	WORK INSTRUCTION					Effectivity Date:		January 26, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS					Validity Date:		n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ		Car Model: SUBARU		Document No.: WI-ENG-PDE-817			
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		0		Page No.: 1 of 9

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-48070 (GR); Black tape [3pcs]; Green tape [1pc]				JIG:		n/a			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		CLAMP ASSY		<div><div>TABLE LAY-OUT</div><div><div>Clamp 82711-52090 (W)/ Clamp Tray</div><div>Clamp 82711-3A540 (W)/ Clamp Tray</div><div>Clamp 82711-48070 (GR)/ Clamp Tray</div><div>Assy parts</div><div>Clamp Assembly jig</div><div>Locking Jig</div><div>Black tape/ Tape holder</div><div>Green tape/ Tape holder</div></div></div> <div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>				<div>Document references: 1. Refer to WI-ENG-PDE-770A-C for Taping assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>			

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
01/26/24 0 Initial issue. Separate process from WI-ENG-PDE-770 Taping assembly process.								D.Castillo		C. Villanueva		A. Arañes		n/a	
Eff. DateRev. NoDetails of Change								Revised		Reviewed		Approved		Noted	


Est. Date:		January 26, 2024	
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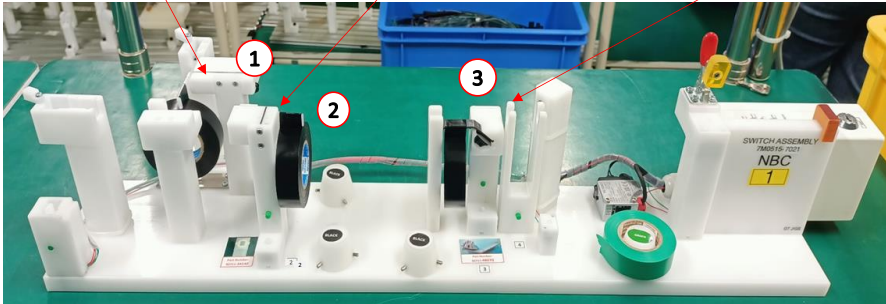
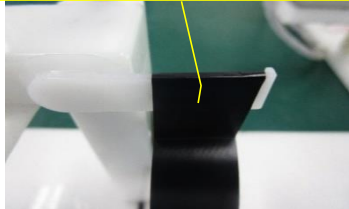


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PARTS:	1. Clamp 82711-52090 (W) 2. Clamp 82711-3A540 (W) 3. Clamp 82711-48070 (GR) 4. Black tape [3pcs] 5. Green tape [1pc]			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	<div><div> 82711-52090 (W)</div><div> 82711-3A540 (W)</div><div> 82711-48070 (GR)</div></div> <div>1. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.</div> <div>2. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 2 using both hands.</div> <div>3. Get 1pc of clamp 82711-48070 (GR) using right hand and set to clamp location 3 using both hands.</div> <div>4. Initially attach Black tape to clamp location 1, 2 and 3 using both hands.</div>			n/a	<p>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <div>One side tape under clamp</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD 82711-52090 (W)</div><div>NG 82711-12A80 (W)</div></div></div>

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PROTOTYPE



PRE-LAUNCH



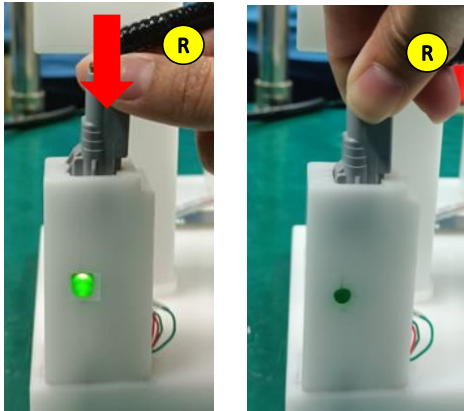
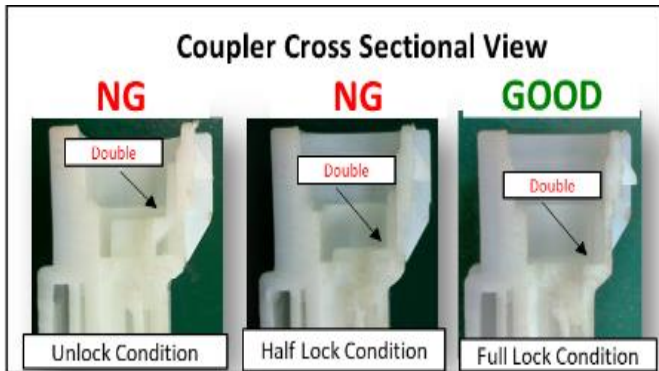

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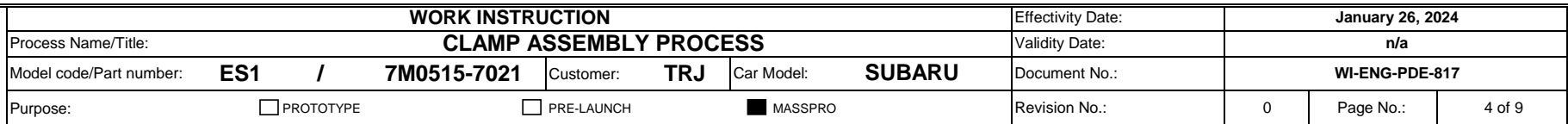
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PARTS:		1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</div></div> <div><div>Before lock</div><div>After lock</div></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</p>

