



WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 15, 2024

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

NB8 / 7N0208-7020a

Customer: TRJ

Car Model: SUBARU-LEGACY

Document No.:

WI-ENG-PDE-972

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Connector 7C83-5524-70 (Y)
2. AVSSf 0.3 White L= 690±3mm

3. AVSSf 0.3 Black/White L= 690±3mm
4. Black Corrugated tube (No Slit) Ø5 L=593±5mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

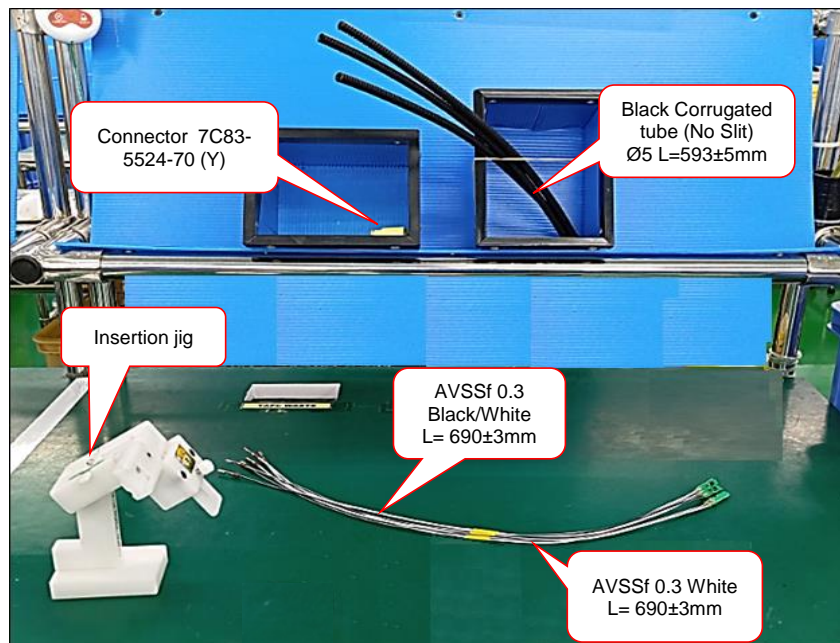
TOOLS/PPE

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

Prepared by

Reviewed by

Approved by

Noted by

07/15/24 0 Initial issue.

A.Hernandez

C. Villanueva

A. Arañes

n/a

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C. Villanueva

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Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 15, 2024

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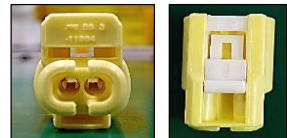
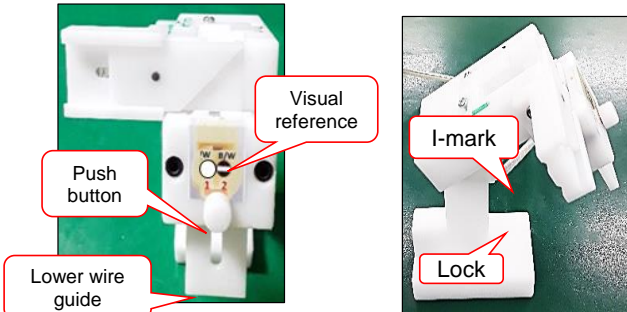
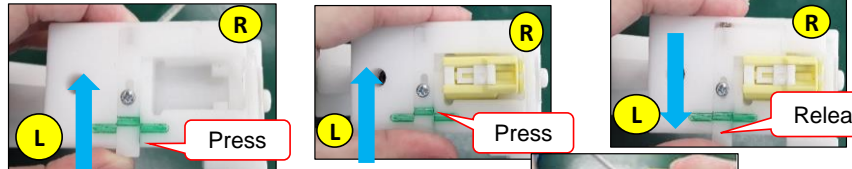

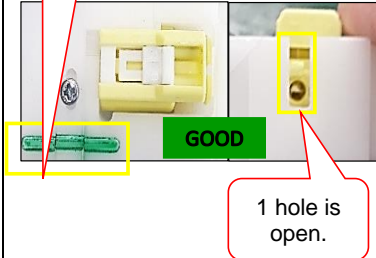

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 7C83-5524-70 (Y) 2. Black Corrugated tube (No Slit) Ø5 L=593±5mm		3. AVSSf 0.3 Black/White L= 690±3mm 4. AVSSf 0.3 White L= 690±3mm		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><p>Press</p><p>Press</p><p>Release</p><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><p>2. Press the lower wire guide using right hand. Slot for White wire will be open.</p></div></div>			n/a	<div>1. No wrong orientation of connector</div> <div>Connector Orientation Illustration</div> <div>I-mark is align.</div>  <p>GOOD</p> <p>1 hole is open.</p>
3		Wire insertion W-B/W to Black Corrugated tube (No Slit) Ø5 L=593±5mm	<div><p>1. Get 1pc of Black Corrugated tube (No Slit) Ø5 L=593±5mm using left hand. Get the W and B/W wires using right hand and insert to the Black Corrugated tube (No Slit) Ø5 L=593±5mm.</p></div>			n/a	1. No wrong use of parts 2. No deformed terminal

