



WORK INSTRUCTION

Process Name/Title:

LOCKING PROCESS

Model Code/Part Number:

N/A

/

6098-2220 (W)

Customer:

N/A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 26, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-667

Revision No.:

0

Page No.:

1 of 2

PARTS:

1. Assy parts

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

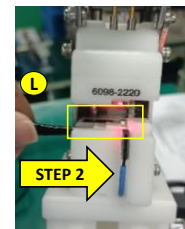
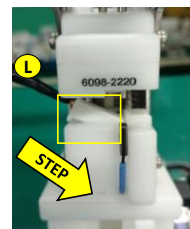
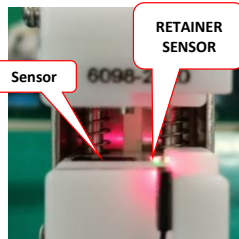
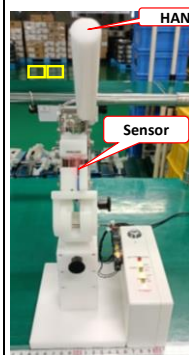
TOOLS/PPE

QUALITY POINTERS

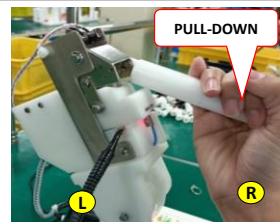
1

n/a

Connector lock



1. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock.
NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.



2. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.

Safety Instruction

Be sure to wear required 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.

1. Maintain 10mm proper holding of wire to connector
2. Connector must be fully inserted to connector slot.
3. Make sure no offset setting before locking process.
4. No wrong setting of connector.
5. No damaged connector lock
6. No unlocked/ half-locked connector.

Important reminders/Note/s:

1. **Incomplete locking process will alarm the jig.**
2. **No retainer in connector cannot proceed.**
3. **If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.**

Revision History

Prepared by

Reviewed by

Approved by

Noted by

04/26/23

0

Initial Issue.

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Eff. Date Rev. No

Details of Change

Revised

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Approved

Noted

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April 26, 2023

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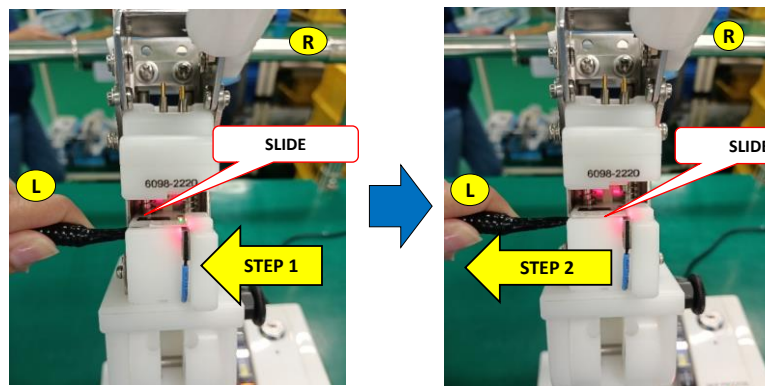
TOOLS/PPE

QUALITY POINTERS

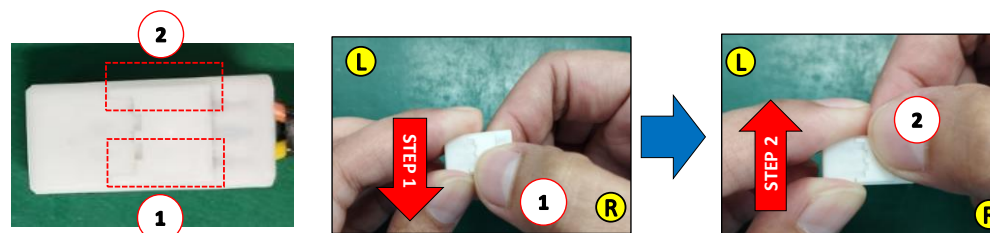
2

n/a

Connector lock
(Continuation)



3. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.



4. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

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