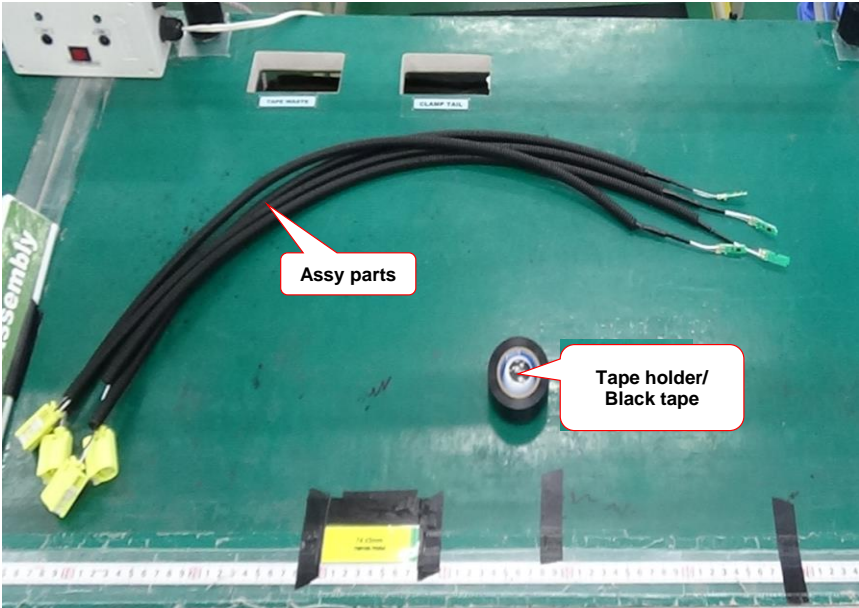
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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-623B		
	Model code/Part number:	ES1 / 7N0164-7020	Customer:	TRJ	Car Model:	SUBARU-FORESTER	
Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	3	Page No.: 1 of 7

PARTS:	1. Assy parts: Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P2	Table Lay-out <div>  </div>	<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> 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
07/10/24	3	Separate assembly (Spot taping) to Clamp assembly process. Transfer Taping 2 from P1 due to process improvement. Inclusion of car model "SUBARU-FORESTER". Update table lay-out, Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a			
04/05/23	2	Change taping procedure due to tape reduction project (Page 2-5).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes			
01/25/23	1	Change from Pre-launch to Masspro. Inclusion of Table lay-out (Page 1). Inclusion of measuring jig and quality pointers (Page 2).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Januray 19, 2023	

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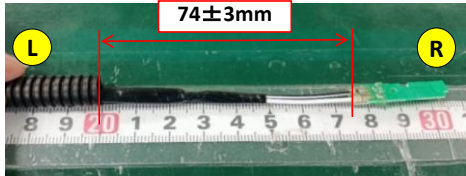

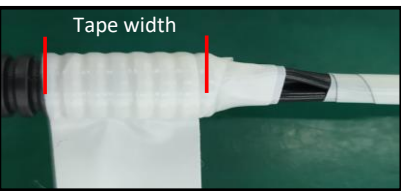
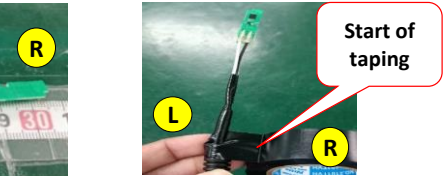

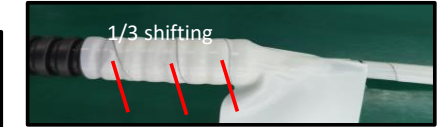

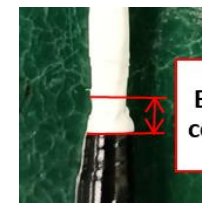
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Corrugated tube to SV tube (Vinyl)	<div data-bbox="611 411 1075 587"></div> <div data-bbox="611 595 954 691">1. Measure from the COT up to edge of hotmelt 74±3mm using both hands.</div> <div data-bbox="636 711 866 743">Taping procedure</div> <div data-bbox="611 770 999 943"></div> <div data-bbox="611 951 969 999">1. 1 wind pre-tape in the middle of COT and SV tube (Vinyl).</div> <div data-bbox="611 1026 1010 1217"></div> <div data-bbox="611 1225 969 1257">3. Conduct 1 wind before shifting.</div> <div data-bbox="1010 411 1451 587"></div> <div data-bbox="1010 595 1451 746">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).</div> <div data-bbox="1010 770 1451 914"></div> <div data-bbox="1010 922 1451 978">2. Shift the tape 1x shifting going to COT must be tape width.</div> <div data-bbox="1010 1002 1451 1129"></div> <div data-bbox="1010 1137 1451 1217">4. Shift the tape 1/3 shifting going to VT see above illustration for proper shifting. <i>Note: 1/3 shifting must be within the COT.</i></div>	<div data-bbox="1503 738 1704 770">MEASURING TAPE</div> <div data-bbox="1480 778 1704 922"></div> <div data-bbox="1715 778 1939 930">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>	<div data-bbox="1738 467 2114 659">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.</div> <div data-bbox="1771 1002 2063 1034">NG Taping Illustration</div> <div data-bbox="1738 1058 1939 1265"></div> <div data-bbox="1906 1137 2114 1201">Exceed 24mm consider as NG</div>

