1				WORK IN	STRUCTION			Effectivity Date:		January 5, 202	24
			Process Name/Title:	TAPIN	NG ASSEMBLY PROC	CESS		Validity Date:		n/a	
	-11		Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SU	JBARU-FORESTER	Document No.:		WI-ENG-PDE-36	66D
			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	0	Page No.:	1 of 9
PARTS:		•	parts; Black tape					JIG:		y checker jig	
N	Ο.	P	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(TERS	
1		P4	Table Lay-out	Assy parts	Table Lay-out Contained the second of the s	10	r jig	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.		ing parts/tools ss parts/tools	
				Revision History				Prepared by R	eviewed by	Approved by	Noted by
									,/ / .//		
01/05/24	0 1	Initial issu	ue. Transfer process from WI-EN	NG-PDE-366B to WI-ENG-PDE-366D due to Pro	ocess improvement	D. Castillo C.Villa	lanueva A. Arañes r	va 8. Castillo C.	/out/)//our- Villanueva	A Araños	n/a
Eff. Date			,	Details of Change					ry 5, 2024	· V. VERTES	iva



			WORK INST	RUCTION		Effectivity Date:		January 5, 202	24
		Process Name/Title:	TAPING	ASSEMBLY PROC	CESS	Validity Date:		n/a	
		Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-36	6D
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	2 of 9
PARTS:	1. Assy 2. Blac	k tape				JIG:	n/a		
NO.	F	PROCESS NAME	WORK PR	ROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(QUALITY POIN	ΓERS
2	P4	Y-Taping	1. Conduct pre-taping at the middle of combined tubes, then wind the tape to left side. 34±2mm taping direction taping direction 25±3mm	2. Shift the tape until re 114±3mm from end of make 2 windings. 3. Confirm measuren up to terminal pointer hands.	each the measurement tape to terminal then ment from end of vinyl tube d tip 34±2mm using both afting until it reach the vinyl tube indings (must be 25±3mm) we force during pulling &	Measuring tape 6 7 8 9 10 1 2 3 4 5 6 7 8 9 8	Importa 1. Use YI visualizat should be 2. Please measurin measure Docume 1. Refer t AND TUE TOLERAI 1. No flip-c 2. No peel 3. No loos 4. No miss 5. No wror 6. No wror	nt reminders/N ELLOW TAPE for elion of shifting lines BLACK TAPE. The use calibrated/ver g tape when gettin ment. The interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interference in the interference is the interference in the interf	lote/s: easy s, but actual rified g the : 8 for TAPE



	_		WORK	INSTRUCTION			Effectivity Date:		January 5, 202	24
	AL	Process Name/Title:		APING ASSEMBLY		Validity Date:		n/a		
		Model code/Part number:	ES1 / 7M0510-7020	C Customer:	TRJ Car Model:	SUBARU-FORESTER	Document No.:		WI-ENG-PDE-36	66D
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	0	Page No.:	3 of 9
PARTS:	1. Assy 2. Black						JIG:	n/a		
NO.	F	PROCESS NAME	WO	RK PROCEDURE/ II	LLUSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
3	P4	Y-Taping (Continuation)	must	5. Wind the tape backward 1/2 shifting. R And the tape 1/3 shifting until it be 25mm. Make 3 windings the hands.	34±2mm 7. Aft taping	Note: Pull down the tape to prevent moving of vinyl tube. ter taping, check the g condition and surement.	E-A-TA	1. Use YE visualization should be 2. Please measuring measuren Docum 1. Refer to AND TUE TOLERAL 1. No flip-02. No peel 3. No loos 4. No miss 5. No wron	ent reference/s o WI-ENG-PDE-58 BE END STANDAR NCE out tape -off tape e tape	asy but actual fied g the



			WORK IN	STRUCTION			Effectivity Date:		January 5, 202	24
		Process Name/Title:		NG ASSEMBLY	/ DDOCESS		Validity Date:		n/a	24
			ES1 / 7M0510-7020C			CUDARU FORESTE				200
		Model code/Part number:		Customer: T	l l	SUBARU-FORESTE			WI-ENG-PDE-36	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASS	PRO	Revision No.:	0	Page No.:	4 of 9
PARTS:	1. Assy						JIG:		y checker jig	
NO.	-	ROCESS NAME	WORK	PROCEDURE/ IL	LUSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
4	P4	Continuity Test	CONNECTOR SETTING Checker 2 CONNECTOR SETTING Checker 2 1. Get the assy parts and set to tester hands. First, set the connector 4F545c Clip Checker 1 then lock. Second, set 7186-8849 (W) to Checker 2 then pull fixture for continuity checking. Third, s connector 7282-8324 (W) to Checker checker fixture for continuity checking. BR-BR wires together within the stopp press by toggle clamp. (See above pic setting).	3-0000 (W) to the connector the checker et the 3 3 then pull the Last, set the er jig then	CLIP CHECKE CLIP CHECKE C. Check if all LED light BR-BR Wires was Continued immediately CALI and immediately CALI and continue the process continue	SW Button SW Button It for Wire1, Wire2 N. If encounter NG buzzer, STOP the attention of rther instruction	Counter Counter Toggle clamp: Off Toggle clamp: On	1. Make s terminal 2. Counte of harnes allowed t	STOPPER ont reminders/If ture no gap in bette and stopper r will be the basis s per box. Only LE o reset the counte g insertion g orientation of co	ween the of quantity ADER are



