









Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/25/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
04/07/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change		Revised	Checked	Approved	Noted	Est. Date:	April 7, 2022		

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**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

April 25, 2022

Model Code/Part Number:

**N/A / 7H0346W7020C**

Customer:

**NBS**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-467

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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1

Page No.:


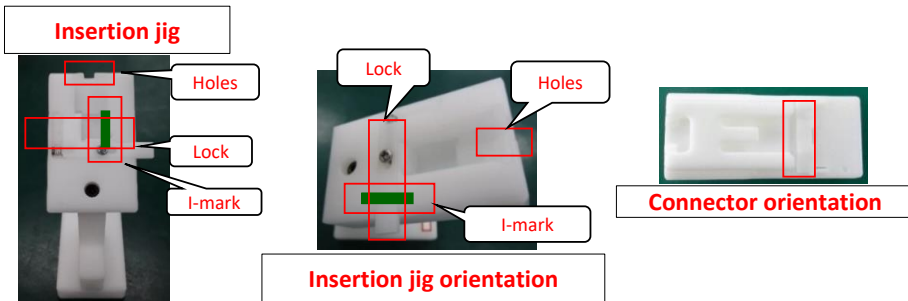
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**PARTS:**

1. Black Vinyl tube  $\phi 5$  L=213 $\pm$ 3mm
2. Connector 6098-3802 (W)

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Vinyl tube $\phi 5$ L=213 $\pm$ 3mm	 <div>1. Hold the Vinyl tube <math>\phi 5</math> L=213<math>\pm</math>3mm using left hand. Get 2 Black wires and insert to Vinyl tube using right hand.</div>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
3	Connector setting to insertion jig 6098-3802 (W)		n/a	<ol style="list-style-type: none"><li>1. No. damaged connector</li><li>2. Use provided jig per model</li><li>3. No wrong orientation of connector</li></ol>

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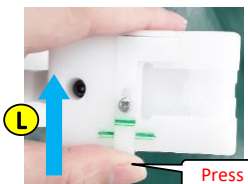
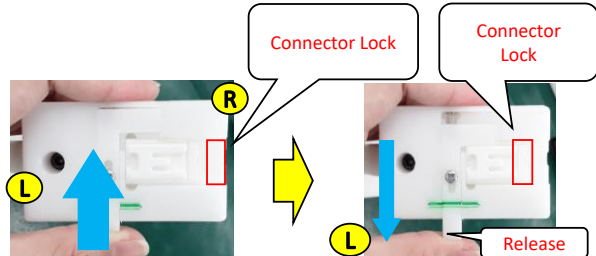
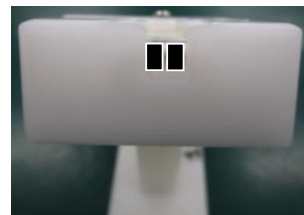




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6098-3802 (W) continuation</p> <div><p>1. Press the lock of insertion jig using left thumb.</p></div> <div><p>2. Get the connector 6098-3802 (W) and insert into jig using right hand and release the lock using left hand.</p></div> <div><p>3. Check the holes/terminal slot for B/B wires.</p></div>			n/a	<div><b>Connector Orientation Illustration</b></div> <div><p>I-mark is align</p></div> <div><p>2 Holes are open.</p></div> <div><p>I-mark is not align</p></div> <div><p>All Holes are open.</p></div> <p>1. No. damaged connector 2. Use provided jig per model 3. No wrong orientation of connector</p>

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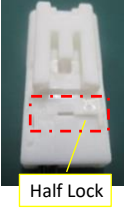

# WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

Effectivity Date:	April 25, 2022
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Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Model Code/Part Number: **N/A / 7H0346W7020C** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		3. AVSSf 0.3 B L=789mm±3mm [2 pcs]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-3802 (W)	 <p><b>Wire facing</b></p>  <p>1. Hold the insertion jig using left hand. Get the <b>1st Black wire</b> and insert to terminal slot 1 using right hand.</p>  <p>2. Get the <b>2nd Black wire</b> and insert to terminal slot 2 using right hand.</p>  <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>			N/A	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p> <ol style="list-style-type: none"> <li>No loose insertion</li> <li>No wrong insertion</li> <li>One by one insertion</li> <li>No deformed terminal</li> <li>No wrong wire facing</li> </ol> <p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p>
4	Connector lock	 <p>1. Put the connector into locking jig using right hand then press to lock 2x. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p>  <p><b>Before pressing</b></p>  <p><b>After pressing</b></p>  <p><b>GOOD</b> Full Lock</p>  <p><b>NG</b> Half Lock</p>			LOCKING JIG 	<ol style="list-style-type: none"> <li>No unlock/half-locked connector</li> <li>Use provided jig tool to lock the connector</li> </ol> <p><b>NOTE:</b> <b>MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b></p>

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