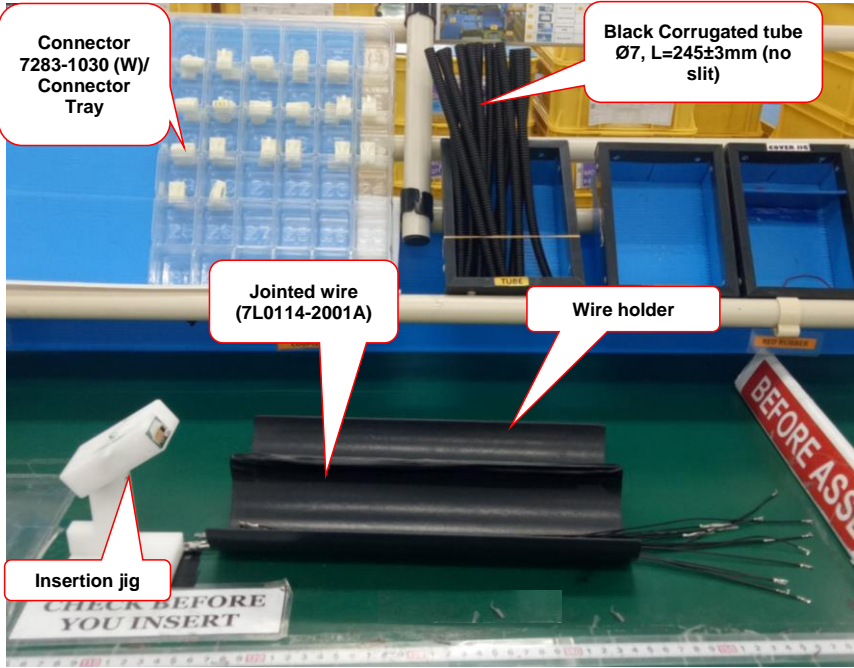
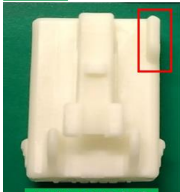
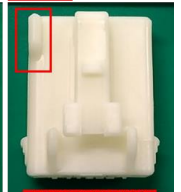


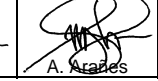
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: TM3 / 7L0114-7021A		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-709		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 5

PARTS:		1. All parts: Connector 7283-1030 (W); Jointed wire B-B 7L0114-2001A; Black corrugated tube Ø7, L=245±3mm (no slit)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	<div style="text-align: center;"> TABLE LAY-OUT </div> 		<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="text-align: center;"> CONNECTOR ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> GOOD  7283-1030 (W) </div> <div style="text-align: center;"> NG  7283-1138 (W) </div> </div>

Revision History								Prepared by	Reviewed by	Approved by	Noted by			
05/10/24	2	Change process sequence and removal of cover jig due to Process improvement. Inclusion of Measurement and improved Visual inspection.				D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
09/27/23	1	Change pre-launch to mass pro. Inclusion of table lay-out.				A.Hernandez	J.Loterte	C.Villanueva	A. Arañes					
07/25/23	0	Initial issue.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 25, 2023			

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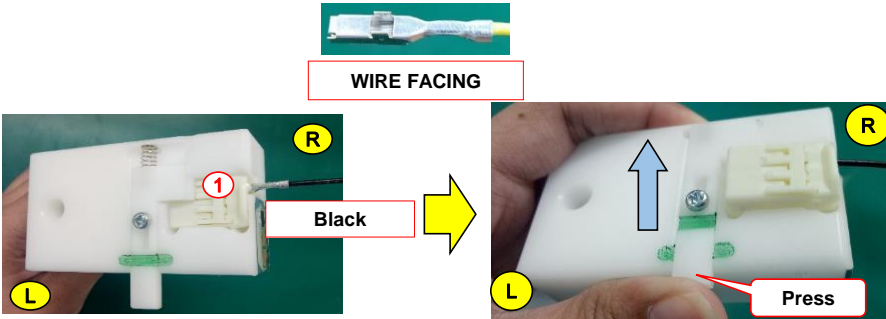
PARTS:		1. Connector 7283-1030 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline	<div><div><p>Insertion Jig</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector lock</p></div><div><p>Connector Orientation</p></div></div> <div><p>Connector setting to insertion jig 7283-1030 (W)</p></div> <div><p>1. Press the lock of insertion jig using left thumb.</p></div> <div><p>2. Insert the connector 7283-1030 (W) using right hand and release the lock using left hand. Note: Follow the connector orientation.</p></div> <div><p>3. Check the holes/terminal slot for Jointed wire (B).</p></div>		n/a	<div><p>Connector Orientation Illustration</p><div><p>I-mark is align</p></div><div><p>1 hole were only open</p></div><div><p>I-mark is NOT align</p></div><div><p>1 hole were open</p></div><p>GOOD</p><p>NG</p><p>CONNECTOR ILLUSTRATION</p><div><p>GOOD</p></div><div><p>NG</p></div><p>7283-1030 (W)</p><p>7283-1138 (W)</p></div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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	Model code/Part number: TM3 / 7L0114-7021A		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-709		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	3 of 5

PARTS:	1. Jointed wire B-B 7L0114-2001A 2. Black corrugated tube Ø7 L=245±3mm (no slit)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	<div>2</div> Wire insertion to Corrugated tube Ø7, L=245±3mm (no slit)	<div> <div>1. Get Black Corrugated tube ø7 L=245±3mm (no slit) using left hand then insert Black wires Jointed wire B-B 7L0114-2001A using right hand.</div></div>	n/a	1. No wrong usage of parts 2. No deformed terminal	
4	Offline <div>2</div> Wire insertion to Connector 7283-1030 (W)	<div> <div>1. Get Jointed wire then insert to terminal slot ① using right hand.</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>		1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.	

