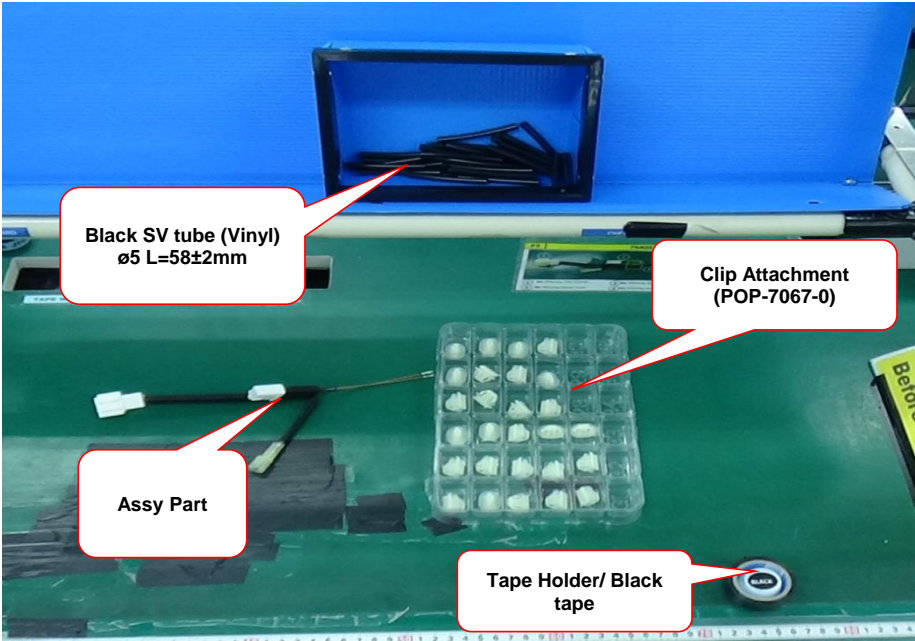
	<b>WORK INSTRUCTION</b>				Effectivity Date:		January 5, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>ES1 / 7M0510-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>SUBARU-FORESTER</b>	Document No.:		<b>WI-ENG-PDE-366C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5

<b>PARTS:</b>		1.Assy Part;Black SV tube (Vinyl) ø5 L=58±2mm; Clip Attachment (POP-7067-0); Balck tape			JIG:		n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P3	<div>Table Lay-out</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		
01/05/24	0	Initial issue. Transfer process from WI-ENG-PDE-366B to WI-ENG-PDE-366C due to Process improvement						D. Castillo	C.Villanueva	A. Arañes	n/a				n/a	
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		January 5, 2024		

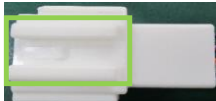
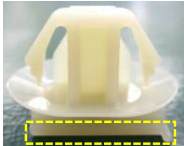
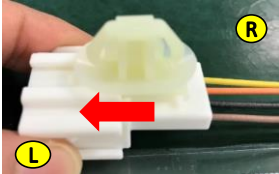
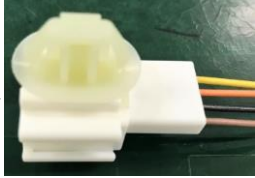

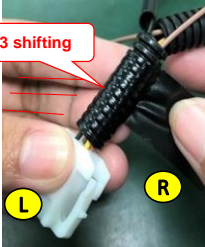

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	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>		
	Process Name/Title:			Document No.:	<b>WI-ENG-PDE-366C</b>		
	Model code/Part number: <b>ES1 / 7M0510-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>SUBARU-FORESTER</b>	Revision No.: 0      Page No.:      2 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


<b>PARTS:</b>		1.Clip Attachment (POP-7067-0) 2. Black Corrugated tube ø7 L=30±3mm (with slit)		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Clip Attachment (POP-7067-0)	<div> <b>CONNECTOR</b></div> <div> <b>CLIP ORIENTATION</b></div> <div> </div> <div>1. Hold the connector using left hand and get the <b>Clip clamp POP-7067-0 (W)</b> then insert using right hand.</div>		n/a	<div>1. No loose clamp attached 2. No damage clamp 3. No wrong use of clamp</div>
3	P3 Half wrap taping to Black Corrugated tube ø7 L=30±3mm (with slit)	<div> <b>Start of taping</b></div> <div> <b>1/3 shifting</b></div> <div></div> <div>1. Hold the assy parts using left hand, get the <b>Black tape</b> using right hand then make <b>2 windings</b> of tape before shifting.</div> <div>2. Make <b>1/3 shifting</b> until it covers the slit of COT, make <b>2 windings</b> of tape before cutting.</div>			

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	Process Name/Title:		Model code/Part number: <b>ES1 / 7M0510-7020C</b>	Customer: <b>TRJ</b>	Car Model: <b>SUBARU-FORESTER</b>	Document No.:	<b>WI-ENG-PDE-366C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 5	

