

	<b>WORK INSTRUCTION</b>						Effectivity Date:		July 19, 2022		
	<b>OFFLINE ASSEMBLY PROCESS</b>						Validity Date:		n/a		
	Process Name/Title:			Model Code/Part Number: <b>200D/220D / 7R0125-7021</b>			Customer: <b>TRMX</b>			Document No.: <b>WI-ENG-PDE-561</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1      Page No.:      1 of 3		

<b>PARTS:</b>	1. All parts: Connector 6098-6663 (B); IRRAX A ROPE-LAY 0.3 B wires L=242±2mm; Black COT (no slit) ø5 L=174±3mm						<b>JIG:</b>	1. Terminal cover jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>						<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	n/a	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>						<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <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 style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<div style="color: red; margin-bottom: 10px;">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	1	Change document purpose from pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes					
07/15/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 15, 2022							

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PROTOTYPE



PRE-LAUNCH



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**PARTS:**

1. Connector 6098-6663 (B)
2. IRRAX A Rope-lay 0.3 B wires L=242±2mm [2pcs.]

JIG

n/a

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

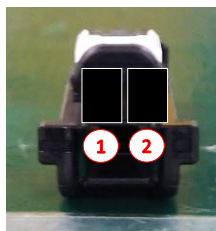
2

n/a

Wire insertion to connector  
6098-6663 (B)



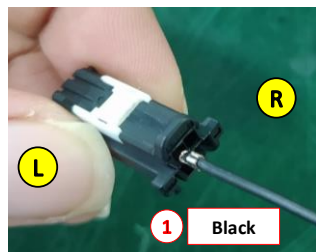
**CONNECTOR  
ORIENTATION**



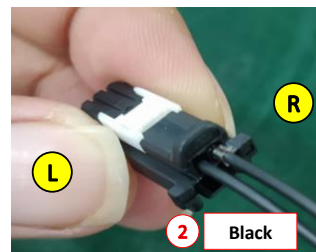
**VISUAL  
REFERENCE**



**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.

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

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

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

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

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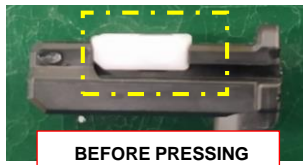



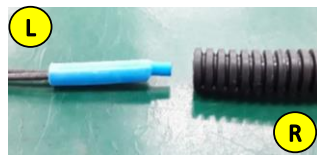


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### PARTS:

1. Assy parts
2. Black Corrugated tube  $\phi 5$  L=174 $\pm$ 3mm (no slit)

### JIG

1. Terminal cover jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Connector lock	  <p>BEFORE PRESSING</p>  <p>AFTER PRESSING</p> <p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands. Touch the connector lock if properly locked. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p>	<p>LOCKING JIG</p> 	<p><i>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</i></p> <ol style="list-style-type: none"><li>1. Use the provided jig per connector</li><li>2. No unlock/half-locked connector</li></ol>
4	Wire insertion to black corrugated tube $\phi 5$ L=174 $\pm$ 3mm (no slit)	  <p>1. Get the terminal cover jig using right hand then insert the <b>B-B wires</b>.</p> <p>2. Get the Corrugated tube <math>\phi 5</math> L=174<math>\pm</math>3mm (no slit) using right hand then insert the <b>B-B wires</b>.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<p>TERMINAL COVER JIG</p> 	<ol style="list-style-type: none"><li>1. No deformed terminal</li><li>2. No wrong usage of parts</li></ol>

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