

	<b>WORK INSTRUCTION</b>						Effectivity Date:		December 18, 2021	
	<b>KITTING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Process Name/Title:				Product Name/Code: <b>840B / 1 7N0120-7020B</b>		Customer: <b>TRJ</b>		Document No.: <b>WI-ENG-PDE-332</b>	
	Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.: 1 of 3

<b>PARTS:</b>	1. All parts (Connector 6098-3810 (W); AVSSf 0.3 B/B L=1175±3mm )				<b>JIG:</b>	1. Insertion jig 2. Locking jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Table Lay-out		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. No missing parts/tools 2. No excess parts/tools  <i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> <span style="border: 1px solid black; padding: 2px;">1</span>

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
12/18/21	1	Change part number from 7N0120-7020A to 7N0120-7020B due to change in clamp (82711-12A80(W) (82711-12A60 (W) location and quantity. Refer to (WI-ENG-PDE-318B). Additional checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance). Improve work procedure in all process.	K. Doria	J. Loterte	C. Villanueva	A. Arañes									
09/10/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Est. Date:	September 10, 2021							

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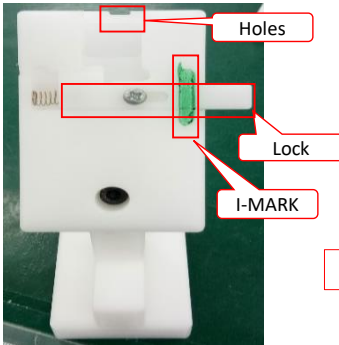


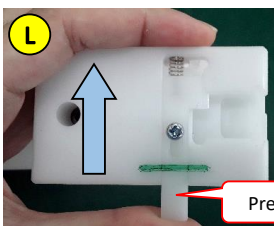
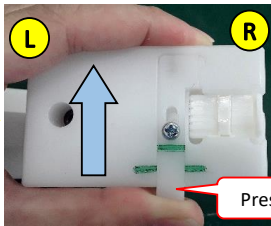
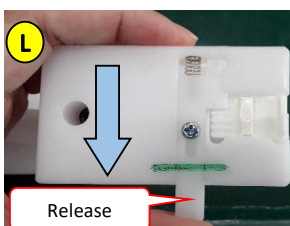



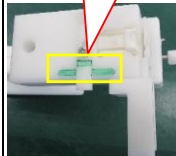



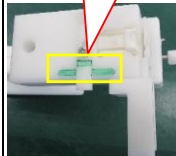

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PARTS:		1. Connector 6098-3810 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector setting to insertion jig 6098-3810 (W)	<div><div><div>INSERTION JIG</div><div></div></div><div><div>Connector lock</div><div></div><div>Connector</div></div><div><div>INSERTION JIG ORIENTATION</div><div></div></div></div> <div><div><div><div><div>L</div><div></div><div>Press</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div></div><div><div><div><div>L</div><div></div><div>Press</div></div><div><div>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb.</div><div>Note: Follow the connector orientation.</div></div></div><div><div><div><div>L</div><div></div><div>Release</div></div><div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div></div><div><div></div></div></div><div>n/a</div><td><div><div>Connector Orientation Illustration</div><div><div><div>I-mark was</div><div></div></div><div><div>1 hole is open</div><div></div></div></div><div>GOOD</div><div><div><div>I-mark is</div><div></div></div><div><div>1 hole is open</div><div></div></div></div><div>NG</div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div></td></div></div>		<div><div>Connector Orientation Illustration</div><div><div><div>I-mark was</div><div></div></div><div><div>1 hole is open</div><div></div></div></div><div>GOOD</div><div><div><div>I-mark is</div><div></div></div><div><div>1 hole is open</div><div></div></div></div><div>NG</div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div>	

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### KITTING ASSEMBLY PROCESS

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Product Name/Code:

840B

/ 1

7N0120-7020B

Customer:

TRJ

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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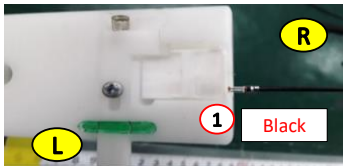
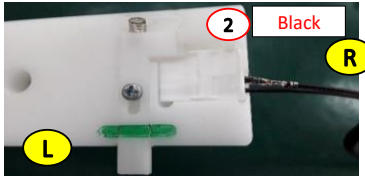
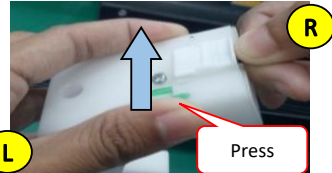


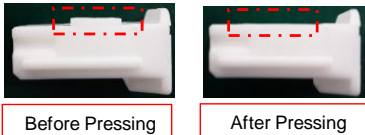
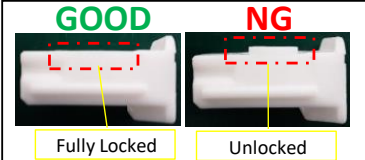

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**PARTS:**

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 <b>1st black wire</b> then insert to terminal slot <b>①</b> using right hand. <b>Note : Insertion should be from left to right.</b></p> <p>2. Get <b>2nd Black wire</b> then insert to terminal slot <b>②</b> 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	<ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol> <p>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b> </p> <p><b>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>
4	Connector lock	   <p>Put the connector into locking jig using both thumb then press to lock <b>2x</b>. Touch the connector lock to confirm if properly pressed. <b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p>	<b>LOCKING JIG</b> 	<p><b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b></p> <ol style="list-style-type: none"><li>1. Use provided jig tool per model to avoid damaged lock.</li><li>2. No unlock/half-locked connector</li><li>3. No damaged lock</li></ol>

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