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|--|---|--|--|--|-----------------------|--|-------------------------------------|------------------|
| | WORK INSTRUCTION | | | | Effectivity Date: | | December 03, 2022 | |
| | OFFLINE ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Process Name/Title: | | Model Code/Part Number: 920B / 7R0122-7020A | | Customer: TRMX | | Document No.: WI-ENG-PDE-601 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | | 1 | Page No.: 1 of 4 |

| | | | | | | | |
|---------------|--|---|--|--|------|---|---|
| PARTS: | 1. All parts: Connector 6098-3909 (W); AVSSf 0.3 wires B L=572±3mm; Black Vinyl tube ø7 L= 291±3mm | | | | JIG: | 1. Insertion jig | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | | TOOLS/PPE | QUALITY POINTERS |
| 1 | n/a | <div style="text-align: center; border: 1px solid black; 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 workplace 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. 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 | |
| 12/03/22 | 1 | Change document purpose from pre-launch to masspro | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | | | | | | | | | |
| 11/29/22 | 0 | Initial issue. | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | | | | | | | | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | | November 29, 2022 | | | | | | |

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PARTS:

1. Connector 6098-3909 (W)

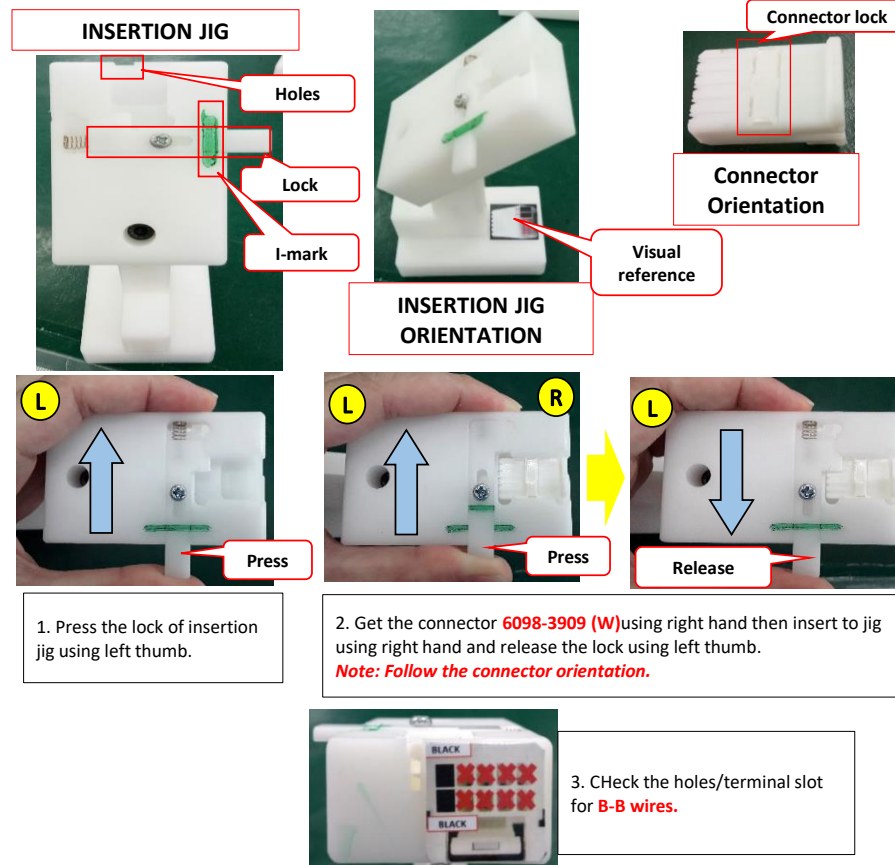
JIG

1. Insertion jig

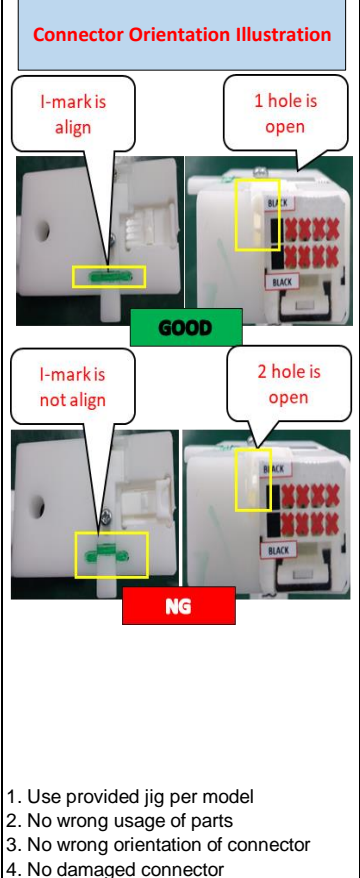
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

n/a

Connector setting to
insertion jig
6098-3909 (W)

n/a



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Purpose:



PROTOTYPE



PRE-LAUNCH






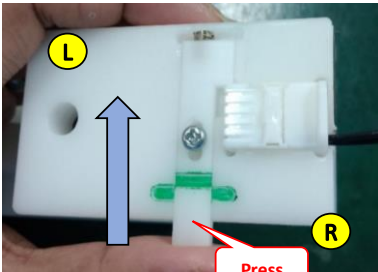
MASSPRO

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| PARTS: | | 1. AVSSf 0.3 wires B-B L=572±3mm | | | JIG | 1. Insertion jig |
|--------|--------------|---|--|--|-----------|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 3 | n/a | <div><p>Wire facing</p></div> <div><p>1. Get 1st black wire then insert to terminal slot ① using right hand. Note: Insertion of wires must be from up to down direction.</p></div> <div><p>2. Get 2nd Black wire then insert to terminal slot ② using right hand.</p></div> <div><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 | <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> |

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PROTOTYPE



PRE-LAUNCH




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| PARTS: | | 1. Assy parts 2. Black vinyl tube Ø7 L=291±3mm | | | JIG | n/a |
|--------|---|--|--|--|-----------|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Wire insertion to Black vinyl tube Ø7 L=291±3mm |  <div>2. Get the vinyl tube Ø7 L=291±3mm using right hand then insert the B-B wires using left hand.</div> | | | n/a | 1. No wrong use of parts 2. No deformed terminal |
| | n/a | | | | | |

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