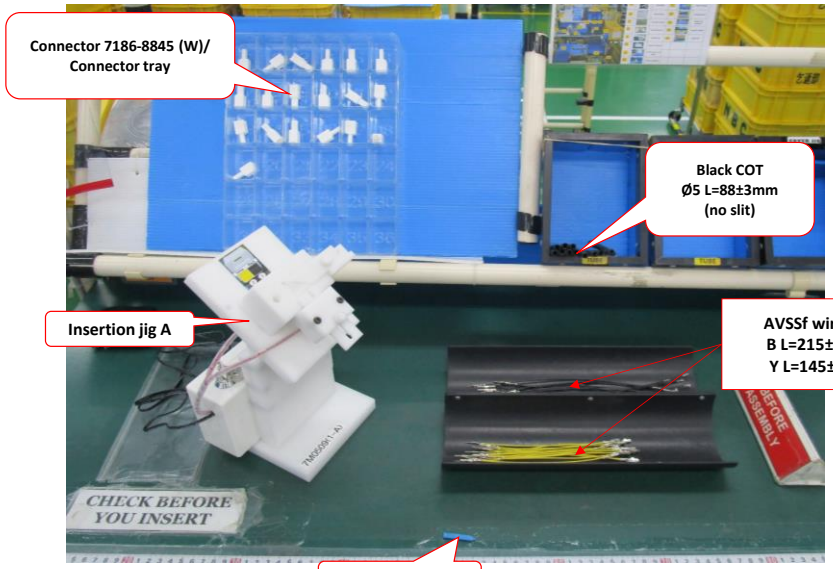
NBC	WORK INSTRUCTION			Effectivity Date:	February 25, 2023
	Process Name/Title:	1 OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a
	Model Code/Part Number:	ES1 / 7M0509-7020C	Customer: TRJ	Document No.:	WI-ENG-PDE-375
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 Page No.: 1 of 6

PARTS:	1. Connector 7186-8845 (W); AVSSf wires 0.3 B L=215±2mm; Y L=145±1mm; Black COT Ø5 L=88±3mm (no slit);	JIG:	1. Insertion jig 2. Terminal cover jig

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

Revision History							Prepared by	Reviewed by	Approved by	Noted by
02/25/23	1	Change the process name/Title from 'Kitting Assembly Process' to 'Offline Assembly Process Improve quality pointers and notes in process no.1 and 3 as document improvement. Additional process in: Process no.3, procedure5 - pushing of wires as countermeasure for encountered terminal backing out. Removal of notes related to the function of insertion jig. Addition of " Must have slightly movement of after insertion. inclusion of Quality Checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
11/25/21	0	Initial issue. Process excluded from WI-ENG-PDE-357A. Provide jig	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	November 25, 2021		

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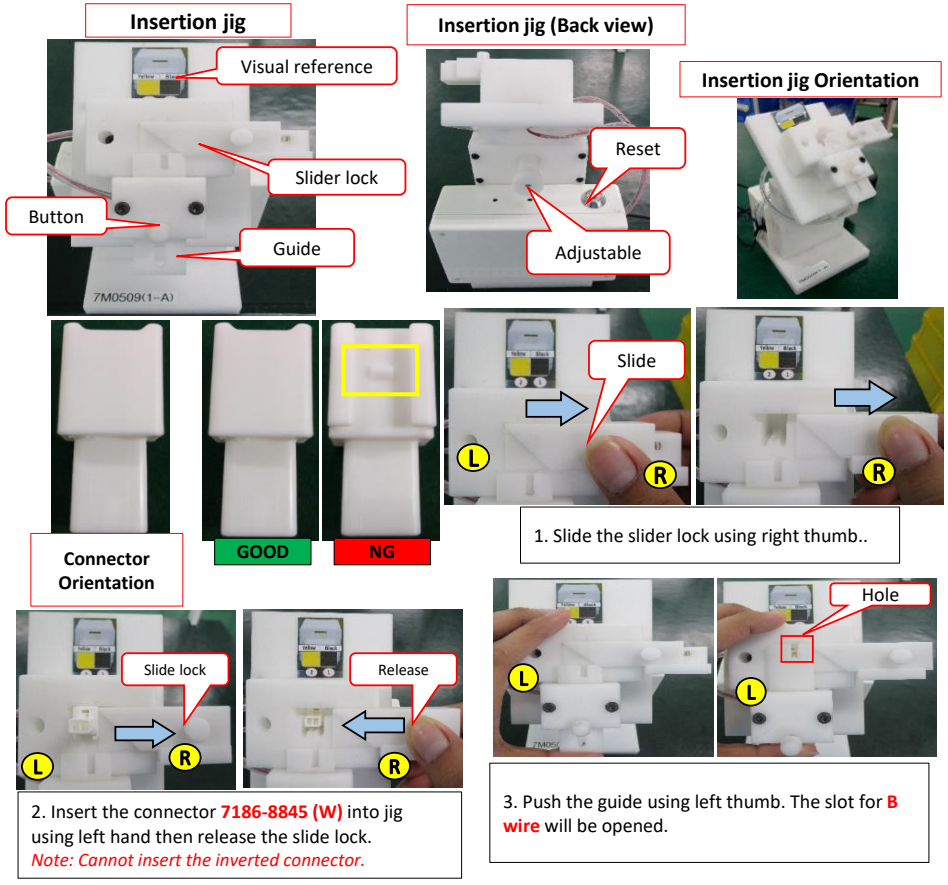
	WORK INSTRUCTION			Effectivity Date:	**February 25, 2023**
	Process Name/Title:	⚠1 **OFFLINE ASSEMBLY PROCESS**		Validity Date:	**n/a**
	Model Code/Part Number: **ES1 / 7M0509-7020C**	Customer: **TRJ**		Document No.:	**WI-ENG-PDE-375**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 Page No.: 2 of 6

