

**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

May 05, 2022Model Code/Part Number: **724W / 7H0352W7020C** Customer: **NBS**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-476

Revision No.:

1

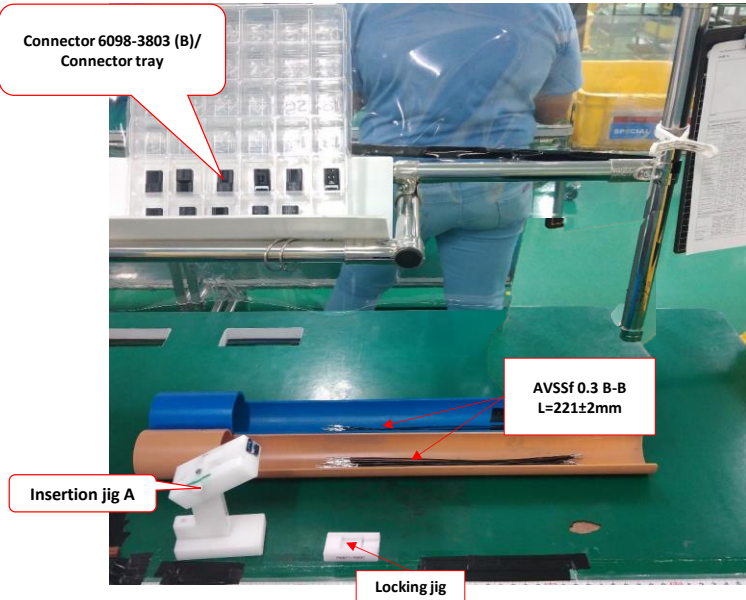
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1 of 3**PARTS:**

1. Connector 6098-3803 (B); AVSSf 0.3 B-B L=221±2mm

JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<p>Table Lay-out</p>  <p>Connector 6098-3803 (B)/ Connector tray</p> <p>AVSSf 0.3 B-B L=221±2mm</p> <p>Insertion jig A</p> <p>Locking jig</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
05/05/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/19/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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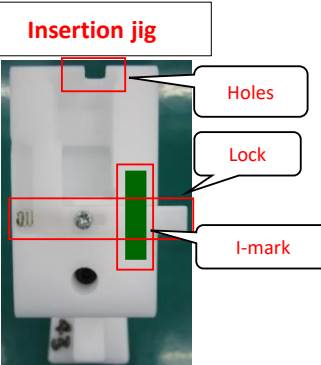
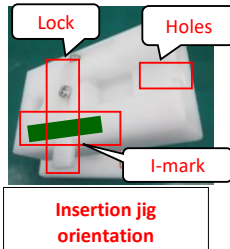


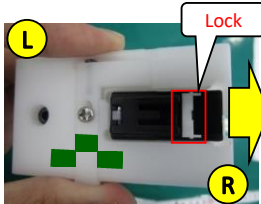
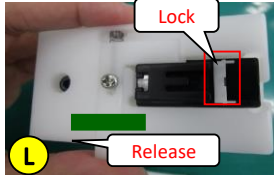


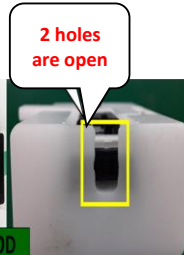


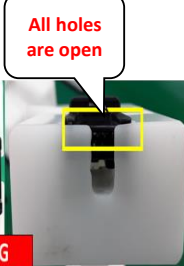


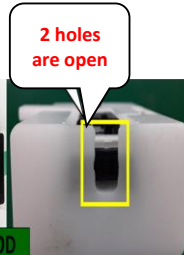


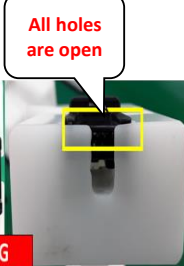

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PARTS:		1. Connector 6098-3803 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to Insertion jig 6098-3803 (B)	<div><div></div><div></div><div></div><div>Connector orientation</div></div> <div><div></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the connector 6098-3803 (B) using right hand then insert to jig using right hand and release the lock using left thumb. <i>Note: Follow the connector orientation.</i></p><div></div><div><p>3. Check the holes/terminal slot for 2 Black wires.</p></div></div></div> <div>n/a</div> <td><div>Connector Orientation Illustration</div><div></div><div></div><div></div><div></div><div></div><div></div><div><p>1. Use provided jig per model</p><p>2. No wrong usage of parts</p><p>3. No wrong orientation of connector</p><p>4. No damaged connector</p></div></td>		<div>Connector Orientation Illustration</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div><p>1. Use provided jig per model</p><p>2. No wrong usage of parts</p><p>3. No wrong orientation of connector</p><p>4. No damaged connector</p></div>	

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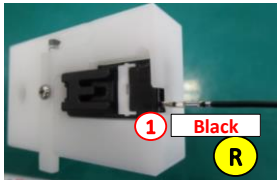
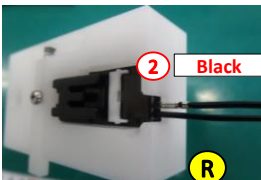
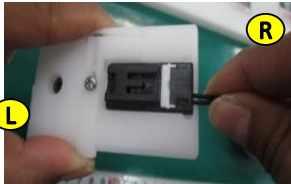


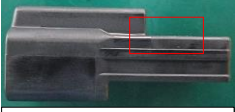



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PARTS:	1. AVSSf 0.3 B L=221±2mm [2pcs.]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3803 (B) n/a	    Wire facing 1 Black (R) 2 Black (R) 1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand. <i>Note: Insertion of wires must be from left to right</i> 2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand. 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.		n/a	<i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force." <i>Note: Please hold the wire near terminal during insertion.</i>
4	Connector lock	     1. Put the connector into locking jig using both hands then press 2x using both hands. Touch the connector lock to confirm if properly locked. <i>Refer to GL-PRO-ASY-017 for the verification of lock.</i> Before pressing After pressing GOOD NG Full Lock Half Lock		LOCKING JIG 	<i>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</i> 1. Use the provided locking jig per modle 2. No unlocked/half-locked connector 2. No damaged lock

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