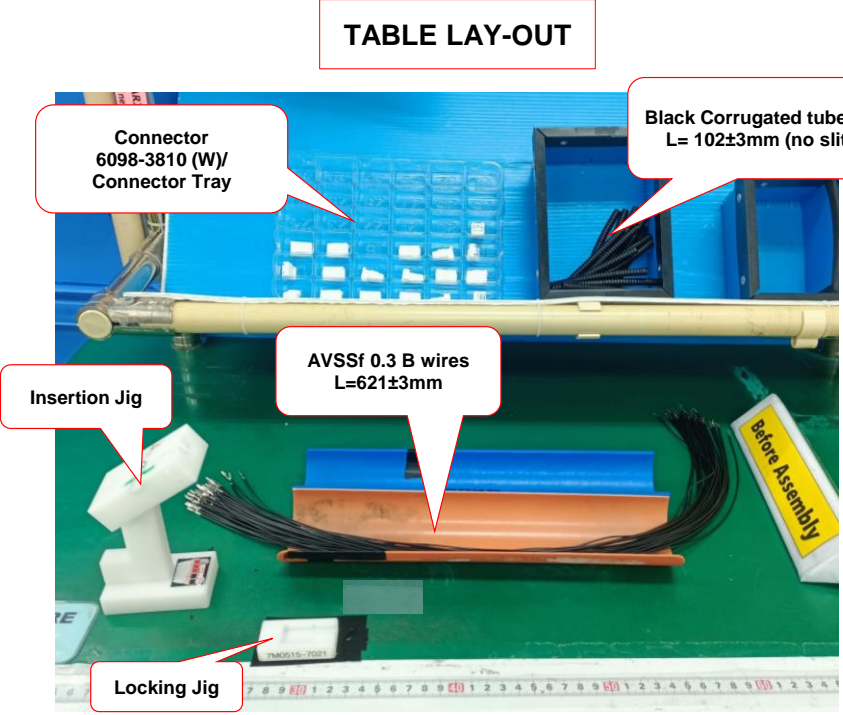
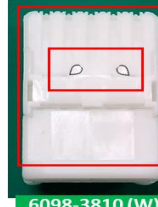
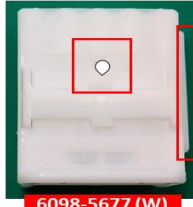


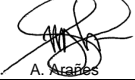
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ	Car Model: SUBARU	Document No.:		WI-ENG-PDE-1145	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 7

PARTS:	1. All parts: Connector 6098-3810 (W); AVSSf 0.3 B wires L=621±3mm; Black Corrugated tube ø5 L=102±3mm (no slit)			JIG:	1. Insertion Jig 2. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	OFFLINE	<p>TABLE LAY-OUT</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>1. No missing parts/tools 2. No excess parts/tools</p> <p>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</p> <p>CONNECTOR ILLUSTRATION</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>GOOD</p>  <p>6098-3810 (W)</p> </div> <div style="text-align: center;"> <p>NG</p>  <p>6098-5677 (W)</p> </div> </div>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/30/24	1	Change from Pre-launch to Masspro. Inclusion of Measurement.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/29/24	0	Initial issue.	D. Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 29, 2024		

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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	OFFLINE	Connector Setting to Insertion jig 6098-3810 (W)		n/a	<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are widely open</div></div><div><div>GOOD</div></div></div><div><div><div>I-mark is not align</div><div>2 holes are partially open.</div></div><div><div>NG</div></div></div></div> <div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div>NG</div><div>6098-5677 (W)</div></div></div></div>

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	Process Name/Title:		Model code/Part number: ES1 / 7M0515-7021B		Customer: TRJ	Car Model: SUBARU		Document No.: WI-ENG-PDE-1145
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	3 of 7	

PARTS:		1. Black Corrugated tube ø5 L= 102±3mm (no slit) 2. AVSSf 0.3 B L=621±3mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	<div><div>1. Get Black corrugated tube ø5 L=102±3mm (No slit) using left hand and get 2pcs of Black wire L=621±3mm then insert using right hand.</div></div>		n/a	1. No Wrong use of parts 2. No deformed terminal

