

	WORK INSTRUCTION				Effectivity Date:		June 5, 2023	
	Process Name/Title: 3 OFFLINE ASSEMBLY PROCESS				Validity Date:		-	
	Model Code/Part Number: 310B / 7M0526-7020C		Customer: TRJ		Document No.:		WI-ENG-PDE-105	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 5

PARTS:	1. Connector 6098-3803 (B) 2. AVSSf 0.3 wires B L=221±2mm				JIG:	1. Insertion jig 2. Locking jig			
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NO.	PROCESS NAME	3	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a		<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Please refer to WI-PRO-CNC-017 for wire and strip length tolerance. 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
6/5/2023	3	Inclusion of Table lay-out; important reminders and note/s; Document references; Quality checkpoints. Improve work procedure / illustration on process connector lock; change title from kitting assembly process to offline assembly process	J. Loterte	C. Villanueva	A. Arañes	n/a				n/a
04/27/21	2	Remove Validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/22/20	1	Change 2x pulling of wires to pull-push-pull-push method.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	November 21, 2018		

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

3

Page No.:

2 of 5

PARTS:		1. Connector 6098-3803 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<p>Connector Setting to Insertion jig 6098-3803 (B)</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6098-3803 B into jig using right hand and release the lock.</p> <p>3. Check the holes/terminal slot for 2 Black wires.</p>		n/a	<p>Connector Orientation Illustration</p> <p>I-mark is align</p> <p>2 holes are open</p> <p>I-mark is not align</p> <p>All holes are open</p> <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p>

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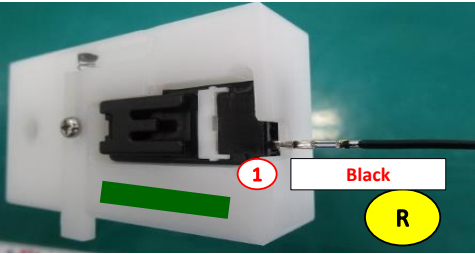
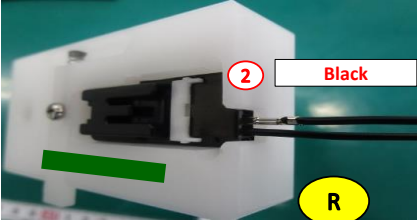
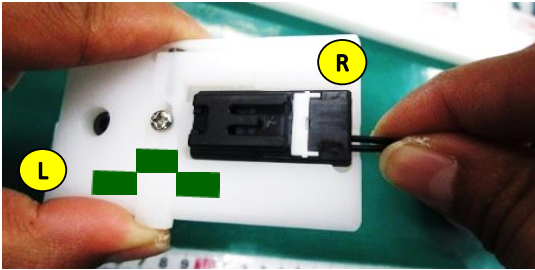

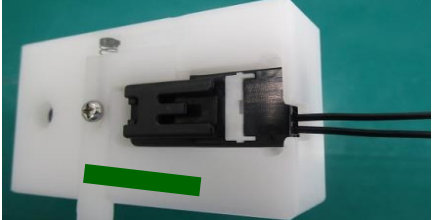
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Revision No.:

3

Page No.:

3 of 5

PARTS:	1. AVSSf 0.3 wires B L=221±2mm [2pcs]			JIG	1. Insertion jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3803 (B)	<div></div> <div></div> <div></div> <div></div> <div></div> <div><p>1. Get the first black wire and insert to connector using right hand. <i>Conduct one by one insertion from left to right.</i></p><p>2. Get the 2nd black wire and insert to connector 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></div>		n/a	<div><p>3</p><p>Important reminders and Note/s;</p><p>1. Make sure wires are properly inserted.</p><p>Conduct Pull-Push-Pull-Push after insertion.</p><p>Do not exert extra force.</p><p>2. Please hold the wire near terminal during insertion.</p></div> <div><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deformed terminal</p><p>5. No wrong wire facing</p></div>

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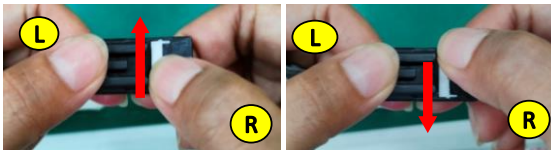

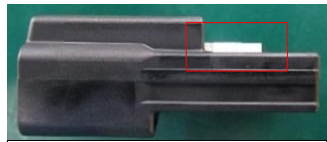
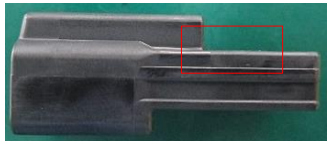


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

4 of 5

PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div><p>LOCKING JIG</p></div>	<div><p>1. Use the provided jig per connector</p><p>2. No unlock/half-locked connector</p></div> <div><p>3 Important reminders and Note/s;</p><p>1. Manual locking may cause damaged lock.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div>

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WI-ENG-PDE-105

Revision No.:

3

Page No.:

5 of 5

PARTS:

n/a

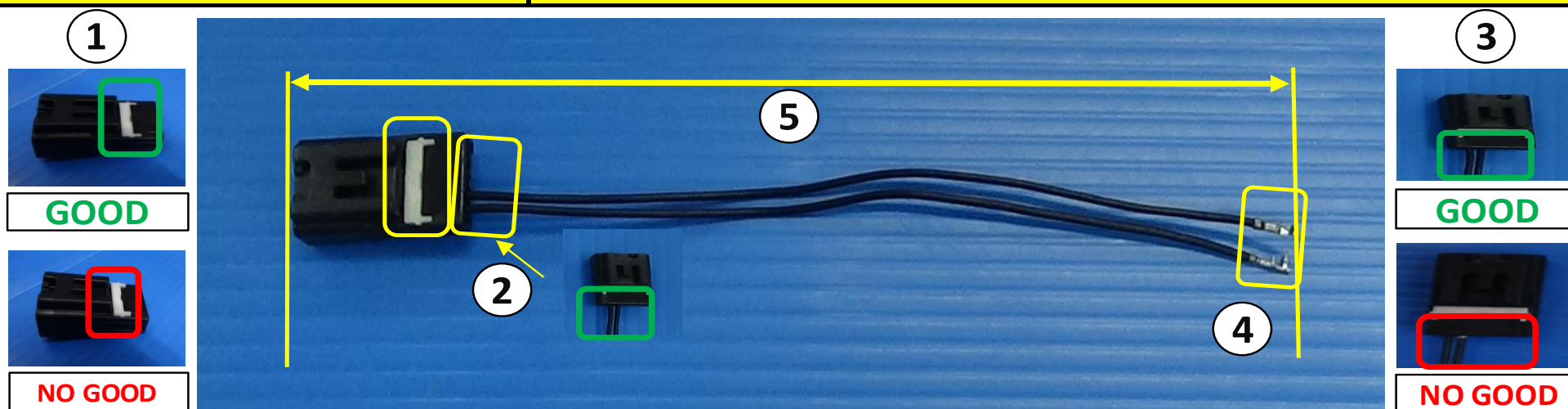
JIG

n/a

3 OFFLINE QUALITY CHECKPOINTS

OFFLINE INSERTION

7M0526-7020C



1 No **Unlock** connector

2 No **Wrong** insert

3 No **Terminal Backing Out**

4 No **Deform** terminal

5 Check the **Alignment**

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