			WORK INS	TRUCTION		Effectivity Date:		January 5, 20)24		
		Process Name/Title:	TAPIN	IG ASSEMBLY PRO	OCESS	Validity Date:	n/a				
		Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-3	366D		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	5 of 9		
PARTS:	1. Assy	parts				JIG:	1. Insertion	jig			
NO.	F	PROCESS NAME	WORK P	PROCEDURE/ ILLUST	FRATION	TOOLS/PPE	-	QUALITY POIN	ITERS		
4	P4	Continuity Test (Continuation)	CONNECTOR SETTING Checker 2		CLIP CHECKER 1 STOPPE SWITCH A AND NB 1	Counter	1. Make sterminal a	STOPPEI ant reminders/ sure no gap in bet and stopper. er will be the basis per box. Only LEA to reset the counter	/Note/s: tween the s of quantity of		

3. Press the $\ensuremath{\mathsf{SW}}$ button using right hand for continuity checking. $\ensuremath{\mathsf{GO}}$ sound will be heard.

SW Button

4. Conduct POINT CHECKING before removing the harness from jig.

Checker 3

5. For the removal of harness from the jig, First, remove the BR-BR wires to toggle clamp. Second, remove the connectors to checker 3, Checker 2 and last is Checker 1.

- No wrong insertion
- 2. No wrong orientation of connector

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.



CONNECTOR SETTING

	_		WORK INS	TRUCTION		Effectivity Date:	1	January 5, 202	24
		Process Name/Title:		G ASSEMBLY PRO	Validity Date:		n/a		
		Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-36		66D
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	6 of 9
PARTS:	n/a					JIG:	n/a		
NO.	ı	PROCESS NAME	WORK F	PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE		QUALITY POIN	TERS
5	P4	Visual/By Two's Inspection	Assembled parts Master sample	2. Check the	ACTUAL AC	AL PRODUCT f clamp attachment.		ASTER SAM	

3. Check the condition of connector lock and insertion.

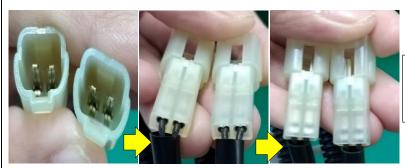
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.



1. Conduct alignment of harness (Master sample vs. assembled parts) using both

ſ			ı										
ı				WORK INS	STRU	JCTION				Effectivity Date:		January 5, 20	024
			Process Name/Title:	TAPIN	IG A	ASSEMB	LY PRO	CESS		Validity Date:		n/a	
		7	Model code/Part number:	ES1 / 7M0510-7020C		Customer:	TRJ	Car Model:	SUBARU-FORESTER	Document No.:		WI-ENG-PDE-3	366D
			Purpose:	PROTOTYPE		PRE-LAUNCH		MASSP	PRO	Revision No.:	0	Page No.:	
ı											_		
	PARTS: n/	/a								JIG:	n/a		

NO. **PROCESS NAME** TOOLS/PPE **QUALITY POINTERS WORK PROCEDURE/ ILLUSTRATION**



4. Check the terminal, insertion and condition of connector lock.

MASTER SAMPLE

7 of 9



Visual/By Two's Inspection 5 (Continuation)



5. Check the Y-Taping condition.



6. Check the terminal appearance. Must be no deformed terminal.

1. No skip checking during 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**

			WORK INST	TRUCTION		Effectivity Date:		January 5, 2024	4
		Process Name/Title:	TAPING	G ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-366	6D
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	8 of 9
PARTS:	n/a					JIG:	n/a		
NO.	F	ROCESS NAME	WORK P	ROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(QUALITY POINT	ERS
7	P4	Measurement	140±5i	70±5mm	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 With a process of the second state of the seco	14±3mm	1.Please of measuring measuren 2.FOR HA OWARIM	ATSUMONO AND	ied



			TRUCTION		Effectivity Date:		January 5, 202	24
	Process Name/Title:		G ASSEMBLY PRO		Validity Date:		n/a	
	Model code/Part number:	ES1 / 7M0510-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-36	36D
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	9 of 9
	·						•	
parts: n/a					JIG:	n/a		
			QUALITY CH	ECKPOINTS				
P4			7M05	10-7020C				
GOOD NO GOOD			1	5	(6) NG	Normal Appe	arance of Y-Taping aping was Tapered ne-shape)	
NO GOOD	(2 conne	ock/ Half Lock Connect ector) sing Clip Type Clamp	40	No Missing Tape No Deformed Termina	6 No Tape on Y-Ta		ape	

NBC (Philippines)

MASTER COPY