



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

November 20, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

NB8 / 7N0208-7020Aa

Customer: TRJ

Car Model: SUBARU-LEGACY

Document No.:

WI-ENG-PDE-1107

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 5

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

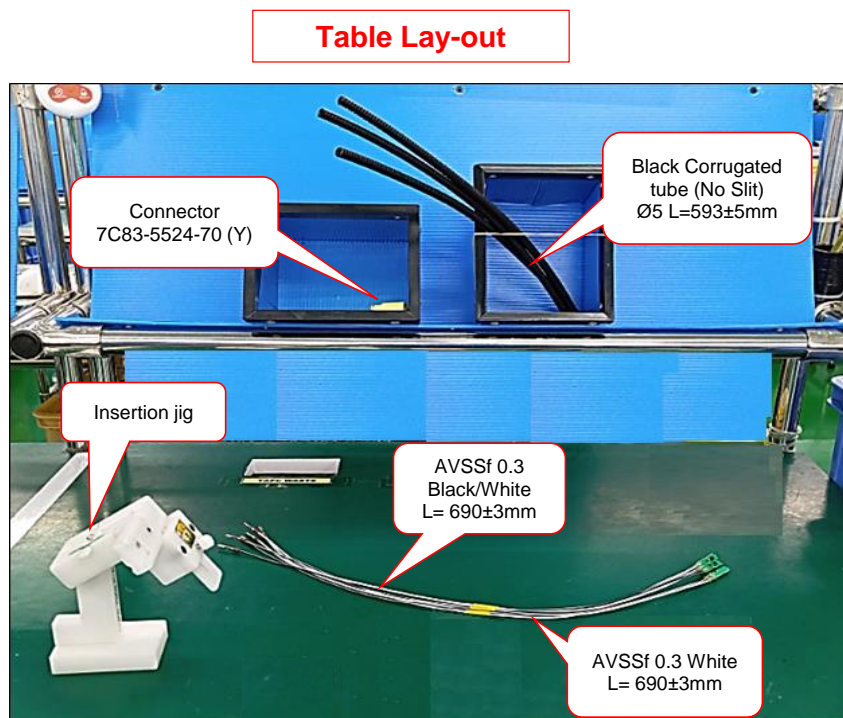
TOOLS/PPE

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
11/20/24	1	Change pre-launch to mass pro.								n/a
10/08/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted				

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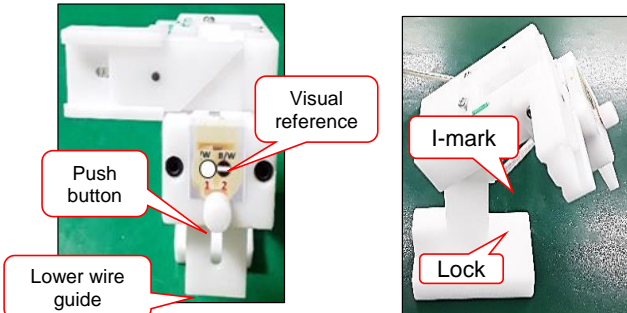

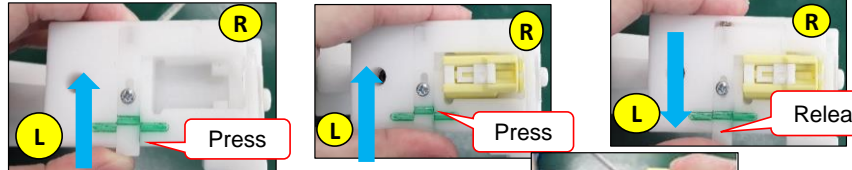

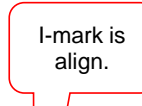
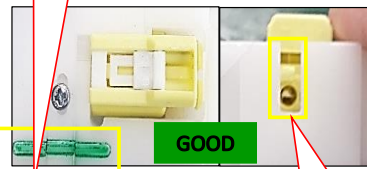

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

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></div> <div></div> <div>Connector Setting</div> <div></div> <div>Insertion jig Setting</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>				n/a	<div>1. No wrong orientation of connector</div> <div>Connector Orientation Illustration</div> <div></div> <div></div> <div>GOOD</div> <div>1 hole is open.</div>
3	Wire insertion W-B/W to Black Corrugated tube (No Slit) Ø5 L=593±5mm	<div></div> <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	<div>1. No wrong use of parts</div> <div>2. No deformed terminal</div>

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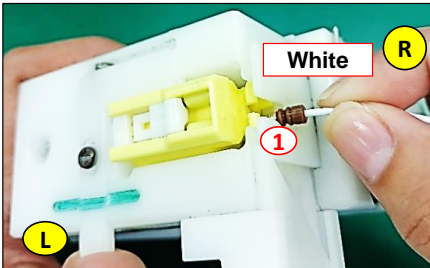
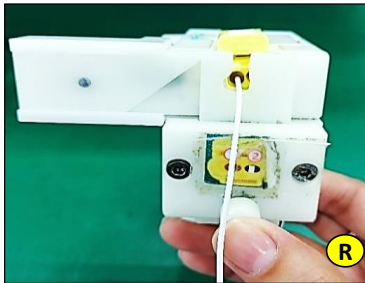
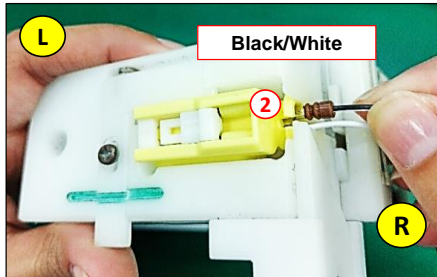

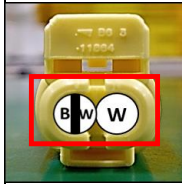
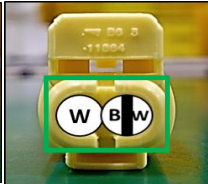
WI-ENG-PDE-1107

Revision No.:

1

Page No.:

3 of 5

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><div>TERMINAL FACING</div></div><div><div><div>1. Get the White wire and insert to terminal slot 1 using right hand.</div></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><div>3. Get the Black/White wire and insert to terminal slot 2 using right hand.</div></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></div></div></div></div></div>			n/a	<div><div>Connector Orientation Illustration</div><div><div>NG</div><div>GOOD</div></div><div><div></div><div></div></div><div><div>Document references:</div><div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div></div></div>

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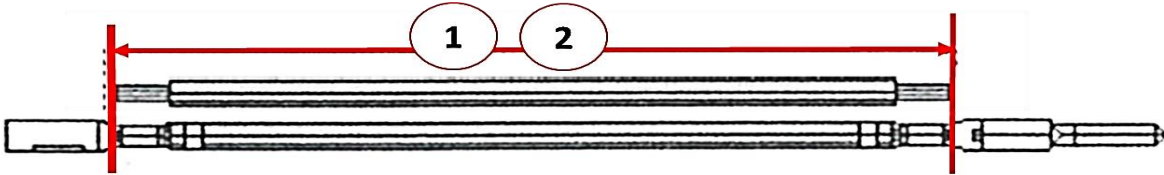


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Revision No.:

1

Page No.:

4 of 5

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></div> <div></div>	<div>MEASURING TAPE</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>	

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Page No.:

5 of 5

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION

7N0208-7020Aa



① No Unlock/Halflock Connector

② No Wrong Insertion

③ No Missing Black COT

④ No Terminal Backing Out

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