



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

NB8 / 7N0207-7020

Customer: TRJ

Car Model: SUBARU-LEGACY

Document No.:

WI-ENG-PDE-863

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Connector 4F5260-0000 (W)
2. AVSSf 0.3 Black Wires L= 577±3mm [2pcs]

3. Black SV tube (Vinyl) Ø5 L=488±3mm
4. Yellow Tape (20mm)

JIG:

1. Locking Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

TABLE LAY-OUT

Connector
4F5260-0000 (W)

Black SV tube (Vinyl)
Ø5 L=488±3mm

Tape Holder/
Yellow Tape

AVSSf 0.3 Black Wires
L= 577±3mm

Locking 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.

1. No damaged connector
2. No wrong use of connector
3. One by one insertion
4. No deformed terminal
5. No terminal backing out

Important reminder's/Note:

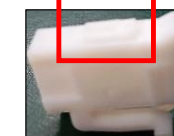
1. Make sure the wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.

2. Do not exert extre force.

Connector Orientation Illustration

NG

GOOD



UNLOCK/
HALF-LOCK

LOCKED

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
7/10/2024	1	Change from Pre-launch to Masspro. Separate the clamp assembly process.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
4/16/2024	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a

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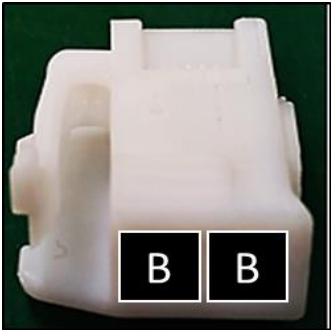


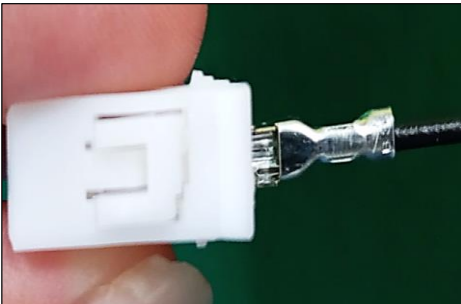
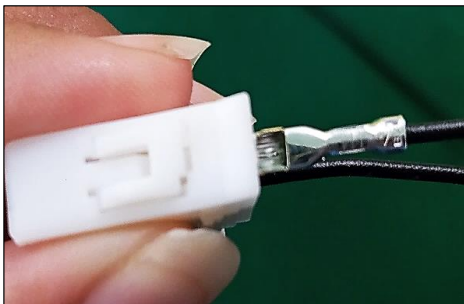

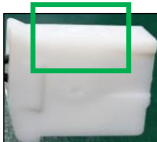
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 4F5260-0000 (W) 2. AVSSf 0.3 Black Wires L= 577±3mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire Insertion to connector 4F5260-0000 (W)	<div></div> <div><div>WIRE FACING</div></div> <div><div>CONNECTOR SETTING</div></div> <div><div>1. Hold the connector using left hand. Get the Black Wire then insert to terminal Slot 1.</div></div> <div><div>2. Get the Black Wire using right hand then insert to terminal Slot 2.</div></div>		n/a	<div>1. No damaged connector 2. No wrong use of connector 3. One by one insertion 4. No deformed terminal 5. No terminal backing out</div> <div>Important reminder's/Note: 1. Make sure the wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. 2. Do not exert extre force.</div> <div>Connector Orientation Illustration</div> <div><div>NG</div></div> <div><div>GOOD</div></div> <div>UNLOCK/ HALF-LOCK</div> <div>LOCKED</div>

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PARTS:

1. Assy part

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

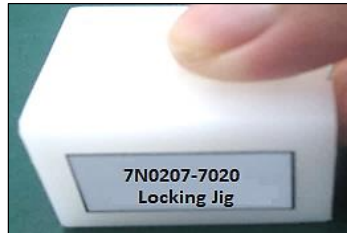
TOOLS/PPE

QUALITY POINTERS

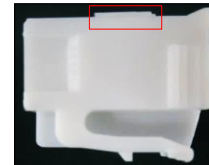
3

P1

Connector Lock



7N0207-7020
Locking Jig

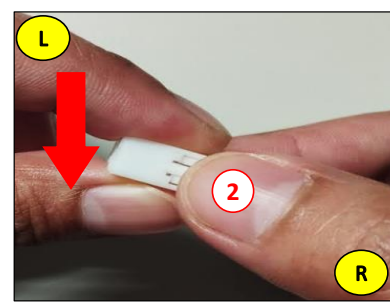
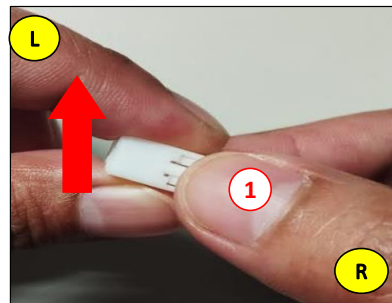


BEFORE PRESSING



AFTER PRESSING

1. Put the connector into locking jig using right hand then press **2x** using both hands.

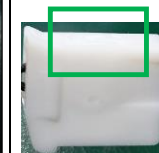


2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.

