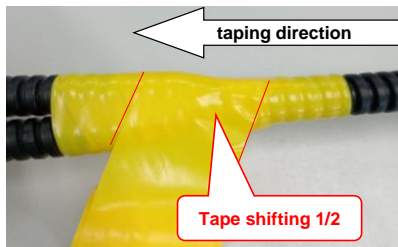
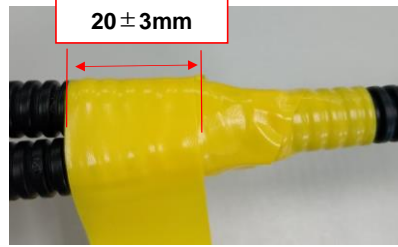
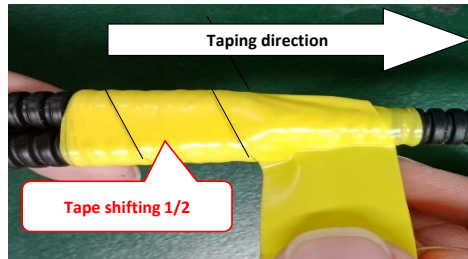
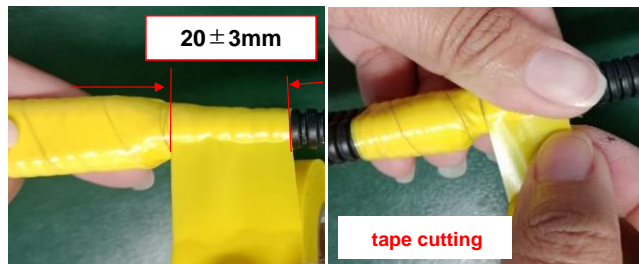
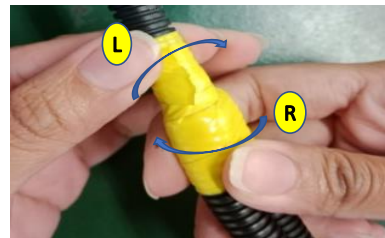

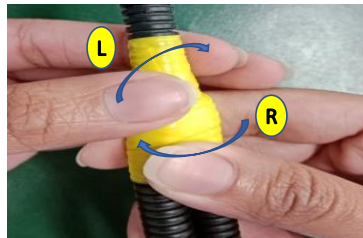
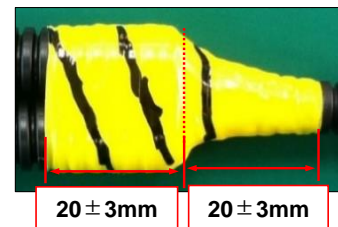
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3 Y-taping (Continuation)	<div><div></div><div><p>7. Winding the tape 1/2 shifting going to the left side.</p></div><div></div><div><p>8. Make 2 windings, width must be 20±3mm.</p></div><div></div><div><p>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</p></div><div></div><div><p>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></div><div></div><div><p>11. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</p></div><div></div><div><p>12. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</p></div><div></div><div><p>13. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</p></div><div></div><div><p>14. Check the Measurement and condition of tape.</p></div></div>		<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes	

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TAPING ASSEMBLY PROCESS

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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1. Assy parts

JIG:

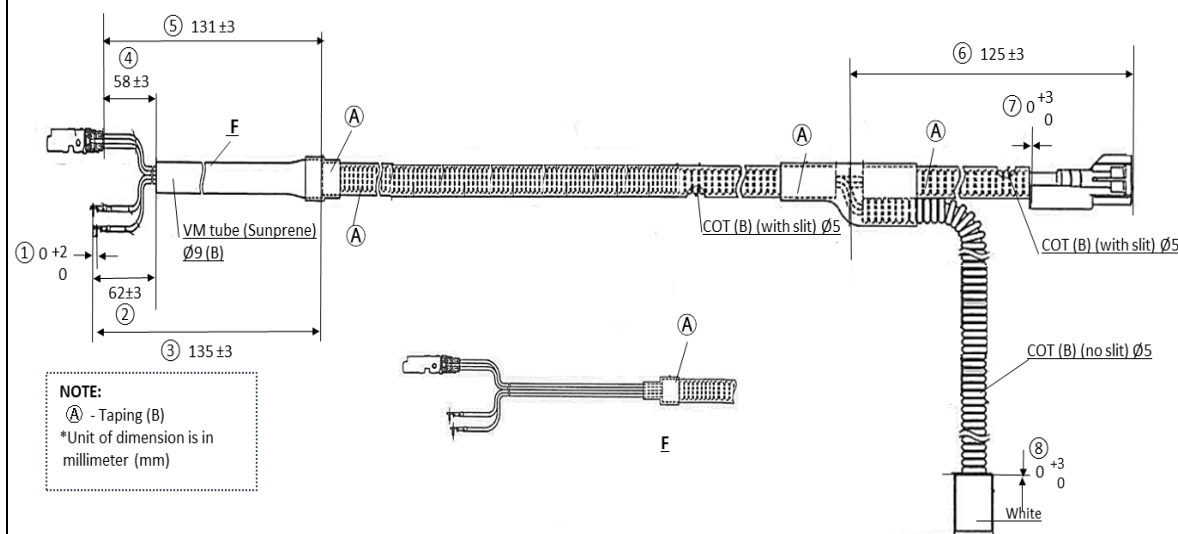
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P3

Measurement

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7M0515-7021B****1****2****No Missing Tape**

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