



WORK INSTRUCTION

Effectivity Date:

November 4, 2024

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

840B / 7N0121-7021

Customer:

TRJ

Document No.:

WI-ENG-PDE-626

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

1 of 5

PARTS:

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	Offline	Table Lay-out	<div>Table Lay-out</div> <div><div>Connector 6098-3810 (W) / Connector Tray</div><div>AVSSf 0.3 B-B wires L=1175±3mm</div><div>Insertion jig</div><div>Wire holder</div><div>Locking jig</div><div>CHECK BEFORE YOU INSERT</div></div>				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>1. No missing parts/tools 2. No excess parts/tools</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>				
			Revision History										
11/04/24	2	Improve measurement and visual inspection. Removal of by two's inspection.				A. Hernandez	C. Villanueva	A. Arañes	n/a	Prepared by	Reviewed by	Approved by	Noted by
02/06/23	1	Change purpose from pre-launch to Masspro. Inclusion of quality checkpoints				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	<div>A. Hernandez</div>	<div>C. Villanueva</div>	<div>A. Arañes</div>	n/a
01/19/23	0	Initial issue Clamp 82711-12A60 (W) quantity from 5pcs. to 4pcs. Clamp 82711-52070 (W)				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	January 19, 2023		

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline	<div><div>INSERTION JIG</div><div></div><div></div><div></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>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.</p></div><div></div></div>		n/a	<div><div>Connector Orientation Illustration</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></div>

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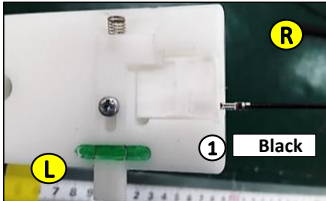
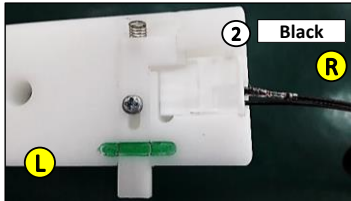


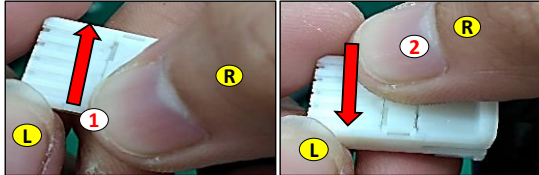



3 of 5

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)	<div><p>Wire Facing</p></div> <div><p>1. Get 1st black wire then insert to terminal slot ① using right hand.</p></div> <div><p>2. Get 2nd Black wire then insert to terminal slot ② using right hand.</p></div> <div><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></div>	n/a	<ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Make sure wires are properly inserted.2. Conduct Pull-Push-Pull-Push after insertion.Do not exert extra force.4. Insertion of wires must be from left to right <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
4	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>Before Pressing</p></div> <div><p>After Pressing</p></div>	<div><p>Locking Jig</p></div>	<ol style="list-style-type: none">1. Use the provided locking jig per model2. No unlock/half-locked connector <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Manual Locking may cause connector damaged

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Page No.:

4 of 5

PARTS:

1. Assy parts

JIG

1. Measuring tape

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

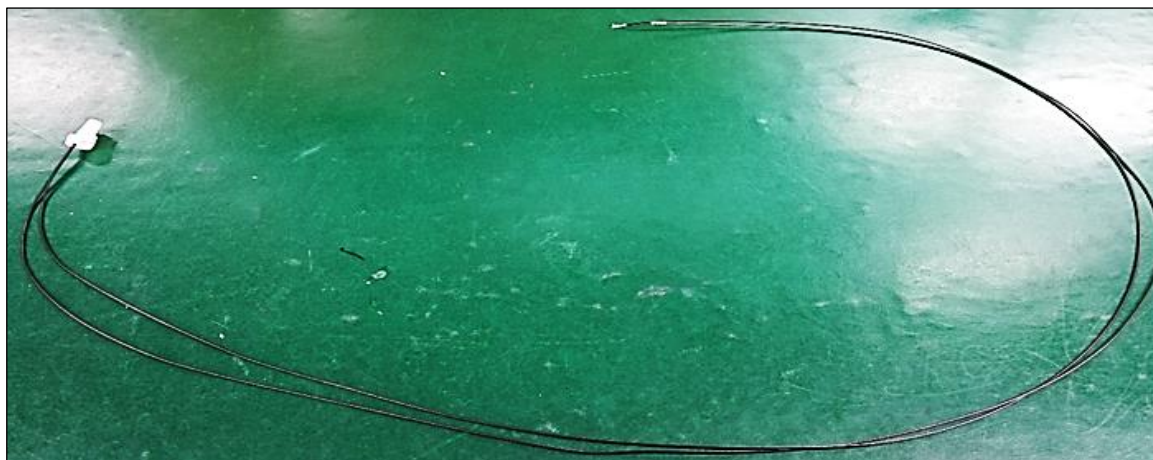
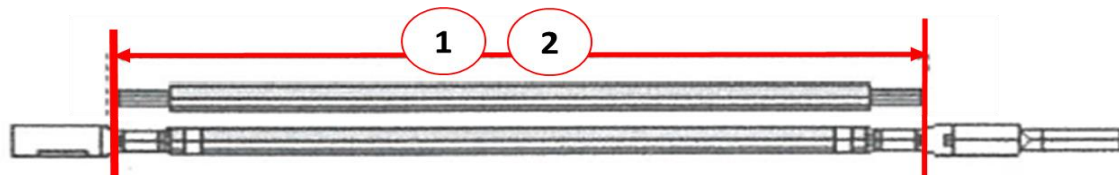
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Offline

