



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Model code/Part number:

TM3

/

7L0113-7021C

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Document No.:

WI-ENG-PDE-946

Purpose:

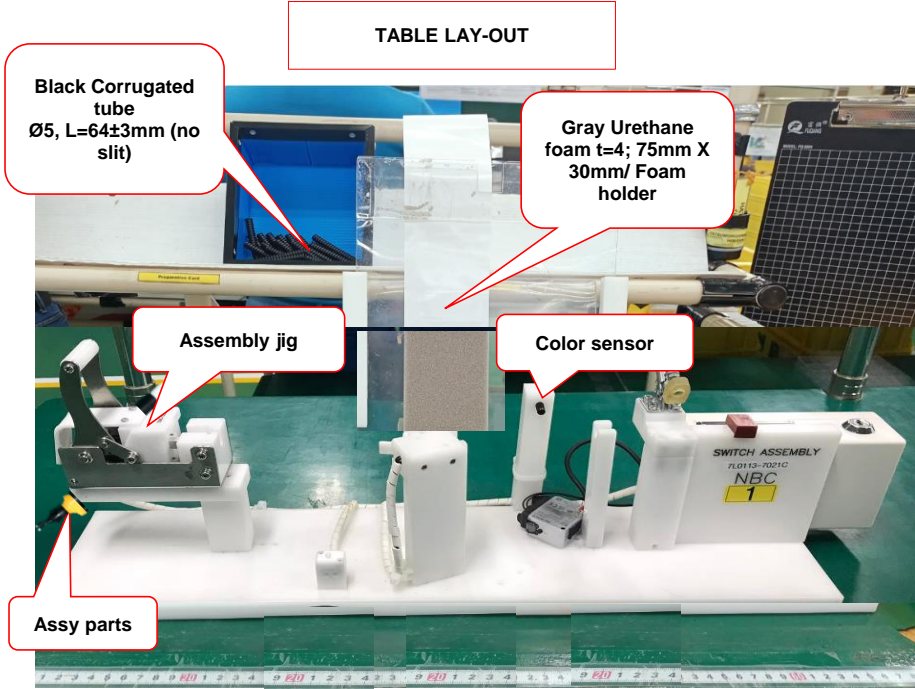
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Assy parts; Gray Urethane foam t=4; 75mm X 30mm				JIG:	1. Assembly jig				
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	Table lay-out					<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>Document reference/s: 1. Refer to WI-ENG-PDE-707A-B for Taping assembly process</p> <p>1. No missing parts/tools. 2. No missing parts/tools.</p>	
Revision History										
							Prepared by	Reviewed by	Approved by	Noted by
07/08/24	0	Initial issue. Separate Urethane foam attachment and assembly from Taping assembly process.				D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: July 08, 2024

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DCC Stamp



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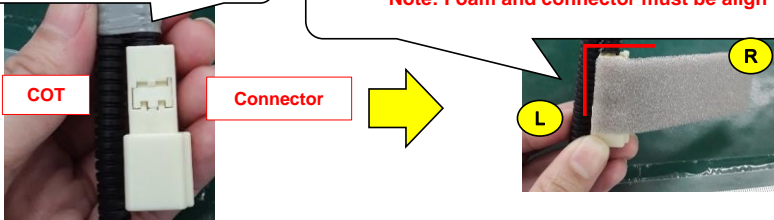
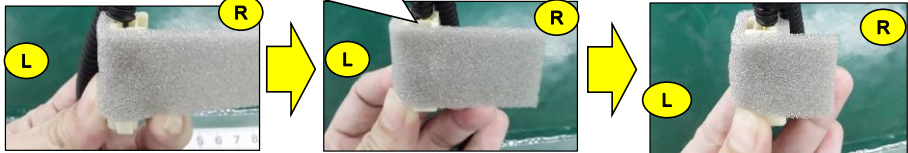
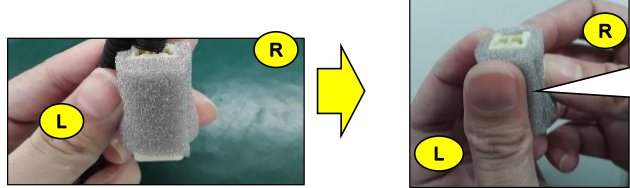

