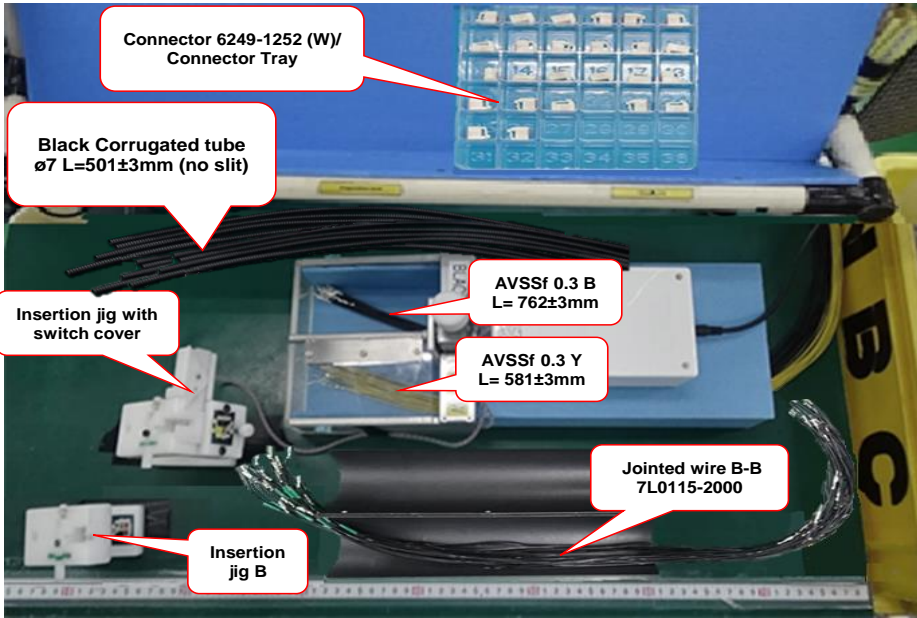

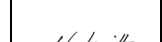

	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>January 21, 2025</b>		
	<b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>		
	Process Name/Title:	<b>TM3 / 7L0115-7020</b>	Customer: <b>TRQSS</b>	Car Model: <b>SUBARU-ASCENT</b>	Document No.:	<b>WI-ENG-PDE-346</b>	
	Model code/Part number:				Revision No.:	<b>3</b>	Page No.: <b>1 of 8</b>
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:	1. Connector 6249-1252 (W); Black Corrugated tube ø7 L=501±3mm (no slit); AVSSf 0.3 B L= 762±3mm; AVSSf 0.3 Y L= 581±3mm; Jointed wire B-B 7L0115-2000			JIG:	1. Insertion with switch cover 2. Insertion jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	OFFLINE	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. WI-ENG-PDE-328 TM3 Wire Taping Process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

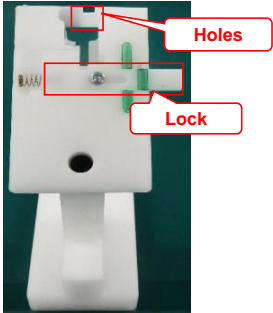
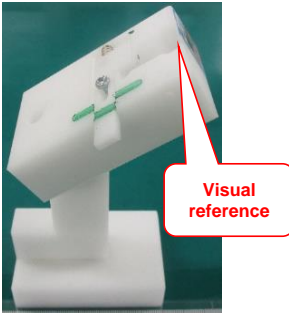

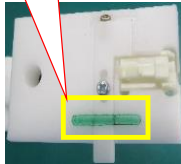

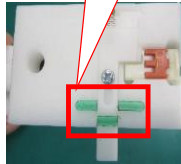

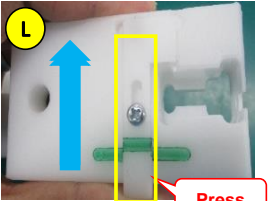
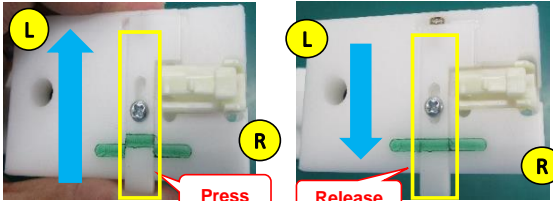
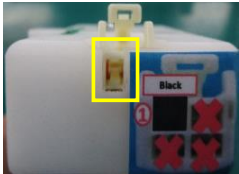
Revision History								Prepared by	Reviewed by	Approved by	Noted by
01/21/25	3	Transfer Process 4-6 from Taping assembly process. Returned the terminal cover jig due to process sequence change. Inclusion of Measurement. Improved Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D.Castillo	 C. Villanueva	 A. Arañes	n/a	
07/02/24	2	Change process sequence and removal of cover jig due to Process improvement. Inclusion of car model "SUBARU-ASCENT"	D.Castillo	C. Villanueva	A. Arañes	n/a					
10/14/22	1	Improve quality pointers in process no.1 and 3 due to document improvement. Change of document title from 'Kitting assembly process' to 'Offline assembly process'	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
09/24/21	0	Initial issue.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2021			