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TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

n/a

Model code/Part number:

ES1 / 7N0164-7020

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Document No.:

WI-ENG-PDE-623B

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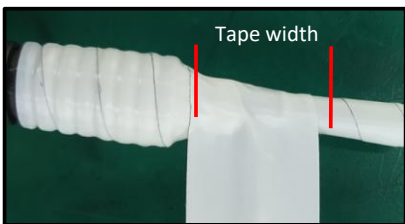


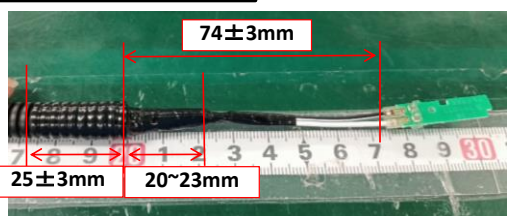


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PARTS:	1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Corrugated tube to SV tube (Vinyl) (Continuation)	<div data-bbox="280 510 336 566">3</div> <div data-bbox="616 406 1019 630"></div> <div data-bbox="638 638 985 694">5. Shift the tape 1x shifting until reach the tape width.</div> <div data-bbox="1041 406 1444 630"></div> <div data-bbox="1075 638 1433 694">6. Conduct 2x windings before end of tape.</div> <div data-bbox="616 710 1041 917"></div> <div data-bbox="1064 782 1433 837">7. Conduct 3x pressing at the end of tape to prevent peel off.</div> <div data-bbox="795 917 1299 1133"></div> <div data-bbox="761 1141 1321 1212">3. After taping, check the taping condition and measurement.</div>	<div data-bbox="1500 702 1713 758">MEASURING TAPE</div> <div data-bbox="1500 758 1713 869"></div>	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <div data-bbox="1769 997 2094 1061">NG Taping Illustration</div> <div data-bbox="1758 1069 1937 1284"></div> <div data-bbox="1904 1133 2094 1252">Exceed 24mm consider as NG</div>

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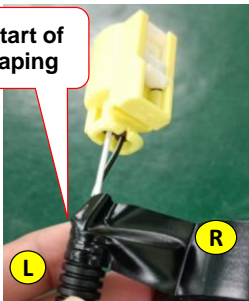

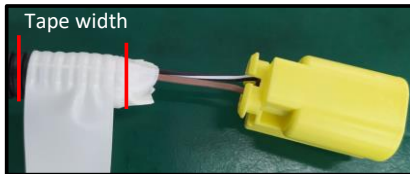
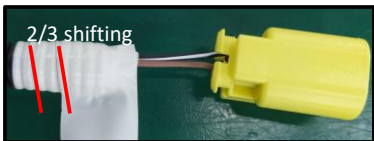
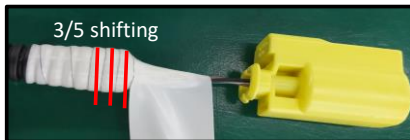

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 3 Corrugated tube to wire near connector	<div><div><div>Start of taping</div></div><div><div>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start taping procedure using both hands. (Please refer below for taping procedure).</div><div><div>Taping Procedure</div></div></div><div><div>2. 2 winds pre-tape in the middle of COT and wires.</div><div><div>Tape width</div></div></div><div><div>3. Shift the tape 1x shifting going to COT must be tape width</div><div><div>2/3 shifting</div></div></div><div><div>4. Conduct 1 wind before shifting</div><div><div>3/5 shifting</div></div></div><div><div>5. Shift the tape 2/3 shifting upward refer to above illustration for shifting direction</div><div><div>6. Shift the tape 3/5 shifting upward note: 3/5 shifting must be within the cot</div></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>2. USED WHITE TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL TAPE SHOULD BE BLACK TAPE.</p> <p>1. No flip-out tape</p> <p>2. No peel-off tape</p> <p>3. No loose tape</p> <p>4. No missing tape</p> <p>5. No wrong dimension</p> <p>6. No wrong use of tape</p>	