PARTS:	1. Connector 7186-8845 (W)	**JIG**	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector setting to insertion jig 7186-8845 (W)	 1. Slide the slider lock using right thumb.. 2. Insert the connector **7186-8845 (W)** into jig using left hand then release the slide lock. *Note: Cannot insert the inverted connector.* 3. Push the guide using left thumb. The slot for **B wire** will be opened.	n/a	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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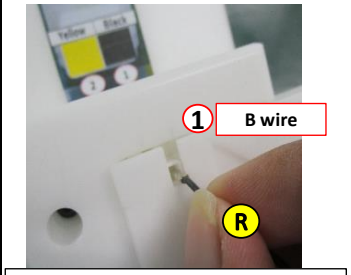
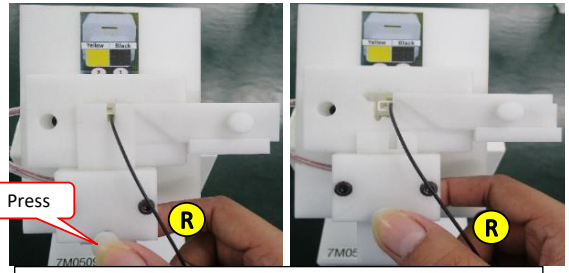
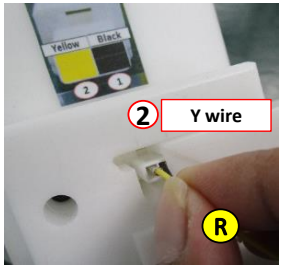
	Process Name/Title:	⚠1 OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a
	Model Code/Part Number:	ES1 / 7M0509-7020C	Customer: TRJ	Document No.:	WI-ENG-PDE-375
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 Page No.: 3 of 6

PARTS:	1. AVSSf wires 0.3 B L=215±2mm; Y L=145±1mm	**JIG**	1. Insertion jig

NO.	PROCESS NAME		⚠1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	⚠1 QUALITY POINTERS
3	n/a	Wire insertion to connector 7186-8845 (W)	 1. Get **Black wire** then insert to terminal slot **1** using right hand. Conduct **Pull-Push-Pull-Push** after insertion. **Wire facing**  2. Press the button using left hand. The slot for **Yellow wire** will be opened.  3. Get **Yellow wire** then insert to terminal slot **2** using right hand. Conduct **Pull-Push-Pull-Push** after insertion.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. Must have slightly movement after insertion. ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal during insertion.*** ***Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion*** ***Documents reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***

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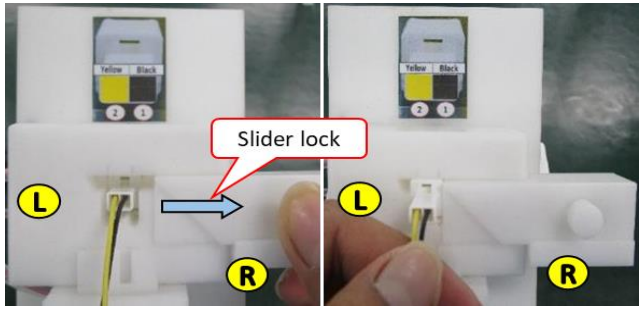
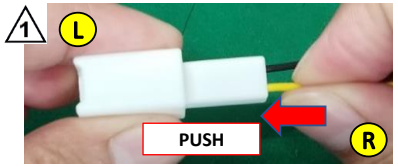
	WORK INSTRUCTION		Effectivity Date:	**February 25, 2023**
	Process Name/Title: 1 **OFFLINE ASSEMBLY PROCESS**		Validity Date:	**n/a**
	Model Code/Part Number: **ES1 / 7M0509-7020C**	Customer: **TRJ**	Document No.:	**WI-ENG-PDE-375**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 Page No.: 4 of 6

