

**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

November 25, 2022

Model Code/Part Number:

310B / 7M0557-7021

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:


WI-ENG-PDE-554

Revision No.:

1

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PARTS:	1. Connector 6198-0451(W) 2. Black Vinyl tube ø5 L=273±3mm		3. TVSSf 0.3 G-B/W L=549±3mm	JIG:	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<div>Table Lay-out</div> <div></div>		<div>Safety Instruction Be sure to wear required 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:  <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div>

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	Reviewed by	Approved by	Noted by
11/25/22	1	Improve Quality pointers: Reminders/notes and references on pages no.1,3 and 4 due to documents improvement.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
06/29/22	0	Initial Issue. Excluded from WI-ENG-PDE-415A due to Process Improvement. Additional Table lay-out	M.Ariola	J. Loterte	C. Villanueva	A. Arañes		June 29,2022		

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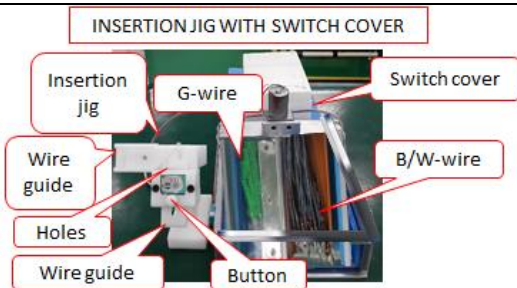
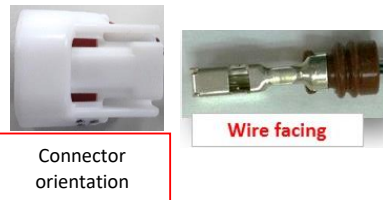
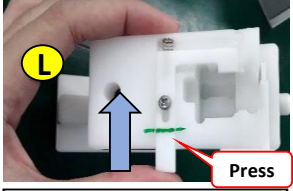
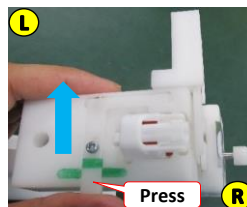
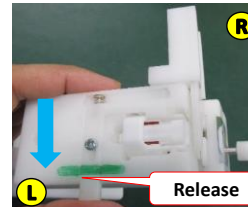
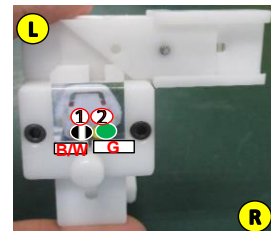
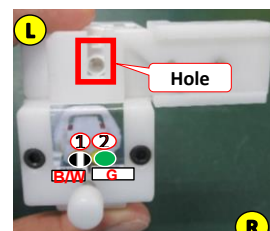


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PARTS:		1. Connector 6189-0451 (W)		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<p>Connector setting to insertion jig 6189-0451 (W)</p>        <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector 6189-0451 (W) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p> <p>3. Push the guide using left hand. The slot for B/W wire will be opened.</p>		n/a	<p>Connector Orientation Illustration</p>   <p>GOOD</p> <p>NG</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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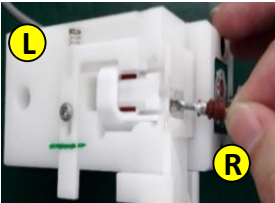
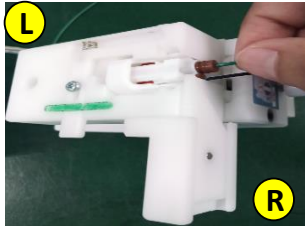
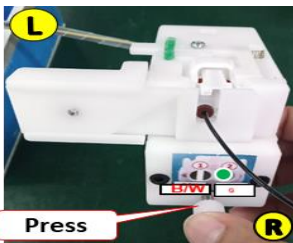
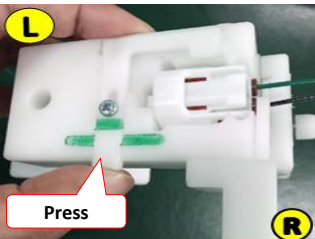
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1

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PARTS:	1. TVSSf 0.3 G-B/W L=549±3mm			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6189-0451 (W)	<div> Wire facing</div> <div> 1. Get the B/W wire then insert to terminal slot ① using right hand.</div> <div> 3. Get the G wire then insert to terminal slot ② using right hand.</div> <div> 2. After insertion of B/W wire press the button using right hand. The slot for G wire will be opened.</div> <div> 4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>1 Important reminders/note/s: 1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>1 Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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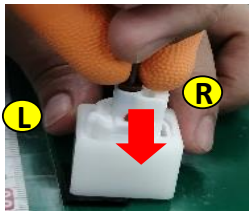

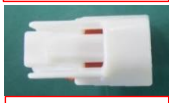


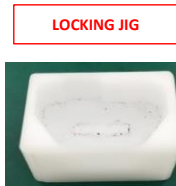


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PARTS:		1. Assy parts 2. Black Vinyl tube Ø5 L=273±3mm			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Connector lock	 <div>1. Put the connector into locking jig then press 2x using both hands. Check the lock if properly locked.</div>  BEFORE PRESSING  AFTER PRESSING  GOOD  NG <div>Check the double lock deformation</div>				<div>1. No half-locked and unlock 2. No lock deformation 3. Use provided jig tool to lock the connector</div> <div>Important reminders/Note/s: </div> <div>1. Manual locking may cause damaged connector lock</div>
5	Wire insertion to Black vinyl tube Ø5 L=273±3mm	 <div>1. Get the Black vinyl tube Ø5 L=273±3mm using right hand then insert the wires using left hand.</div>			n/a	1. No wrong use of parts

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