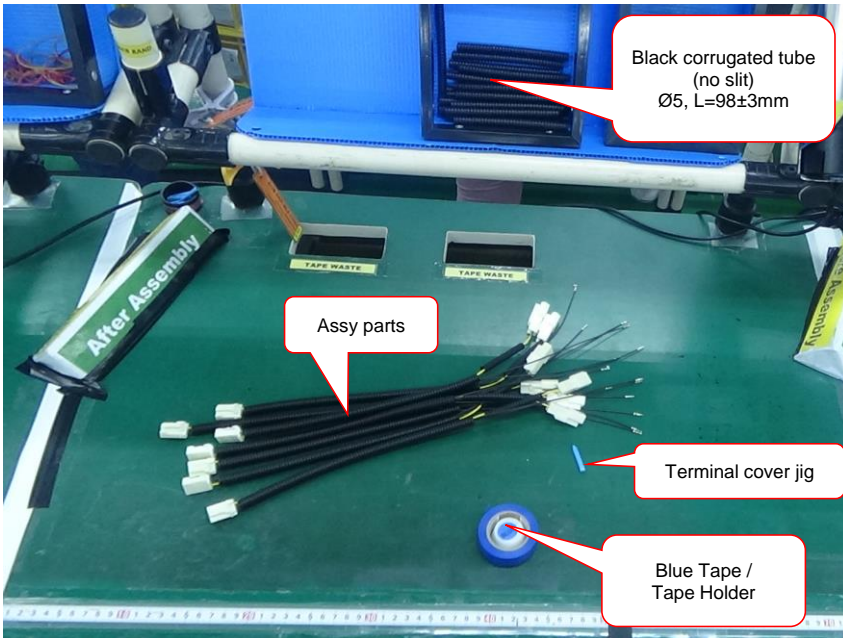


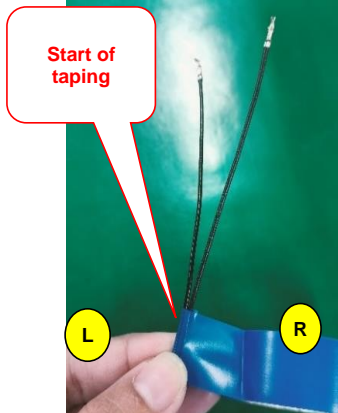
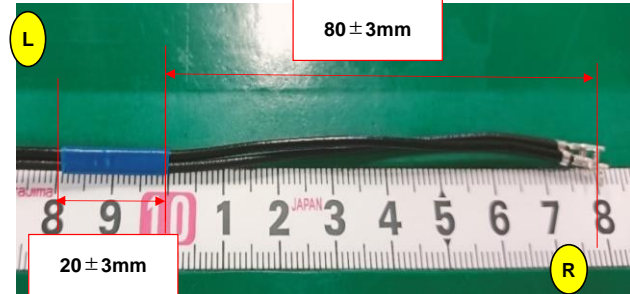
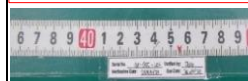
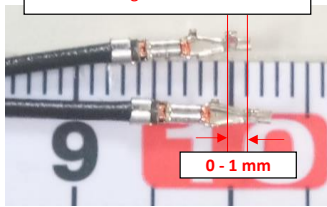
	WORK INSTRUCTION				Effectivity Date:	July 04, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: TM3 / 7L0145-7020A		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-714B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 5

PARTS:		1. Assy parts; Black corrugated tube Ø5, L=98±3mm (no slit); Blue tape				JIG:		1. Terminal cover jig	
NO.	PROCESS NAME	<div style="text-align: center;"> <div style="border: 1px solid black; padding: 2px;">2</div> WORK PROCEDURE/ ILLUSTRATION </div>				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>  </div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		1. No deformed terminal 2. No wrong usage of parts	
Revision History									
						Prepared by	Reviewed by	Approved by	Noted by
07/04/24	2	Separate Assembly process to Clamp assembly process. Transfer Taping 3 and Y-taping to P3 due to process improvement. Improved Table lay-out and Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	n/a
08/26/23	1	Change from Pre-launch to Masspro. Inclusion of table lay-out. Provide continuity checker jig. Change process sequence (Page 3-4) to prevent wrong use of tape.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes
07/24/23	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 24, 2023		

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	WORK INSTRUCTION				Effectivity Date:	July 04, 2024			
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: TM3 / 7L0145-7020A		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-714B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	2 of 5	

PARTS:		1. Blue tape 2. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2 <div>2</div>	<div><div>100 ± 3mm</div><div>1. Hold wires using left hand, measure the wire up to terminal tip 100±3mm.</div><div><div>Start of taping</div><div>2. Get the Blue tape, conduct 2x windings of tape then cut using both hand.</div><div><div>80 ± 3mm</div><div>20 ± 3mm</div><div>3. After taping, check the measurement and taping condition.</div></div></div><div><div>MEASURING TAPE</div></div><div><div>Wire alignment tolerance</div><div>0 - 1 mm</div></div></div>		Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use <u>BLUE TAPE</u> only. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 04, 2024

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TM3

/ 7L0145-7020A

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☐ PROTOTYPE

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PARTS:

