



WORK INSTRUCTION

KITTING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 840B / 1 7N0121-7020B

Customer: TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

December 18, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-333

Revision No.:

1

Page No.:

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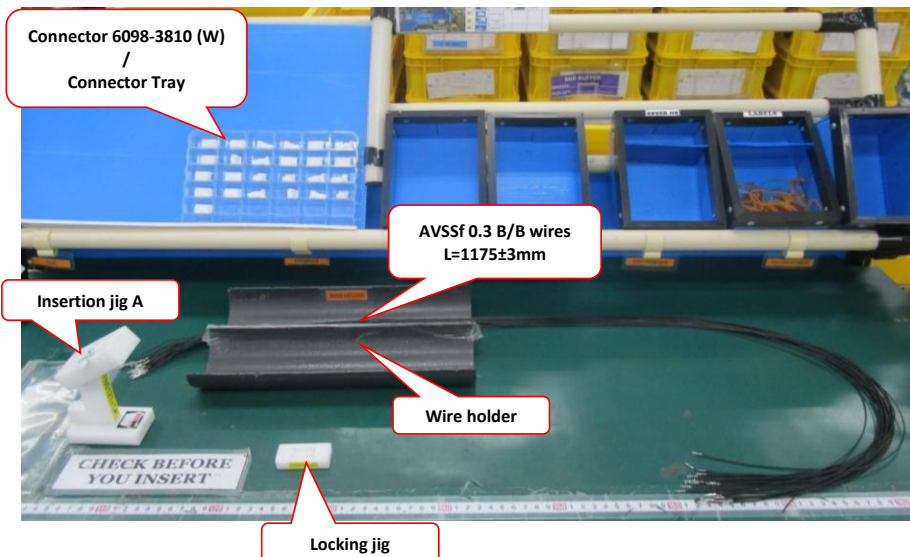
PARTS:

1

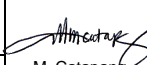
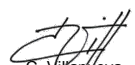
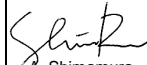

1. All parts: Connector 6098-3810 (W); AVSSf 0.3 B/B L=1175±3mm

JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	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.	Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
12/18/21	1	Change part number from 7N0121-7020A to 7N0121-7020B due to change orientation of clamp. Additional quantity of band clamp 82711-12A60 (W) from n=4pcs. to n=5pcs; Reduced quantity of clamp 82711-12A80 (W) from n=4pcs. to n=3pcs Refer to WI-ENG-PDE-319B. Additional checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance).	M. Catapang	J. Loterte	A. Shimamura	A. Arañes				
09/10/21	0	Initial issue	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2021		

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840B

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PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

n/a

Connector setting to
insertion jig
6098-3810 (W)

INSERTION JIG

Holes

Lock

I-MARK

Connector lock

Connector

INSERTION JIG ORIENTATION

L

R

Press

Press

Release

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

2. Get the connector **6098-3810 (W)** using right hand then insert to jig using right hand and release the lock using left thumb.
Note: Follow the connector orientation.

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

n/a

Connector Orientation Illustration

I-mark is align

1 hole is open

GOOD

I-mark is

1 hole is open

NG

1. 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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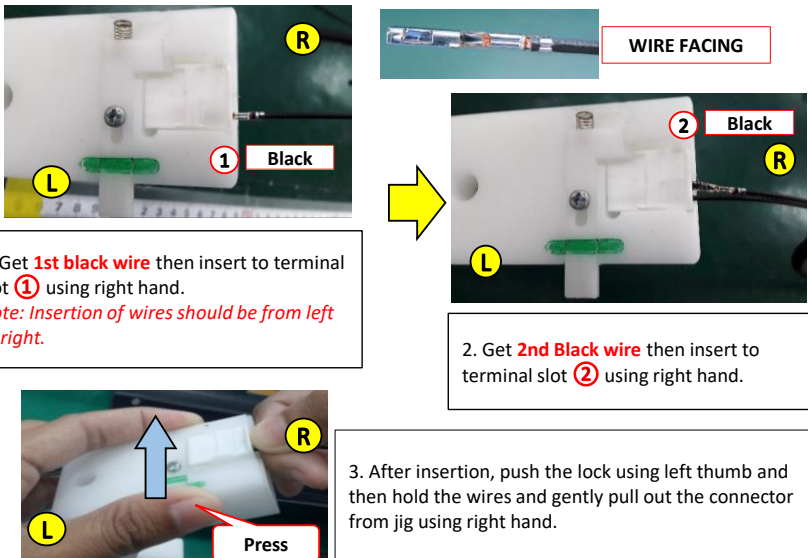

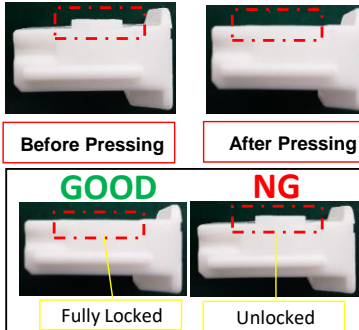

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PARTS:

1. AVSSf 0.3 B/B L=1175±3mm [2pcs.]
2. Assy parts

JIG

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Connector 6098-3810 (W)	 <p>1. Get 1st black wire then insert to terminal slot ① using right hand. <i>Note: Insertion of wires should be from left to right.</i></p> <p>2. Get 2nd Black wire then insert to terminal slot ② using right hand.</p> <p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p>	n/a	<p>1. Insertion jig 2. Locking jig</p> <p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>Note: Please hold the wire near terminal during insertion.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>
4	Connector lock	 <p>1. Put the connector into locking jig using both thumb then press to lock 2x using both hands. Touch the connector lock to confirm if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p>  <p>Before Pressing After Pressing</p> <p>GOOD NG</p> <p>Fully Locked Unlocked</p>	<p>LOCKING JIG</p> 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</p> <p>1. Use provided jig tool per model to avoid damaged lock. 2. No unlock/half-locked connector 3. No damaged lock</p>

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