



WORK INSTRUCTION

Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Model Code/Part Number: **715W / 7H0420W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 06, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-511

Revision No.:

1

Page No.:

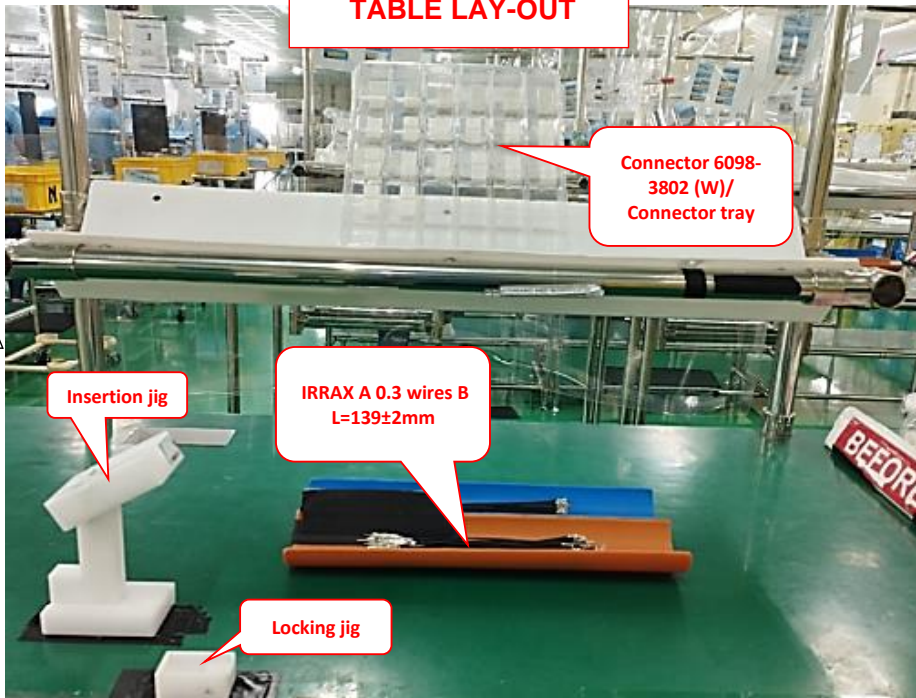
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PARTS:

1. All parts; Connector 6098-3802 (W); IRRAX A 0.3 wires B L=139±2mm

JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<div>TABLE LAY-OUT</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 work place 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>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</div> <div>1. No missing parts/tools. 2. No excess parts/tools.</div>

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
05/06/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	M.Ariola	J. Loterte	C.Villanueva	A. Arañes
05/02/22	0	Initial Issue	M.Ariola	J. Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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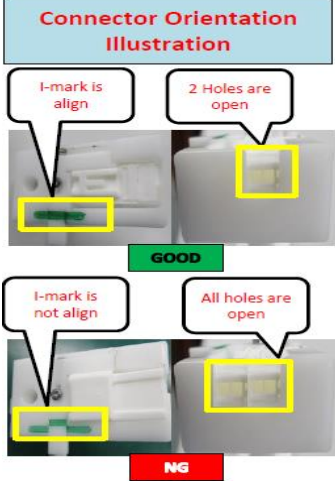
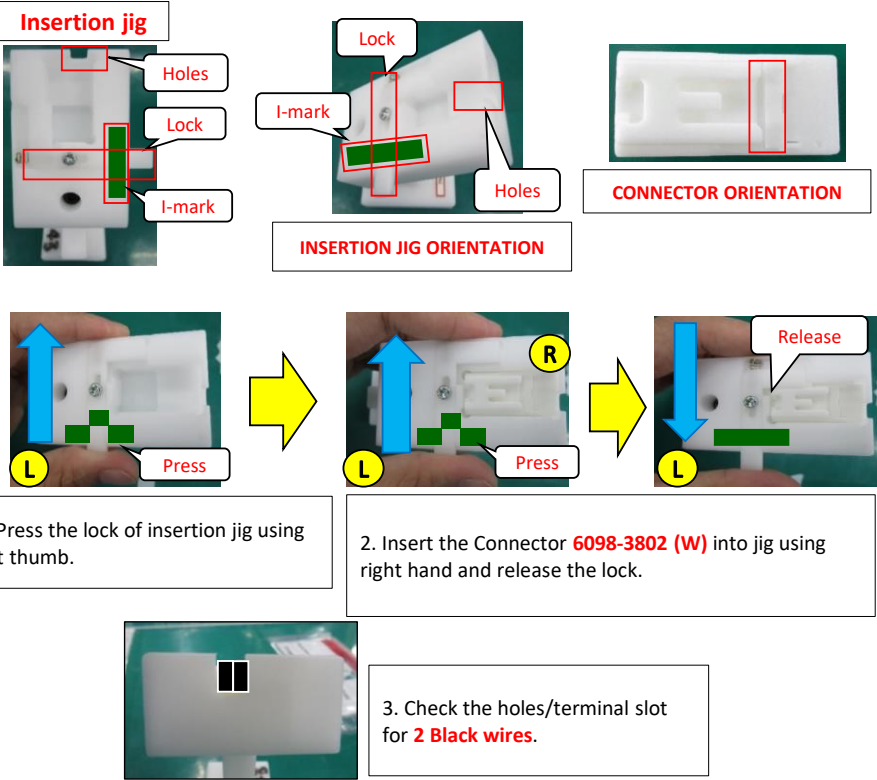
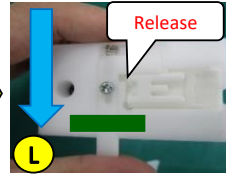
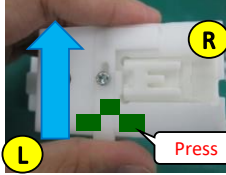
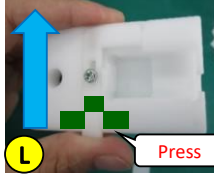


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Model Code/Part Number: **715W / 7H0420W7020** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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>GOOD</p><p>NG</p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

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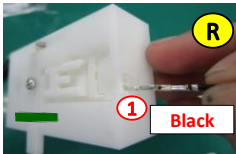
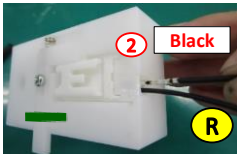
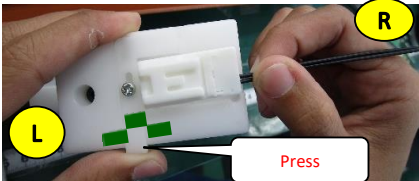

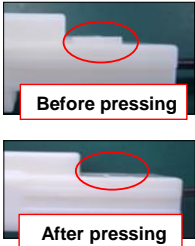



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PARTS:

- 1.Connector 6098-3802 (W)
2. IRRAX A 0.3 wires B L=139±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)	    <ol style="list-style-type: none">1. Get the 1st black wire and insert to connector using right hand. Conduct one by one insertion from left to right.2. Get the 2nd black wire and insert to connector using right hand.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.	n/a	<div>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</div> <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deform terminal5. No wrong wire facing <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure</div>
4	Connector lock	    <ol style="list-style-type: none">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.	LOCKING JIG 	<div>GOOD NG</div> <ol style="list-style-type: none">1. Use the provided jig per connector2. No unlock/half-locked coupler <div>Note: Manual locking may cause damaged lock.</div>

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