



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 / 7N0209-7020a

Customer: TRJ

Car Model: SUBARU-LEGACY

Document No.:

WI-ENG-PDE-949

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

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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
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

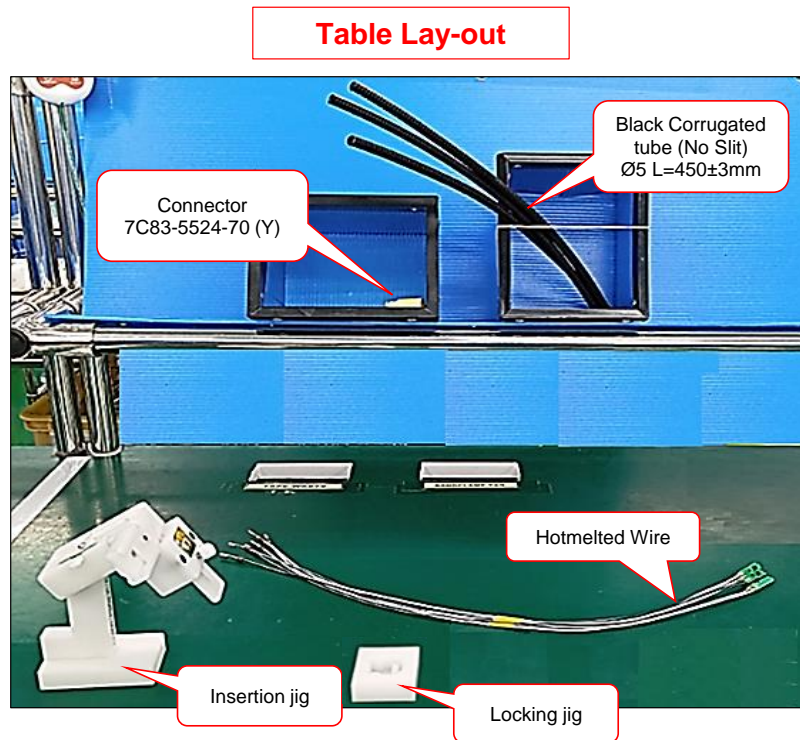
TOOLS/PPE

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

Prepared by

Reviewed by

Approved by

Noted by

07/15/24 0 Initial issue.

A.Hernandez

C. Villanueva

A. Arañes

n/a

A.Hernandez

C. Villanueva

A. Arañes

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Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 15, 2024

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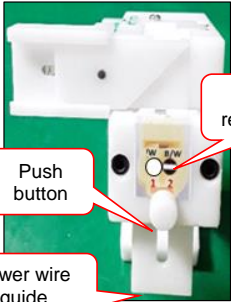
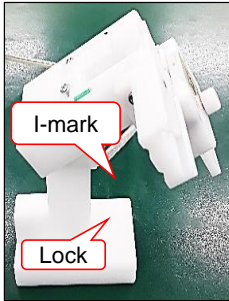

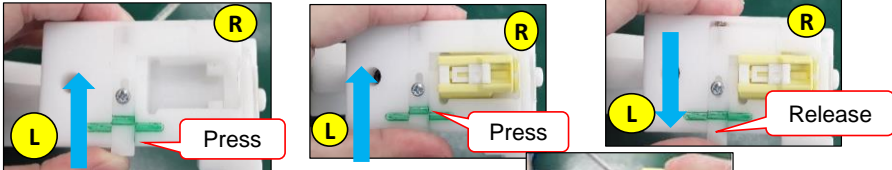

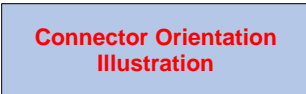
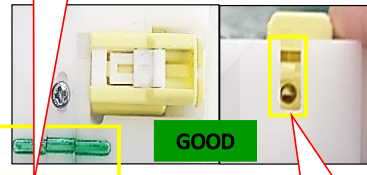

