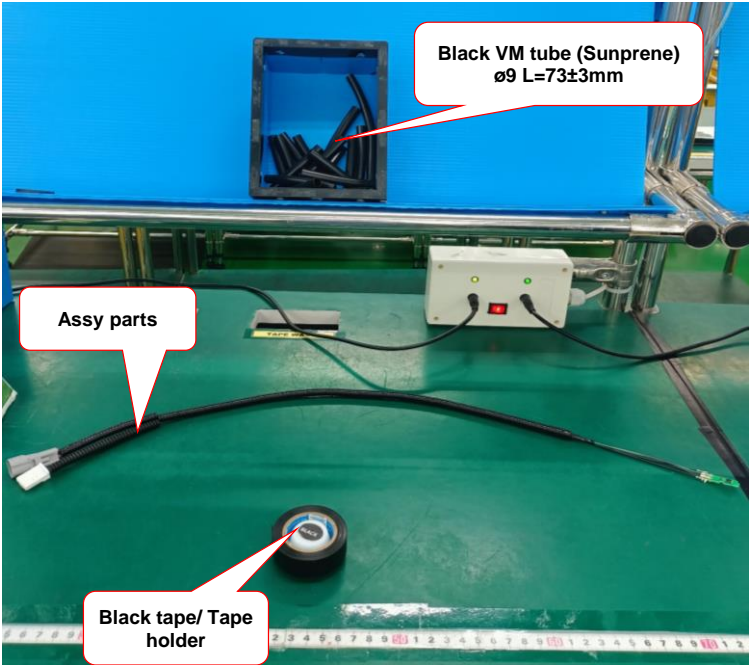


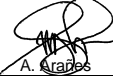
	WORK INSTRUCTION				Effectivity Date:		January 26, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ		Car Model: SUBARU		Document No.: WI-ENG-PDE-770C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5

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>TABLE LAY-OUT</div>  <div>Black VM tube (Sunprene) ø9 L=73±3mm</div> <div>Assy parts</div> <div>Black tape/ Tape holder</div>		<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level!</b> 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	
															
01/26/2024 0 Initial issue								D.Castillo		C. Villanueva		A. Arañes		n/a	
Eff. Date Rev. No Details of Change								Revised		Reviewed		Approved		Noted	
								Est. Date:		January 26, 2024					

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## WORK INSTRUCTION

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January 26, 2024

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## TAPING ASSEMBLY PROCESS

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7M0515-7021

Customer:

TRJ

Car Model:

SUBARU

Document No.:

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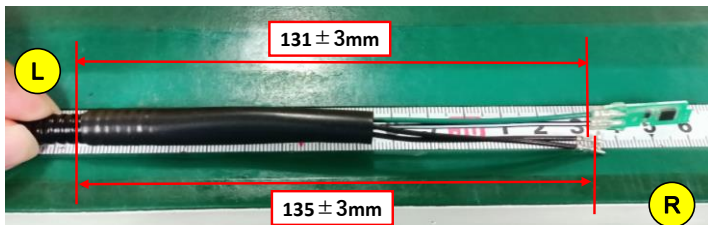

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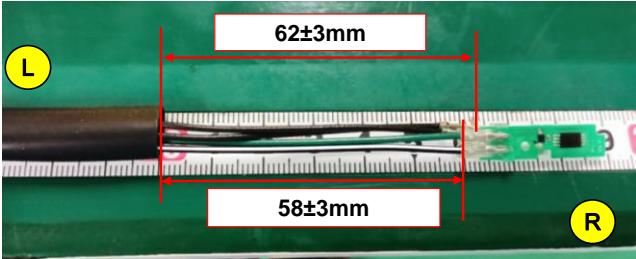

