

	WORK INSTRUCTION						Effectivity Date:		September 23, 2022		
	OFFLINE ASSEMBLY PROCESS						Validity Date:		n/a		
	Process Name/Title:				Model Code/Part number		Customer:		Document No.:		
	Purpose:				200D/220D / 7R0131-7020		TRMX		WI-ENG-PDE-548		
<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2		Page No.:		1 of 5	

PARTS:	1. Connector 6098-3810 (W); AVSSf 0.3 B L=281±2mm; Black Corrugated tube ø5 L= 199±3mm (no slit)						JIG:	1. Insertion Jig 2. Locking Jig 3. Terminal Cover 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; margin-top: 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; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div> Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. </div> <div style="text-align: center; margin-top: 10px;"> CONNECTOR ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px;">GOOD</div> <div style="background-color: green; color: white; padding: 2px 5px;">6098-3810 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px;">NG</div> <div style="background-color: red; color: white; padding: 2px 5px;">6098-5677 (W)</div> </div> </div>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
09/23/22	2	Improve: Work procedure/Illustration on process no.4; Quality pointers and note on Pg. no. 1, 2, 3 and 4	M. Ariola	J.Loterte	C.Villanueva	A. Arañes					
06/16/22	1	Change purpose from Pre-launch to Masspro. Additional table lay-out.	K. Doria	J.Loterte	C. Villanueva	A. Arañes					
06/10/22	0	Initial issue. Excluded from WI-ENG-PDE-442	K. Doria	J.Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 10, 2022			

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Model Code/Part number **200D/220D / 7R0131-7020**

Customer:

TRMX

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n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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2

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PARTS:

1. Connector 6098-3810 (W)

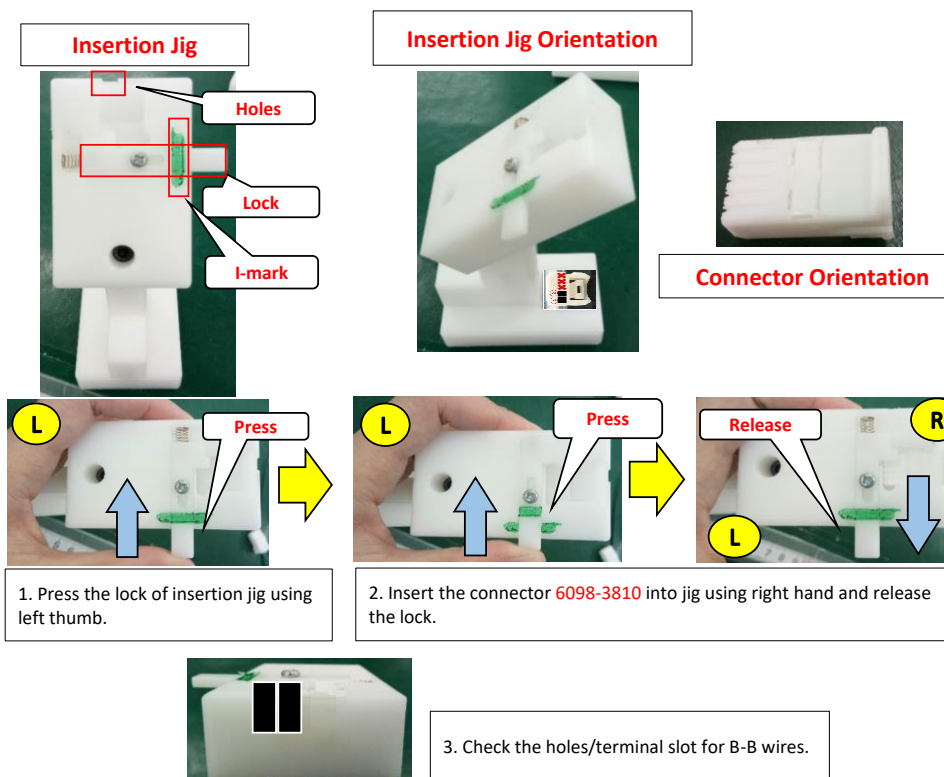
JIG

1. Insertion Jig

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

2

P1

Connector Setting to
Insertion jig
6098-3810 (W)

n/a

2. 1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector
2. **Connector Orientation Illustration**
- I-mark is align 2 Holes are widely open
GOOD
- I-mark is not align 2 holes are partially open.
NG
2. **CONNECTOR ILLUSTRATION**
- GOOD NG
- 6098-3810 (W) 6098-5677 (W)

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PROTOTYPE



PRE-LAUNCH

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PARTS:

