



# WORK INSTRUCTION KITTING ASSEMBLY PROCESS

Effectivity Date:	May 20, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-270		
Revision No.:	0	Page No.:	1 of 2

Process Name/Title:	KITTING ASSEMBLY PROCESS		
Product Name/Code:	550B / 7L0083-7022	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

<b>PARTS:</b>		1. Connector 6098-3802 (W) 2. AVSSf 0.3 B wires L=799mm [2 pcs]		<b>JIG:</b>	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	Connector setting to insertion jig 6098-3802 (W)	<p><b>Insertion jig</b></p> <p><b>Lock</b></p> <p><b>Holes</b></p> <p><b>I-mark</b></p> <p><b>Insertion jig orientation</b></p> <p><b>Connector orientation</b></p> <p><b>Connector Lock</b></p> <p><b>Press</b></p> <p><b>Release</b></p> <p><b>1. Press the lock of insertion jig using left thumb.</b></p> <p><b>2. Get the connector 6098-3802 (W) and insert into jig using right hand and release the lock using left hand.</b></p> <p><b>3. Check the holes/terminal slot for B/B wires.</b></p>	<p><b>Safety Instruction</b></p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Connector Orientation Illustration</b></p> <p><b>I-mark is align</b></p> <p><b>2 Holes are open.</b></p> <p><b>I-mark is not align</b></p> <p><b>All Holes are open.</b></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>	

## Revision History

								Prepared by:	Checked by:	Approved by:	Noted by:
05/20/21	0	Transfer process from Sub-assy to Kitting. Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003.	D.Castillo	C.Villanueva	A. Shimamura	A. Arañes		D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	May 22, 2021			

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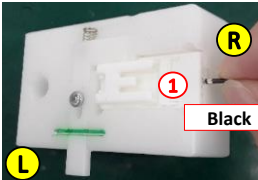
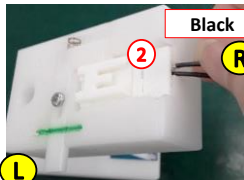







Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	n/a			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the first <b>Black wire</b> and insert to <b>Slot 1</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></p></div> <div><p>2. Get the second <b>Black wire</b> and insert to <b>Slot 2</b> of connector using right hand.</p></div> <div><p>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</p></div>		N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.
3	Connector lock	<div><p>Put the connector into locking jig using both thumb then press to lock <b>2x</b>. Check the connector lock to confirm if properly pressed. <b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>GOOD Full Lock</p></div> <div><p>NG Half Lock</p></div>		<div>Locking jig</div> 	<p><b>Note:</b> Use provided jig tool to lock the connector. Manual locking may cause damaged lock.</p> <p>1. No unlock/half-locked connector 2. Use provided jig tool to lock the connector</p>

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