



WORK INSTRUCTION

Effectivity Date:

March 21, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

GC7(FHI)/ 15G060-0010

Customer: TRP

Car Model: SUBARU-LEGACY

Document No.:

WI-ENG-PDE-016C

Purpose:

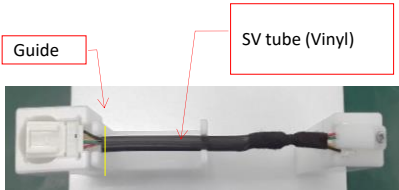
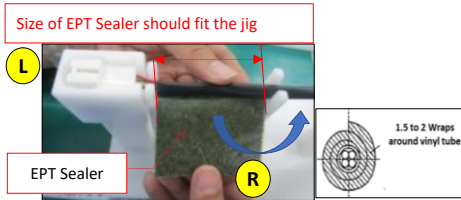
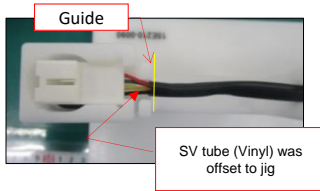
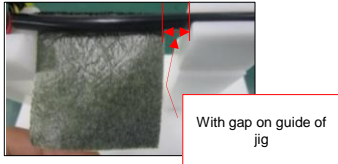

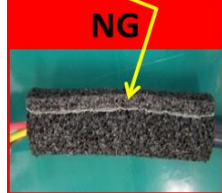

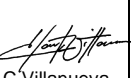

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

1 of 4

PARTS:		1. EPT Sealer No.686 60x52x3 2. Assy parts				JIG:		1. EPT Sealer attachment jig							
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1		P3 EPT Sealer attachment		<div><div><div>Guide</div><div>SV tube (Vinyl)</div><div>Receiver base lock</div><div></div><div>1. Set the harness to attachment jig and lock the receiver base lock. Make sure that SV tube (Vinyl) was not offset to jig.</div></div><div><div><div>Size of EPT Sealer should fit the jig</div><div></div><div>2. Get the EPT sealer and attach it initially at the bottom part of the SV tube (Vinyl). (See illustration). Slowly wrap the EPT sealer on the vinyl tube in a clockwise direction. Make 1.5 to 2 wraps around the SV tube (Vinyl). Note: Do not stretch or pull the EPT sealer</div></div><div><div><div>NO GOOD SETTING OF HARNESS TO JIG</div><div></div><div>NO GOOD ATTACHMENT OF EPT SEALER</div><div></div></div></div></div></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 work place 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><div>MEASURING TAPE </div></div>		<div><div>1. No peel-off attachment 2. No flip out 3. No loose/tight attachment 4. No wrong attachment</div><div>Important reminders/Note/s: 1. Do not stretch or pull the EPT sealer. 2. No gap on the guide or jig.</div><div>Document reference/s: 1. Please refer to WI-ENG-PDE-060 for Continuity test and WI-ENG-PDE-059 for End Tape Process.</div><div><div>Peel-off EPT</div><div>NG</div><div></div></div></div>					
Revision History															
03/21/24		5		Update Measurement Work procedure/illustration and add nakamono.				D.Castillio		C.Villanueva		A. Arañes		n/a	
08/08/23		4		Update template; Inclusion of CAR MODEL "SURABU-LEGACY" ; Additional procedure for EPT Sealer attachment (Point checking on measuring guide) (Refer to ENGDRR-144 for Document revision request). Improve Quality pointer on page no.2				M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
10/19/22		3		Improve Quality pointers; Reminders/Notes and references on page no. 1 to 3; Improvew work procedure/illustration on process no. 2- Visual/ By/two's inspection due to process improvement.				M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	
								Prepared by		Reviewed by		Approved by		Noted by	
														n/a	
								D. Castillo		C.Villanueva		A. Arañes			
								Est. Date:		October 07, 2019					

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 21, 2024

Model code/Part number:

GC7(FHI)/ 15G060-0010Customer: **TRP**Car Model: **SUBARU-LEGACY**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-016C

Purpose:


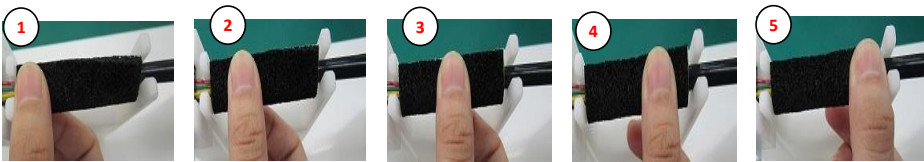
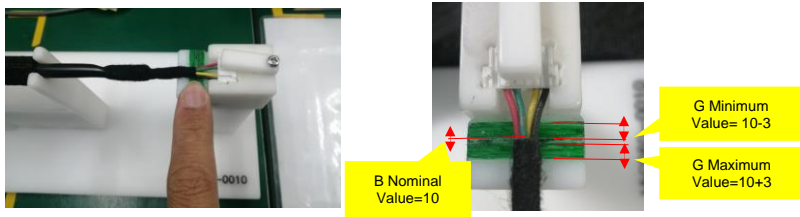
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:


2 of 4

PARTS:	1. Assy parts		JIG:	1. EPT Sealer attachment jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	EPT Sealer attachment	N/A	<div>MEASURING GUIDE ILLUSTRATION</div> <div></div> <div>1. No skip checking during inspection. 2. Conduct 100% point checking. 3. No wrong dimension</div>
		<div>3. After attachment of EPT sealer, make 5 times slowly pushing from left to right using left thumb.</div> <div></div> <div>4. Conduct point checking on measuring guide to verify if end tape is within limit.</div> <div></div>		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	March 21, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: GC7(FHI)/ 15G060-0010		Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-016C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	3 of 4


PARTS:	1. Assembled parts 2. Master sample			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Visual/By two's Inspection			

1. Check the double lock, terminal condition and presence of clamp

2. Check the EPT sealer attachment

3. Check the taping condition.


4. Check the presence of terminal claw on connector holes




5. Compare to Master sample by tapping

Master sample

Assembled parts

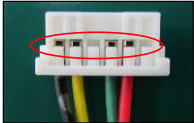


MASTER SAMPLE



1. No skip checking during inspection.

TERMINAL CLAW ON CONNECTOR HOLES



CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 21, 2024

Model code/Part number:

GC7(FHI)/ 15G060-0010Customer: **TRP**Car Model: **SUBARU-LEGACY**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-016C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

4 of 4

PARTS:

n/a

JIG:

n/a

NO.**PROCESS NAME**

5

WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

4

P3

Measurement



1. No wrong dimension.

5

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

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp