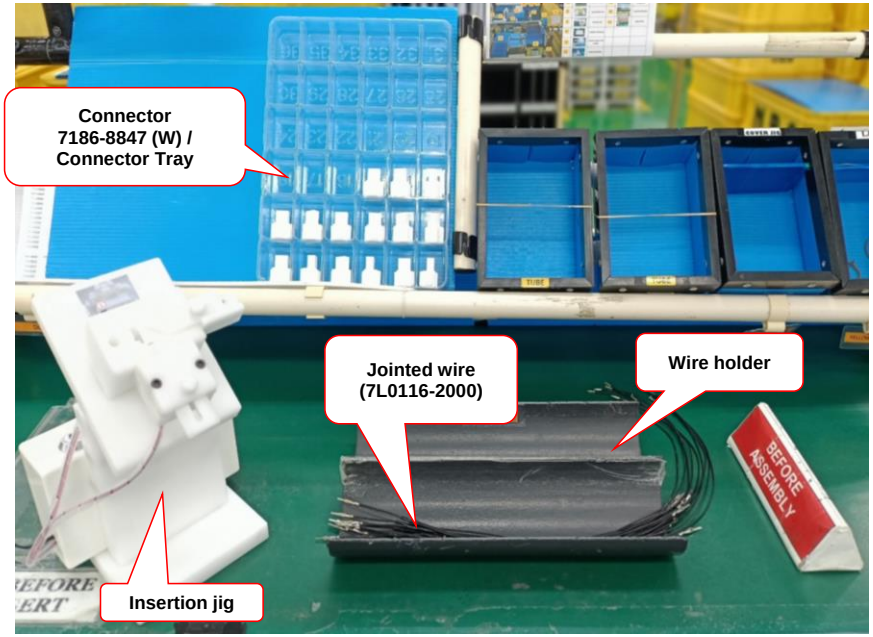
	WORK INSTRUCTION			Effectivity Date:	September 11, 2024
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	TM3 / 7L0116-7020	Customer: TRQSS / Car Model: SUBARU ASCENT	Document No.:	WI-ENG-PDE-354
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3 / Page No.: 1 of 5

PARTS:	1. Connector 7186-8847(W); Jointed wire B-B 7L0116-2000	JIG:	1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Offline △3 Table Lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear required 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-PRO-CNC-017** for Wire and Strip Length Tolerance* 1.No missing parts/tools 2.No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
09/11/24	3	Inclusion of Car model "SUBARY-ASCENT", Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A
02/25/23	2	Improve quality pointers and notes in process no.3 as document improvement. Additional process in: Process no.3, procedure 4 - pushing of wires as countermeasure for encountered terminal backing out. Removal of notes related to the function of insertion jig. Addition of " Must have slightly movement of after insertion. inclusion of Quality Checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
09/30/22	1	Change Document name/Title from 'Kitting Assembly Process' to 'Offline Assembly Process. Improve Quality pointers and notes on page no.1, 2 and 3	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	N/A
Est. Date:	October 15, 2021		

