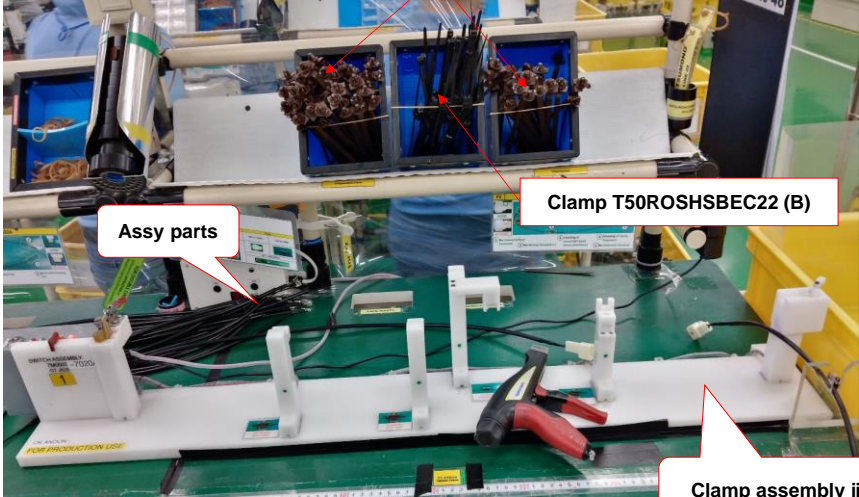
	WORK INSTRUCTION				Effectivity Date:	June 11, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-900		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 6


PARTS:	1. Assy parts: Clamp 82711-16820 (BR); Clamp T50ROSHSBEC22 (B)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<p style="text-align: center;">TABLE LAY-OUT</p> 		<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 workplace 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-199A-B for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

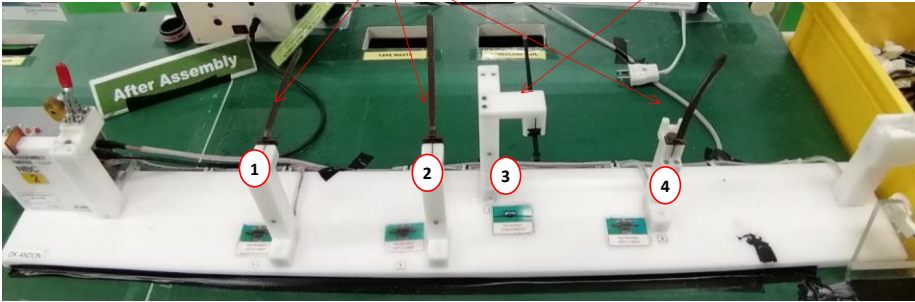


Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.		D.Castillo	C.Villanueva	A. Arañes	N/A
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 11, 2024

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 6


PARTS:	1. Assy parts 2. Clamp 82711-16820 (BR) [3pcs.] 3. Clamp T50ROSHSBEC22 (B)			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	<div><div>82711-16820 (BR)</div><div>T50ROSHSBEC22 (B)</div></div> <div>1. Get 3pcs. of band clamp 82711-16820 (BR) using right hand. Set to clamp location 1, 2 and 4 using both hands.</div> <div>2. Get 1 pc of band clamp T50ROSHSBEC22 (B) using right hand. Set to clamp location 3 using both hands.</div>			n/a	<div>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts 4. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-16820 (BR)</div></div><div><div>NG</div><div>82711-26380 (BR)</div></div></div>