PARTS:	1. AVSSf wires 0.3 B L=215±2mm; Y L=145±1mm	**JIG**	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to connector 7186-8845 (W) (Continuation)	 4. After insertion, slide the slider lock using right thumb then hold the wires and gently pull out the connector from jig using left hand.  5. After removing the connector from jig, Conduct pushing (1x) of Y wire using right hand confirm if the wires are fully inserted. Repeat the process to B wire.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. Must have slightly movement after insertion. 1 ***Important reminders/Note/s:*** ***1. Please hold the wire near terminal during insertion. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion*** 1 ***3. Conduct Pushing of wires after removing the connector from jig.*** ***4. Pushing of wires will be done one by one of every inserted wire.*** ***Documents reference/s:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***

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	Model Code/Part Number:	ES1 / 7M0509-7020C	Customer: TRJ	Document No.:	WI-ENG-PDE-375
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 Page No.: 5 of 6

PARTS:	1. Assy parts 2. Black corrugated tube Ø5 L=88±3mm (no slit)	**JIG**	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Wire insertion to Black corrugated tube Ø5 L=88±3mm (no slit)	 1. Get the terminal cover jig using right hand then insert to **B wire** using right hand. 2. Get the corrugated tube **Ø5 L=88±3mm (no slit)** using right hand then insert the **B wire** using left hand. 3. Continue to insert the **Y wire** using left hand. 4. After insertion, remove the terminal cover jig using right hand.	**TERMINAL COVER JIG** 	1. No deformed terminal 2. No wrong usage of parts

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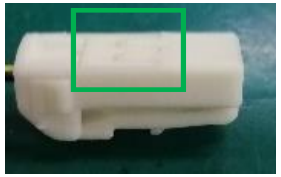
PARTS:	n/a	**JIG**	n/a

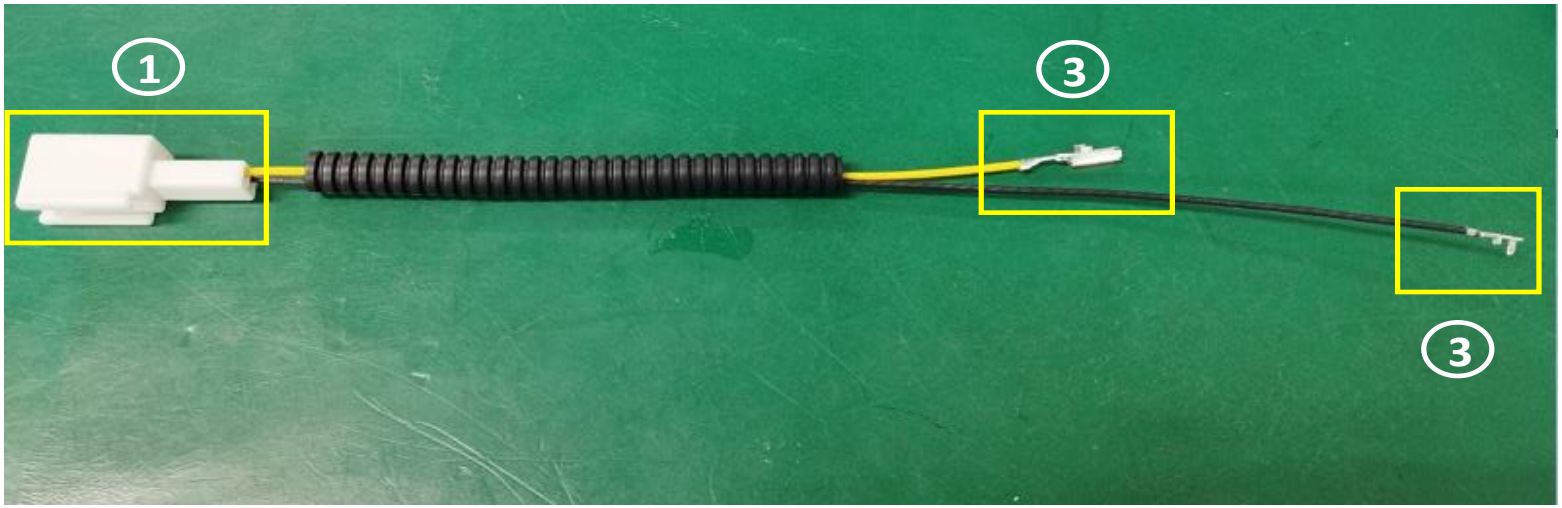
1 **QUALITY CHECKPOINTS**

OL 7M0509-7020C



GOOD

NO GOOD



1 No Terminal Backing Out

2 No wrong insert

3 No Deformed Terminal

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