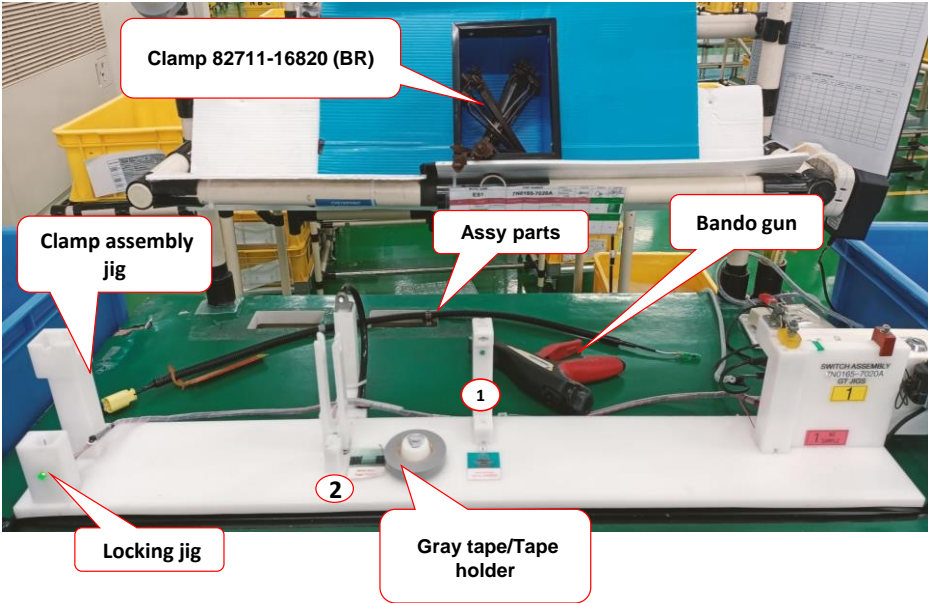

	WORK INSTRUCTION			Effectivity Date:	November 19, 2024		
	CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:	ES1 / 7N0165-7020C	Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:	WI-ENG-PDE-1165	
	Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.: 1 of 6

PARTS:	1. Assy parts: Clamp 82711-16820 (BR) ; Gray tape (10mm)			JIG:	1. Clamp assembly jig with locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div>Table Lay-out</div> 		<div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <ol style="list-style-type: none"> Maintain and always practice 5's. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <div> BANDO GUN</div>	<ol style="list-style-type: none"> No missing parts/tools No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
11/19/24	1	Change pre-launch to mass pro.				A.Hernandez	C. Villanueva	A. Arañes	n/a	
11/18/24	0	Initial issue.				A.Hernandez	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: November 18, 2024

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**WORK INSTRUCTION****CLAMP ASSEMBLY PROCESS**

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November 19, 2024

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ES1 / 7N0165-7020C

Customer: TRJ

Car Model: SUBARU-FORESTER

Validity Date:

n/a

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Purpose:


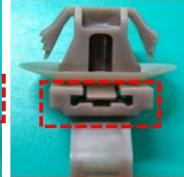

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Clamp 82711-16820 (BR)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	<div><div>82711-16820 (BR)</div></div> <div>1. Get 1pc. of clamp 82711-16820 (BR) using right hand then set to clamp location 1 using both hands.</div>	<div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div>82711-16820 (BR)82711-26380 (BR)</div><div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp. 1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</div></div>

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WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

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Car Model: SUBARU-FORESTER

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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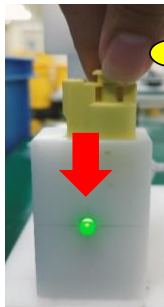