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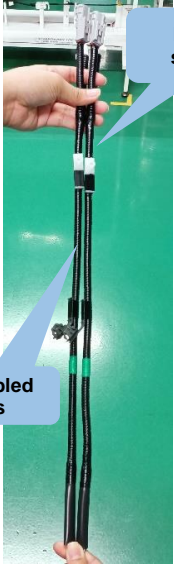
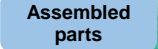








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PARTS:	1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY Visual/By Two's Inspection	          <div>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</div> <div>2. Check the connector lock condition, insertion and terminal.</div> <div>3. Check the presence of clamp attachment, taping condition, color of tape and Spot taping condition.</div>	 <div>1. No skip checking during inspection.</div>	<div>MASTER SAMPLE</div>

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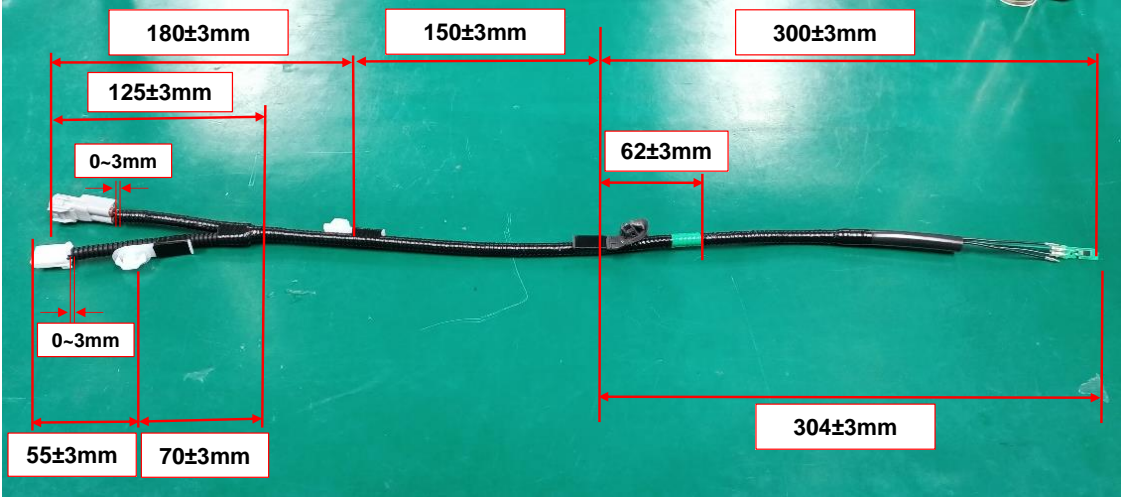

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PARTS:	1. Assy parts 2. Master sample			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	CLAMP ASSY	Visual/By Two's Inspection (Continuation) <div>   </div> <div>      </div> <div> 4. Check the Taping condition of Half-wrap, Y-taping and VM tube to COT. Conduct slightly bending to avoid overlook of missing tape. </div> <div> 5. Check the Hotmelted and terminal appearance. </div>		<div> MASTER SAMPLE </div> <div> 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position </div>	

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PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
6	CLAMP ASSY	<div>Measurement</div> 			<div>MEASURING TAPE</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</div>	

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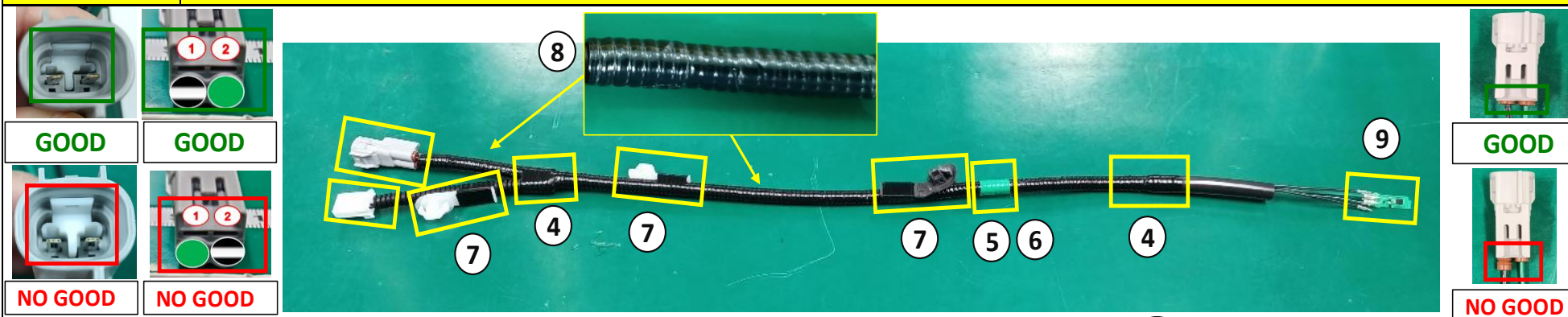
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**CLAMP ASSY****7M0515-7021****① No Unlock/ Halflocked Connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Missing tape****⑤ No Wrong use of tape (Green tape)****⑥ No Missing Spot tape (Green tape)****⑦ No Missing clamp (3pcs)****⑧ Check Half-wrap taping****⑨ No Deformed Terminal and Hotmelted**

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