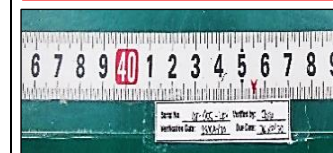
Measurement

Note:

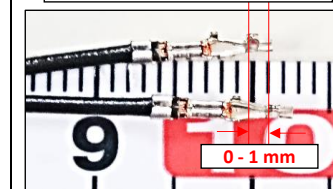
1. Measurement point: End of core wire to the end of core wire
2. Terminal is reference only.



MEASURING TAPE



Wire alignment tolerance



Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

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5 of 5

PARTS:

n/a

JIG

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

Offline Assembly

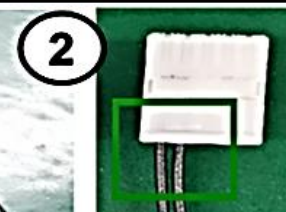
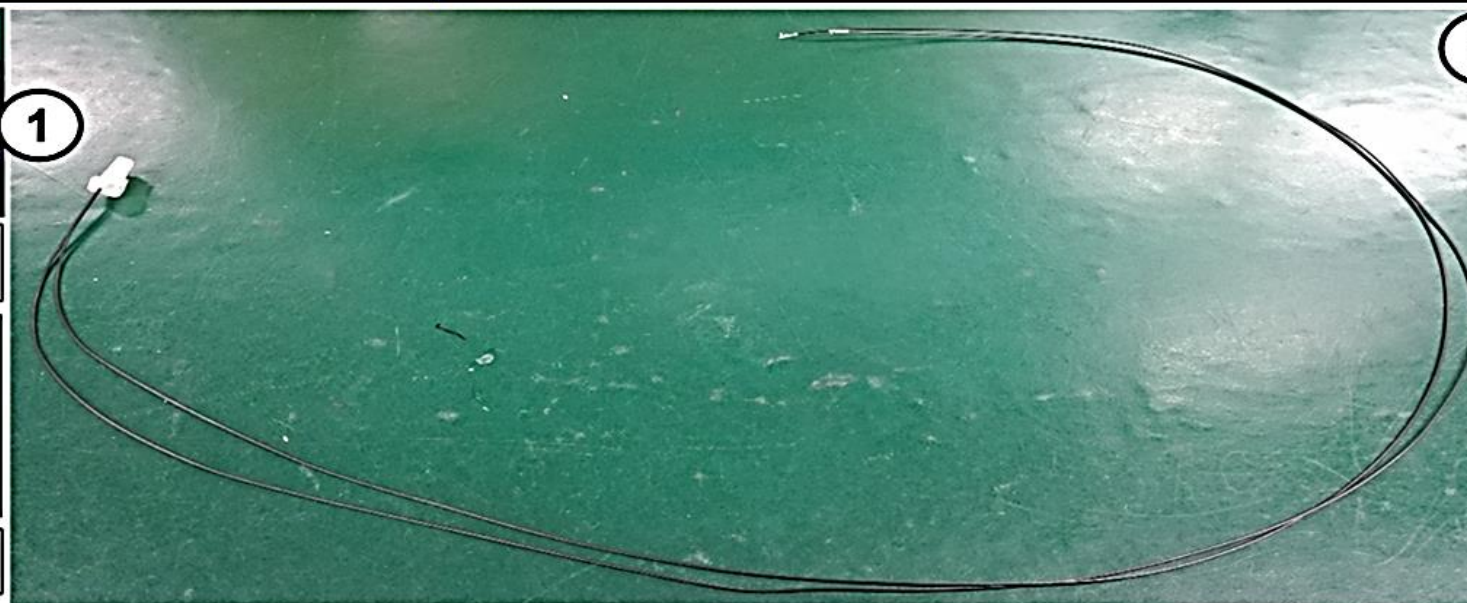
7N0121-7021



GOOD



NO GOOD



GOOD



NO GOOD

- ① No Unlock/Half-Lock/Damaged Connector
- ② No Wrong Insertion

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