



# WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

|                   |                |           |        |
|-------------------|----------------|-----------|--------|
| Effectivity Date: | May 04, 2022   |           |        |
| Validity Date:    | n/a            |           |        |
| Document No.:     | WI-ENG-PDE-506 |           |        |
| Revision No.:     | 0              | Page No.: | 1 of 4 |

|                            |                                    |                                     |   |
|----------------------------|------------------------------------|-------------------------------------|---|
| Process Name/Title:        | 900B/910B / 7N0072-7020C           |                                     |   |
| Model Code/Product Number: | 900B/910B / 7N0072-7020C           | Customer:                           | TRJ   |
| Purpose:                   | <input type="checkbox"/> PROTOTYPE | <input type="checkbox"/> PRE-LAUNCH | <input checked="" type="checkbox"/> MASSPRO |

|        |   |     |                                    |
|--------|---|-----|------------------------------------|
| PARTS: | 1. All parts; Connector 6098-3810(W); AVSSf 0.3 B-G wires L=679±3mm; Black vinyl tube ø5 L=69±3mm | JIG | 1. Insertion jig<br>2. Locking jig |
|--------|---|-----|------------------------------------|

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

|                  |        |                   |          |             |               |             |              |
|------------------|--------|-------------------|----------|-------------|---------------|-------------|--------------|
| Revision History |        |                   |          | Prepared by | Reviewed by   | Approved by | Noted by     |
| 05/04/22         | 0      | Initial Issue.    | M.Ariola | J. Loterte  | C. Villanueva | A.Arañes    | M.Ariola     |
| Eff.Date         | Rev.No | Details of Change | Revised  | Reviewed    | Approved      | Noted       | Est. Date    |
|                  |        |                   |          |             |               |             | May 04, 2022 |

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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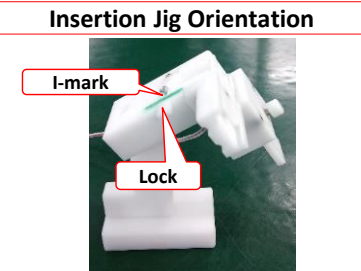
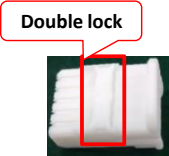

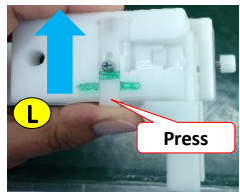
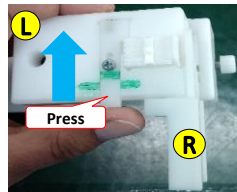
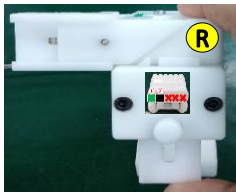
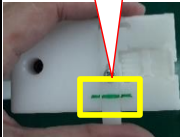

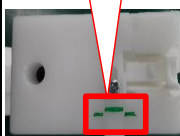

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### PARTS:

1. Connector 6098-3810 (W)

### JIG

1. Insertion jig

| NO. | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION  | TOOLS/PPE | QUALITY POINTERS   |
|-----|---|---|-----------|--|
| 2   | n/a<br>Connector setting to<br>Insertion jig<br>6098-3810 (W) | <p><b>Insertion Jig Orientation</b></p>  <p><b>Double lock</b></p>  <p><b>CONNECTOR ORIENTATION</b></p>  <p><b>Press</b></p>  <p><b>Release</b></p>  <p><b>Holes</b></p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector <b>6098-3810 (W)</b> using right hand and release the lock using left hand.<br/><i>Note: Follow the connector orientation.</i></p> <p>3. Push the guide using right thumb, hole for <b>G</b> wires will be opened.</p> | n/a       | <p><b>Connector Orientation</b></p> <p><b>I-mark was align</b></p>  <p><b>GOOD</b></p> <p><b>1 hole were only open</b></p>  <p><b>I-mark is NOT align</b></p>  <p><b>NG</b></p> <p><b>1 hole were open</b></p>  <p>1. Use the provided jig per model<br/>2. No wrong orientation of connector<br/>3. No wrong use of connector<br/>4. No damaged connector</p> |

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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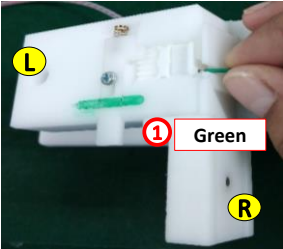
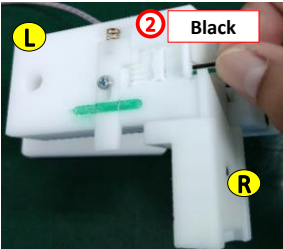
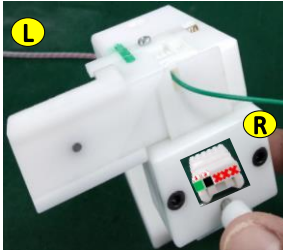
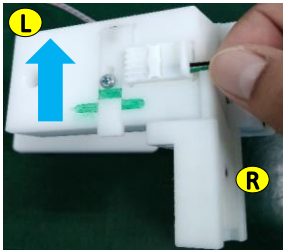
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1. AVSSf 0.3 G-B wires L=679±3mm

**JIG**

1. Insertion jig

| NO. | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   | TOOLS/PPE | QUALITY POINTERS   |
|-----|--|--|-----------|--|
| 3   | n/a<br><br>Wire insertion to Connector 6098-3810 (W) | <div><p>Wire facing</p></div> <div><p>1. Get the <b>Green wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Get the <b>Black wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>B wires</b> will be opened.</p></div> <div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div> | n/a       | <p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p><i>Note: Please hold the wire near terminal during insertion.</i></p> <p>1. No loose insertion<br/>2. No wrong insertion<br/>3. One by one insertion<br/>4. No deformed terminal<br/>5. No wrong wire facing</p> <p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion.<br/>Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p> |

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☐ PRE-LAUNCH








☒ MASSPRO

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| PARTS: |  | 1. Assy parts<br>2. Black vinyl tube $\phi 5$ L=69 $\pm$ 3mm   |  |  | JIG  | 1. Locking jig   |
|--------|--|--|--|--|--|--|
| NO.    | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   |  |  | TOOLS/PPE  | QUALITY POINTERS   |
| 4      | Connector lock   | <div></div> <div>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands. Touch the connector if it is properly locked.<br/><i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></div> <div><div><br/>Before Pressing</div><div><br/>After Pressing</div><div><div><br/>GOOD<br/>Fully Locked</div><div><br/>NG<br/>receiver</div></div></div> |  |  | <div>LOCKING JIG</div>  | <p><b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b></p> <p>1. Use the provided locking jig per model<br/>2. No unlocked/half-locked connector<br/>2. No damaged lock</p> |
| 5      | Wire insertion to Black vinyl tube $\phi 5$ L=69 $\pm$ 3mm | <div></div> <div>1. Get the Black Vinyl tube <math>\phi 5</math> L=69<math>\pm</math>3mm using right hand then insert the <b>G-B wires</b>.</div>  |  |  | n/a  | 1. No wrong use of parts   |

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