1. Blue tape
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

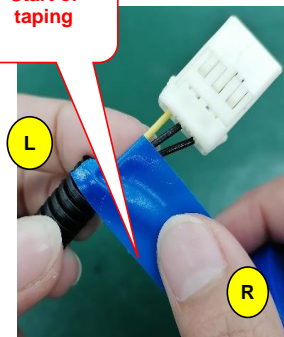
QUALITY POINTERS

3

P2

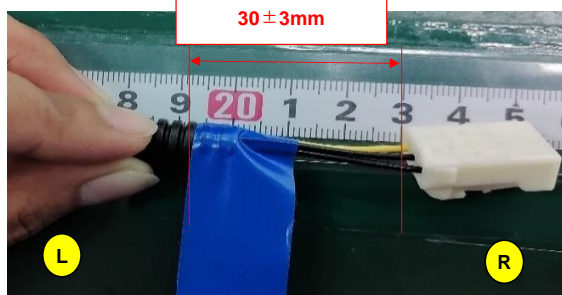
Taping 1
COT to wire near
terminal

Start of
taping



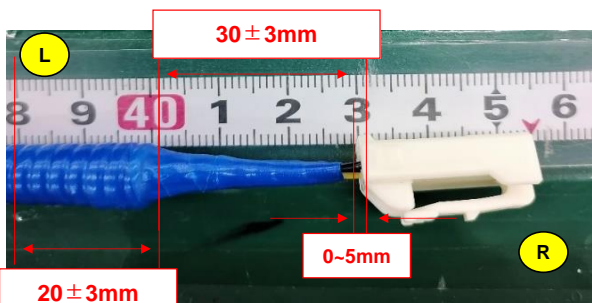
1. Hold the COT using left hand, get the **Blue tape** using right hand then start pre-taping using both hands.

$30 \pm 3\text{mm}$



2. Measure from end of COT up to edge of connector $30 \pm 3\text{mm}$ then continue the taping process using both hands.

MEASURING TAPE



3. After taping, check the measurement and taping condition.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension


Important reminders/Note/s:





1. Please use calibrated/verified measuring tape when getting the measurement.
2. Use **BLUE TAPE** only.

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	WORK INSTRUCTION				Effectivity Date:	July 04, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: TM3 / 7L0145-7020A		Customer: TRQSS	Car Model: SUBARU-ASCENT	Document No.:	WI-ENG-PDE-714B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	4 of 5

PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=98±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Wire insertion to Black corrugated tube (no slit) Ø5 L=98±3mm	<div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B and B jointed wires using left hand.</div></div>		<div>TERMINAL COVER JIG</div> 	1. No deformed terminal 2. No wrong usage of parts
		<div><div>2. Get the corrugated tube (no slit) Ø5 L=98±3mm using right hand then insert the B and B jointed wires using left hand.</div></div>			
		<div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div>			

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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

Effectivity Date:

July 04, 2024

Validity Date:

n/a

Model code/Part number:

TM3**/****7L0145-7020A**

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Document No.:

WI-ENG-PDE-714B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

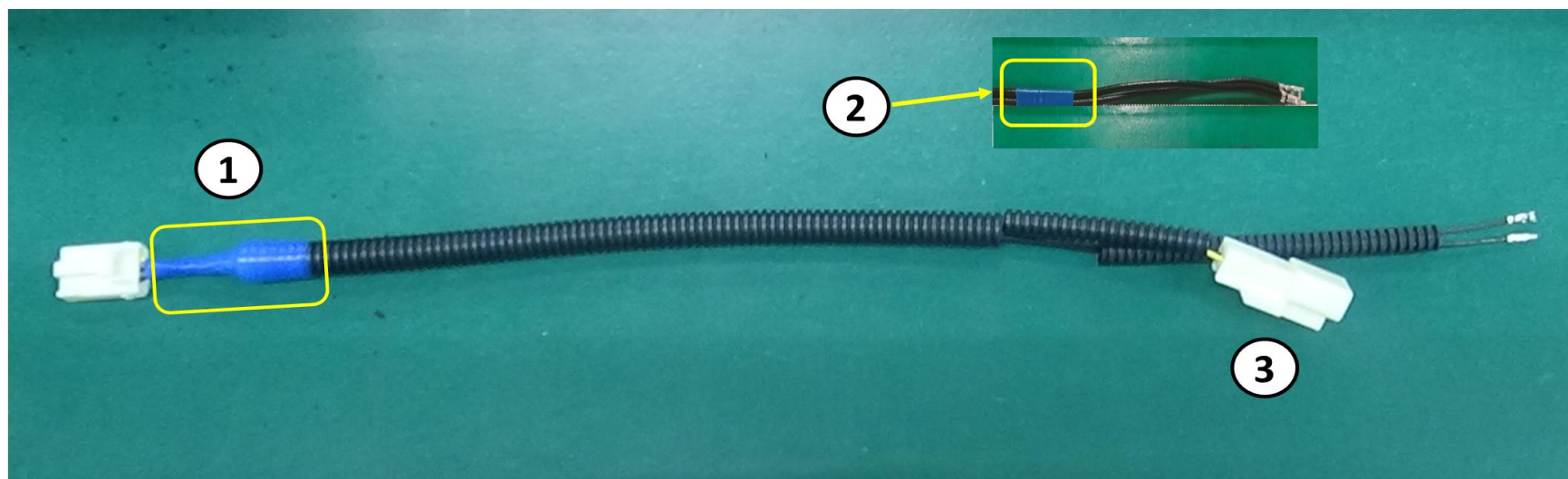
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7L0145-7020A**

1 No Missing / Wrong used of Tape
(Blue Tape)

2 No Missing Spot Tape

3 No Deformed Terminal

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