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	OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>TM3 / 7L0115-7020</b>	Customer: <b>TRQSS</b>	Car Model: <b>SUBARU-ASCENT</b>	Document No.:	<b>WI-ENG-PDE-346</b>
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	3      Page No.:      2 of 8

PARTS:		1. Connector 6249-1252 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	OFFLINE Connector Setting to insertion jig 6249-1252 (W)	<div><div>Insertion Jig</div></div> <div><div>Insertion Jig Orientation</div></div> <div></div> <div><div>Visual reference</div></div> <div><div>Connector Orientation</div></div>		n/a	<div><div>Connector Orientation Illustration</div></div> <div><div>I-mark is align</div></div> <div><div>1 hole were only open</div></div> <div><div>GOOD</div></div> <div><div>I-mark is NOT align</div></div> <div><div>1 hole were open</div></div> <div><div>NG</div></div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>	
		<div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>2. Insert the connector <b>6249-1252 (W)</b> using right hand and release the lock. <b>Note: Follow the connector orientation.</b></div></div><div><div><div>3. Check the holes/terminal slot for <b>B Jointed wire</b></div></div></div></div></div>				

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**TM3 / 7L0115-7020**

Customer:

**TRQSS**

Car Model:

**SUBARU-ASCENT**

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH




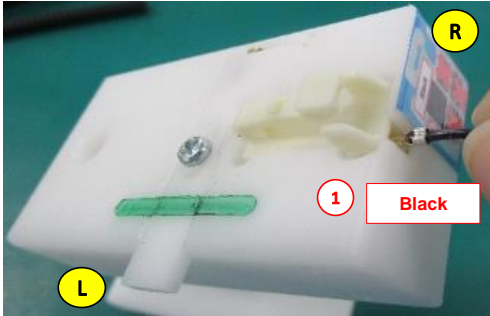
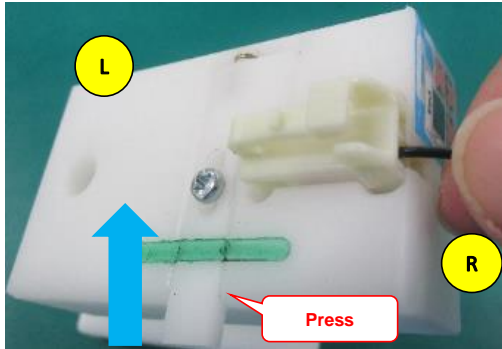
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PARTS:		1. Jointed wire B-B 7L0115-2000		JIG:	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	Wire insertion to connector 6249-1252 (W)	<div><div>TERMINAL FACING</div></div> <div><div>1. Get <b>Jointed wire</b> then insert to terminal slot <b>1</b> using right hand.</div></div> <div><div>2. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Document references:</b></p> <p>1. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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PRE-LAUNCH



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PARTS:	1. Assy parts		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	OFFLINE Connector Setting to insertion jig 6249-1252 (W) (Assy parts)	<div><div>Insertion jig</div><div>I-mark</div><div>Side guide</div><div>Visual reference</div><div>Push button</div><div>Lower guide</div><div>Insertion jig orientation</div><div>Connector Orientation</div><div><div>1. Push the lower wire guide using right hand.</div></div><div><div>2. Press the lock of insertion jig using left thumb.</div></div><div><div>3. Insert the connector 6249-1252 (W) into jig using right hand and release the lock. <b>Note: Follow the connector orientation.</b></div></div><div><div>4. Check the hole/terminal slot for <b>Black wire.</b></div></div><div><div>Press</div></div><div><div>Press</div></div><div><div>Release</div></div><div><div>Hole</div></div></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole were only open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>2 holes were open</div><div>NG</div></div></div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>

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Car Model:

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Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH




