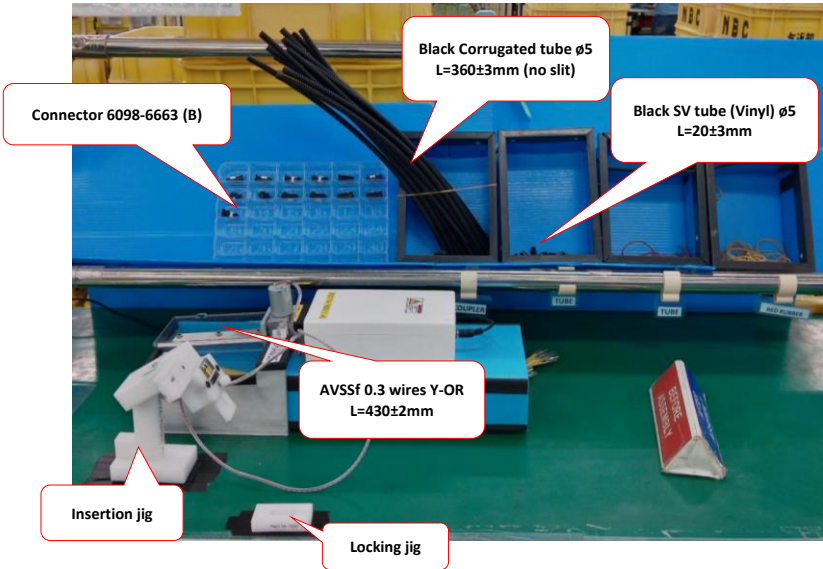




# WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

Effectivity Date:	January 31, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-633		
Revision No.:	1	Page No.:	1 of 5

Process Name/Title:			
Model Code/Part Number:	373D / 7N0174-7020	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=430±2mm; Black Corrugated tube ø5 L=360±3mm (no slit); Black SV tube (Vinyl) ø5 L=20±3mm			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><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><b>Document references:</b> 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
01/31/23	1	Change document purpose from pre-launch to masspro. Inclusion of quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
01/28/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 28, 2023			

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### PARTS:

1. Connector 6098-6663 (B)

### JIG

1. Insertion jig with switch cover

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

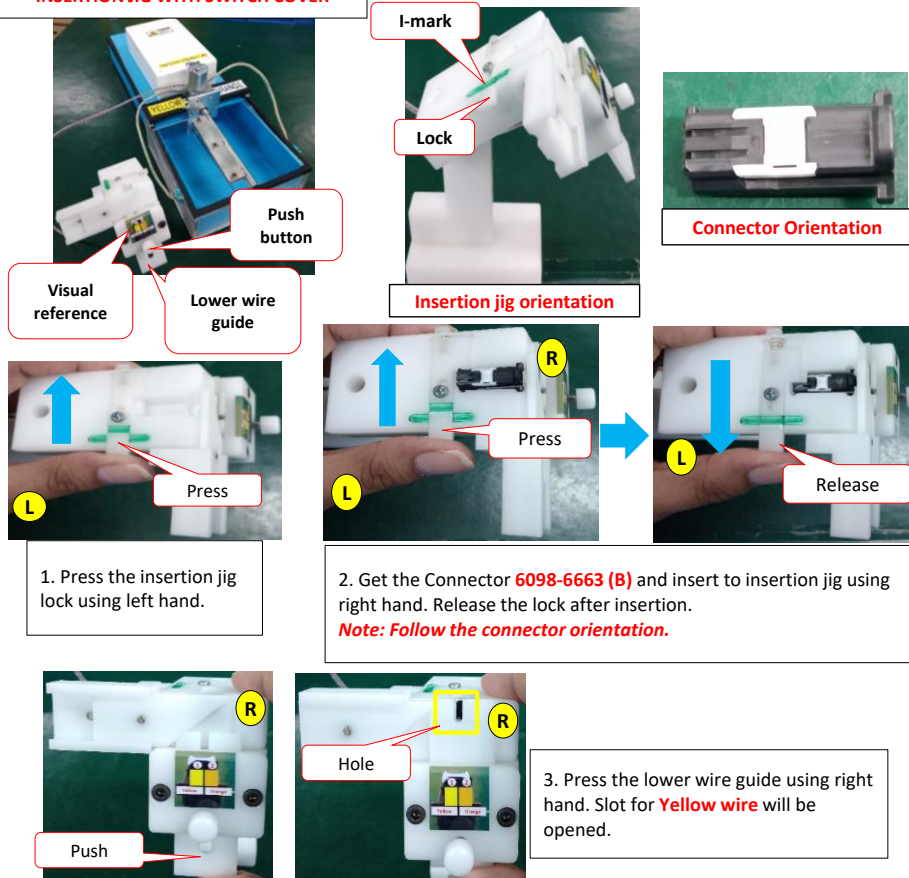
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2

