



WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: NB8 / 7N0209-7020Aa Customer: TRJ Car Model: SUBARU-LEGACY

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

November 20, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1110

Revision No.:

1

Page No.:

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PARTS:

1. Connector 7C83-5524-70 (Y) 3. AVSSf 0.3 Black/White L= 450±2mm
2. Black Corrugated tube (No Slit) Ø5 L=353±4mm 4. AVSSf 0.3 White L= 450±2mm

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

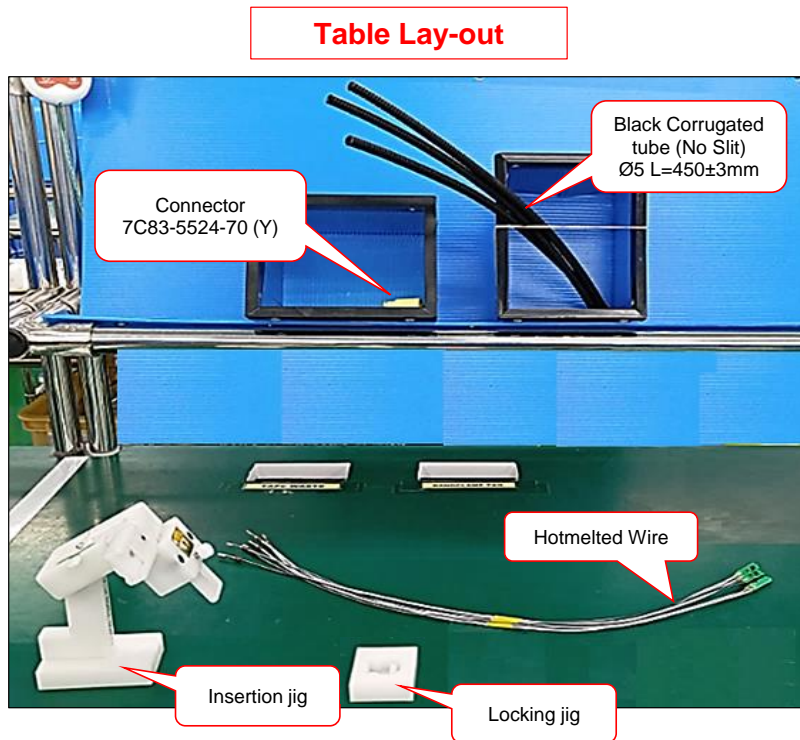
TOOLS/PPE

QUALITY POINTERS

1

offline

Table Lay-out



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 wrong use of parts
2. No excess/lacking of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/20/24	1	Change pre-launch to mass pro.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
10/03/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 03, 2024		

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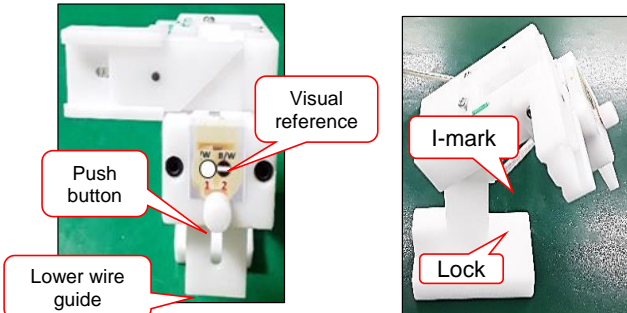
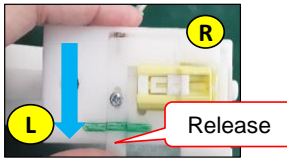
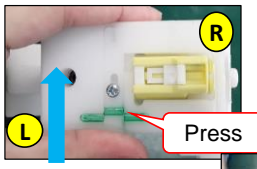
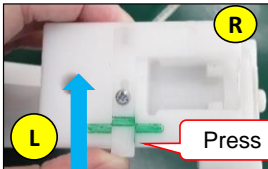

