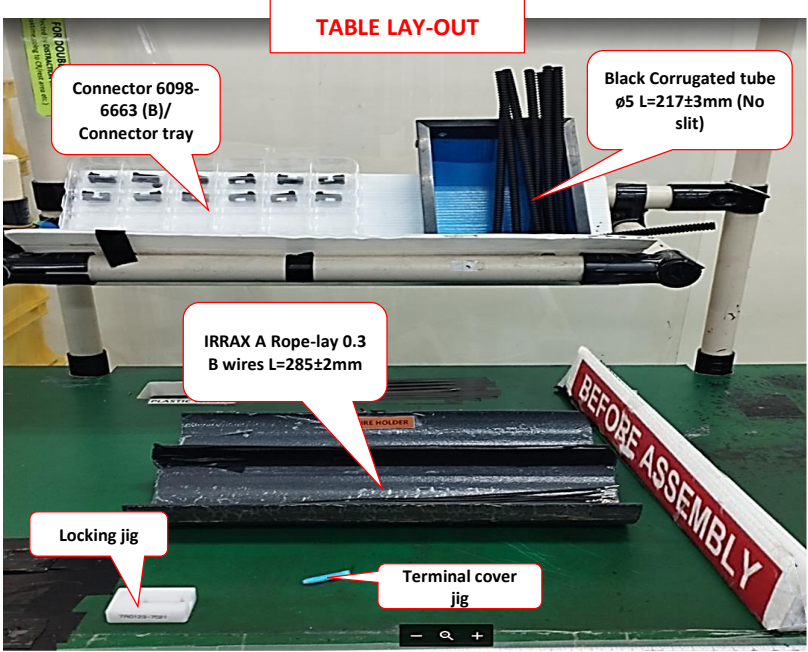


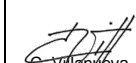

	<b>WORK INSTRUCTION</b> <b>OFFLINE ASSEMBLY PROCESS</b>				Effectivity Date:		July 19, 2022	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: 200D/220D / 7R0123-7021		Customer: TRMX		Document No.:		WI-ENG-PDE-567	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0		Page No.: 1 of 3	

<b>PARTS:</b>		1. Connector 6098-6663 (B) 2. IRRAX A Rope-lay 0.3 B wires L=285±2mm. 3. Black Corrugated tube ø5 L=217±3mm (No slit)		<b>JIG:</b> 1. Locking jig 2. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	
1	n/a			<div> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	
				<b>QUALITY POINTERS</b> <div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.</div> 1. No missing parts/ tools. 2. No excess parts/tools.	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
07/19/22	0	Initial Issue. Excluded from WI-ENG-PDE-560 due to process Improvements. Change Process name from <i>Kitting Assembly Process</i> to <i>Offline Assembly Process</i> . Additional Table Lay-out						 M. Ariola		 J. Loterte		 C. Villanueva		 A. Arañes	
Eff. Date	Rev. No	Details of Change						Prepared	Reviewed	Approved	Noted	Est. Date:	July 19, 2022		

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# WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 19, 2022

Model Code/Part Number:

200D/220D

/

7R0123-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-567

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

2 of 3

### PARTS:

- 1.Connector 6098-6663 (B)
- 2.IRRAX A Rope-lay 0.3 B wires L=285±2mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

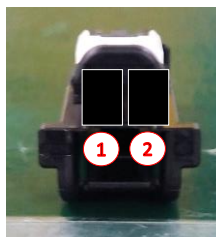
2

n/a

Wire insertion to  
connector  
6098-6663 (B)



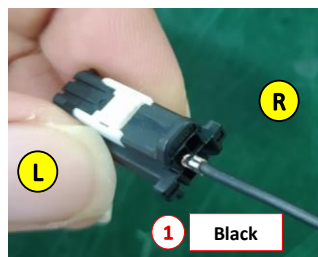
CONNECTOR  
ORIENTATION



VISUAL  
REFERENCE

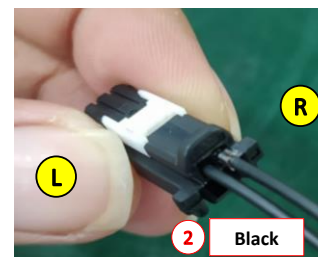


Wire facing



1. Hold the connector **6098-6663 (B)** then get the **first Black wire** and insert to terminal **slot 1** using right hand. Conduct **2x** push pull after wire insertion.

**Note: Insertion of wire must be from left to right.**



2. Hold the connector **6098-6663 (B)** then get the **second Black wire** and insert to terminal **slot 2** using right hand. Conduct **2x** push pull after wire insertion.

n/a

**Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.**

Make sure wires are properly inserted.  
Conduct **Pull-Push-Pull-Push** after insertion.  
Do not exert extra force.

1. No wrong orientation of connector
2. No wrong use of connector
3. No damaged connector
4. No wrong insertion of wires
5. No loose insertion
6. No wrong insertion
7. One by one insertion
8. No deformed terminal
9. No wrong wire facing

**Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.**

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# WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

Effectivity Date:	July 19, 2022		
Validity date	n/a		
Document No.:	WI-ENG-PDE-567		
Revision No.:	0	Page No.:	3 of 3

Process Name/Title:	200D/220D / 7R0123-7021		
Model Code/Part Number:	200D/220D	/	7R0123-7021
Customer:	TRMX		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. Assy parts 2. Black Corrugated tube ø5 L=217±3mm (No slit)		JIG	1. Terminal cover jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Connector lock	  <b>BEFORE PRESSING</b>  <b>AFTER PRESSING</b> <div>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands. Touch the connector if it is properly locked. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></div>		<b>LOCKING JIG</b> 	<b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b>  1. Use provided jig tool per model 2. No unlock/half-locked connector
4	Wire insertion to black corrugated tube ø5 L=217±3mm (no slit)	 <div>1. Get the terminal cover jig using right hand then insert the <b>B-B wires</b>.</div>  <div>2. Get the Corrugated tube ø5 L=217±3mm (no slit) using right hand then insert the <b>B-B wires</b>.</div>  <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<b>TERMINAL COVER JIG</b> 	1. No deformed terminal 2. No wrong usage of parts

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