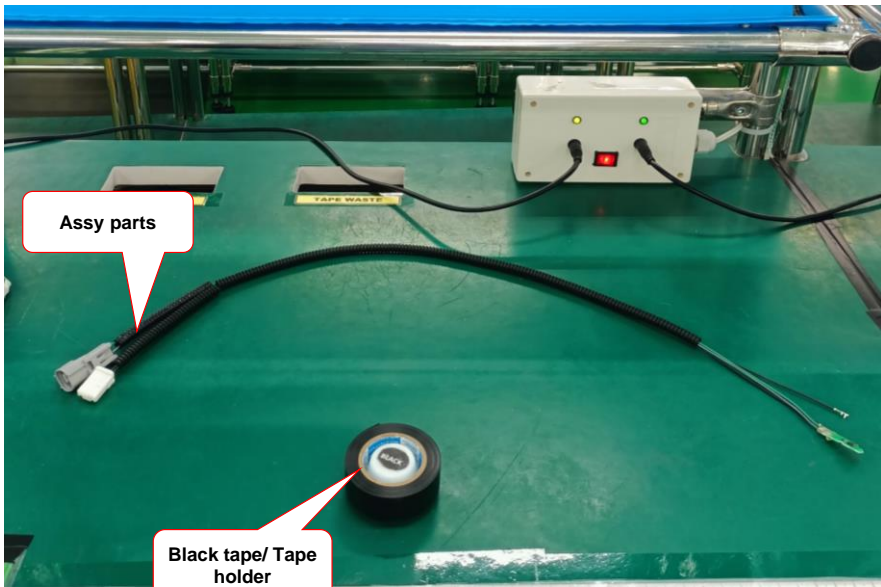

	WORK INSTRUCTION			Effectivity Date:	October 30, 2024			
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a			
	Process Name/Title:			Model code/Part number:	ES1 / 7M0515-7021B	Customer:	TRJ	
			Car Model:	SUBARU	Document No.:	WI-ENG-PDE-1146B		
Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	1 of 4

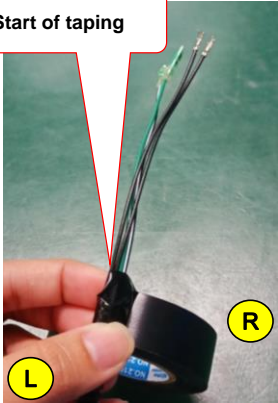
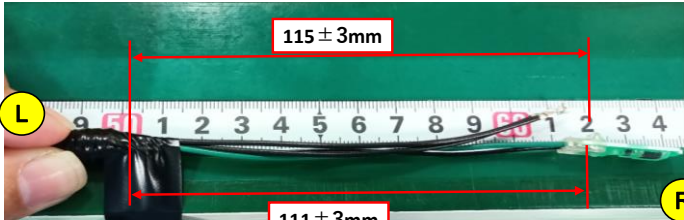
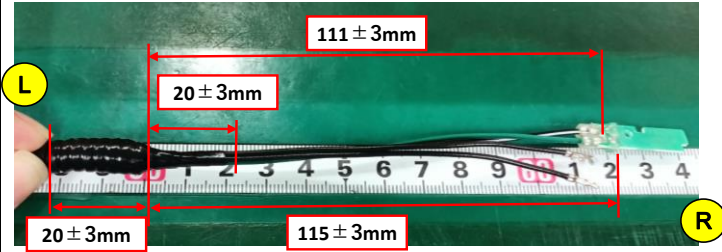

PARTS:	1. All parts: Assy parts; Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out	<div>TABLE LAY-OUT</div> 	<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/30/24	1	Change from Pre-launch to Masspro.			D.Castillo	C. Villanueva	A. Arañes	n/a	
10/29/24	0	Initial issue.			D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:
									October 29, 2024