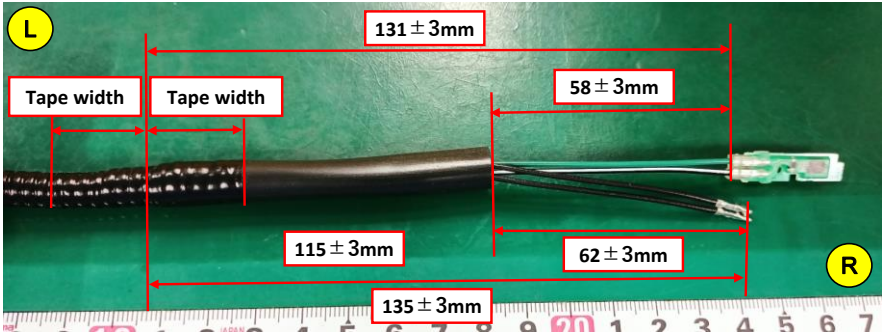

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=73 $\pm$ 3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3  Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=73 $\pm$ 3mm	<div><div><p>1. Get the terminal cover jig using right hand then insert the terminal <b>B-B wires</b> using left hand.</p></div><div><p>2. Hold the <b>Black VM tube (Sunprene) <math>\varnothing 9</math> L=73<math>\pm</math>3mm</b> using right hand then Insert first the <b>hotmelted wires</b> and then next the <b>B-B wires</b> with cover jig using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div><div><p>4. Measure from VM tube (Sunprene) up to the edge of hotmelt <b>131<math>\pm</math>3mm</b> and VM tube (Sunprene) up to terminal tip <b>135<math>\pm</math>3mm</b>.</p></div></div> <div><div>TERMINAL COVER JIG</div></div>		1. No wrong use of parts 2. No deformed terminal	

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU	Document No.:	WI-ENG-PDE-770C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 5

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> <div></div> <div></div> <div>3. After taping, check the dimension, terminal appearance and taping condition.</div>		<div>MEASURING TAPE</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></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>	

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## TAPING ASSEMBLY PROCESS

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Car Model:

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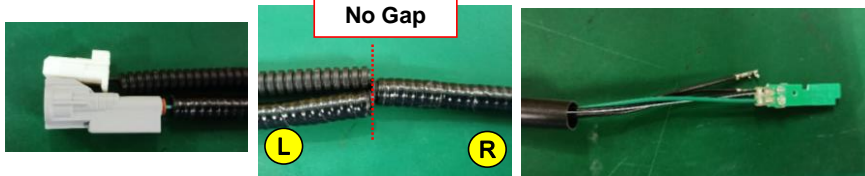
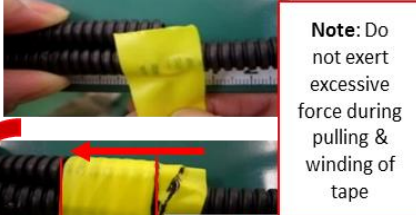

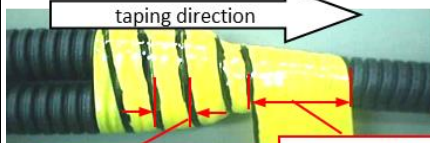


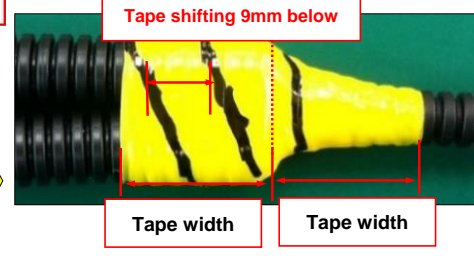

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Y-taping	<div><div></div><div></div><div></div><div></div><div></div><div></div><div>4.Winding the tape backward 1/2 shifting.</div><div></div><div>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div><div>1. Fix the corrugated tube .</div><div>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be <b>Tape width</b>.</div><div>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be <b>25mm</b>.</div></div> <div><div>MEASURING TAPE</div></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><p><b>Document references:</b></p><p>1. Refer to WI-PRO-ASY-001 for Taping process</p><ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol></div>		

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**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

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Model code/Part number: **ES1 / 7M0515-7021** Customer: **TRJ** Car Model: **SUBARU**

Document No.:

**WI-ENG-PDE-770C**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P3****7M0515-7021**

① **No MISSING TAPE**    ② **NO MISSING VM TUBE**    ③ **NO DEFORMED TERMINAL AND HOTMELTED**

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