



# WORK INSTRUCTION

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

Model Code/Part Number: **715W / 7H0421W7020**

Customer: **NBS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 06, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-515

Revision No.:

1

Page No.:

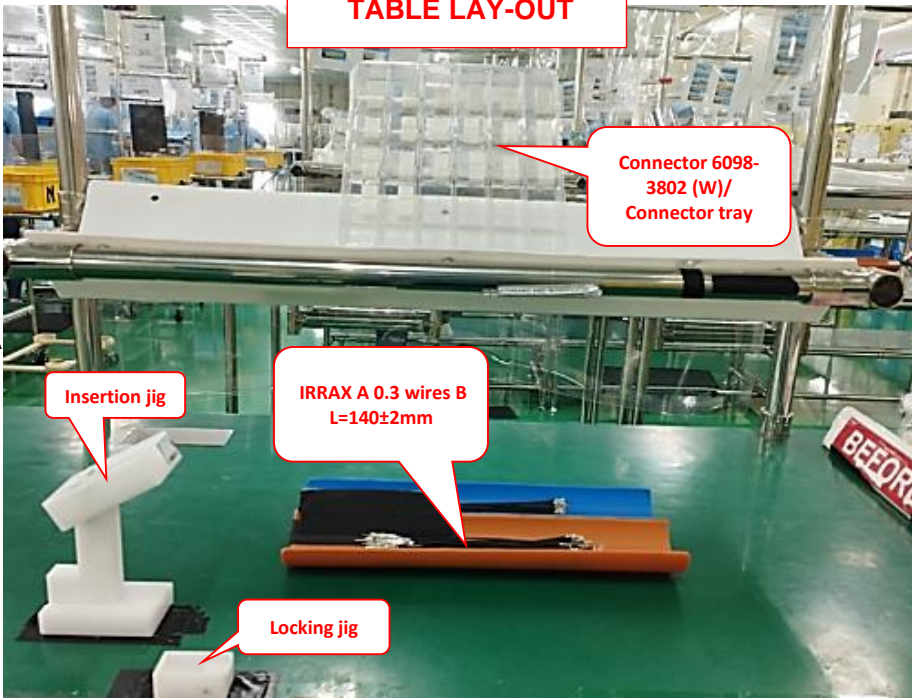
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## PARTS:

1. All parts; Connector 6098-3802 (W); IRRAX A 0.3 wires B L=140±2mm

## JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<p><b>TABLE LAY-OUT</b></p> 	<p><b>Safety Instruction</b> Be sure to wear prescribed 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 work place 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: Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</i></p> <ol style="list-style-type: none"><li>1. No missing parts/tools.</li><li>2. No excess parts/tools.</li></ol>

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
05/06/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	M.Ariola	J. Loterte	C.Villanueva	A. Arañes
05/02/22	0	Initial Issue	M.Ariola	J. Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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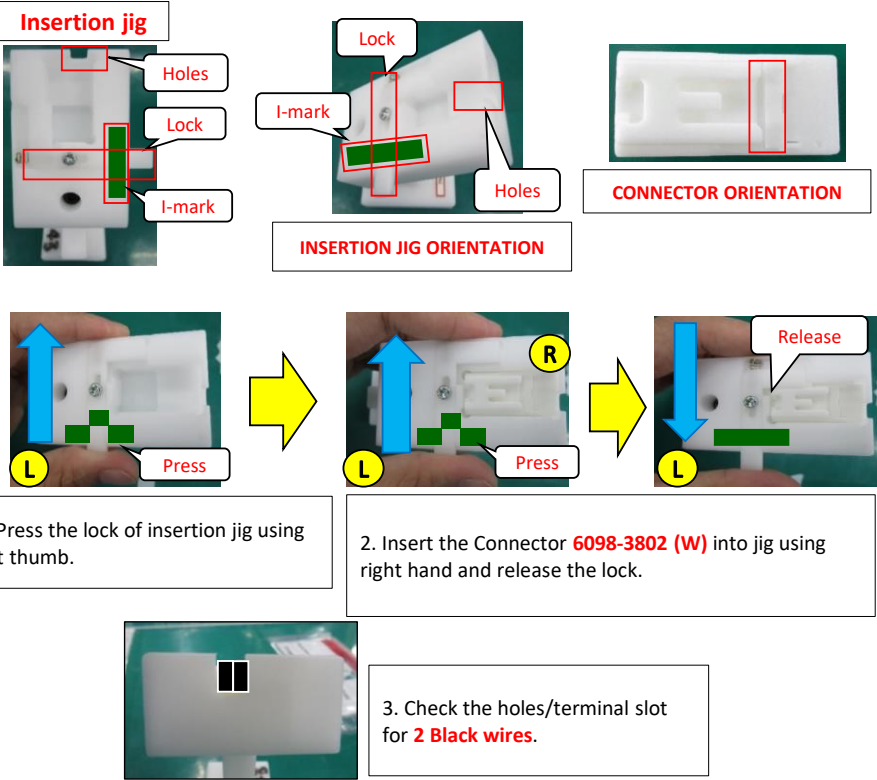
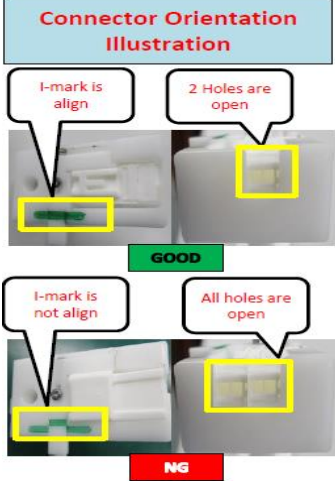
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Effectivity Date:	May 06, 2022		
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Model Code/Part Number: **715W / 7H0421W7020** Customer: **NBS**


Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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

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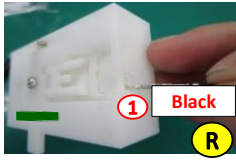
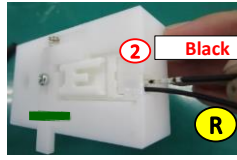
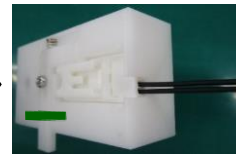
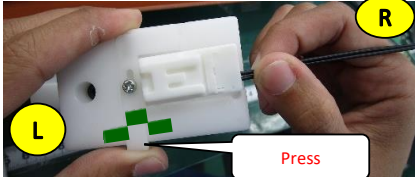

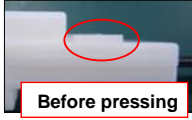



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.: 3 of 3

<b>PARTS:</b>	1. IRRAX A 0.3 wires B L=140±2mm [2pcs]		<b>JIG</b>	1. Insertion jig 2. Locking jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to Connector 6098-3802 (W)	 <p><b>Wire facing</b></p>    <p>1. Get the <b>1st black wire</b> and insert to connector using right hand. Conduct one by one insertion from left to right.</p> <p>2. Get the <b>2nd black wire</b> and insert to connector using right hand.</p> <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>  <p><b>Press</b></p>	n/a	<p><i>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</i></p> <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>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure</i></p>
4	Connector lock	  <p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b>. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p> <div> <div> <p><b>GOOD</b></p>  <p>Full Lock</p> </div> <div> <p><b>NG</b></p>  <p>Half Lock</p> </div> </div>	<b>LOCKING JIG</b> 	<p>1. Use the provided jig per connector 2. No unlock/half-locked coupler</p> <p><i>Note: Manual locking may cause damaged lock.</i></p>

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