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 4

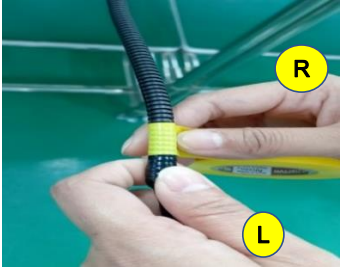
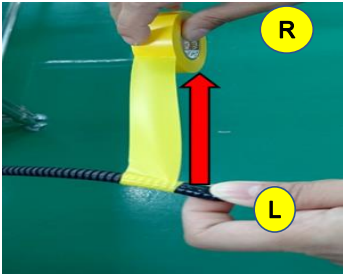
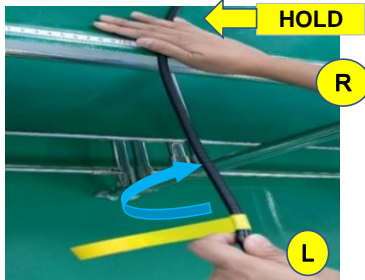
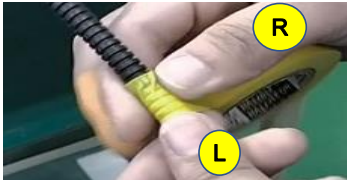

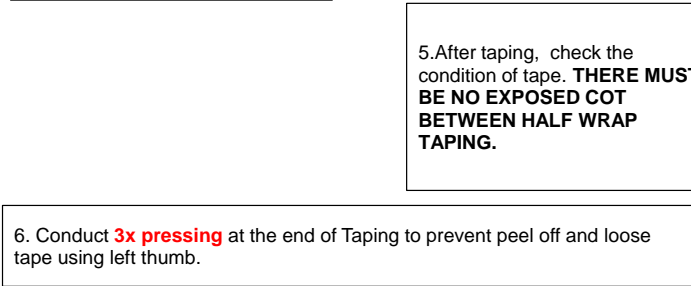
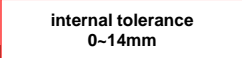
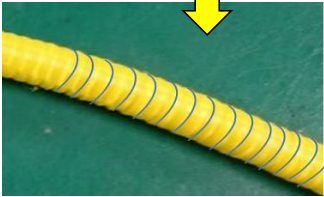
PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 1 COT to wire near terminal and hotmelted	<div><div>Start of taping</div><div>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div> <div><div>2. Measure from end of the corrugated tube up to hotmelted wires 131±3mm and corrugated tube to terminal pointed tip 115±3mm then continue the taping process using both hands.</div></div> <div><div>3. After taping, check the measurement, terminal appearance and taping condition.</div></div>			<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references: 1. Refer to WI-PRO-ASY-001 for Taping process</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 4

PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	P2	Half-wrap taping 2	<div><p>1. Attach the tape, then make 2 windings.</p></div> <div><p>2. Pull the tape around 150mm~200mm.</p></div> <div><p>3. Hold the other side of the harness on the table and apply force to rotate the tape to make halfwrap shifting until cover the COT with slit.s</p></div> <div><p>4. Make 2 windings before cut the tape.</p></div> <div><p>5. After taping, check the condition of tape. THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</p></div> <div><p>6. Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb.</p></div> <div><p>internal tolerance 0~14mm</p></div> <div><p>Appearance after Taping</p></div>			<p>Important reminders/Note/s</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used <u>WHITE TAPE</u> to easily visualize the tape shifting, but actual should be <u>BLACK TAPE</u>.</p> <p>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</p> <p>1. No loose/tight tape 2. No flip-out tape 3. No peel-off tape 4. No exposed COT between tape windings</p>	

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SUBARU

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WI-ENG-PDE-1146B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 4

PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS

TAPING - P2

7M0515-7021B



2

1

FULL TAPING MUST BE
HALF WRAP (NO
EXPOSE COT)

2

No Missing Tape



Proper alignment of
B-B wires and hotmelt

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