LOCKING JIG

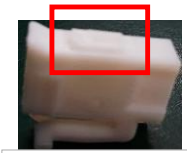


GOOD



LOCK

NG



UNLOCK/
HALF-LOCK

Important reminders/Notes:

1. Manual locking may cause damaged connector lock.
2. Do not exert extra force. It may cause damaged of connector.

Document references:

1. Refer to GL-PRO-ASY-017 for the verification of connector lock.

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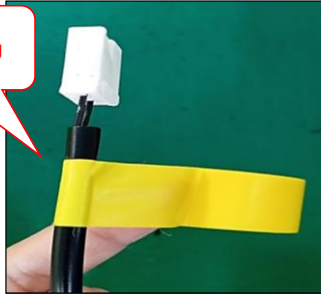
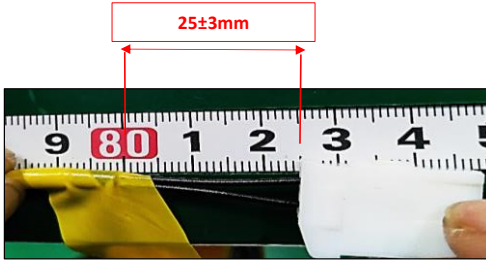
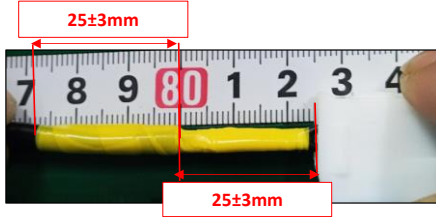


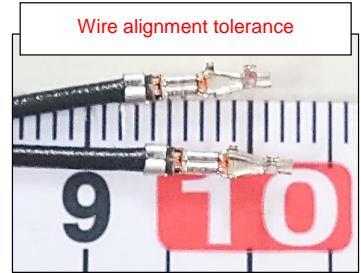
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PARTS:		1. Assy parts 2. Black SV tube (vinyl) Ø5 L=488±3mm 3. Yellow Tape (20mm)	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black SV tube (vinyl) Ø5 L=488±3mm	 <p>1. Get the tip of B-B Wire then insert to Black SV tube (vinyl) Ø5 L=488±3mm .</p>	n/a	1. No wrong use of parts 2. No deformed terminal
5	P1 Taping 1 SV tube (vinyl) to wire near connector	<p>Start of taping</p>  <p>1. Hold the SV tube (vinyl) using left hand. Get the Yellow tape and start taping using right hand.</p>  <p>2. Measure from SV tube up to the end of connector 25±3mm using both hands then continue the taping process.</p>   <p>3. After taping, check the dimension and taping condition.</p>	<p>MEASURING TAPE</p> 	<p>Wire alignment tolerance</p>  <p>1. No wrong use of tape 2. No deformed terminal 3. No wrong dimension 4. No loose tape 5. No peel-off tape 6. No flip-out tape</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use <u>YELLOW TAPE</u> only.</p>

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PARTS:

1. Assy part

JIG:

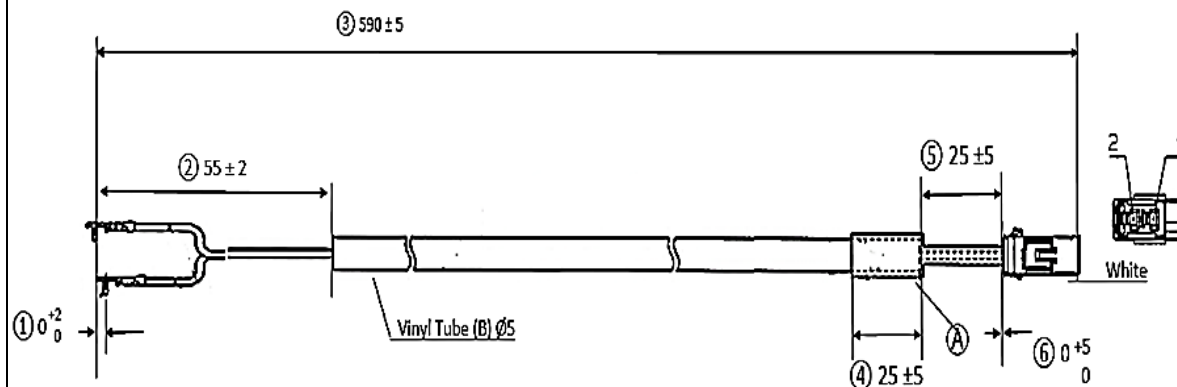
1. Measuring tape

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

6

P1

Measurement



1. No wrong dimension

Important reminders and note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

MEASURING TAPE

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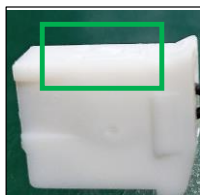
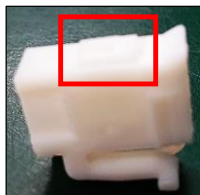
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P1****7N0207-7020****GOOD****NG***Note: With By two's inspection***GOOD****NO GOOD****1 No Unlock/Halflock Connector****2 No Missing Tape****3 No Wrong Dimension****4 No Terminal Backing Out****5 Check the Tape Condition**

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