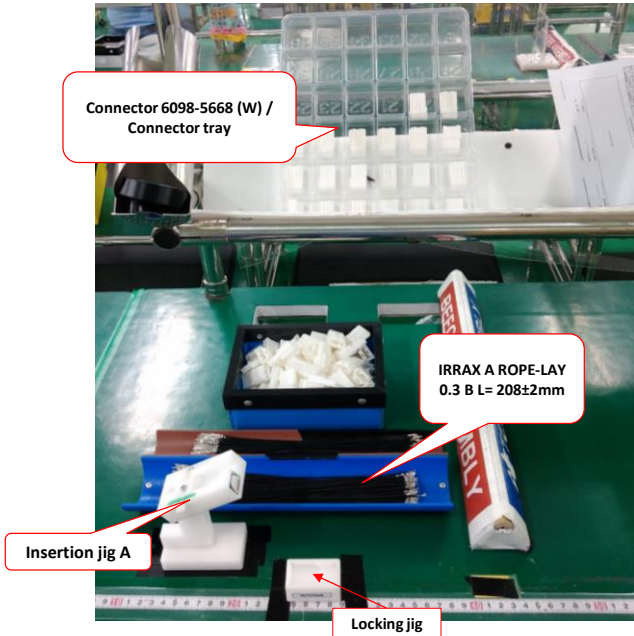
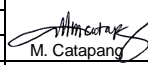

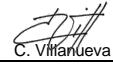
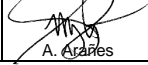
	WORK INSTRUCTION						Effectivity Date:		May 12, 2022	
	Process Name/Title: OFFLINE ASSEMBLY PROCESS						Validity Date:		n/a	
	Model Code/Product Number: 740B / 7H0422W7020				Customer: NBS		Document No.:		WI-ENG-PDE-513	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1 Page No.: 1 of 3	

PARTS:		1. Connector 6098-5668 (W); IRRAX A ROPE-LAY 0.3 B L= 208±2mm				JIG:		1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	n/a	<div style="text-align: center;"> Table Lay-out </div> 				<div style="border: 1px dashed red; padding: 5px;"> 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;"> 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>		<div style="color: red;"> 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					
05/12/22	1	Change document purpose from pre-launch to masspro. Additional table layout.						M. Catapang	J. Loterte	C. Villanueva	A. Arañes								
04/29/22	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes								
Eff. Date	Rev. No	Details of Change						Revised	Checked	Approved	Noted	Est. Date:		April 29, 2022					

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WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

May 12, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 740B / 7H0422W7020

Customer:

NBS

Document No.:

WI-ENG-PDE-513

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Connector 6098-5668 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

n/a

Connector setting to
insertion jig
6098-5668 (W)

INSERTION JIG

Holes

Lock

I-mark

CONNECTOR ORIENTATION

Holes

I-mark

GOOD

I-mark is align

2 Holes are open

NG

I-mark is not align

All holes are open

Press

Release

Press

1. Press the lock of insertion jig using left thumb.

2. Insert the connector 6098-5668 (W) into jig using right hand and release the lock.
Note: Follow the connector orientation.

3. Check the holes/terminal slot for **B-B wires**.

n/a

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

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1

Page No.:

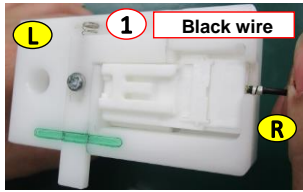

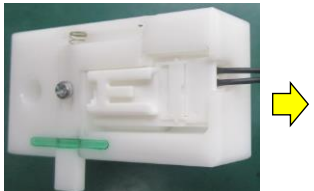
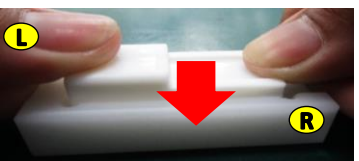

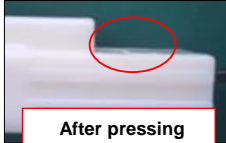


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PARTS:

1. IRRAX A ROPE-LAY 0.3 B L= 208±2mm [2pcs.]

JIG

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-5668 (W)	<div><div><p>1. Get the B wire then insert to terminal slot 1 using right hand. <i>Note: Insertion of wire must be from left to right.</i></p></div><div><p>2. Get the B 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></div>	n/a	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <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>
4	Connector Lock	<div><div><p>1. Put the connector into locking jig both hands then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p></div><div><p>Before pressing</p><p>After pressing</p></div><div><p>GOOD Full Lock</p><p>NG Half Lock</p></div></div>	Locking jig	<p><i>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</i></p> <ol style="list-style-type: none">1. Use the provided locking jig per model2. No unlock/half-locked connector

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