

**WORK INSTRUCTION**

Effectivity Date:

May 5, 2022

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: **724W / 7H0350W7020D**

Customer:

NBS

Document No.:

WI-ENG-PDE-474

Purpose:

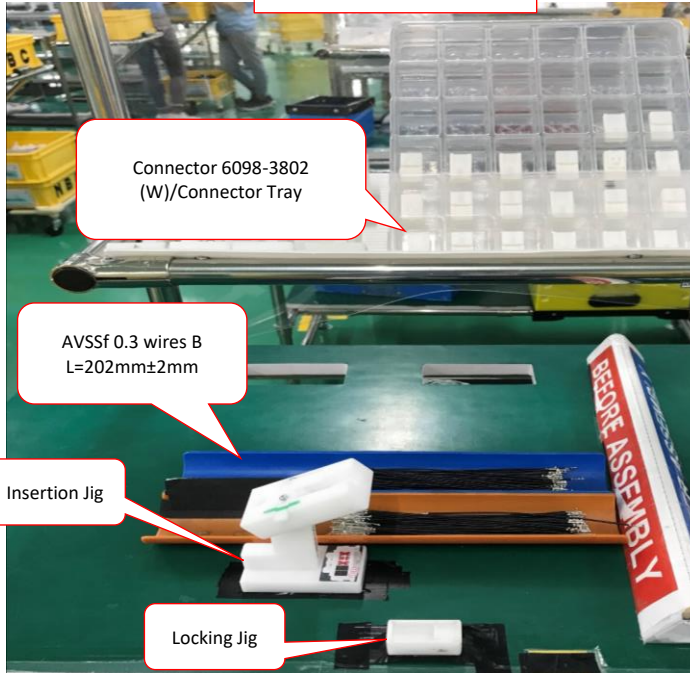
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Connector 6098-3802 (W); AVSSf 0.3 wires B L=202mm±2mm				JIG:	1. Insertion jig 2. Locking jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	n/a	<div><p>TABLE LAY-OUT</p></div>				<div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><p>Housekeeping</p><p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p></div> <div><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>		<div><p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance.</i></p></div> <p>1. No missing parts/ tools. 2. No excess parts/tools.</p>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/5/22	1	Change Pre-launch to Masspro.				K. Doria	J. Loterte	C. Villanueva	A. Arañes
04/19/22	0	Initial Issue.				K. Doria	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted
						Est. Date:	April 19, 2022		

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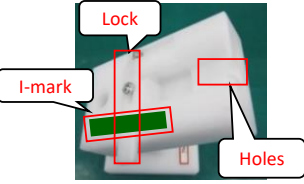
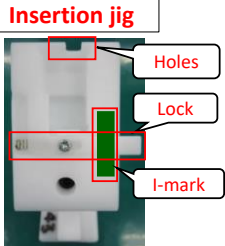
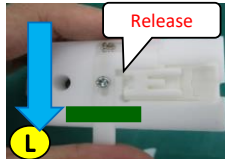
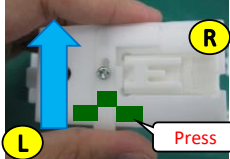
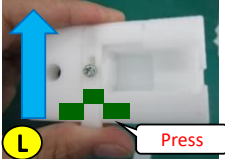
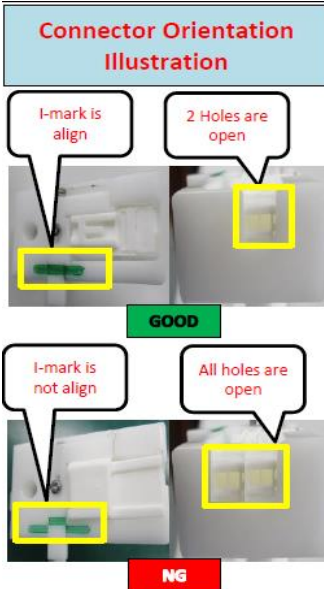
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PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector Setting to Insertion jig 6098-3802 (W)	<div><p>CONNECTOR ORIENTATION</p><p>INSERTION JIG ORIENTATION</p></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the Connector 6098-3802 (W) into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for 2 Black wires.</p></div>		n/a	<div><p>Connector Orientation Illustration</p><p>I-mark is align 2 Holes are open GOOD</p><p>I-mark is not align All holes are open NG</p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

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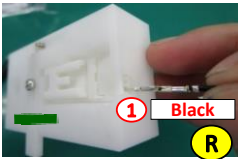
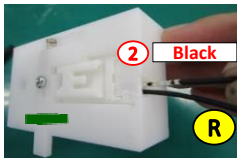
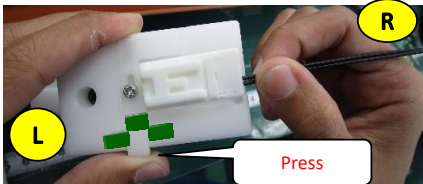





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PARTS:		1. AVSSf 0.3 wires B L=202mm±2mm [2pcs]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the first black wire and insert to connector using right hand. Conduct one by one insertion from left to right.</p></div> <div><p>2. Get the 2nd black wire and insert to connector 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	<div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
4	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press to lock 2x. Refer to GL-PRO-ASY-017 for verification of connector lock.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>GOOD</p><p>Full Lock</p></div> <div><p>NG</p><p>Half Lock</p></div>			LOCKING JIG	<div>1. Use the provided jig per connector 2. No unlock/half-locked coupler</div> <div>Note: Manual locking may cause damaged lock.</div>

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