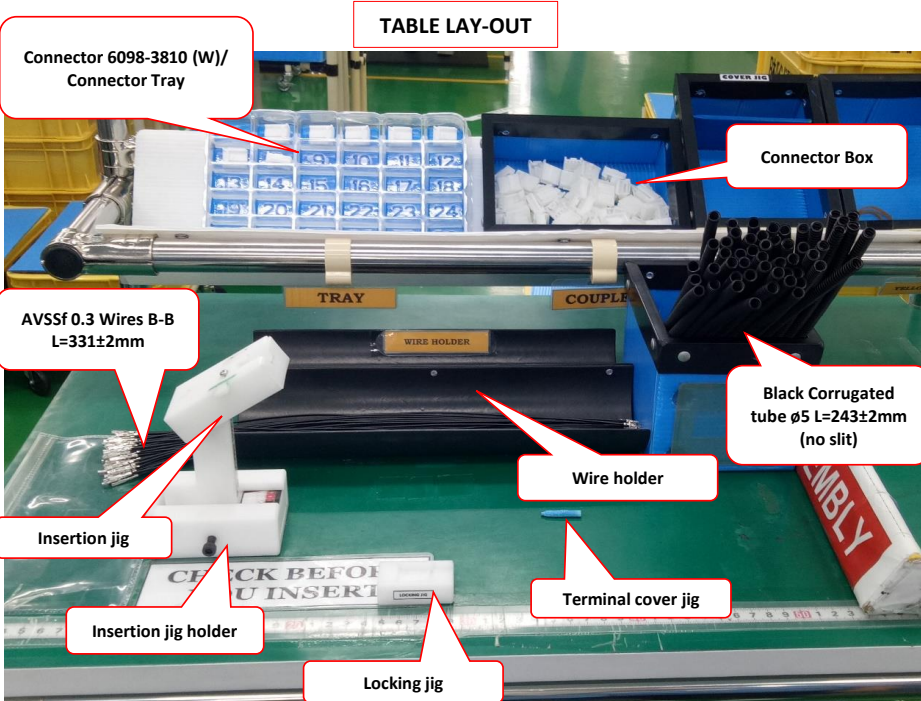

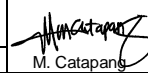


	WORK INSTRUCTION				Effectivity Date: September 17, 2022	
	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date: n/a	
	Model Code/Part Number: 817B / 7N0052-7020B		Customer: TRJ		Document No.: WI-ENG-PDE-264	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.: 1 of 4	

PARTS: 1. Connector 6098-3810 (W); IRRAX A 0.3 B L=331±2mm [2pcs.]; Black corrugated tube (no slit) ø5 L=243±2mm		JIG: 1. Insertion jig 2. Terminal cover jig	
NO. 1	PROCESS NAME n/a	WORK PROCEDURE/ILLUSTRATION <div style="text-align: center;">  </div>	TOOLS/PPE <div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction Be sure to wear prescribed 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> </div>
		QUALITY POINTERS <p>Document reference/s:  3</p> <p>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 3. No wrong position of parts/tools</p>	

				Prepared by		Reviewed by		Approved by		Noted by	
09/17/22	3	Improve quality pointers: Reminders/notes and references in process no.1,2,3 and 4 due to document improvement. Change of document title from 'Kitting assembly process' to 'Offline assembly process. Improve work procedure and illustration in process no.4 - connector lock.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
01/03/22	2	Inclusion of wire tolerance in all wires in parts section. Additional checkpoint "Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance". Change COT length from L=245±3mm to L=243±2mm due to encountered minimum dimension from end tape to terminal tip				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
07/17/21	1	Removal of validity date. Change status from pre-launch to masspro. Apply note in quality pointers.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:	April 17, 2021

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WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **817B / 7N0052-7020B**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

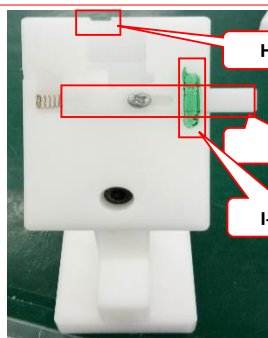
QUALITY POINTERS

2

n/a

Connector setting to
insertion jig
6098-3810 (W)