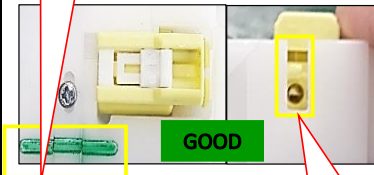

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PARTS:		1. Connector 7C83-5524-70 (Y) 2. Black Corrugated tube (No Slit) Ø5 L=353±4mm		3. AVSSf 0.3 Black/White L= 450±2mm 4. AVSSf 0.3 White L= 450±2mm		JIG:	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	offline	Connector setting to Insertion jig 7C83-5524-70 (Y)	<div><p>Connector Setting</p><p>Insertion jig Setting</p><div></div><div><p>1. Press the insertion jig lock using left hand. Get the Connector 7C83-5524-70 (Y) and insert to insertion jig using right hand. Release the lock after insertion. See above illustration for proper orientation.</p></div><p>2. Press the lower wire guide using right hand. Slot for White wire will be open.</p></div>			n/a	<div><p>1. No wrong orientation of connector</p><p>Connector Orientation Illustration</p><p>I-mark is align.</p><p>1 hole is open.</p></div>
3		Wire insertion W-B/W to Black Corrugated tube (No Slit) Ø5 L=353±4mm	<div><p>1. Get 1pc of Black Corrugated tube (No Slit) Ø5 L=353±4mm using left hand. Get the W and B/W wires using right hand and insert to the Black Corrugated tube (No Slit) Ø5 L=353±4mm.</p></div>			n/a	<div><p>1. No wrong use of parts</p><p>2. No deformed terminal</p></div>

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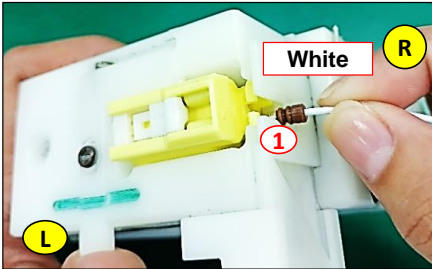
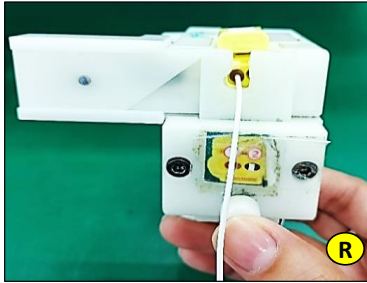
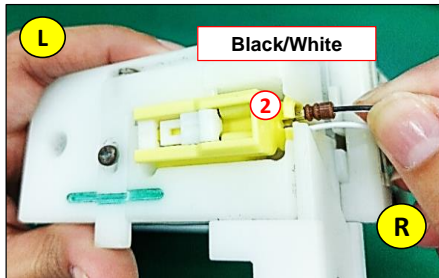



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 7C83-5524-70 (Y) 2. AVSSf 0.3 White L= 450±2mm		3. AVSSf 0.3 Black/White L= 450±2mm	JIG:	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	offline	Wire Insertion to connector 7C83-5524-70 (Y)	<div><div>WIRE FACING</div></div> <div><div>1. Get the White wire and insert to terminal slot 1 using right hand.</div></div> <div><div>2. After insertion of White wire, press the button using right thumb. Slot for Black/White wire will be open.</div></div> <div><div>3. Get the Black/White wire and insert to terminal slot 2 using right hand.</div></div> <div><div>4. After insertion, press the insertion jig lock using left hand and then hold the wire and gently pull out the connector from jig using right hand.</div></div>			n/a	<div>1. No wrong use of parts 2. No deformed terminal</div> <div>Connector Orientation Illustration</div> <div><div>NG</div><div>GOOD</div><div></div><div></div></div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

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☐ PROTOTYPE

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PARTS:

1. Assy part

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

offline

Connector Lock



1. Hold the connector using right hand and insert into locking jig. **Push 2x** to lock the connector properly..

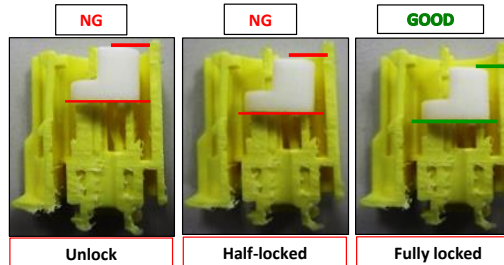


Before Pressing



After Pressing

CROSS SECTIONAL VIEW



Locking Jig

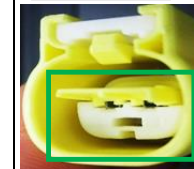
1. Use the provided locking jig per model
2. No unlock/half-locked connector
3. No damaged connector

Important reminders/Notes:

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

GOOD

NG



LOCK



UNLOCK/
HALF-LOCK

Document references:

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

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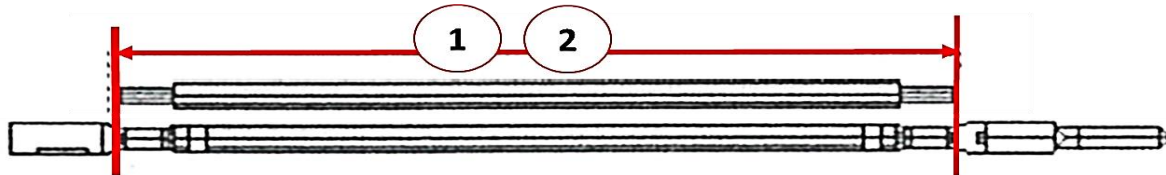


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PARTS:		1. Assy Parts		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	offline	Measurement	<div><p>Note:</p><p>1. Measurement point: End of core wire to the end of core wire</p><p>2. Terminal is reference only.</p></div> <div></div> <div></div>	<div>MEASURING TAPE</div> <div></div>	<p>1. No wrong dimension</p> <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>

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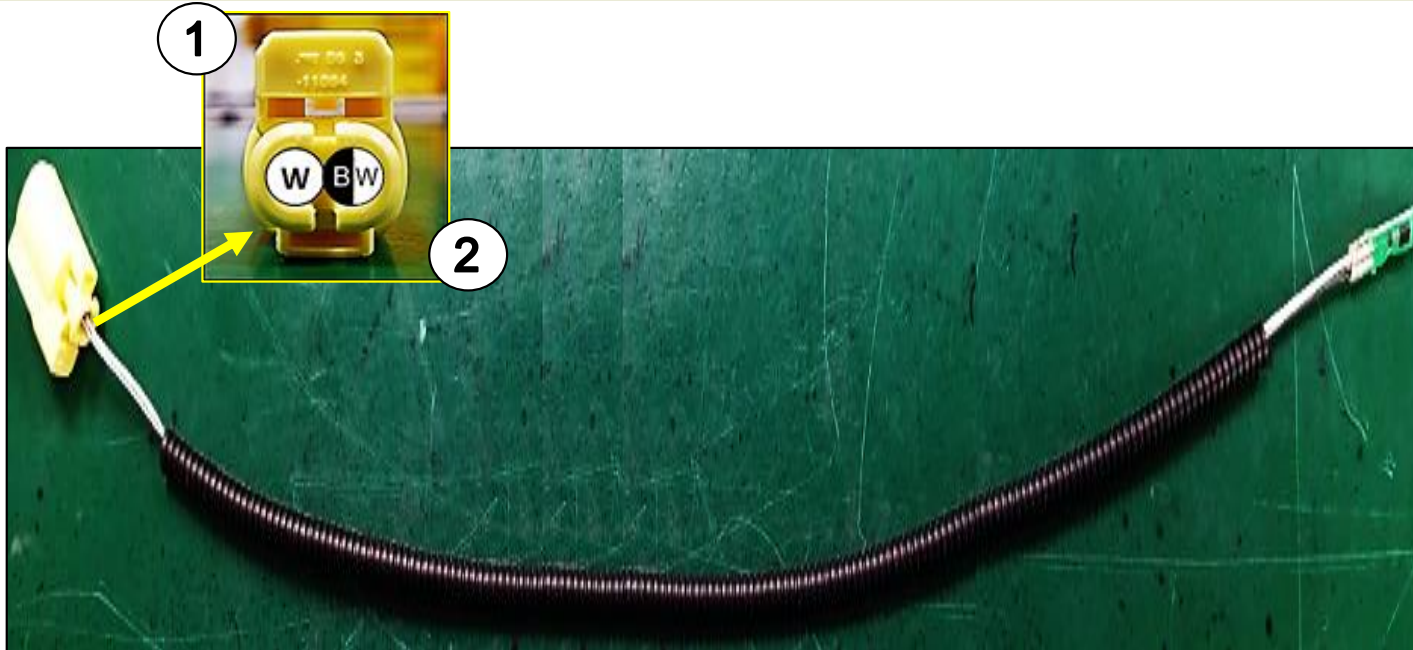
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0209-7020Aa****1 No Unlock/Halflock Connector****2 No Wrong Insertion****3 No Missing Black COT****4 No Terminal Backing Out**

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