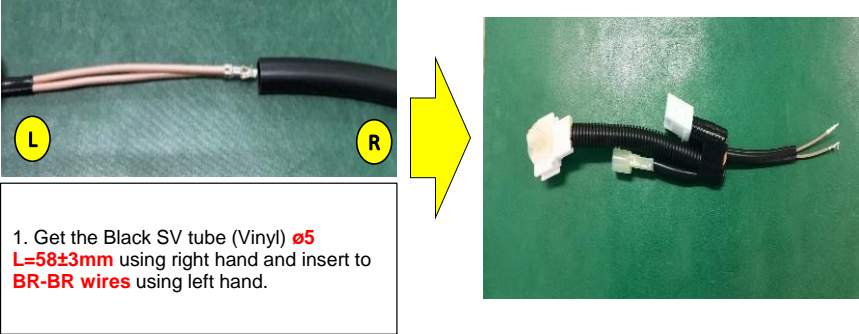
  

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P3	Spot Taping	<div>  <div>           1. Start pre-taping the combined corrugated tube and vinyl tube. Make 2 windings. <i>(Do not cut the tape).</i> </div> </div> <div>  <div>           2. Get the other corrugated tube and start pre-taping with the combined corrugated tube and vinyl tube. Make <b>2 windings</b>.         </div> </div> <div>  <div>           Note: If the <b>Black SV tube ø5 L=60±2mm</b> was used, the <b>Black wires</b> will be stressed/stretched while Y-taping. It must be the <b>Black SV tube ø5 L=58±3mm</b> </div> </div>	<div> <b>Measuring tape</b> </div> 	<div> <b>Important reminders/Note/s:</b> </div> <ol style="list-style-type: none"> <li>1. Please use calibrated/verified measuring tape when getting the measurement.</li> <li>2. Used <u>YELLOW tape</u> for easy visualization of shifting lines , but actual should be <u>BLACK tape</u>.</li> </ol> <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 use of tape</li> <li>6. No wrong dimension</li> </ol> <div> <b>Y-Taping orientation</b> </div> 

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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		<b>n/a</b>	
	Model code/Part number: <b>ES1 / 7M0510-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>SUBARU-FORESTER</b>	Document No.:		<b>WI-ENG-PDE-366C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:

<b>PARTS:</b>		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=58±3mm			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	n/a	<div><p>1. Get the Black SV tube (Vinyl) ø5 L=58±3mm using right hand and insert to BR-BR wires using left hand.</p></div>			n/a	1. No deformed terminal 2. No wrong usage of parts
	P3					

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**WORK INSTRUCTION**

Process Name/Title:

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Effectivity Date:

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n/a

Model code/Part number:

**ES1 / 7M0510-7020C**Customer: **TRJ**Car Model: **SUBARU-FORESTER**

Document No.:

**WI-ENG-PDE-366C**

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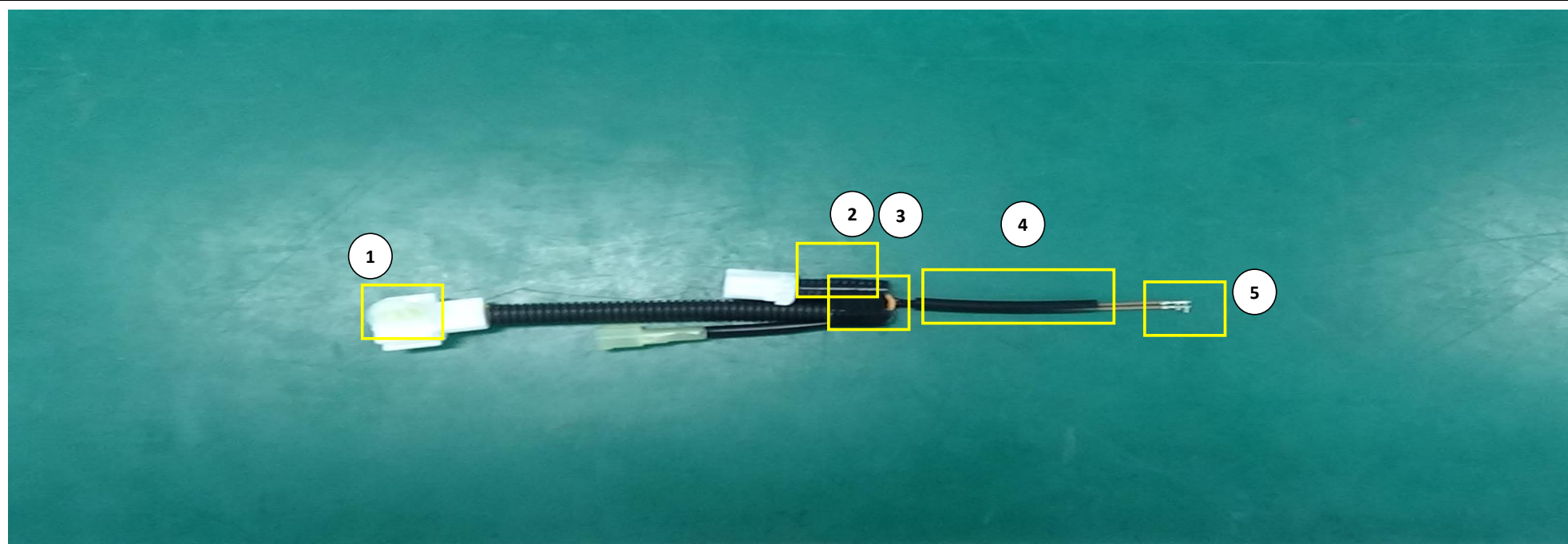
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**PARTS:**

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P3****7M0510-7020C**

1

**No Missing Clip Clamp**

2

3

**No Missing Tape**

4

**No Deform Terminal**

5

**No Deform Terminal**

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