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 7C83-5524-70 (Y) 2. Black Corrugated tube (No Slit) Ø5 L=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><div></div><div></div><div></div><div></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><div><p>2. Press the lower wire guide using right hand. Slot for White wire will be open.</p></div></div></div>			n/a	<div>1. No wrong orientation of connector</div> <div></div> <div><p>I-mark is align.</p><p>GOOD</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></div> <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>1. No wrong use of parts</div> <div>2. No deformed terminal</div>

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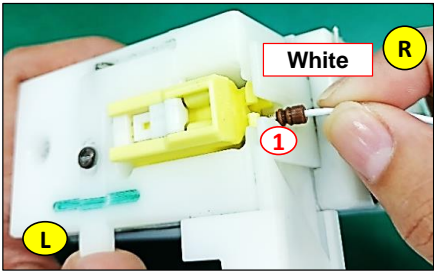
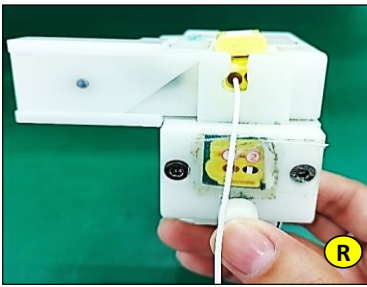
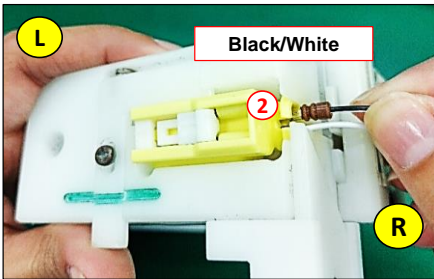
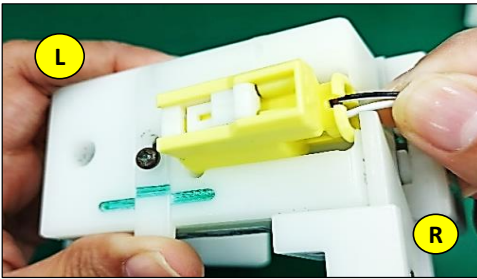
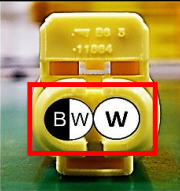
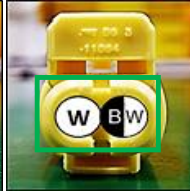
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PARTS:	1. Connector 7C83-5524-70 (Y) 2. AVSSf 0.3 White L= 450±2mm 3. AVSSf 0.3 Black/White L= 450±2mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	offline Wire Insertion to connector 7C83-5524-70 (Y)	<div data-bbox="864 395 1133 448"></div> <div data-bbox="831 456 1155 491">WIRE FACING</div> <div data-bbox="544 528 976 799"></div> <div data-bbox="577 807 943 863">1. Get the White wire and insert to terminal slot 1 using right hand.</div> <div data-bbox="1043 512 1408 799"></div> <div data-bbox="999 807 1469 871">2. After insertion of White wire, press the button using right thumb. Slot for Black/White wire will be open.</div> <div data-bbox="551 903 983 1182"></div> <div data-bbox="584 1190 949 1246">3. Get the Black/White wire and insert to terminal slot 2 using right hand.</div> <div data-bbox="994 903 1469 1182"></div> <div data-bbox="999 1190 1469 1262">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>	n/a	<div data-bbox="1738 427 1951 472">1. No wrong use of parts 2. No deformed terminal</div> <div data-bbox="1738 815 2116 871">Connector Orientation Illustration</div> <div data-bbox="1738 879 2116 1126"><div data-bbox="1783 879 1883 927">NG</div><div data-bbox="1962 879 2085 927">GOOD</div><div data-bbox="1738 935 1917 1126"></div><div data-bbox="1928 935 2116 1126"></div></div> <div data-bbox="1738 1166 1984 1190">Document references:</div> <div data-bbox="1738 1214 2116 1262">1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