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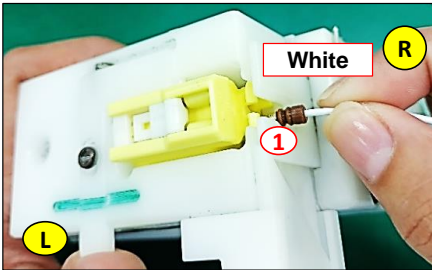
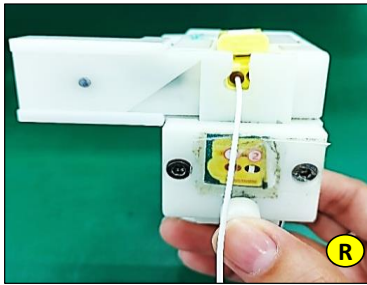
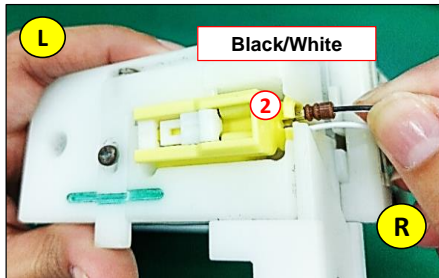

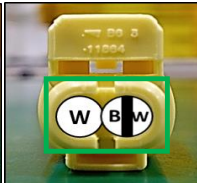
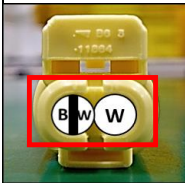
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PARTS:		1. Connector 7C83-5524-70 (Y) 2. AVSSf 0.3 White L= 690±3mm		3. AVSSf 0.3 Black/White L= 690±3mm	JIG:	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	offline	Wire Insertion to connector 7C83-5524-70 (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>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

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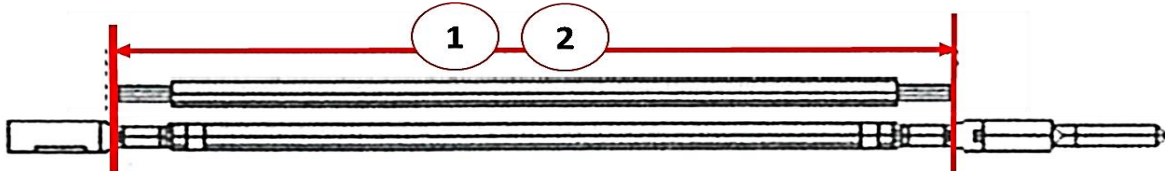


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PARTS:	1. Assy Parts		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div>	<div>1. No wrong dimension</div> <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			<div></div> <div><div>MEASURING TAPE</div><div></div></div>	

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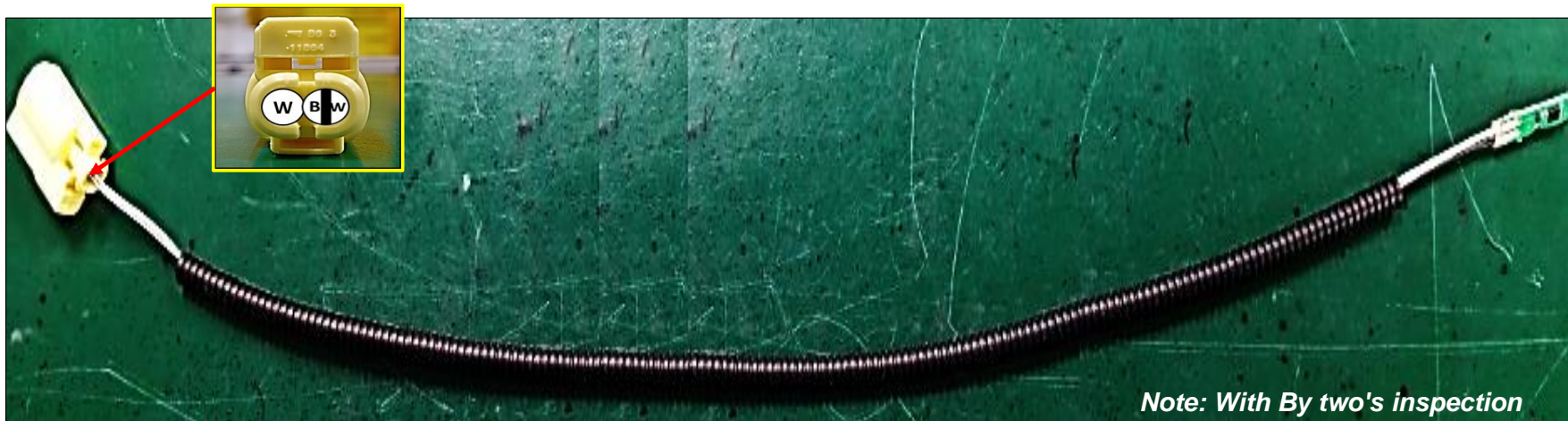
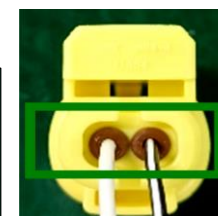
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0208-7020a***Note: With By two's inspection***GOOD****NG****1 No Wrong Insertion****2 No Terminal Backing Out**

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