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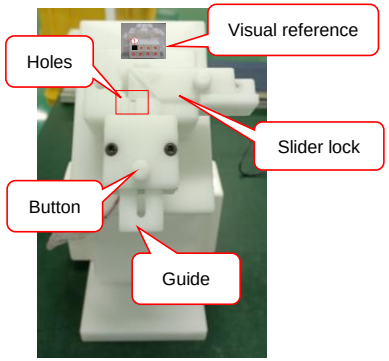
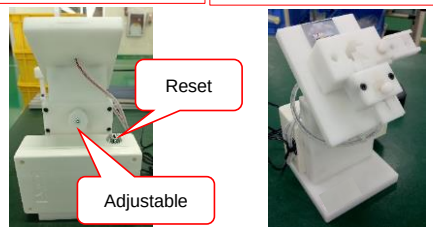
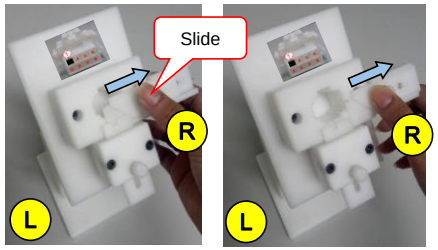
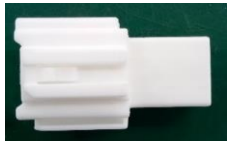
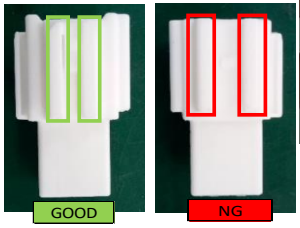
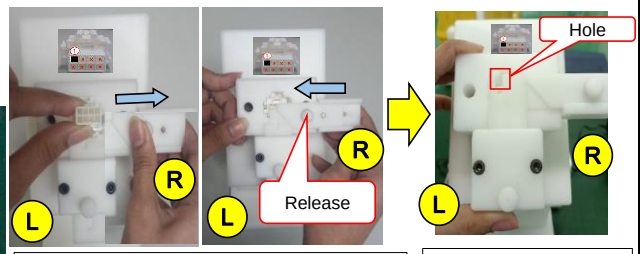
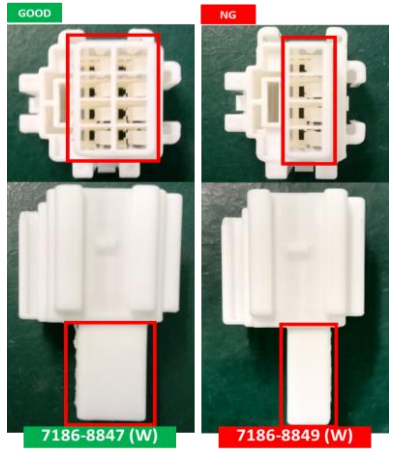
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	2 of 5

PARTS:	1. Connector 7186-8847 (W)	JIG:	1. Inssertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Offline	Connector setting to insertion jig 7186-8847(W)	**Insertion jig**  **Insertion jig (Back view)** **Insertion jig Orientation**   1. Slide the slide lock using right  **Connector Orientation**   2. Insert the connector (7186-8847) into jig using left hand and release the side lock. *Note: Cannot insert the inverted connector.* 3. Push the guide using right hand. The slot for Jointed wire will be opened.	n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector **CONNECTOR ORIENTATION** 

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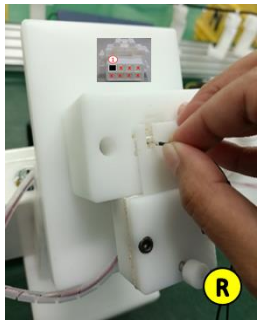
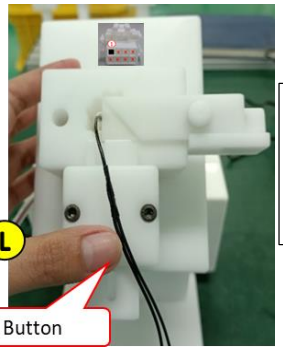
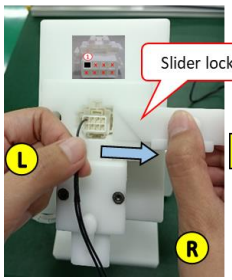
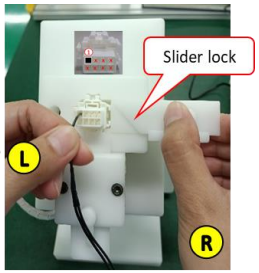
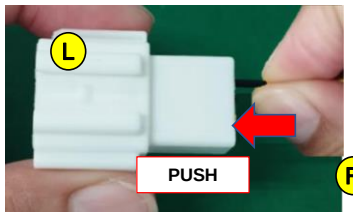
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3 / Page No.: 3 of 5