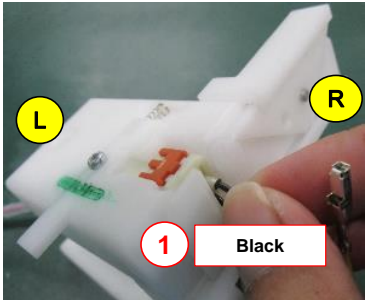
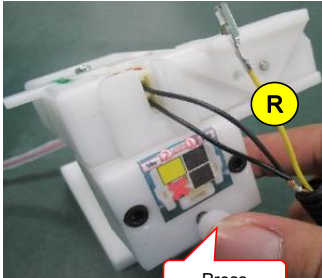
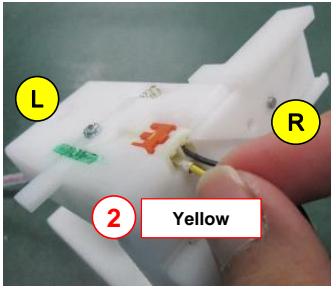
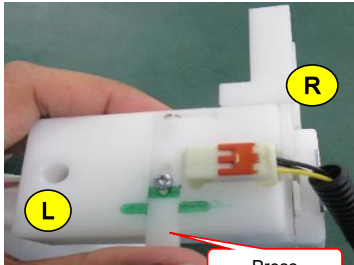
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PARTS:		1. Assy parts 2. AVSSf 0.3 Y wire L=581±3mm 3. AVSSf 0.3 B wire L=762±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	OFFLINE Wire insertion to connector 6249-1252 (W) (Assy parts)	<div><div></div><div><div></div><div><div></div></div></div><div><div></div><div><div></div></div></div></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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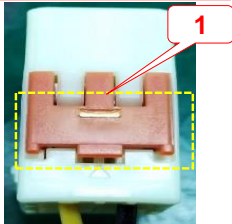
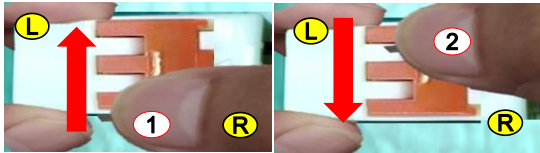
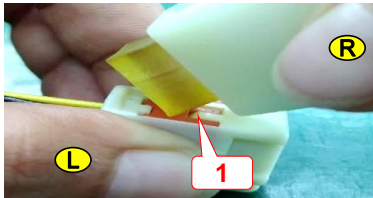
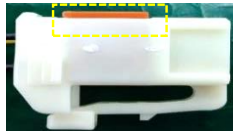
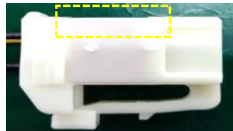
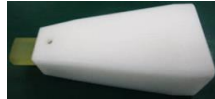
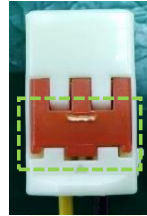





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	Model code/Part number: <b>TM3 / 7L0115-7020</b>		Customer: <b>TRQSS</b>	Car Model: <b>SUBARU-ASCENT</b>	Document No.:	WI-ENG-PDE-346	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	6 of 8

<b>PARTS:</b> 1. Assy parts 2. Black Corrugated tube (no slit) ø7 L=501±3mm	<b>JIG:</b> 1. Locking jig 2. Terminal cover jig			
<b>NO.</b> 6	<b>PROCESS NAME</b> Connector lock	<b>WORK PROCEDURE/ ILLUSTRATION</b> <div> <div> <b>LOCKING SEQUENCE</b>   </div> <div>    </div> <div> <p>1. Place the connector on the table while holding using left hand. Get the pushing jig using right hand and start the locking based on above illustration. Push the center part of the connector lock.</p> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p> </div> </div>	<b>TOOLS/PPE</b> <div> <b>Pushing jig</b>  </div>	<b>QUALITY POINTERS</b> <div> <p><b>Important reminders/Note/s:</b></p> <p>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>2. <b>Use the provided jig tool to lock the connector.</b></p> <p>3. <b>Position of pushing jig during locking must be slanted</b></p> <p>1. No unlocked/half-locked connector 2. No damage connector</p> <div> <b>LOCKED CONDITION</b>   </div> </div>
7	<b>Wire insertion to Black corrugated tube (no slit) ø7 L=501±3mm</b>	<div>    </div> <div> <p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>B-B wires</b> using left hand.</p> <p>2. Get the corrugated tube (no slit) ø7 L=501±3mm using right hand then insert the <b>B-B wires</b> and <b>B-Y wires</b> using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>	<b>TERMINAL COVER JIG</b> 	1. No wrong usage of parts 2. No deformed terminal tip

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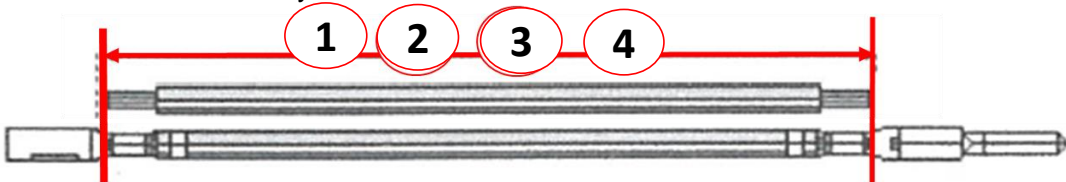

