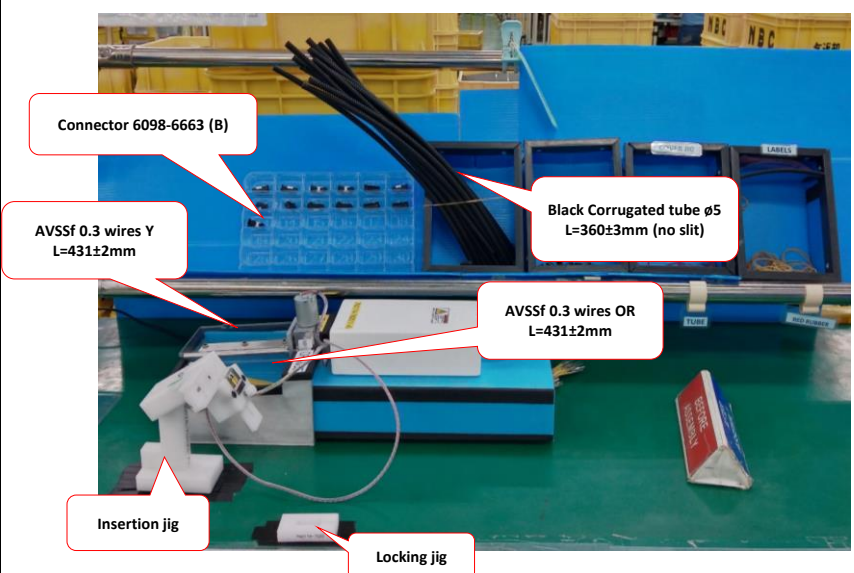




WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

Effectivity Date:	April 26, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-665		
Revision No.:	0	Page No.:	1 of 5

Process Name/Title:	373D / 7N0174-7020A			Customer:	TRJ
Model Code/Part Number:	373D	/	7N0174-7020A	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. All parts: Connector 6098-6663 (B) ; AVSSf 0.3 wires Y-OR L=431±2mm; Black Corrugated tube ø5 L=360±3mm (no slit);			JIG:	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<p>Table Lay-out</p> 		<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
04/26/23	0	Initial issue	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: April 26, 2023

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OFFLINE ASSEMBLY PROCESS

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Model Code/Part Number: 373D / 7N0174-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-655

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:

1. Connector 6098-6663 (B)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

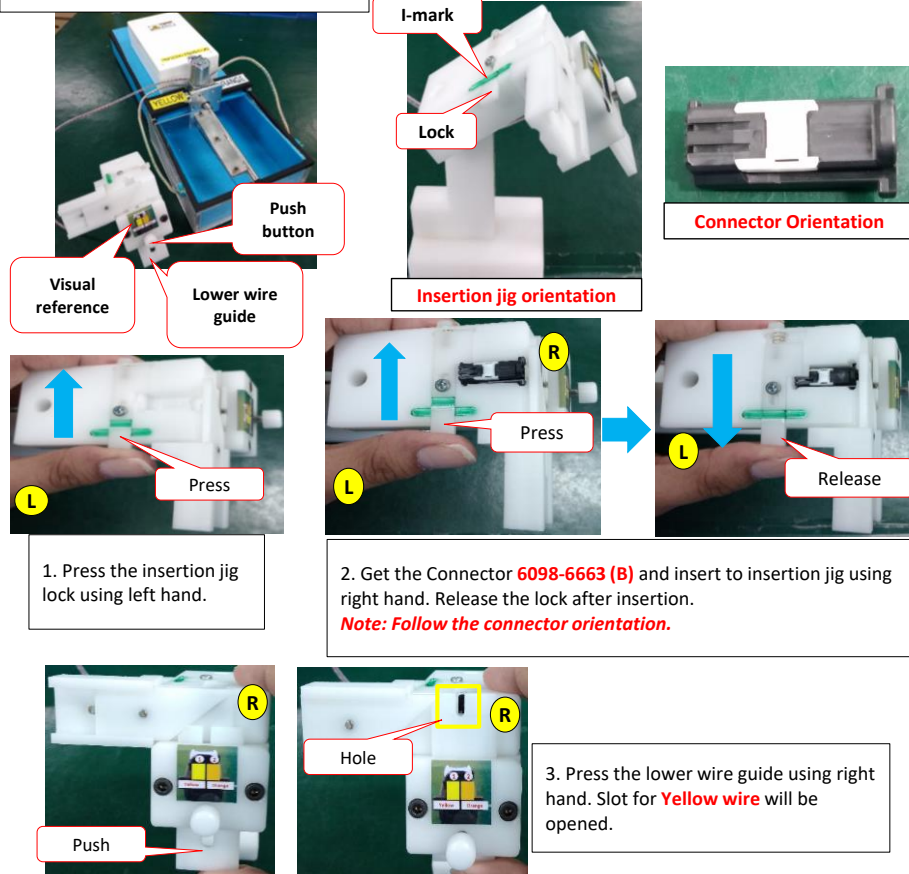
QUALITY POINTERS

2

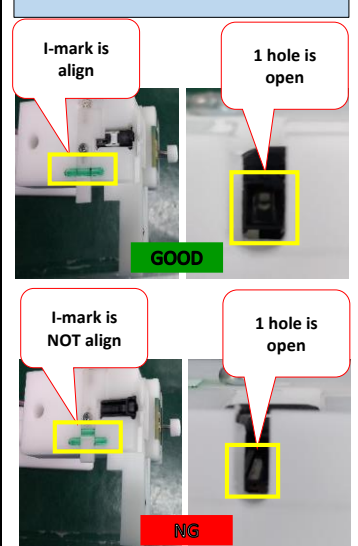
n/a

Connector setting to
insertion jig
6098-6663 (B)

INSERTION JIG WITH SWITCH COVER



Connector Orientation Illustration



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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Customer:

TRJ

Document No.:

WI-ENG-PDE-655

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

3 of 5

PARTS:

1. AVSSf 0.3 wires Y-OR L=431±2mm

JIG

1. Insertion jig

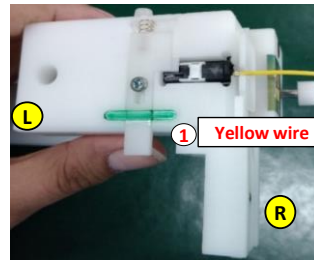
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

n/a

Wire insertion to connector
6098-6663 (B)

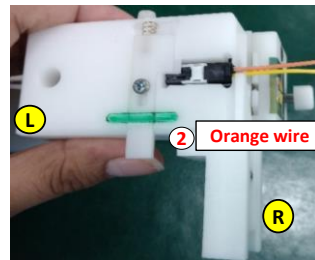
Wire facing



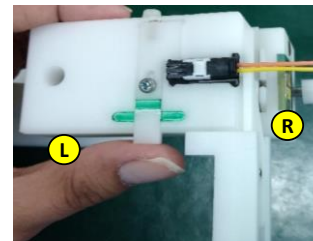
1. Hold the insertion jig using left hand.
Get the **Yellow wire** then insert to
terminal slot **1** using right hand.



2. Press the button using right thumb. The
slot for **Orange wire** will be opened.



3. Get the **Orange wire** then insert to
terminal slot **2** using right hand.



4. After insertion, push the lock using left thumb
and then hold the wires and gently pull out the
connector from jig using right hand.

n/a

Important reminders/Note/s:

1. Please hold the wire near terminal.
 2. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deform terminal
5. No wrong wire facing.

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Document No.:

WI-ENG-PDE-655

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

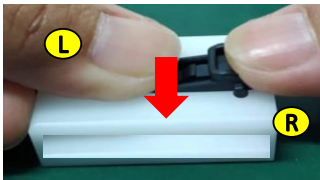






4 of 5

PARTS:

1. Assy parts

2. Black Corrugated tube $\varnothing 5$ L=360 \pm 3mm (no slit)**JIG**

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Connector lock	 <p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands.</p>   <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>   		Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use provided jig tool per model 2. No unlock/half-locked connector
5	Wire insertion to Black corrugated tube $\varnothing 5$ L=360 \pm 3mm (no slit)	 <p>1. Get the Black Corrugated tube $\varnothing 5$ L=360\pm3mm (no slit) using right hand then insert the Y-OR wires using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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Document No.:

WI-ENG-PDE-633

Purpose:



PROTOTYPE



PRE-LAUNCH



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Revision No.:

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Page No.:

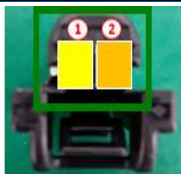
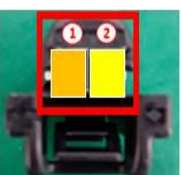
5 of 5

PARTS:

1. Assy parts

JIG

n/a

QUALITY CHECKPOINTS**N/A****7N0174-7020A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/Halflock Connector****3** No **Terminal Backing Out****2** No **Wrong Insert****4** No **Deformed Terminal**

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