

**WORK INSTRUCTION**

Effectivity Date:

May 19, 2022

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

715W

/

7H0338W7020A

Customer:

NBS

Document No.:

WI-ENG-PDE-507

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

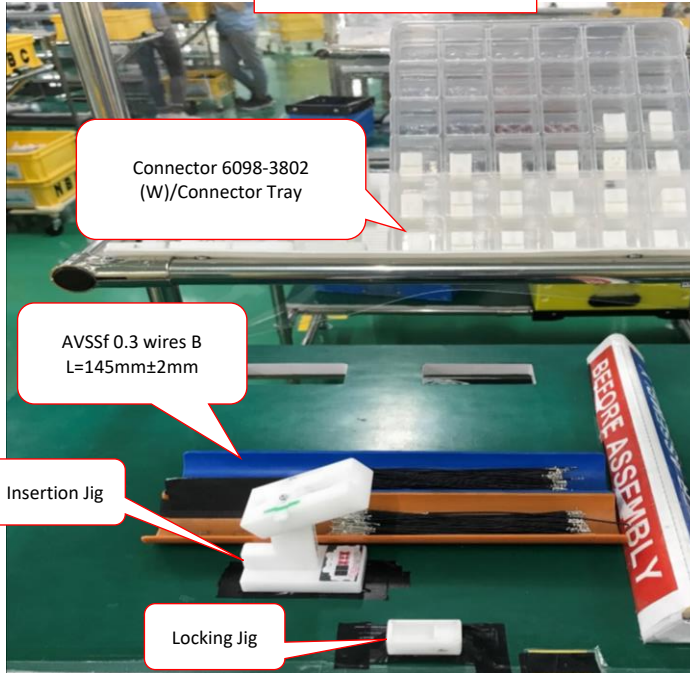
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PARTS:




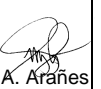
1. Connector 6098-3802 (W); AVSSf 0.3 wires B L=145mm±2mm

JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance.</i> 1. No missing parts/ tools. 2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/19/22	1	Change Pre-launch to Masspro. Additional Table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/29/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Est. Date:	April 29, 2022									

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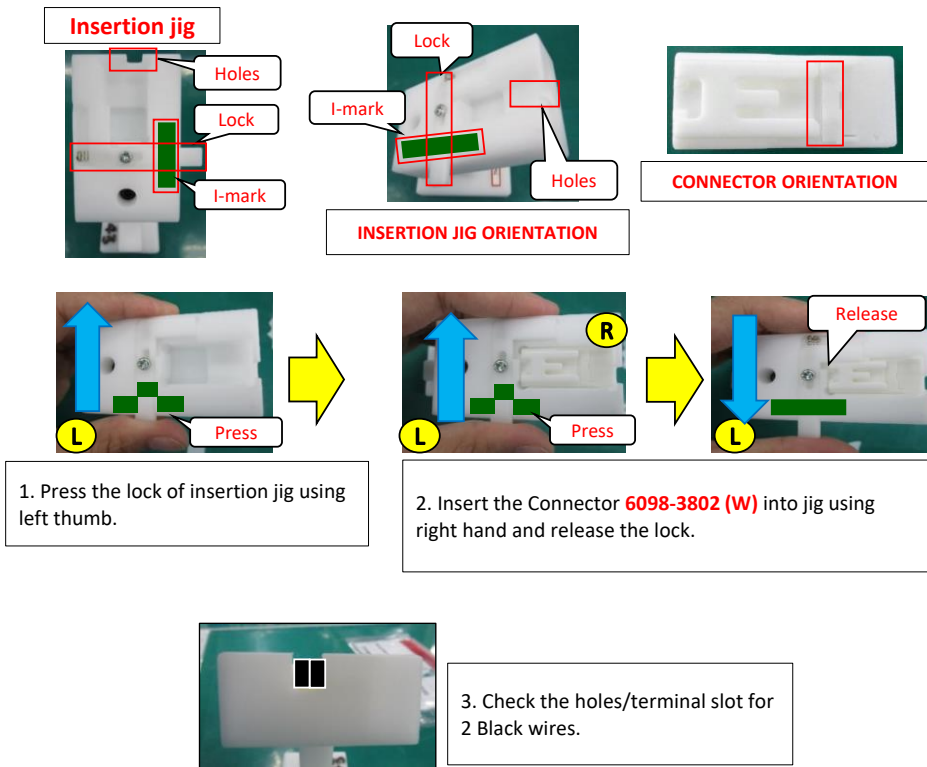
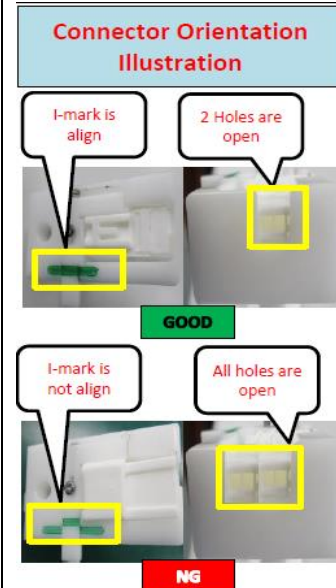
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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></div>		n/a	<div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>

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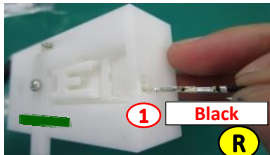
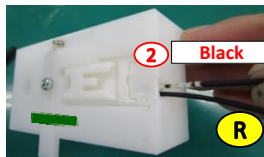

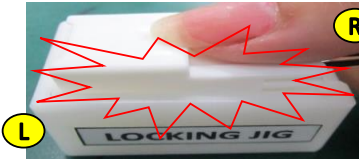



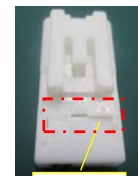

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PARTS:		1. AVSSf 0.3 wires B L=145mm±2mm [2pcs.]		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3802 (W)	<div>WIRE FACING</div> <div>1 Black R</div> <div>2 Black R</div> <div>Press</div> <div><p>1. Get the 1st B wire then insert to connector using right hand. Note: Insertion of wire must be from left to right.</p><p>2. Get the 2nd B wire then insert to connector using right hand.</p><p>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</p> <ol style="list-style-type: none">No wrong orientation of connectorNo wrong use of connectorNo damaged connectorNo wrong insertion of wiresNo loose insertionNo wrong insertionOne by one insertionNo deformed terminalNo wrong wire facing <div>Note: Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>
4	Connector lock	<div>L R</div> <div>Before pressing</div> <div>After pressing</div> <div>GOOD Full Lock</div> <div>NG Half Lock</div> <div>LOCKING JIG</div> <div><p>Put the connector into locking jig using right hand then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked. Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p></div>			<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <ol style="list-style-type: none">Use the provided jig per connectorNo unlock/half-locked of connector lock

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