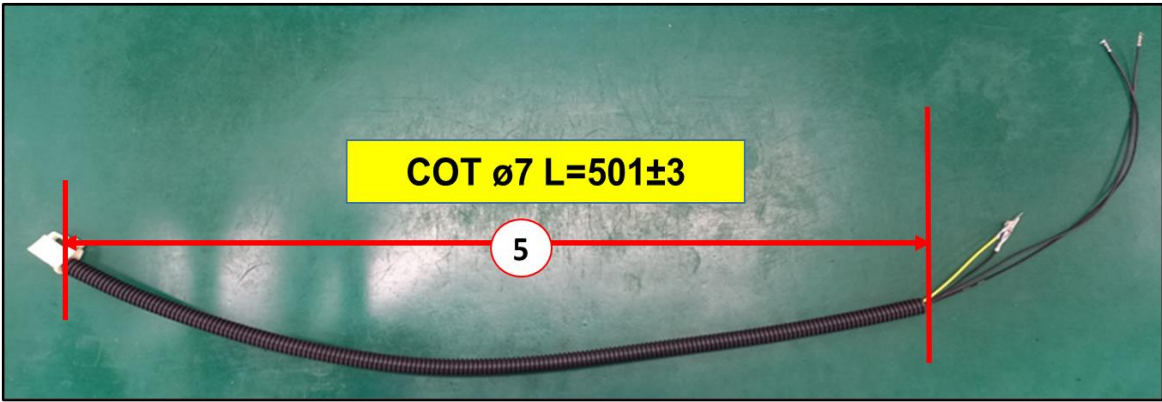
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	OFFLINE	<div>3</div> <p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p> 	<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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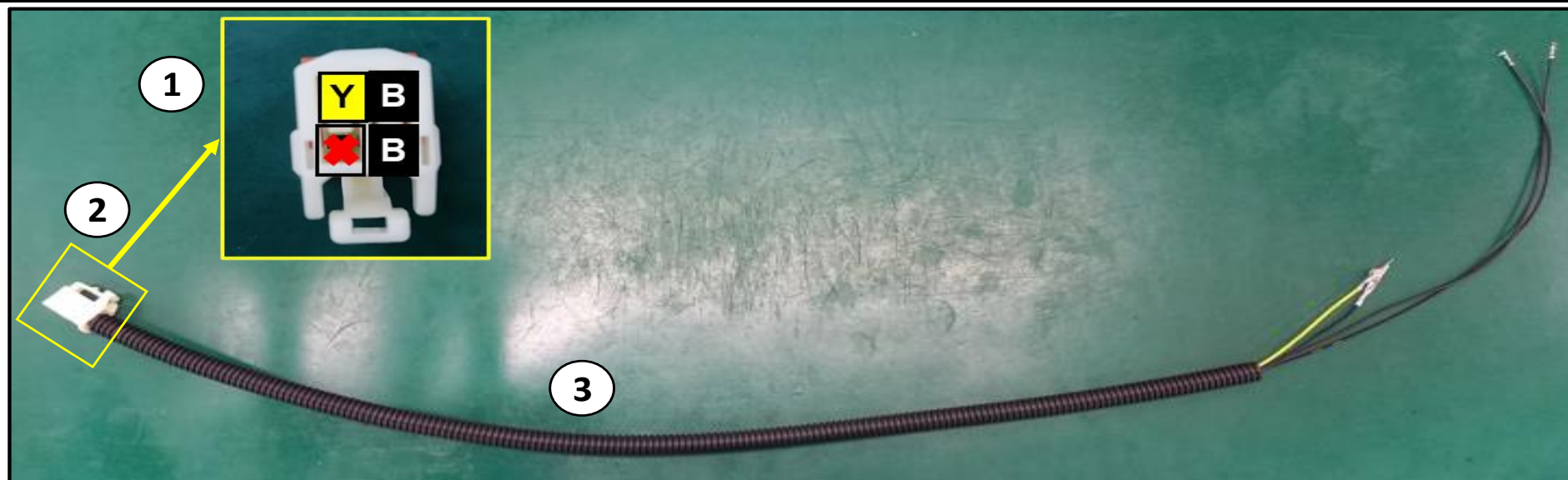
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0115-7020****① No Wrong insert****② No Unlocked/Half-locked connector****③ No Missing Cot****④ No Deformed terminal****⑤ No Terminal Backing out**

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