

**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

September 22, 2022

Model Code/Part Number:

**220D / 7L0135-7020**

Customer:

**TRQSS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-457**

Revision No.:

1

Page No.:

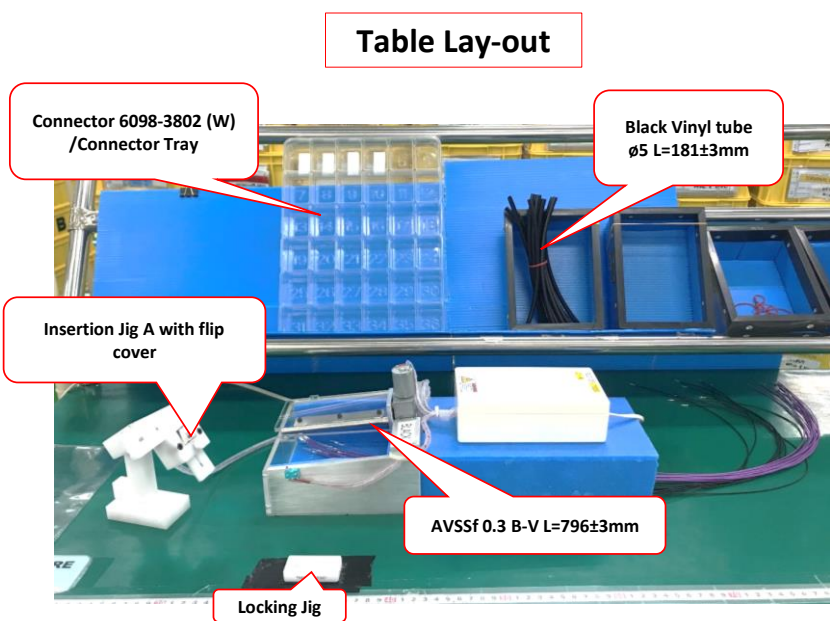

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**PARTS:**


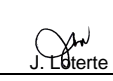



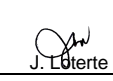


1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B-V L=796±3mm; Black Vinyl tube ø5 L=181±3mm

JIG:

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	<b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<b>Document reference/s:</b>  1 <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>  1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
09/22/22	1	Improve quality pointers: Reminders/notes and references in process no.1,2,3,4 and 5 due to document improvement. Work procedure/illustration in process no.4 - connector lock	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/28/22	0	Initial issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Est. Date:	March 28, 2022									

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PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<div><div><div>INSERTION JIG WITH SWITCH COVER</div><div></div></div><div></div><div><div></div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div></div><div>3. Push the guide using right hand. The slot for Violet wire will be opened.</div></div><div><div></div><div>2. Insert the connector 6098-3802 into jig using right hand and release the lock.</div></div></div>		n/a	<div><div>Connector Orientation Illustration</div><div></div><div><div>CONNECTOR ILLUSTRATION</div><div></div><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></div></div>

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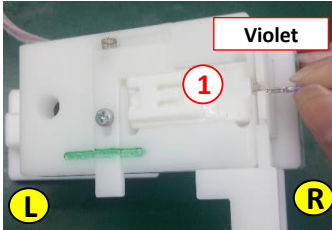
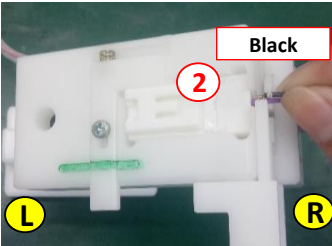
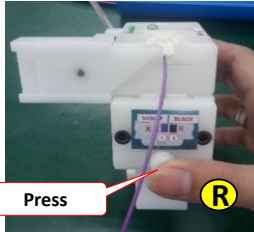
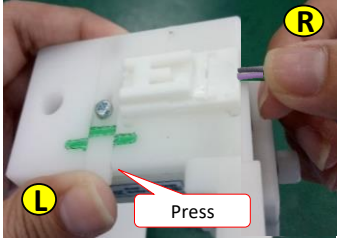
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSSf 0.3 B-V L=796±3mm			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><p>Wire facing</p></div> <div><p>Violet</p><p>1</p><p>L R</p><p>1. Get the <b>Violet wire</b> then insert to terminal slot ① using right hand.</p></div> <div><p>Black</p><p>2</p><p>L R</p><p>3. Get the <b>Black wire</b> then insert to terminal slot ② using right hand.</p></div> <div><p>Press</p><p>R</p><p>2. After insertion of Violet wire press the button using right hand. The slot for <b>Black wire</b> will be opened.</p></div> <div><p>Press</p><p>L R</p><p>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>			n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>1</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please hold the wire near terminal.</b></p> <p><b>2. Make sure wires are properly inserted.</b></p> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p> <p><b>Do not exert extra force.</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p> <p><b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>

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PARTS:

n/a

JIG

1. Locking jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

n/a

1

Connector Lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower  
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



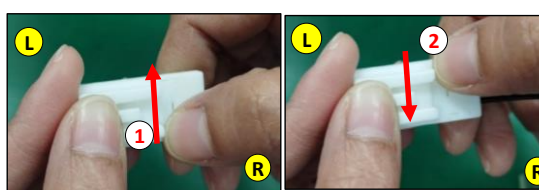
Right thumb-upper  
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



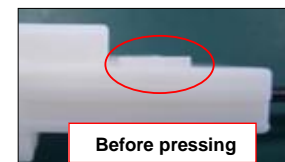
Right thumb-middle  
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



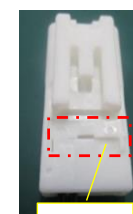
6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



GOOD

NG



1

Important reminders/Note/s:

1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR

1. Use the provided jig tool to lock the connector.

2. No unlock/half-locked connector

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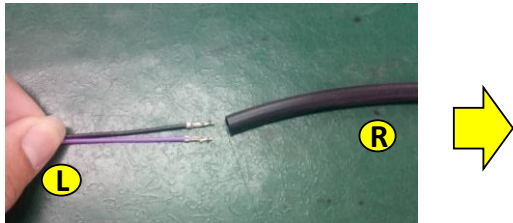
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<b>PARTS:</b>	1. Black Vinyl tube $\phi 5$ L=181 $\pm$ 3mm 2. Assy parts				<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	Wire insertion to Black Vinyl tube $\phi 5$ L=181 $\pm$ 3mm	 <div data-bbox="607 671 1079 804">Get vinyl tube <math>\phi 5</math> L=181<math>\pm</math>3mm using right hand then insert Violet and Black wire using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal	
	n/a					

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