

**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**September 9, 2022**Model Code/ Part Number: **817B / 7N0051-7020B**Customer: **TRJ**

Validity Date:

**n/a**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-258**

Revision No.:

**2**

Page No.:

**1 of 5****PARTS:**

1. Connector 6098-5677(W); IRRAX ROPE-LAY B L=366mm; Black Corrugated tube Ø5, L=280±3mm (no slit)

JIG:

1. Insertion jig
2. Terminal cover jig
3. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No missing parts/tools 2. No excess parts/tools</div> <div><b>Document references:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
09/09/22	2	Change Document name from (Kitting Assembly Process) to (Offline Assembly Process). Improve work procedure/illustration on process no. 1,2,3 and 4; Quality pointers and notes on Pg. no. 1, 3 and 4 due to process improvement.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes
07/08/21	1	Changed from pre-launch to masspro.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
04/08/21	0	Initial issue	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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PARTS:

1. Connector 6098-5677 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

2 WORK PROCEDURE/ ILLUSTRATION

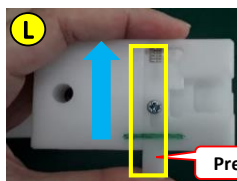
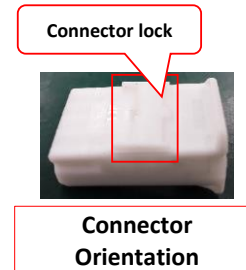
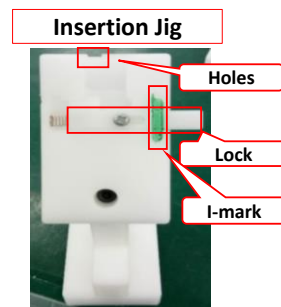
TOOLS/PPE

QUALITY POINTERS

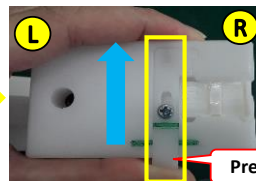
2

P1

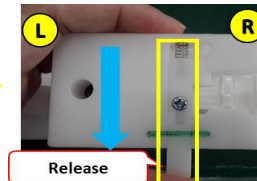
Connector setting to  
insertion jig  
6098-5677 (W)



1. Press the lock of insertion  
jig using left thumb.



2. Get the connector 6098-5677(W) using right hand and insert to  
insertion jig. Release the lock after insertion.



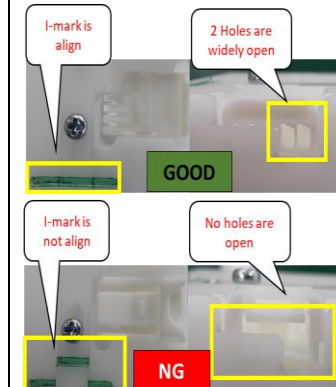
3. Check the holes/terminal slot for 2 Black wires.



n/a

1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

### Connector Orientation Illustration



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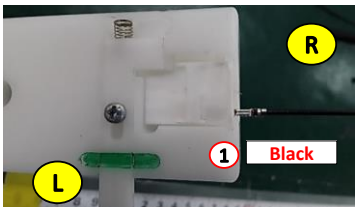
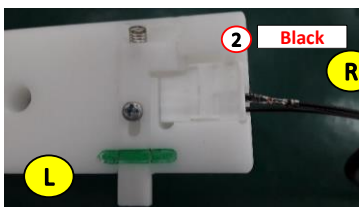
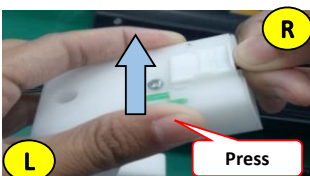
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PARTS:		1. IRRAX ROPE-LAY B L=366mm [2pcs]			JIG	1. Insertion jig
NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Connector 6098-5677 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Get <b>1st black wire</b> then insert to terminal slot ① using right hand.</p></div> <div><p>2. Get <b>2nd Black wire</b> then insert to terminal slot ② using right hand.</p></div> <div><p>3. After insertion, push 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	<div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></div> <div><p>2 Important reminders/Note/s:</p><p>1. Please hold the wire near terminal during insertion.</p><p>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Donot exert extra force.</p><p>3. Insertion should be from left to right.</p></div>

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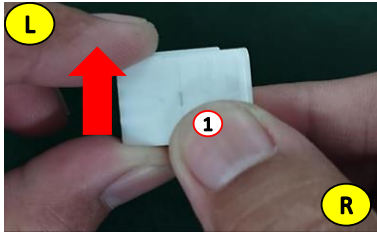



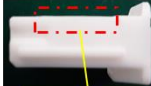

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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><p>1. Put the connector into locking jig using both thumb then press to lock <b>2x</b>.</p><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>Before Pressing</p><p>After Pressing</p></div>	<div><p>Locking jig</p></div>	<p>1. Use provided jig tool per model to avoid damaged lock. 2. No Unlock and half-locked connector 3. No damaged lock</p> <p>2 Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>2</p> <div><p>GOOD</p><p>Fully Locked</p><p>NG</p><p>UnLocked</p></div>

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PARTS:		1. Black Corrugated tube Ø5, L=280±3mm (no slit) 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Corrugated tube Ø5, L=280±3mm (no slit)	<div><div></div><div></div><div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand and insert the wires.</div><div>2. Get the corrugated tube Ø5, L=280±3 (no slit) using right hand and insert to wires.</div></div><div><div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal

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