

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

Effectivity Date:

September 30, 2021Model Code/Part Number: **660B / 7R0111-7020B**Customer: **TRMX**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-348

Revision No.:

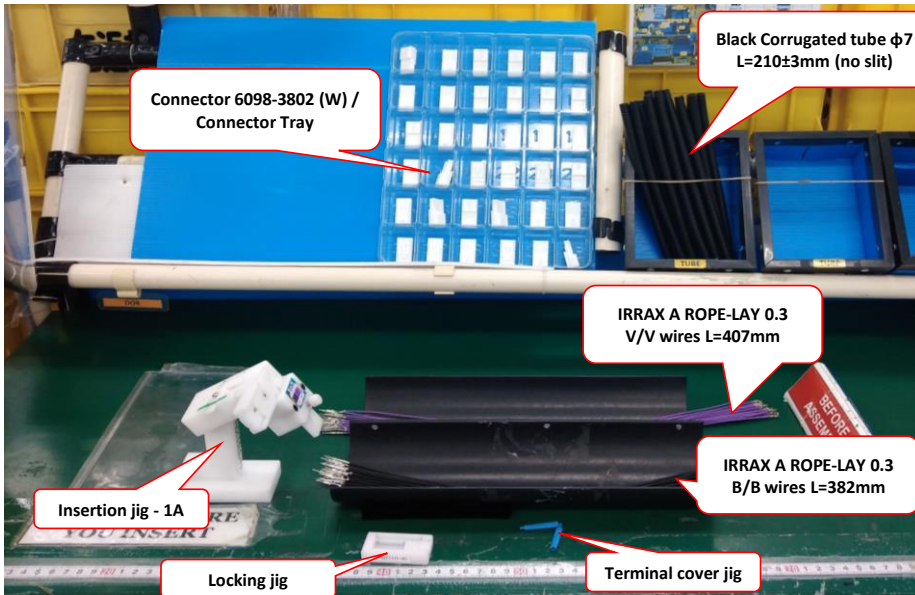
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1 of 4**PARTS:**1. All parts (Connector 6098-3802 (W); IRRAX A ROPE-LAY 0.3 B/B L=382mm; V/V L=407mm; Black corrugated tube (no slit) $\phi 7$ L=210 \pm 3mm)

JIG:

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

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/30/21	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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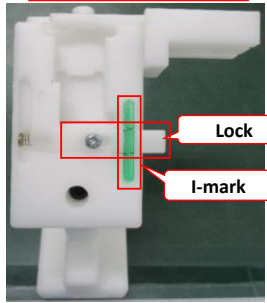
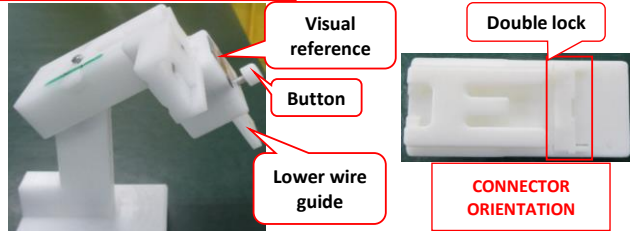
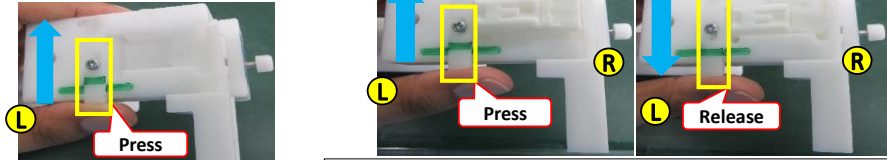
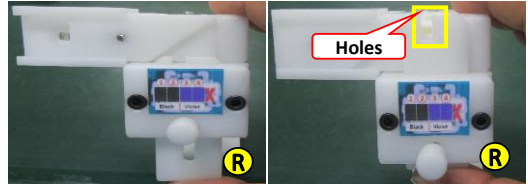
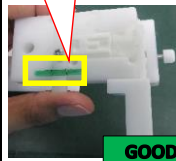
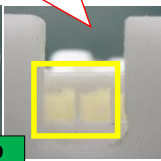
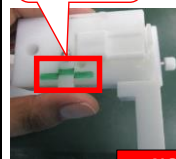
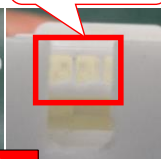
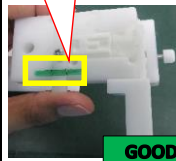
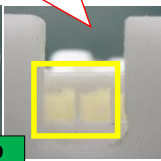
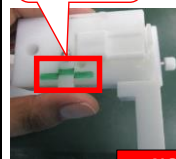
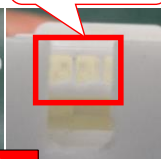
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PARTS:		1. Connector 6098-3802 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector setting to insertion jig 6098-3802 (W)	<div><div><div>Insertion Jig</div></div><div><div>Insertion Jig Orientation</div></div><div></div><div><div>2. Insert the connector 6098-3802 (W) using right hand and release the lock using left hand. Note: Follow the connector orientation.</div></div><div></div><div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div> <div><div>1. Press the lock of insertion jig using left thumb.</div></div> <div>n/a</div> <td colspan="2"><div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div></div><div>2 holes were only open</div></div><div>GOOD</div><div><div>I-mark is NOT align</div></div><div>2 holes were open</div><div>NG</div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></td>		<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div></div><div>2 holes were only open</div></div> <div>GOOD</div> <div><div>I-mark is NOT align</div></div> <div>2 holes were open</div>  <div>NG</div> <div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div>	

