

**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

April 21, 2022

Model Code/Part Number:

N/A / 7H0399W7021

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-469

Purpose:

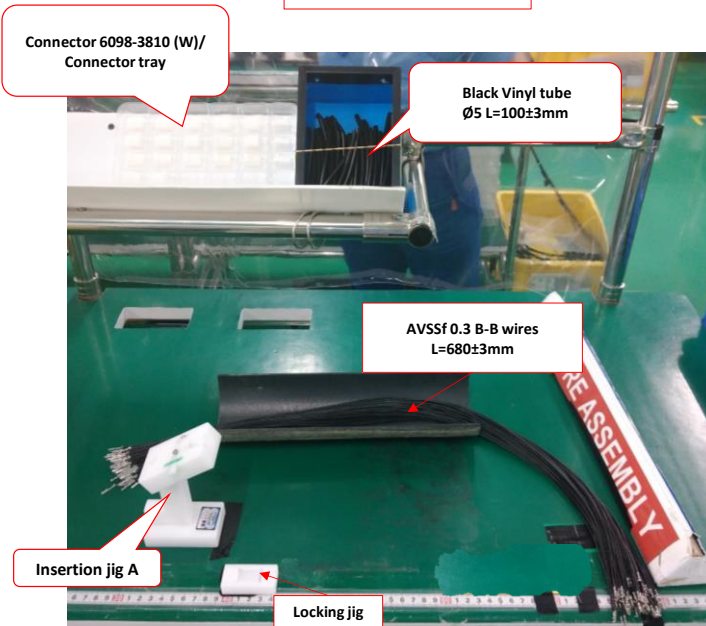
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Connector 6098-3810 (W); AVSSf 0.3 B-B wires L=680±3mm; Black Vinyl tube Ø5 L=100±3mm			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>  <p>Connector 6098-3810 (W)/ Connector tray</p> <p>Black Vinyl tube Ø5 L=100±3mm</p> <p>AVSSf 0.3 B-B wires L=680±3mm</p> <p>Insertion jig A</p> <p>Locking jig</p>		<div>Safety Instruction Be sure to wear required 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>	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/21/22	1	Change document purpose from pre-launch to masspro. Additional table layout	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/07/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				

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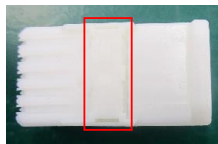
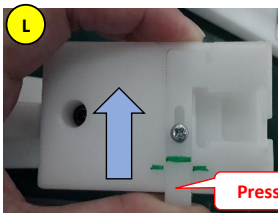
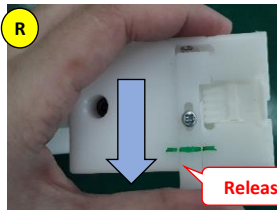

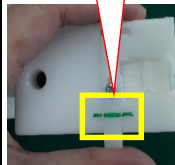
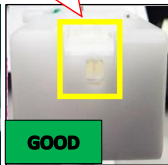
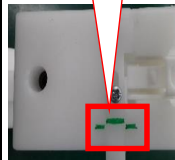
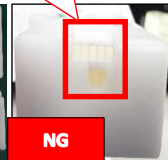
WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

Effectivity Date:	April 21, 2022		
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Model Code/Part Number: **N/A / 7H0399W7021** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 6098-3810 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to insertion jig 6098-3810 (W)	<div><div>INSERTION JIG</div><div></div><div>INSERTION JIG ORIENTATION</div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div><div>L</div><div></div><div>Press</div><div><div>R</div><div></div><div>Release</div></div><div>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div>		n/a	<div><div>CONNECTOR ILLUSTRATION</div><div><div>I-mark was align</div><div></div><div>2 holes were only open</div><div></div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div></div><div>All holes were open</div><div></div><div>NG</div></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

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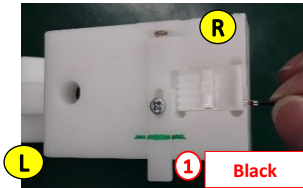
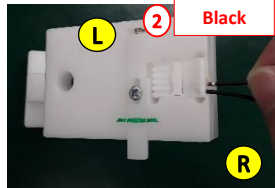
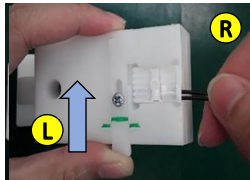

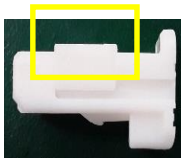
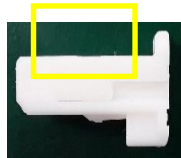

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. AVSSf 0.3 B-B wires L=680±3mm			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3810 (W)	<div><div></div><div></div><div></div><div><p>1. Get the 1st Black wire then insert to connector slot 1 using right hand. Note: insertion process must be from left to right.</p><p>2. Get the 2nd Black wire then insert to connector slot 2 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></div> <div><p>n/a</p></div> <div><p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p></div>			
4	Connector Lock	<div><div></div><div></div><div></div><div><p>Before pressing</p><p>After pressing</p></div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock if properly locked.Refer to GL-PRO-ASY-017 for locking verification.</p></div></div> <div><div><p>LOCKING JIG</p></div></div> <div><p>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p><p>1. Use provided jig tool per model 2. No unlock/half-locked connector</p></div>			

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1. Assy parts
2. Black Vinyl tube Ø5 L=100±3mm

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black Vinyl tube Ø5 L=100±3mm		n/a	1. No wrong use of parts
	n/a			

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