



WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

Effectivity Date:

May 05, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/ Part Number: 715W RR LH / 7H0351W7020D

Customer:

NBS

Document No.:

WI-ENG-PDE-472

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6098-5673 (GR)
2. AVSSf wire B L=224±2mm

JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<div>1</div> <div>TABLE LAY-OUT</div> <div>Connector 6098-5673 [GR]/ Connector tray</div> <div>AVSSf wires B L= 224±2mm</div> <div>Insertion jig</div> <div>Locking jig</div> <div>Assy parts</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 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>	<ol style="list-style-type: none">1. No missing parts/ tools.2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
05/05/22	1	Change from Pre-launch to Masspro. Additional Table Lay-out.	M.Ariola	J.Loterte	C. Villanueva	A.Arañes				
04/19/22	0	Initial Issue.	M.Ariola	J.Loterte	C. Villanueva	A.Arañes	M.Ariola	J. Loterte	C. Villanueva	A.Arañes

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PARTS:

1. Connector 6098-5673 (GR)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Wire insertion to Connector 6098-5673 (GR)	<p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector (6098-5673) into jig using right hand and release the lock.</p> <p>3. Check the holes/terminal slot for B-B wires.</p>	n/a	<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> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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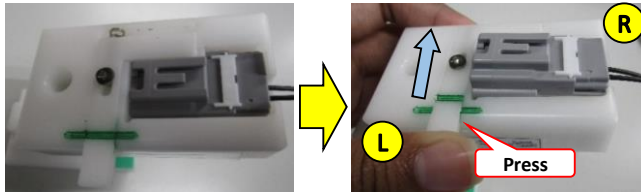
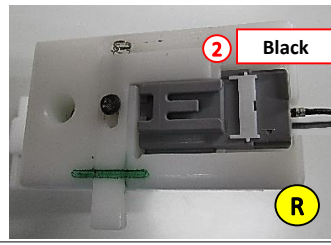

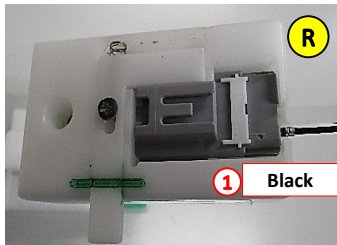
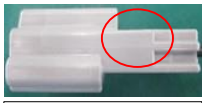



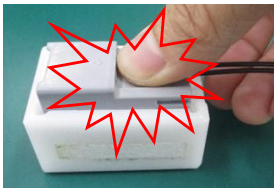

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PARTS:

1. Connector 6098-5673 (GR)
2. AVSSf wire B L=224±2mm [2pcs.]

JIG

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Connector 6098-5673 (GR)	<div><p>1. Get the first Black wire and insert to Slot 1 of connector using right hand. Note : Insertion should be left to right.</p><p>2. Get the second Black wire and insert to Slot 2 of connector using right hand. Note : Insertion should be left to right.</p><p>3. After insertion, press 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> <ol style="list-style-type: none">1. No loose insertion2. No wrong dimension3. One by one insertion4. No deformed 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>
4	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then 2x pressing to lock. Touch the connector lock to confirm if properly pressed.</p></div>	<div>Locking jig</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED CONNECTOR</div> <ol style="list-style-type: none">1. Use Provided jig tool per model.2. No unlocked/half-locked connector

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