



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

NB8 / 7N0207-7021

Customer: TRJ

Car Model: SUBARU-LEGACY

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 08, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1193

Revision No.:

2

Page No.:

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PARTS:

- Connector 4F5260-0003 (W)
- AVSSf 0.3 Black Wires L= 607±3mm [2pcs]
- Black SV tube (Vinyl) Ø5 L=518±3mm
- Yellow Tape

JIG:

1.Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

TABLE LAY-OUT

Connector
4F5260-0003 (W)

Black SV tube (Vinyl)
Ø5 L=518±3mm

Tape Holder/
Yellow Tape

AVSSf 0.3 Black Wires
L= 607±3mm

Locking Jig

Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

- Maintain and always practice 5's.
- 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.

- No damaged connector
- No wrong use of connector
- One by one insertion
- No deformed terminal
- No terminal backing out

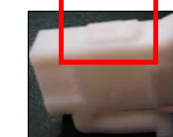
Important reminder's/Note:

- Make sure the wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
- Do not exert extre force.

Connector Orientation Illustration

NG

GOOD



UNLOCK/
HALF-LOCK

LOCK

Revision History

Revision History							Prepared by	Checked by	Reviewed by	Approved by
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	February 05, 2025		
05/08/2025	2	Correction of measurement of overall harness length from L=610mm to L=620mm	A.Buban	J. Loterte	C. Villanueva	A. Arañes				
03/04/2025	1	Change pre-launch to mass-pro	A.Buban	J. Loterte	C. Villanueva	A. Arañes				
02/05/2025	0	-Initial issue. -Change wire length from L=602mm to L=607mm and black vinyl tube length from L=513mm to L=518mm	A.Buban	J. Loterte	C. Villanueva	A. Arañes				

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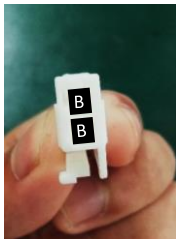
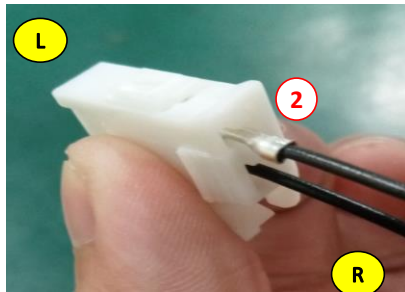
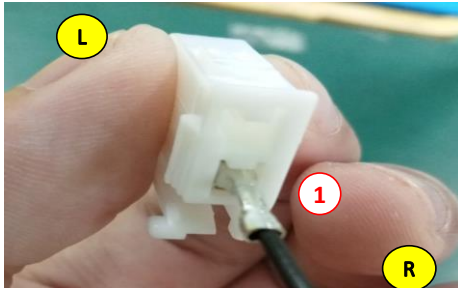



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PARTS:		1. Connector 4F5260-0003 (W) 2. AVSSf 0.3 Black Wires L= 607±3mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Wire Insertion to connector 4F5260-0003 (W)</div> <div><div>WIRE FACING</div><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>2. Get the Black Wire using right hand then insert to terminal Slot 2.</div></div>		<div>LOCKING JIG</div> 	<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:</div> <div>1. Make sure the wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</div> <div>2. Do not exert extre force.</div> <div>Connector Orientation Illustration</div> <div><div>NG</div><div>UNLOCK/ HALF-LOCK</div></div> <div><div>GOOD</div><div>LOCKED</div></div>

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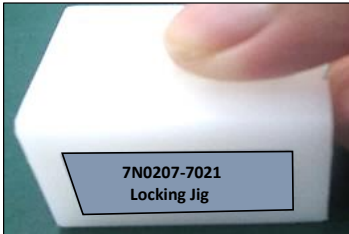
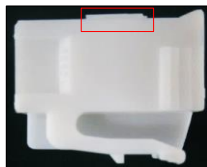

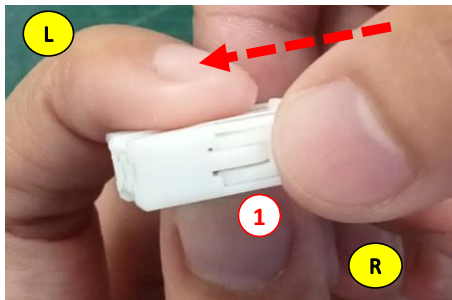
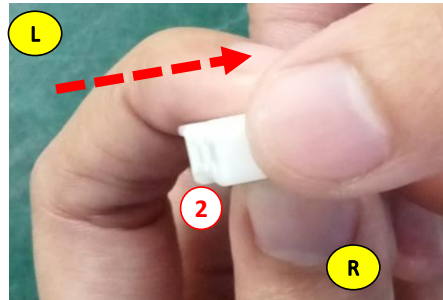