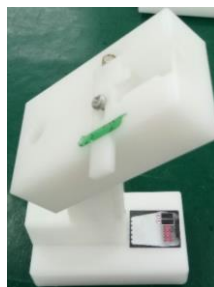
INSERTION JIG



Holes

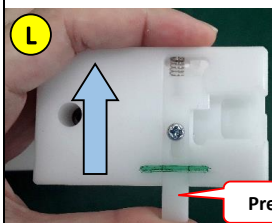
Lock

I-mark



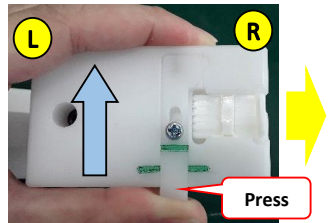
Connector
Orientation

INSERTION JIG ORIENTATION



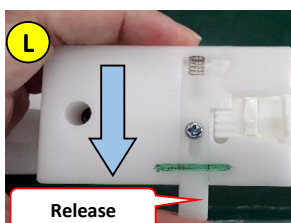
Press

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



Press

2. Get the connector **6098-3810 (W)** using right hand then insert to jig
using right hand and release the lock using left thumb.
Note: Follow the connector orientation.



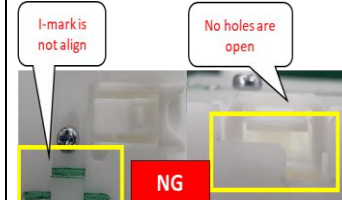
Release



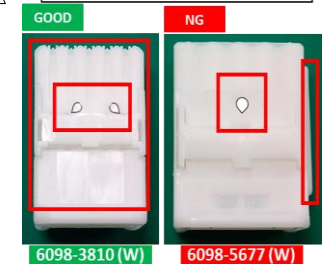
3. Check the holes/terminal slot
for **B/B wires**.

n/a

Connector Orientation Illustration



CONNECTOR 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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**WORK INSTRUCTION**

Effectivity Date:

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Model Code/Part Number: **817B / 7N0052-7020B**

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WI-ENG-PDE-264

Purpose:


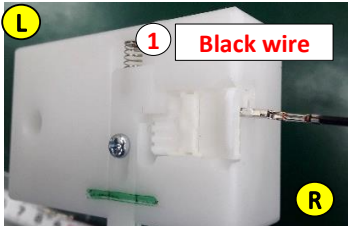

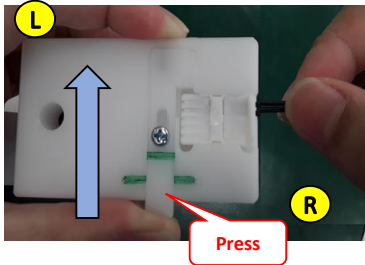
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PARTS:	1. IRRAX A 0.3 B L=331±2mm [2pcs.]			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to connector 6098-3810 (W)	<div><p>Wire facing</p></div> <div><p>1. Get 1st black wire then insert to terminal slot ① using right hand.</p></div> <div><p>2. Get 2nd Black wire 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	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>3</p> <p>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. 3. Insertion of wires must be from left to right</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

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n/a

Process Name/Title:

Model Code/Part Number: 817B / 7N0052-7020B

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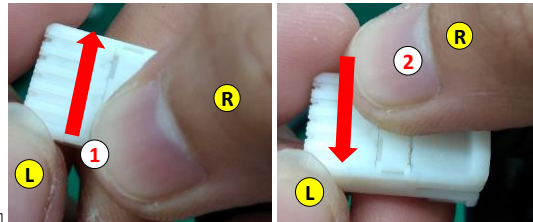


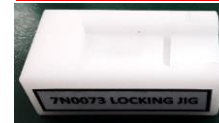
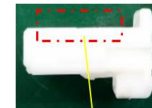
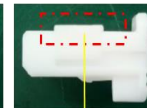




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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\phi 5$ L=243 \pm 2mm		JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector Lock	<div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div> <div><p>Before Pressing</p><p>After Pressing</p></div>		<div>LOCKING JIG</div> 	<div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div> <div>CONNECTOR LOCK CONDITION</div> <div><p>GOOD</p><p>Fully Locked</p><p>NG</p><p>UnLocked</p></div>
5	Wire insertion to Black Corrugated tube (no slit) $\phi 5$ L=243 \pm 2mm	<div><div><p>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div><div><p>2. Get the corrugated tube (no slit) $\phi 5$ L=243\pm2mm using right hand then insert the B-B wires using left hand.</p></div><div><p>3. Remove the terminal cover jig after insertion using right hand.</p></div></div>		<div>TERMINAL COVER JIG</div> 	<div>1. No wrong use of parts 2. No deformed terminal</div>

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