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☐ PRE-LAUNCH


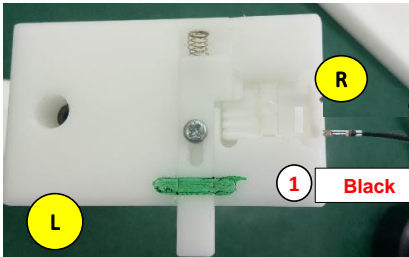
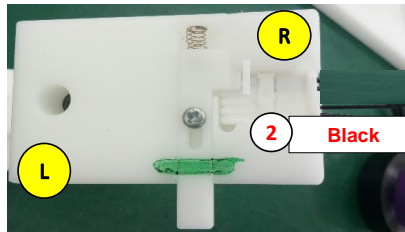
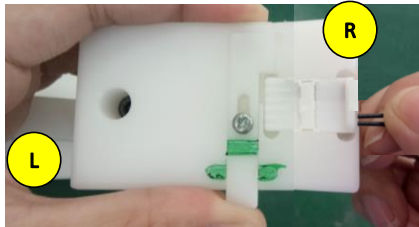
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	OFFLINE	<div><div></div><div>Wire facing</div></div> <div><div></div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</div></div> <div><div></div><div>2. Get the 2nd Black wire and insert to Slot 2 of connector using right hand.</div></div> <div><div></div><div>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.</div></div>		n/a	<div>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

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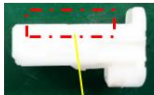
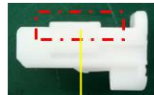
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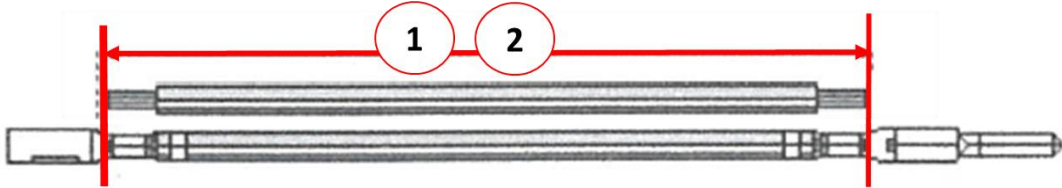
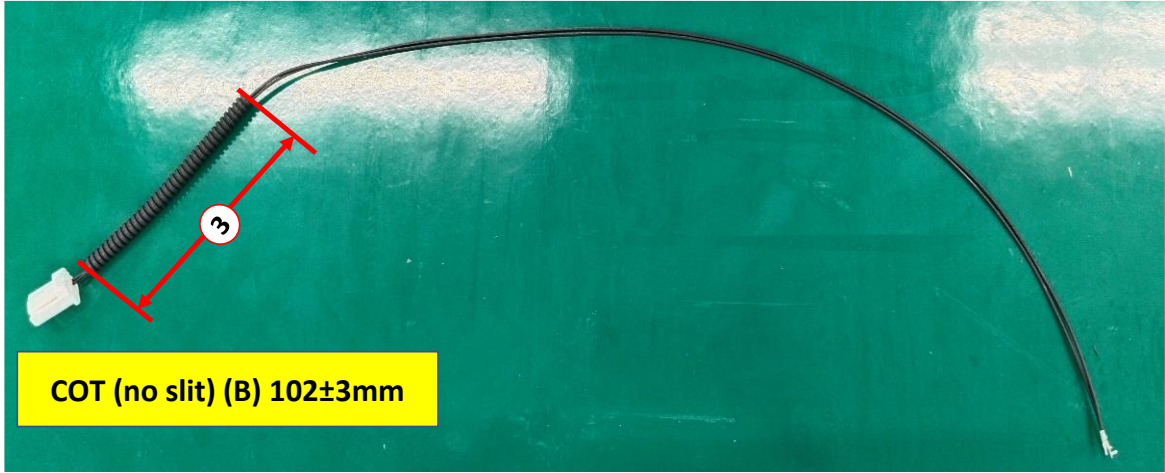
PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	Connector lock			<div>1. Use provided jig tool per model to avoid damaged lock. 2. No Unlock and half-locked connector 3. No damaged lock</div> <div>Important reminders/Note/s: 1. Manual locking may cause damaged connector lock.</div> <div><div>LOCK CONDITION</div><div><div><div>GOOD</div><div></div><div>Fully Locked</div></div><div><div>NG</div><div></div><div>UnLocked</div></div></div></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	6 of 7