1. AVSSf 0.3 B L=281±2mm [2pcs]

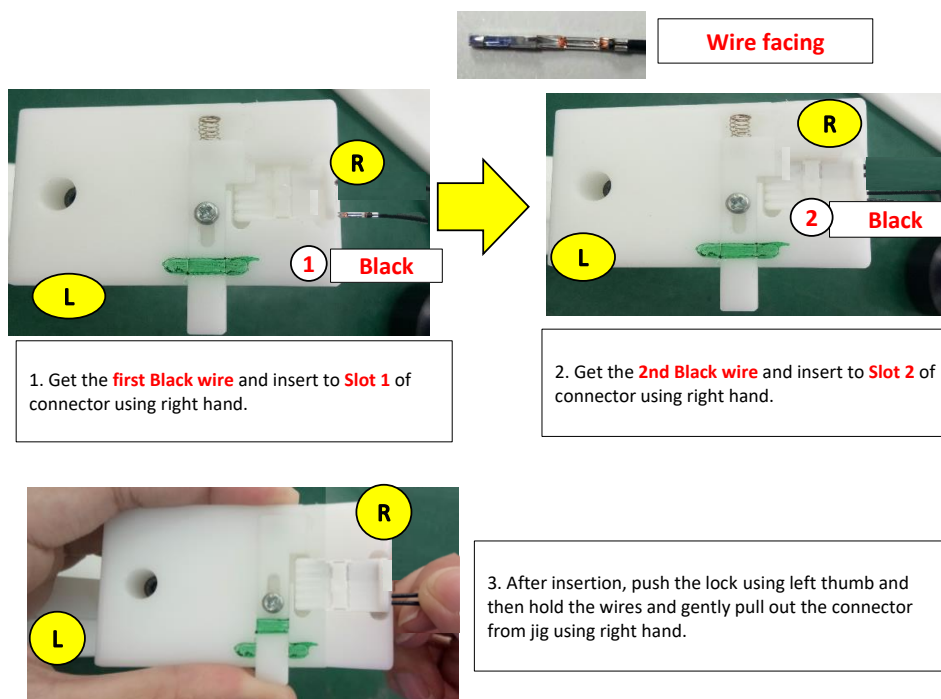
JIG

1. Insertion jig
2. Locking jig

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

3

P1

Wire Insertion to
Connector
6098-3810 (W)

n/a

1. No loose insertion
2. No wrong dimension
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Important reminders/Note/s

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

Document references:

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

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PROTOTYPE

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PRE-LAUNCH

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2

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

2. WORK PROCEDURE/ ILLUSTRATION

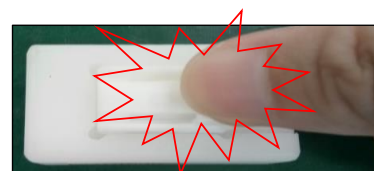
TOOLS/PPE

QUALITY POINTERS

4

P1

Connector lock



1. Put the connector into locking jig using right hand then press to lock 2x.



Before Pressing



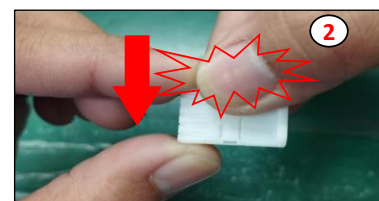
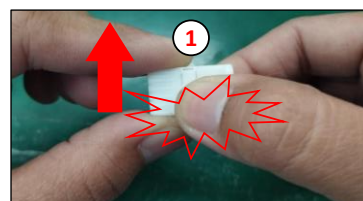
After Pressing

LOCKING JIG

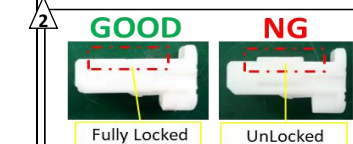


2. Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.



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PROTOTYPE

☐

PRE-LAUNCH

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PARTS:

1. Black Corrugated tube $\varnothing 5$ L= 199 \pm 3mm (no slit)
2. Assy parts

JIG

1. Terminal cover jig

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

5

P1

Wire insertion to Black
Corrugated tube
 $\varnothing 5$ L=199 \pm 3mm
(no slit)



1. Get the terminal cover jig using right hand then insert to **B-B wires**.



2. Get the corrugated tube (no slit) $\varnothing 5$ L=199 \pm 3mm using right hand and insert to **B-B wires**.



3. After insertion, remove the terminal cover jig using right hand.

TERMINAL COVER JIG

1. No wrong usage of parts
2. No deformed terminal

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