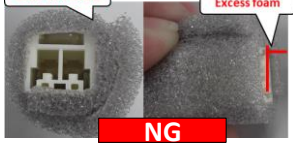
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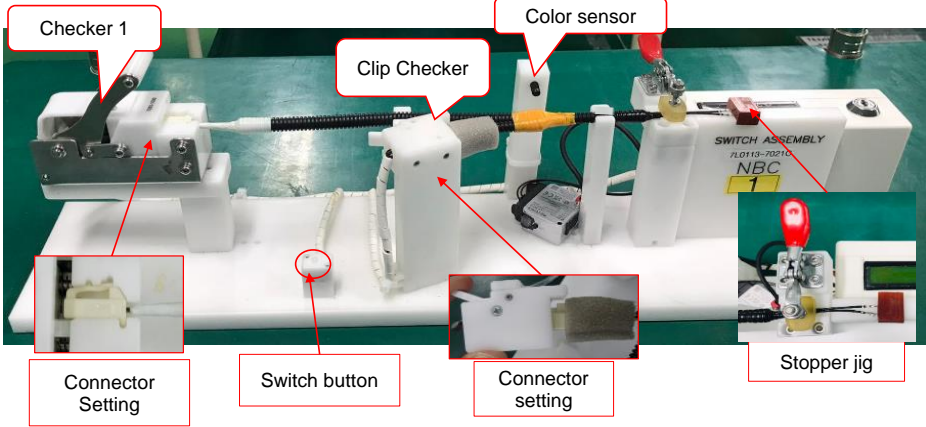

PARTS:		1. Assy parts 2. Gray Urethane foam t=4; 75mm X 30mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<p>Step 1: Identify the right facing to attached the foam</p>  <p>Step 2: Get the Urethane foam and begin the attachment. Note: Foam and connector must be align</p> <p>Step 3: Attached the foam in all sides of the connector. Note: Follow the attachment sequence based on the illustration</p>  <p>Step 4: Press the Urethane foam side by side after attachment.</p> 		n/a	<p>1. No damaged urethane foam 2. No missing Urethane foam 3. No stretch Urethane foam</p>  <p>Over-stretched</p>  <p>Excess foam</p> <p>Important reminders/Note/s:</p> <p>1.Tolerance from Urethane foam to connector must be 0~3mm. 2. Do not Stretch the Urethane foam.</p>

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	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			JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div><p>1. Get the assy parts then put into jig (<i>See above picture for correct setting</i>). First set the connector 7283-1130 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 7282-1028 (W) to Clip checker 2 then lock. Last, set the B-B wires to the stopper jig then pull down the toggle clamp. Jig will be buzz if the sensor detects ORANGE TAPE.</p><p>2. Check if all LED light for POWER ON, WIRE1 & WIRE2 and COLOR SENSOR was ON. If encounter abnormality or hearing NG buzzer, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p><div><p>3. Press the switch button using right hand. GO buzzer will be heard.</p><p>4. Conduct POINT CHECKING before removing the harness from the jig.</p></div></div></div> <div><p>STOPPER</p></div> <div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between the terminal and stopper.</p></div>		n/a	<div><p>1. No deformed terminal</p><p>2. No wrong usage of parts</p></div>

