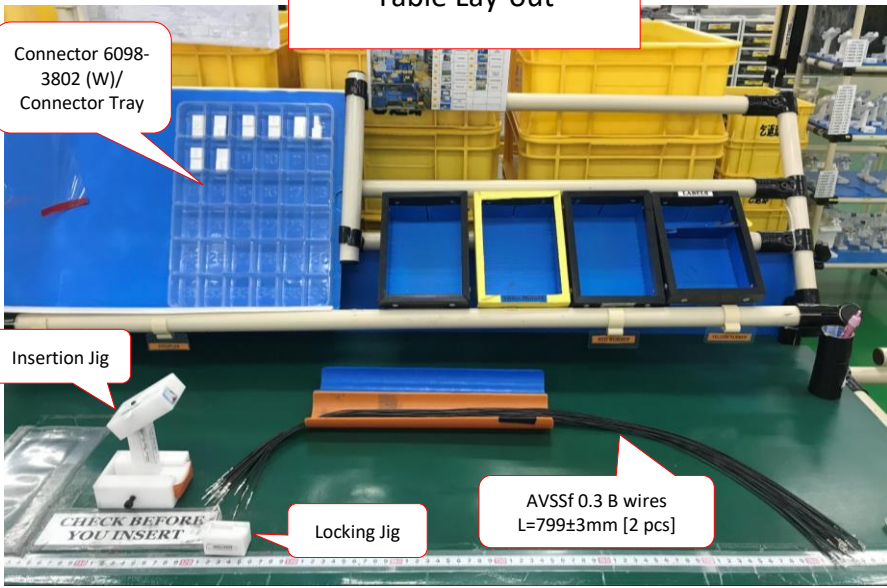




	<b>WORK INSTRUCTION</b>		Effectivity Date:	<b>February 3, 2022</b>	
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>		Validity Date:	n/a	
	Product Name/Code: <b>550B / 7L0082-7023</b>	Customer: <b>TRQSS</b>	Document No.:	<b>WI-ENG-PDE-388</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

<b>PARTS:</b>	1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B wires L=799±3mm [2 pcs]	<b>JIG:</b>	1. Insertion jig 2. Locking Jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Table Lay-out		<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History				Prepared by:	Checked by:	Approved by:	Noted by:			
02/03/22	0	Initial issue. Clamp quantity 82711-52090 (W), 2 clamps ;(Refer to WI-ENG-PDE-386B).	K. Doria	J. Loterte	C. Villanueva	A. Arañes	 K. Doria	 J. Loterte	 C. Villanueva	 A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	February 03, 2022		

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WORK INSTRUCTION  
OFFLINE ASSEMBLY PROCESS

Effectivity Date:	February 3, 2022		
Validity Date:	n/a		
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Process Name/Title:	OFFLINE ASSEMBLY PROCESS		
Product Name/Code:	550B / 7L0082-7023	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Connector 6098-3802 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector setting to insertion jig 6098-3802 (W)	<p>Insertion jig orientation</p> <p>Connector orientation</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector 6098-3802 (W) and insert into jig using right hand and release the lock using left hand.</p> <p>3. Check the holes/terminal slot for B/B wires.</p>		n/a	<p>Connector Orientation Illustration</p> <p>I-mark is align</p> <p>2 Holes are open.</p> <p>I-mark is not align</p> <p>All Holes are open.</p> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

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Customer: TRQSS

Validity Date:

n/a

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Purpose:


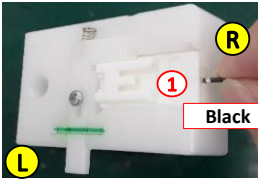
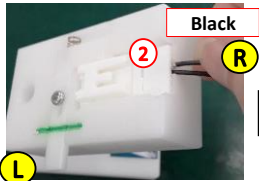


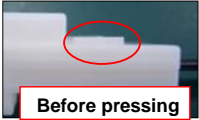




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSSf 0.3 B wires L=799±3mm [2 pcs]		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the first <b>Black wire</b> and insert to <b>Slot 1</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></p></div> <div><p>2. Get the second <b>Black wire</b> and insert to <b>Slot 2</b> of connector using right hand.</p></div> <div><p>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</p></div>		N/A	<p><b>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p> <p><b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p> <ol style="list-style-type: none"><li>No loose insertion</li><li>No wrong insertion</li><li>One by one insertion</li><li>No deformed terminal</li><li>No wrong wire facing</li></ol> <p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p>
4	Connector lock	<div><p>Put the connector into locking jig using both thumb then press to lock <b>2x</b>. Check the connector lock to confirm if properly pressed. <b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>GOOD</p><p>Full Lock</p></div> <div><p>NG</p><p>Half Lock</p></div>		<div><p>Locking jig</p></div>	<p><b>Note:</b> Use provided jig tool to lock the connector. Manual locking may cause damaged lock.</p> <ol style="list-style-type: none"><li>No unlock/half-locked connector</li><li>Use provided jig tool to lock the connector</li></ol>

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