PARTS:	1. Jointed wire B-B 7L0116-2000	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline	Wire insertion to Connector 7186-8847 (W)	 Wire facing  1. Get **Jointed wire** then insert to terminal slot **1** using right hand.  2. Press the button using left hand. **GO** sound will be heard.   3. After insertion, slide the slide lock using right thumb and then hold the jointed wire and gently pull out the connector from jig using left hand.  4. After removing the connector from jig, Conduct pushing (1x) of Jointed wire using right hand confirm if the wires are fully inserted.	n/a	***Important reminders/Note/s:*** ***1. Please hold the wire near terminal during insertion. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion*** ***3. Conduct Pushing of wires after removing the connector from jig.*** ***4. Pushing of wires will be done one by one of every inserted wire.*** ***Documents reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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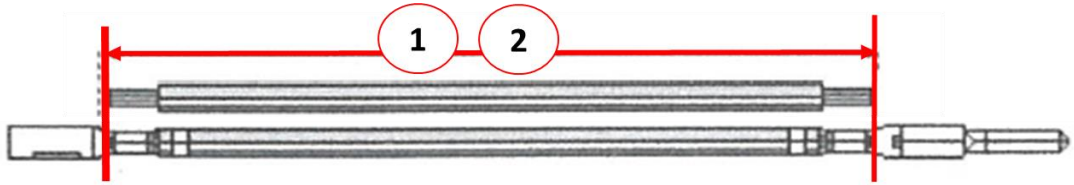
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline	Measurement	△3 Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.  	**MEASURING TAPE** 	***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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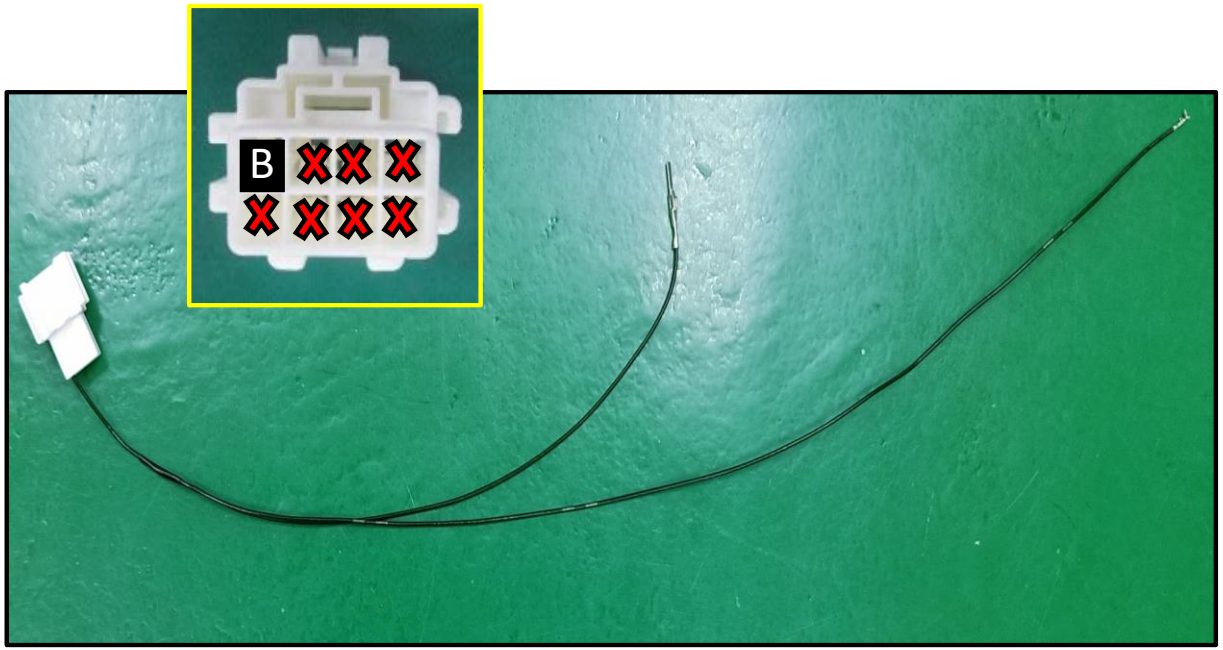
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.: 5 of 5

PARTS:	1. Assy parts	JIG:	N/A

△3 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

OFFLINE INSERTION 7L0116-7020



① No Wrong Insert

② No Terminal Backing out

③ No Deformed Terminal

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