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

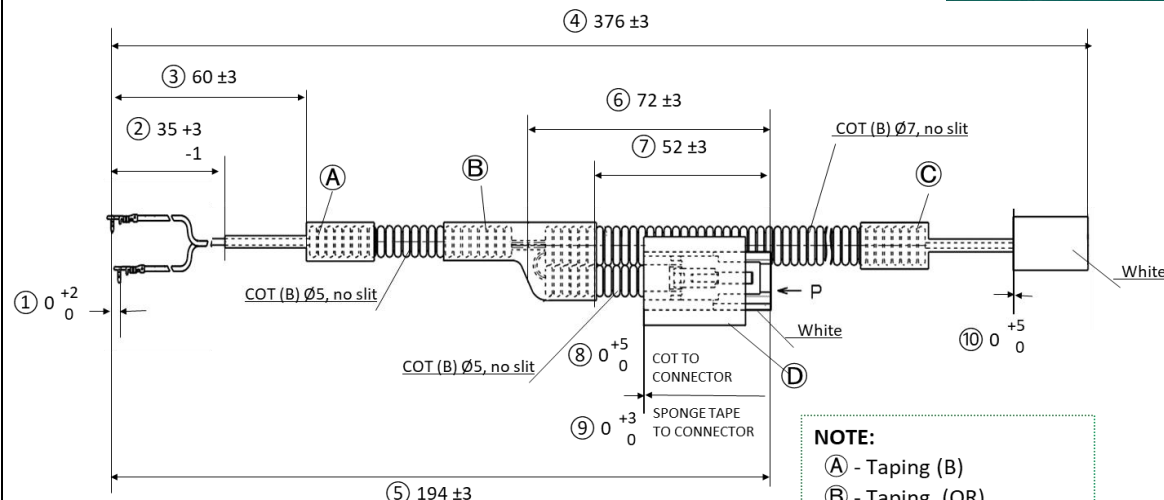
TOOLS/PPE

QUALITY POINTERS

4

Clamp
Assy

Measurement



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

1. No wrong dimension

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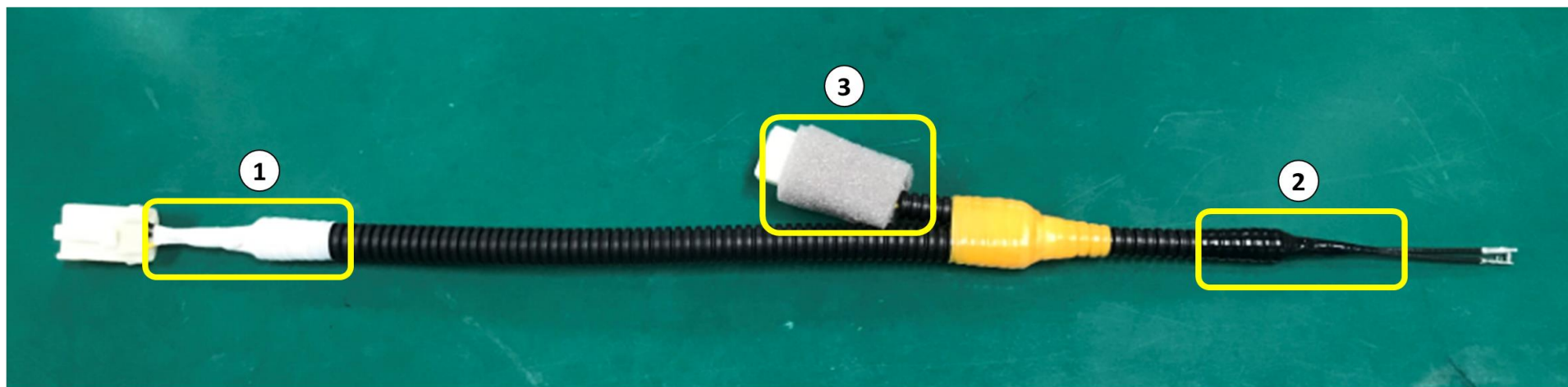
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0113-7021C****1****No Missing Tape
(White tape)****2****No Missing Tape
(Black tape)****3****No Missing Urethane
foam**

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