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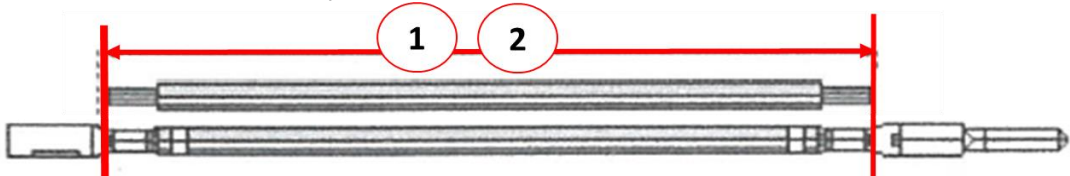

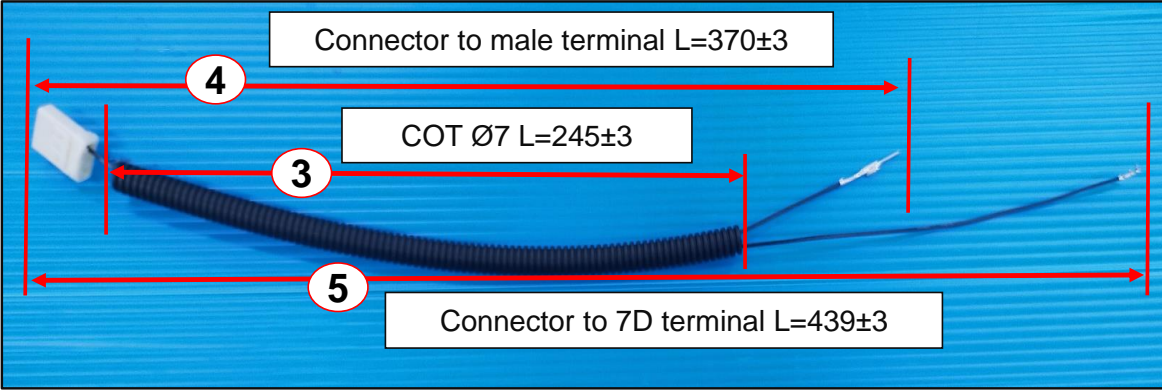
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	<div>Measurement</div> <div><div><div>2</div></div><div><p>Note:</p><p>1. Measurement point: End of core wire to the end of core wire</p><p>2. Terminal is reference only.</p></div></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>
		<div><p>Connector to male terminal L=370±3</p><p>COT Ø7 L=245±3</p><p>Connector to 7D terminal L=439±3</p></div>	<p>1. No wrong dimension</p>	

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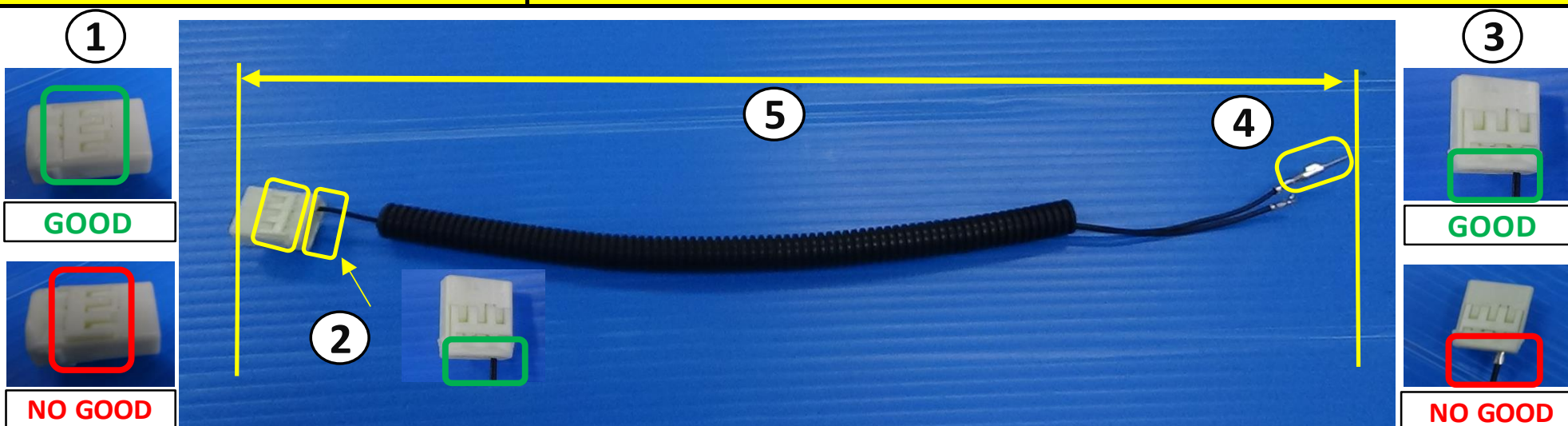
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PARTS:

1. Assy parts

JIG:

n/a

**2 VISUAL INSPECTION****OFFLINE INSERTION****7L0114-7020A****1 No Lock connector****3 No Terminal Backing Out****2 No Wrong insert****4 No Deformed terminal****5 Check the Alignment**

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