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
6	OFFLINE	Measurement	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>			
		<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>   <p>COT (no slit) (B) 102±3mm</p>					

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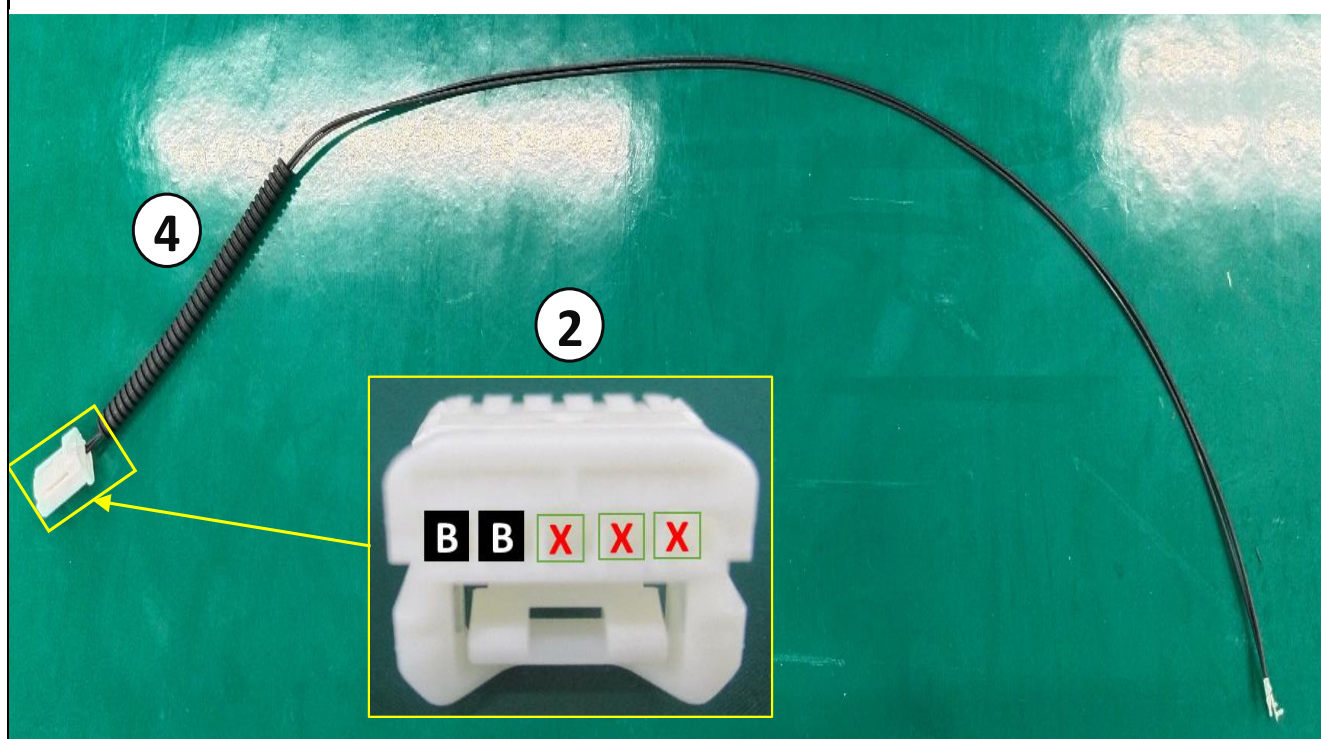
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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7M0515-7021B**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Missing COT**

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