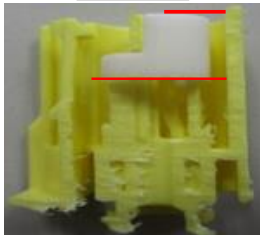
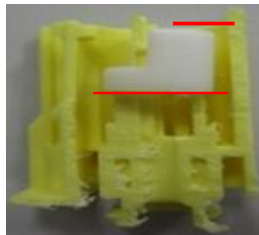
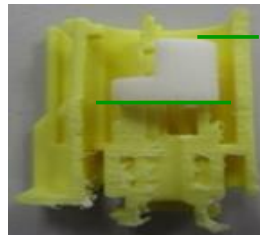
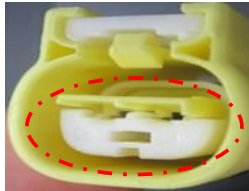
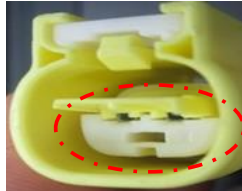

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PARTS:	1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	<div><div><div></div><div></div><div><div>1. Put the connector into locking jig using right hand then press 2x to lock using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

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ES1 / 7N0165-7020C

Customer: TRJ

Car Model: SUBARU-FORESTER

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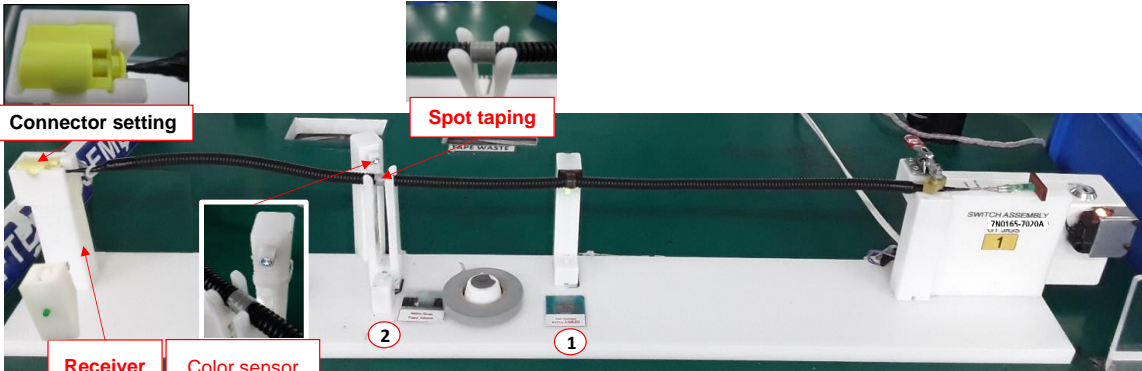



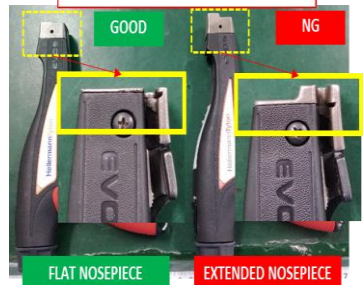
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PARTS:		1. Assy parts 2. Gray tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div><div></div><div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 7C83-5524-70 (Y) to Receiver Base 1. Continue to set the harness in jig then set the PCB end within the stopper then press by Toggle clamp. Continue if the sequence light on clamp location 1 was ON.</p><div><div><p>GOOD NG</p></div><div><p>BANDO GUN ALIGNMENT</p><div><p>PERPENDICULARITY</p><p>OK</p><p>NG NG</p></div></div></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>2. Initially tighten the band clamp on location 1 using both hands.</p><p>3. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 2 was ON.</p><p>4. Get the Gray tape (10mm) then conduct 3 windings of tape (spot taping) using both hands. Color sensor light will beep/buzz if sensor detects Gray tape. Press the SW button after taping. Go sound will be heard</p><p>5. Conduct POINT CHECKING before removing the harness from jig.</p></div></div>		<div><p>Indicates Nominal value of end tape</p><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and PCB.</p><p>2. Green mark indicates both maximum and minimum dimension of an end tape. If exceed/not hitting Green mark, end tape condition marked as NG.</p><p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p><div><div><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div></div></div>	

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ES1 / 7N0165-7020C

Customer:

TRJ

Car Model:

SUBARU-FORESTER

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Purpose:


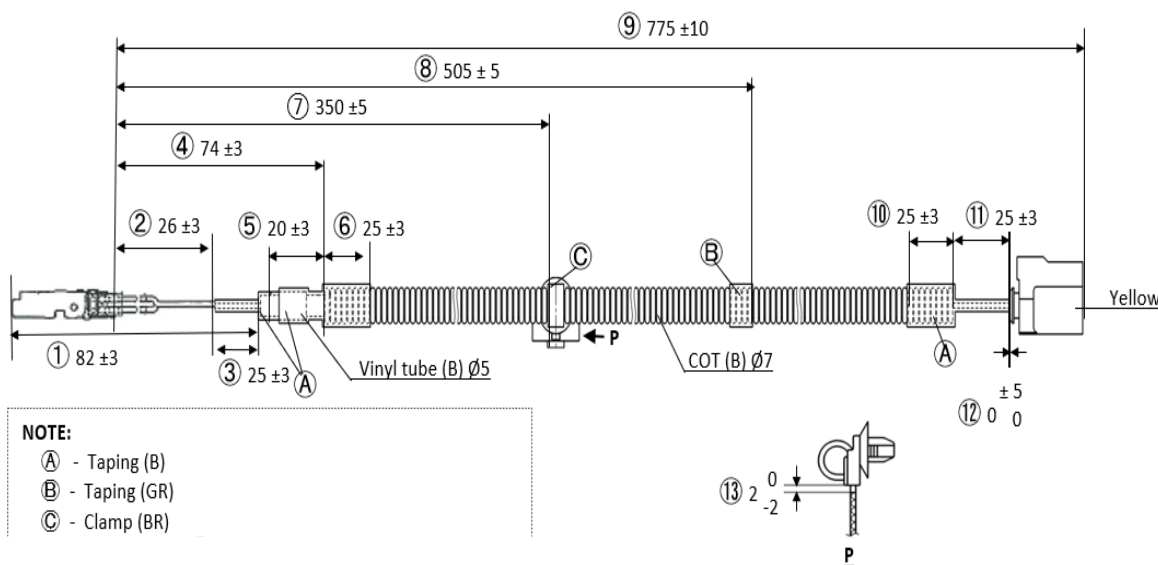
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	Measurement	<div>MEASURING TAPE</div> 		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape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

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Model code/Part number:

ES1 / 7N0165-7020CCustomer: **TRJ**Car Model: **SUBARU-FORESTER**

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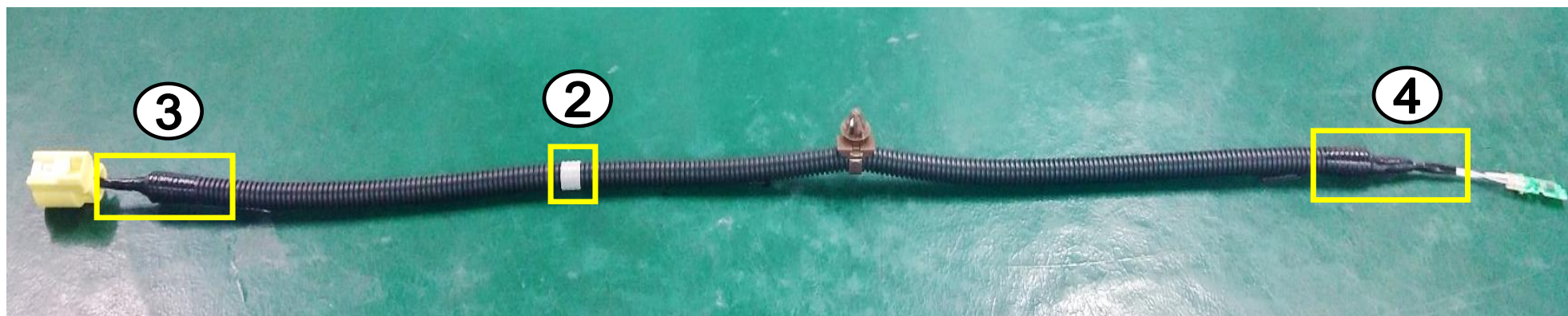
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0165-7020C**

① No unlock/half-locked
connector

② No Missing spot tape
(Gray tape)

③ No Missing Tape
(COT to wire near Connector)

④ No Missing Tape
(COT to wire near SV tube)

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