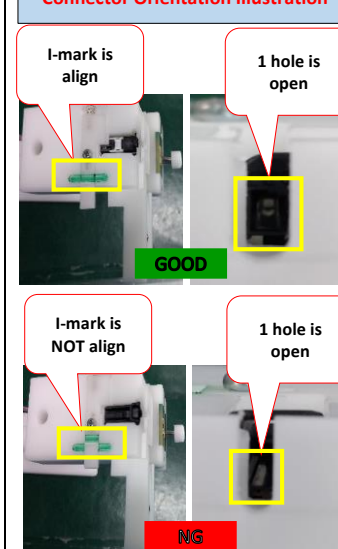
n/a

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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Purpose:



PROTOTYPE



PRE-LAUNCH



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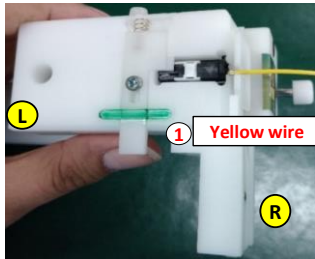
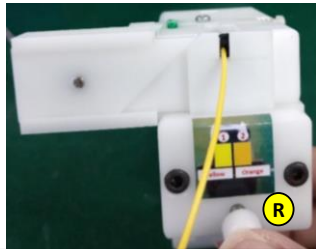
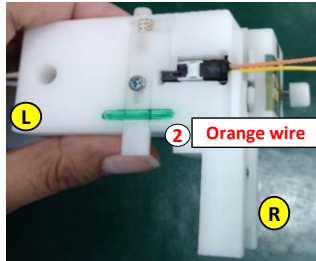
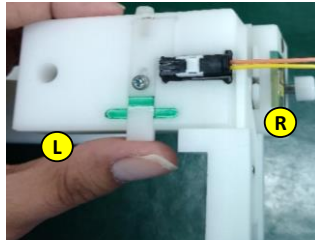
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**PARTS:**

1. AVSSf 0.3 wires Y-OR L=430±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)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>Orange wire</b> will be opened.</p></div> <div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>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.</p></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal.</li><li>2. Make sure wires are properly inserted.</li></ol> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b></p> <ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li></ol> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deform terminal</li><li>5. No wrong wire facing.</li></ol>

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Purpose:









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PARTS:		1. Assy parts 2. Black Corrugated tube $\phi 5$ L=360 $\pm$ 3mm (no slit) 3. Black SV tube (Vinyl) $\phi 5$ L=20 $\pm$ 3mm			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 <b>2x</b> using both hands.</p>  <p>1</p>  <p>2</p> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>  <p>BEFORE PRESSING</p>  <p>AFTER PRESSING</p>			LOCKING JIG 	<b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>  1. Use provided jig tool per model 2. No unlock/half-locked connector
5	Wire insertion to Black corrugated tube $\phi 5$ L=360 $\pm$ 3mm (no slit)	 <p>1. Get the Black Corrugated tube <math>\phi 5</math> L=360<math>\pm</math>3mm (no slit) using right hand then insert the <b>Y-OR wires</b> using left hand.</p>			n/a	1. No wrong use of parts 2. No deformed terminal
6	Wire Insertion to Black SV tube (Vinyl) $\phi 5$ L=20 $\pm$ 3mm	 <p>1. Get the Black SV tube (Vinyl) <math>\phi 5</math> L=20<math>\pm</math>3mm using right hand then insert the <b>Y-OR wires</b> using left hand.</p>			n/a	1. No wrong use of parts

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/

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☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG

n/a



## QUALITY CHECKPOINTS

N/A

7N0174-7020



GOOD



GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

- 1 No Unlock/Halflock Connector
- 2 No Wrong Insert
- 3 No Terminal Backing Out
- 4 No Deformed Terminal

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