			WORK INSTRUCTION									Effectivity Date:			March 4, 2022			
			Process Name/Title: OFFLINE ASSEMBLY PROCESS									Validity Date:			n/a			
			Model Code/Part Number:	550B	/ 7L0083-70	23	Customer:	TRQS	3	Do	Document No.:		WI-ENG-PDE-448			ţ		
			Purpose:	☐ PR	ОТОТҮРЕ		PRE-LAUNCH	MASS	SPRO	Re	vision No.:		0	Pag	e No.:	1 of 3		
ļ-		ı								•		1						
PARTS:		1. All pa	1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B wires L=799mm±3mm									JIG:	1. Insertior	. Insertion jig				
N	Ο.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION							TOOLS	/PPE	QUALITY POINTERS					
			Table Lay-out		Connector 6098-3802 (W)/Connector tray					Safety Instruction Be sure to wear required 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.			Note: Refer to WI-PRO-CNC- 017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools					
	-	1			Revision Hist	ory			1			Prepared by	y: Check	ed by:	Approved by:	Noted by:		
03/4/22	0	Initial Issu	e.					K. Doria	J. Loterte	C. Villanue	va A. Arañes	N. Doria	J. Ld	terte C	. Villanueva	A. Aranes		

Revised Checked Approved

Noted Est. Date:

March 4, 2022

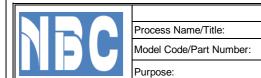
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Details of Change



WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS 7L0083-7023 Customer: TRG

TRQSS

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PRE-LAUNCH

MASSPRO

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PARTS: 1. Connector 6098-3802 (W) JIG 1. Insertion jig **PROCESS NAME WORK PROCEDURE/ ILLUSTRATION** TOOLS/PPE **QUALITY POINTERS** NO. **Connector Orientation** Insertion jig Lock Illustration Holes Holes I-mark is 2 Holes are Lock align Connector orientation open. I-mark I-mark Insertion jig orientation Connector Lock Connector Lock All Holes are I-mark is not align open. Connector setting to

insertion jig 6098-3802 (W)

2

1. Press the lock of insertion jig using left thumb.

2. Get the connector 6098-3802 (W) and insert into jig using right hand and release the lock using left hand.

Press



3. Check the holes/terminal slot for B/B wires.

Use provided jig per model

- 2. No wrong usage of parts
- 3. No wrong orientation of connector
- 4. No damaged connector

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			March 4, 2022											
		Process Name/Title:	Effectivity Date: Validity Date:		n/a									
		Model Code/Part Number:				E ASSEMBLY PROCE 23 Customer:		SS	Document No.:		WI-ENG-PDE-448			
		Purpose:	☐ PRO	OTOTYPE	: 🗆	PRE-LAUNCH	MAS	SSPRO	Revision No.:		0	Page No.:	3 of 3	
	ı										1			_
PARTS:	2. AVS	Sf 0.3 B wires L=799mm±3m	nm [2 pcs]							JIG	1. Insert 2. Locki			
NO.	F	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/	QUALITY POINTERS				
3		Wire insertion to connector 6098-3802 (W)	Slot 1 of conne	ector usi	Black ire and insert to no right hand	thumb, hold the	k wire and insert t	sing left pull out the	N/A		for W. Tolera Note: for Pu 1. No loo 2. No wi 3. One b 4. No de 5. No wi Make su Conduct insertion	Refer to GI Refer to GI III-Push pro ose insertion ong insertion by one insert formed term ong wire factors wire sare progressives.	-PRO-ASY-029 cedure. on inal ing properly inserted. cull-Push after	
4		Connector lock	thumb then p connector loc pressed.	oress to l ck to con	o locking jig using both lock 2x. Check the firm if properly	Before pressing After pressing	GOOD Full Lock	NG Half Lock	Locking	jig	connect Manual damag	al locking mo ged lock. llock/half-loc rovided jig to	ol to lock the ny cause ked connector ool to lock the	

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Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.