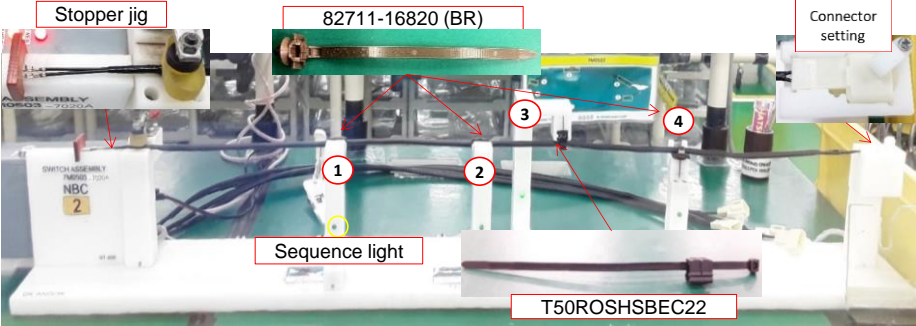

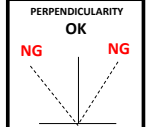


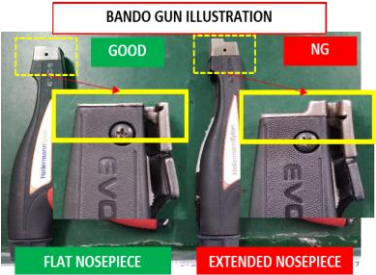
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	Model code/Part number: ES1 / 7M0503-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Revision No.: 0 Page No.: 3 of 6		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Assy parts 2. Clamp 82711-16820 (BR) [3pcs.] 3. Clamp T50ROSHSBEC22 (B)			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	<div><div></div><div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 7282-1026 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Last, set the B-B wires together within stopper jig then press by toggle clamp. Continue if sequence light in location 1 was ON.</p><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, was On. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Initially tighten the band clamp from location 1, 2 3 and 4 using both hands. (Refer below illustration for locaton 3)</p><p>4. Get the Bando Gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 2 was ON.</p></div><div><p>BANDO GUN ALIGNMENT</p><p>GOOD NG</p><p>Bando Gun cutting reference for location 1 and 2</p></div><div><p>PERPENDICULARITY</p><p>OK NG NG</p></div><div><p>Fixed setting of band clamp cutter: 1 ~ 2</p></div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div></div> <div><p>BANDO GUN</p></div>			<div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals</p><p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun</p></div> <div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div>	

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PARTS:		1. Assy parts 2. Clamp 82711-16820 (BR) [3pcs.]		3. Clamp T50ROSHSBEC22 (B)		JIG:		1. Clamp assembly jig	
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
3		CLAMP ASSY Clamp assembly jig (Continuation)		<div><div><div><div>Stopper jig</div><div>82711-16820 (BR)</div><div>Connector setting</div><div>Sequence light</div><div>T50ROSHSBEC22</div></div><div><div>1</div><div>2</div><div>3</div><div>4</div></div></div><div><div>5. Cut the band clamp on clamp location 2 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 3 was ON.</div><div>6. Cut the band clamp on clamp location 3 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 4 was ON.</div><div>7. Cut the band clamp on clamp location 4 using both hands. Press the SW button after cutting of band clamp. Go sound will be heard.</div><div>8. After assembly, conduct POINT CHECKING before removing the harness from jig.</div></div><div><div><div><div>Bando Gun cutting reference for location 3</div><div>BANDO GUN ALIGNMENT</div><div><div><div><div>GOOD</div><div>NG</div></div><div><div>VERTICAL LINE</div><div>OK</div><div>NG</div></div></div><div><div>Fixed setting of band clamp cutter: 1 ~ 2</div></div></div><div><div>BANDO GUN ALIGNMENT</div><div><div><div>PERPENDICULARITY</div><div>OK</div><div>NG</div></div><div><div>GOOD</div><div>NG</div></div></div><div>Bando Gun cutting reference for location 4</div></div></div></div><div><div><div>BANDO GUN</div><div></div></div></div></div></div>		<div><div><div><div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between stopper and terminals</div></div><div>1. No damaged clamp</div><div>2. No wrong use of clamp</div><div>3. No missing clamp</div><div>4. No wrong use of bando gun</div></div><div><div>BANDO GUN ILLUSTRATION</div><div><div><div>GOOD</div><div>NG</div></div><div><div>FLAT NOSEPIECE</div><div>EXTENDED NOSEPIECE</div></div></div></div></div></div>			

