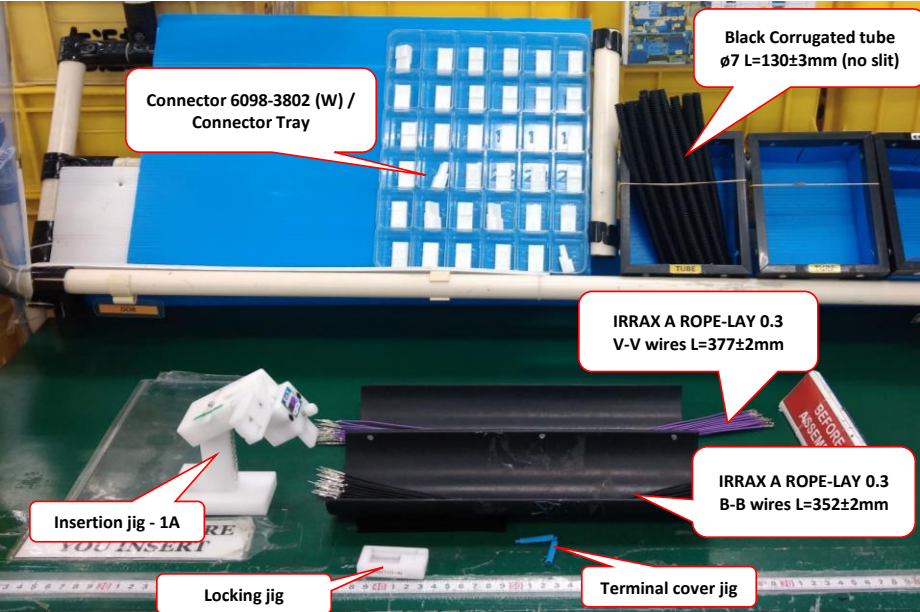




	WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS				Effectivity Date:		September 30, 2022	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: 660B / 7R0111-7021		Customer: TRMX		Document No.:		WI-ENG-PDE-450	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2		Page No.: 1 of 5	

PARTS:		1. All parts: Connector 6098-3802 (W); IRRAX A ROPE-LAY 0.3 B-B L=352±2mm; V-V L=377±2mm; Black corrugated tube (no slit) ø7 L=130±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	<p>Table Lay-out</p> 			<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>		<p>Document reference/s: 2</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</p>	

Revision History				Prepared by		Reviewed by		Approved by		Noted by			
09/30/22	2	Improve quality pointers: Reminders/notes and references in process no.1,2,3,4 and 5 due to document improvement: Work procedure/illustration in process no.4 - connector lock.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/11/22	1	Change document purpose from prelaunch to masspro				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/09/22	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 09, 2022		

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WI-ENG-PDE-450

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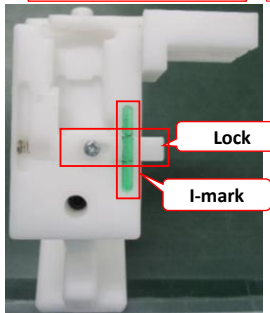
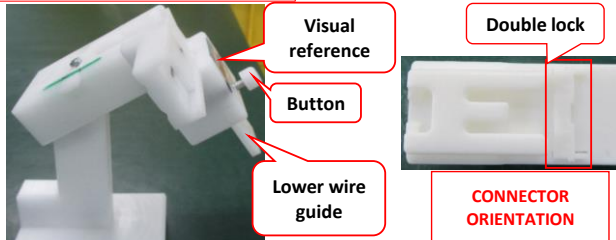
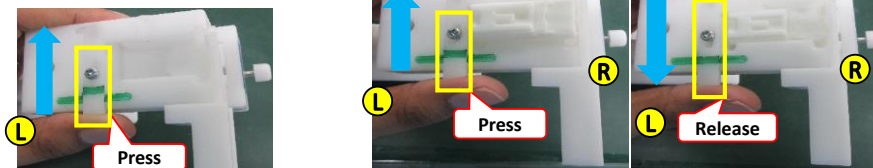
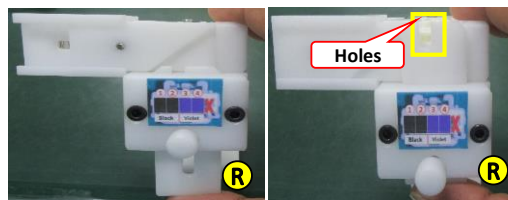
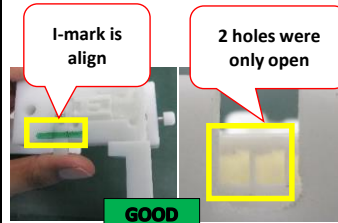
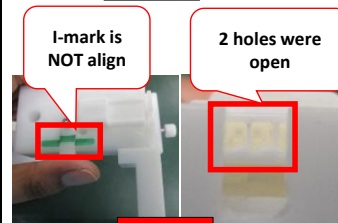
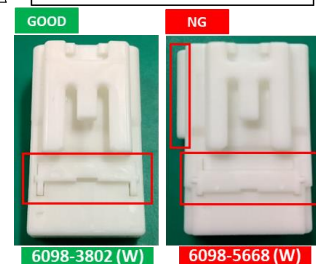
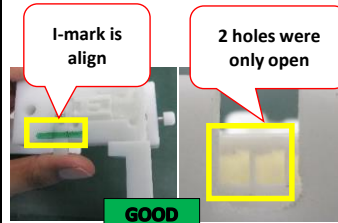
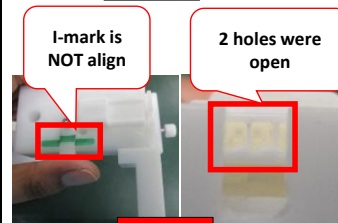
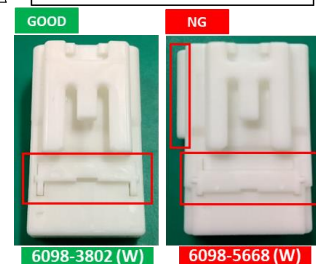
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PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<div><div><p>Insertion Jig</p><p>Lock</p><p>I-mark</p></div><div><p>Insertion Jig Orientation</p><p>Visual reference</p><p>Button</p><p>Lower wire guide</p><p>Double lock</p><p>CONNECTOR ORIENTATION</p></div><div><p>Press</p><p>Release</p></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the connector 6098-3802 (W) using right hand and release the lock using left hand. <i>Note: Follow the connector orientation.</i></p></div><div><p>Holes</p><p>3. Check the holes/terminal slot for B-B wires.</p></div></div> <div>n/a</div> <td><div><p>Connector Orientation Illustration</p><p>I-mark is align</p><p>2 holes were only open</p><p>GOOD</p><p>I-mark is NOT align</p><p>2 holes were open</p><p>NG</p><p>2</p><p>CONNECTOR ILLUSTRATION</p><p>GOOD</p><p>NG</p><p>6098-3802 (W)</p><p>6098-5668 (W)</p><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div></td>		<div><p>Connector Orientation Illustration</p><p>I-mark is align</p><p>2 holes were only open</p><p>GOOD</p><p>I-mark is NOT align</p><p>2 holes were open</p><p>NG</p><p>2</p><p>CONNECTOR ILLUSTRATION</p><p>GOOD</p><p>NG</p><p>6098-3802 (W)</p><p>6098-5668 (W)</p><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div>	