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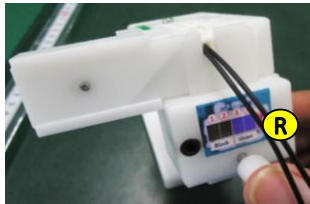
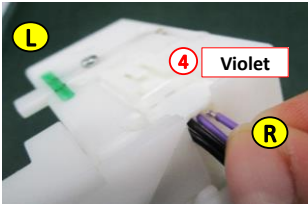

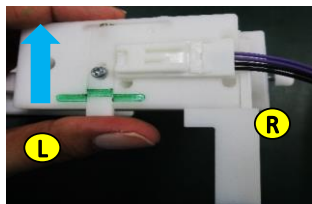
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PARTS:		1. IRRAX A ROPE-LAY 0.3 B/B L=382mm; V/V L=407mm			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to Connector 6098-3802 (W)	<div><div><div>WIRE FACING</div></div><div><div>1. Get the 1st Black wire then insert to terminal slot 1 using right hand.</div></div><div><div>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</div></div><div><div>3. Press the button using right thumb. The slot for V/V wires will be opened.</div></div><div><div>4. Get the 1st Violet wire then insert to terminal slot 3 using right hand.</div></div><div><div>5. Get the 2nd Violet wire then insert to terminal slot 4 using right hand.</div></div><div><div>6. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div></div> <div>n/a</div> <td><p><i>Note:</i> Please hold the wire near terminal during insertion.</p><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p><i>Note:</i> Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></td>		<p><i>Note:</i> Please hold the wire near terminal during insertion.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><i>Note:</i> Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>	

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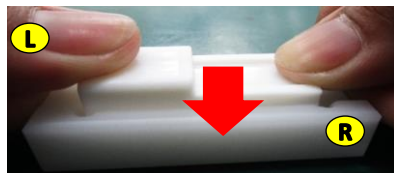
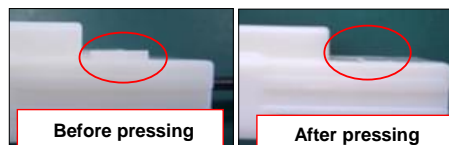
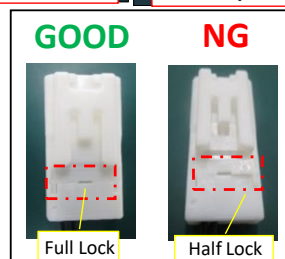


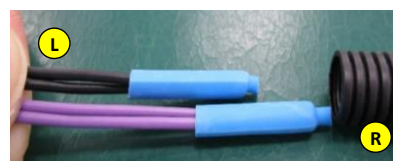


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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\phi 7$ L=210 \pm 3mm		JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock	<div></div> <div>1. Put the connector into locking jig both hands then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></div> <div></div> <div></div>		<div>LOCKING JIG</div> 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p>
5	n/a Wire insertion to Black corrugated tube $\phi 7$ L=210 \pm 3mm (no slit)	<div></div> <div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B/B-V/V wires using left hand.</div> <div></div> <div>2. Get the corrugated tube (no slit) $\phi 7$ L=210\pm3mm using right hand then insert B/B-V/V wires using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig of all wires using right hand.</div>		<div>TERMINAL COVER JIG</div> 	<p>1. No wrong usage of parts 2. No deformed terminal tip</p>

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