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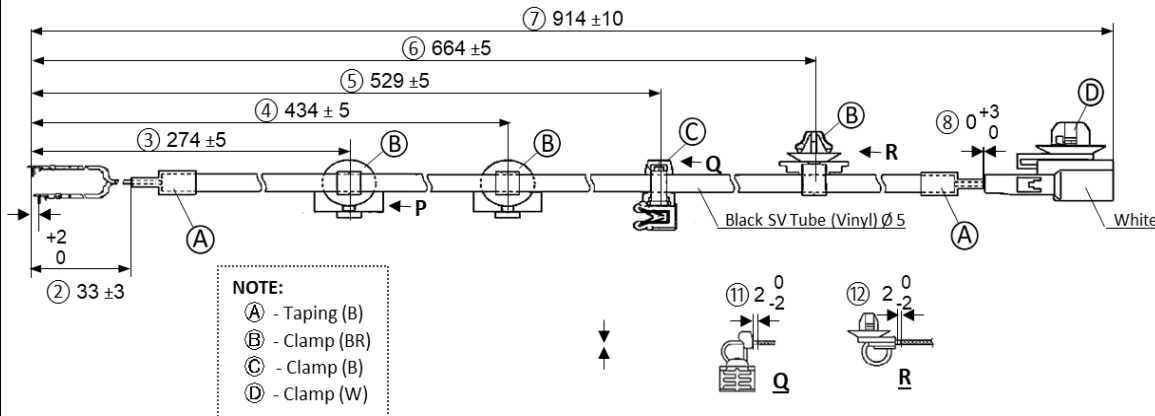
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PARTS:		1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Measurement	<div><div>MEASURING TAPE</div></div>	<div><div>Important reminders and note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div></div>	1. No wrong dimension

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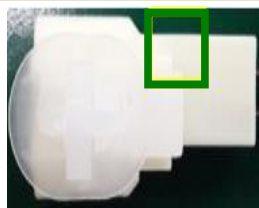
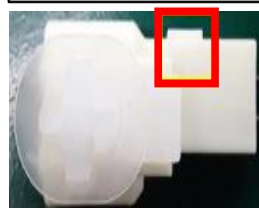
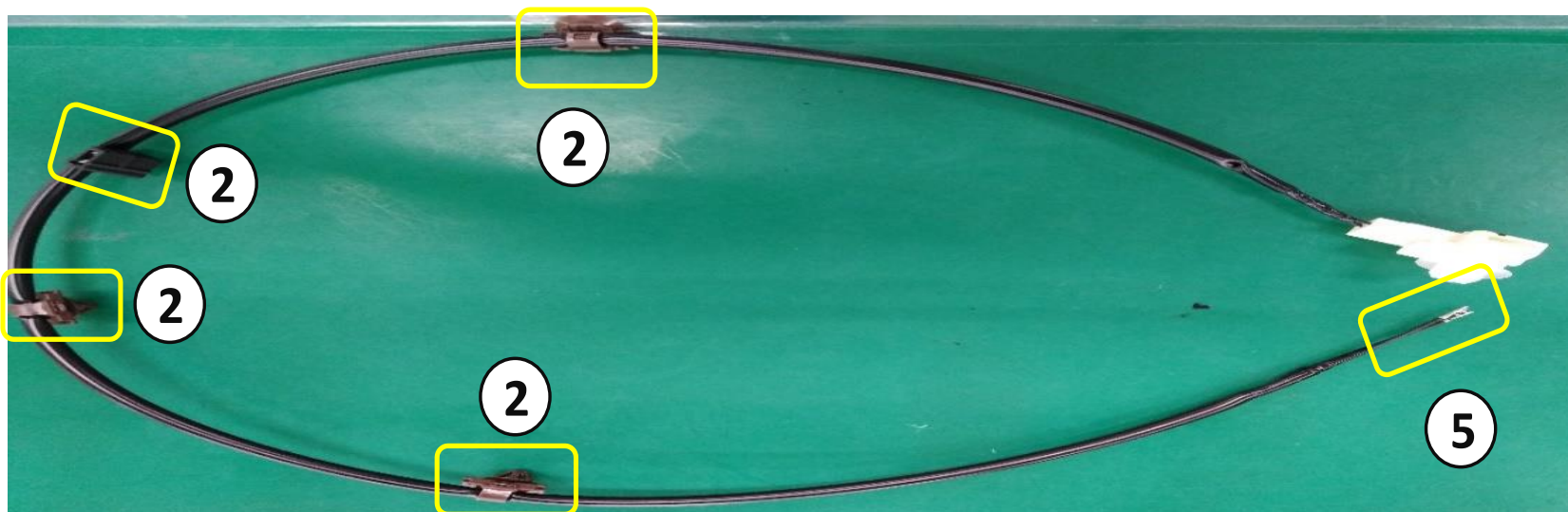
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0503-7020A****GOOD****NO GOOD****1** No Unlock/Halflock
Connector**2** No Missing Clamp(4pcs.)**3** Checking of
loose/tight band
clamp attachment**4** Checking of Clamp
Alignment**5** No Deformed Terminal

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