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TAPING ASSEMBLY PROCESS

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Model code/Part number:

ES1 / 7N0164-7020

Customer:

TRJ

Car Model:

SUBARU-FORESTER

Document No.:

WI-ENG-PDE-623B

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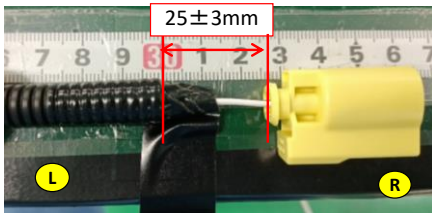
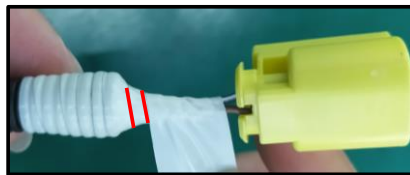

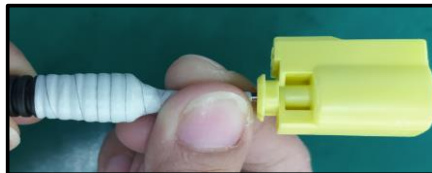
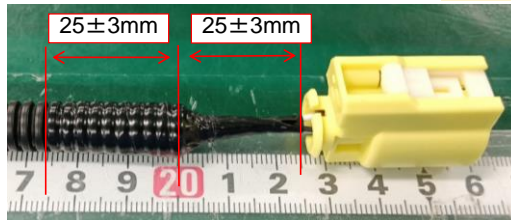

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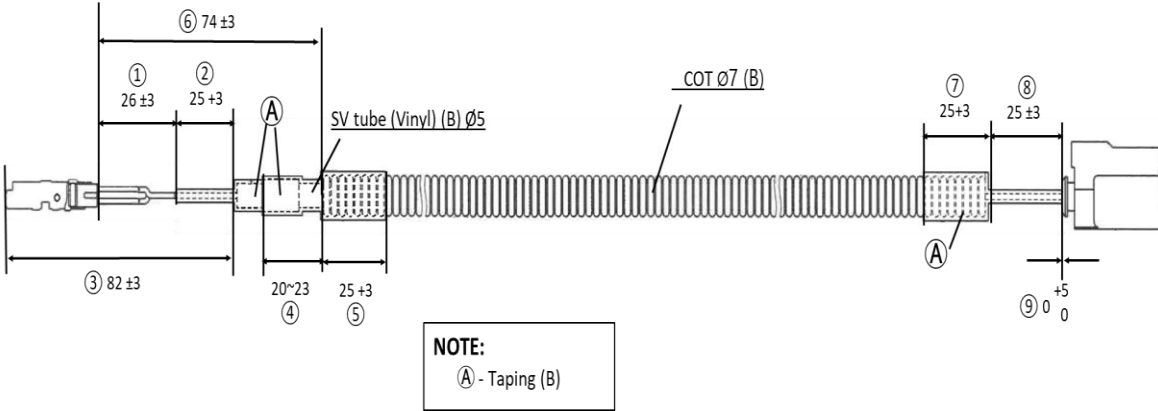

PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 3 Corrugated tube to wire near connector (Continuation)	<div></div> <div>7. Measure from corrugated tube up to connector 25±3mm using right hand then continue the taping procedure.</div> <div></div> <div>8. Shift the tape 1/2 shifting upward until reach the 0~5mm from connector to tape.</div> <div></div> <div>9. Conduct 2x windings before end of tape.</div> <div></div> <div>10. Conduct 3x pressing at the end of tape to prevent peel off.</div> <div></div> <div>11. After taping, check the taping condition and measurement.</div>		<div>MEASURING TAPE</div> 	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 <u>BLACK TAPE</u>. 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

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: ES1 / 7N0164-7020		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-623B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	6 of 7

PARTS:	1. Black tape 2. Assy parts			JIG:	n/a	
NO.	PROCESS NAME	3	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P2	Measurement	<div></div>	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	

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Car Model: SUBARU-FORESTER

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PARTS:

1. Assy parts

JIG:

n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7N0164-7020



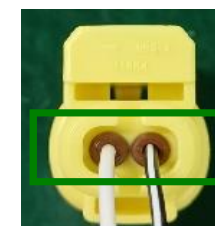
1 No Terminal Backing out

2 No Missing Parts

3 No COT to SV tube (Vinyl);

4 COT to wire near connector

1



GOOD



NO GOOD

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