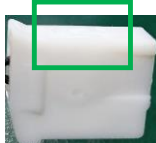
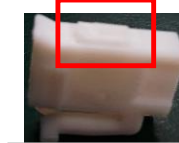
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PARTS:		1. Assy part		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Connector Lock	<div><div><div>7N0207-7021 Locking Jig</div></div><div><div>BEFORE PRESSING</div></div><div><div>AFTER PRESSING</div></div><div><div>1. Put the connector into locking jig using right hand then press 2x using both hands.</div></div><div><div><div>L 1 R</div></div><div><div>L 2 R</div></div><div><div>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div></div></div></div>		<div>LOCKING JIG</div> <div></div>	<div><div>1. Use the provided locking jig per model</div><div>2. No unlock/half-locked connector</div><div>3. No damaged connector</div></div> <div><div>Important reminders/Notes:</div><div>1. Manual locking may cause damaged connector lock.</div><div>2. Do not exert extra force. It may cause damaged of connector.</div></div> <div><div><div>GOOD</div><div></div><div>LOCK</div></div><div><div>NG</div><div></div><div>UNLOCK/ HALF-LOCK</div></div></div> <div><div>Document references:</div><div>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</div></div>

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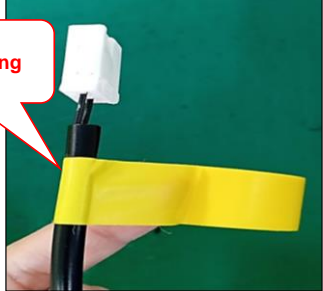

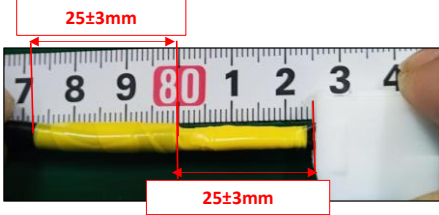


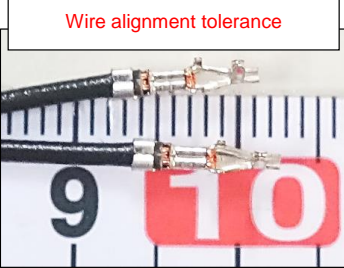
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PARTS:		1. Assy parts 2. Black SV tube (vinyl) Ø5 L=518±3mm 3. Yellow tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black SV tube (vinyl) Ø5 L=518±3mm	 1. Get the tip of B-B Wire using left hand then insert to Black SV tube (vinyl) Ø5 L=518±3mm .	n/a	1. No wrong use of parts 2. No deformed terminal
5	P1 Taping 1 SV tube (vinyl) to wire near connector	 1. Hold the SV tube (vinyl) using left hand. Get the Yellow tape and start taping using right hand.  2. Measure from SV tube up to the end of connector 25±3mm using both hands then continue the taping process.   3. After taping, check the dimension and taping condition.		 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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use <u>YELLOW TAPE</u> only.

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PARTS:

1. Assy parts

JIG:

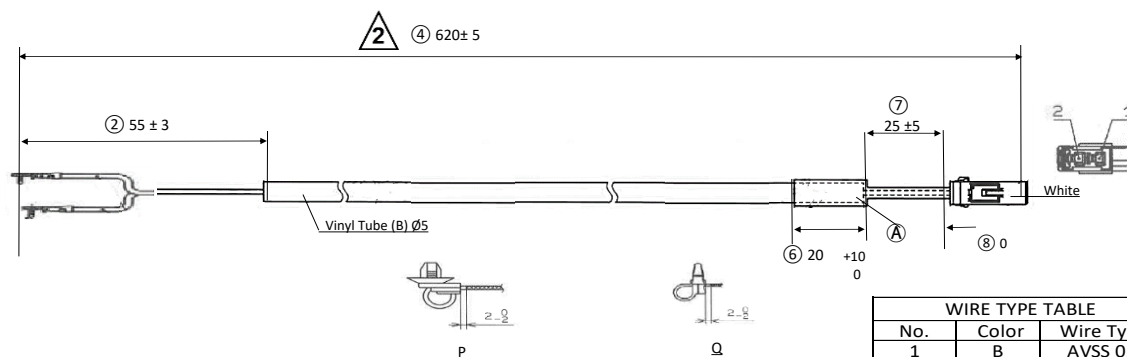
1. Measuring tape

NO.**PROCESS NAME****2****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P1

Measurement

**NOTE:**

(A) - Taping (Y)

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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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7N0207-7021**

- ① No **Unlock/Halflock Connector**
- ② No **Missing Tape/No Wrong Use of Tape**
- ③ No **Terminal Backing Out**

February 5, 2025

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