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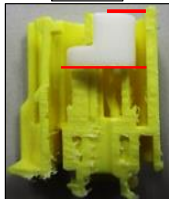
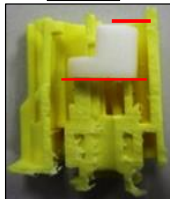
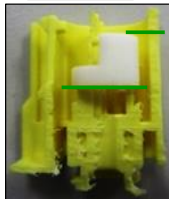

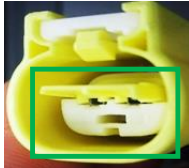
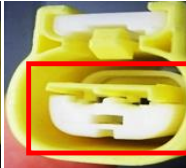
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PARTS:	1. Assy part			JIG:	1. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	offline	Connector Lock	<div></div> <div><div> Before Pressing</div><div> After Pressing</div></div> <div><div>CROSS SECTIONAL VIEW</div><div><div> Unlock</div><div> Half-locked</div><div> Fully locked</div></div></div> <div><p>1. Hold the connector using right hand and insert into locking jig. Push 2x to lock the connector properly..</p><p>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div>	<div>Locking Jig</div> <div></div>	<p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged connector</p> <p>Important reminders/Notes:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>2. Do not exert extra force. It may cause damaged of connector.</p> <div><div>GOOD</div><div>NG</div></div> <div><div> LOCK</div><div> UNLOCK/ HALF-LOCK</div></div> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</p>

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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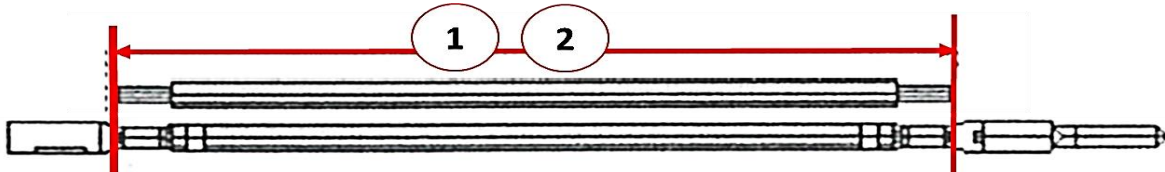
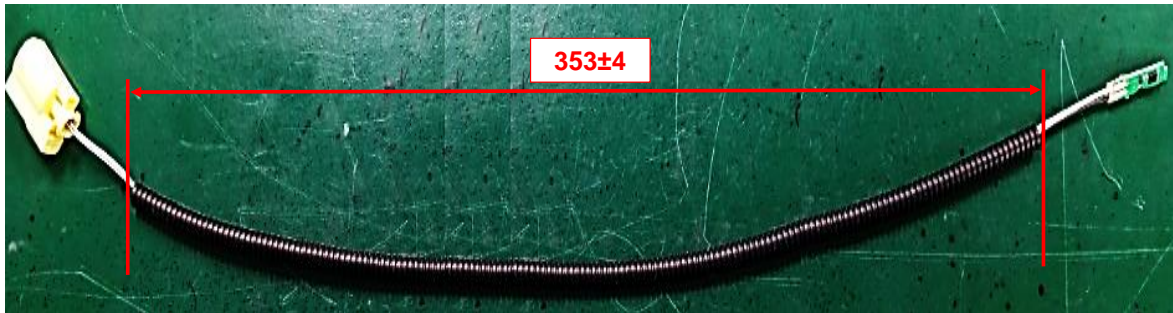

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PARTS:	1. Assy Parts		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	offline	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>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

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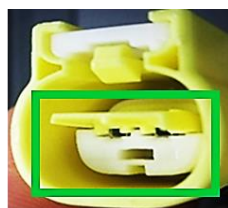
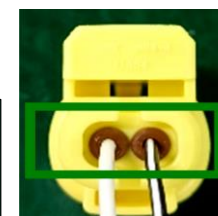
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE****7N0209-7020a****GOOD****NG***Note: With By two's inspection***GOOD****NG**

- ① **No Unlock/Halflock Connector**
- ② **No Terminal Backing Out**

- ③ **No Wrong Insertion**

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