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Model Code/Part Number: **660B / 7R0111-7021**

Customer: **TRMX**

Document No.:

WI-ENG-PDE-450

Purpose:

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☐ PRE-LAUNCH




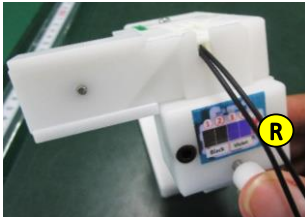
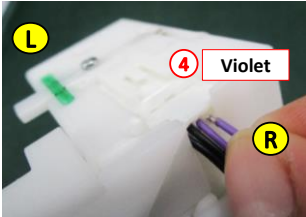
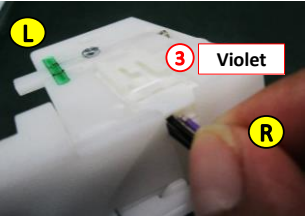
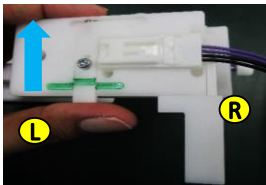
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PARTS:		1. IRRAX A ROPE-LAY 0.3 B-B L=352±2mm; V-V L=377±2mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	<div>Wire insertion to Connector 6098-3802 (W)</div> <div><div><p>WIRE FACING</p></div><div><p>1. Get the 1st Black wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</p></div><div><p>3. Press the button using right thumb. The slot for V-V wires will be opened.</p></div><div><p>4. Get the 1st Violet wire then insert to terminal slot 3 using right hand.</p></div><div><p>5. Get the 2nd Violet wire then insert to terminal slot 4 using right hand.</p></div><div><p>6. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>			n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>5. No wrong wire facing</div> <div>2 Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal.</div> <div>2. Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div> <div>2 Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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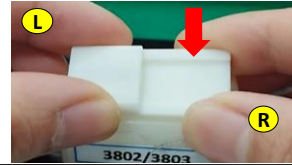



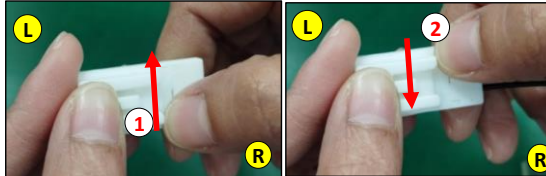

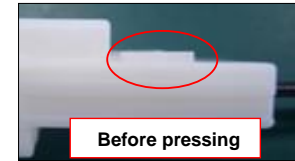



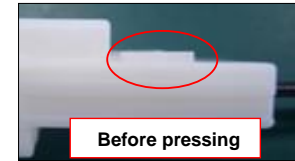



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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div><div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div> <div><p>LOCKING JIG</p></div> <td><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>Full Lock</p></div><div><p>Half Lock</p></div></div><div><p>GOOD NG</p></div><div>2 Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div><div>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</div></td>		<div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div><p>Full Lock</p></div><div><p>Half Lock</p></div></div> <div><p>GOOD NG</p></div> <div>2 Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</div>	

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WI-ENG-PDE-450

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\varnothing 7$ L=130 \pm 3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black corrugated tube $\varnothing 7$ L=130 \pm 3mm (no slit)	<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) $\varnothing 7$ L=130\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>			<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal tip
	n/a					

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