

**WORK INSTRUCTION**Process Name/Title: **KITTING ASSEMBLY PROCESS**Product Name/Code: **550B / 7L0082-7022**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**May 20, 2021**

Validity Date:

**n/a**

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**WI-ENG-PDE-269**

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**0**

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**1 of 2****PARTS:**

1. Connector 6098-3802 (W)
2. AVSSf 0.3 B wires L=799mm [2 pcs]

**JIG:**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Connector setting to insertion jig 6098-3802 (W)	<p><b>Insertion jig</b></p> <p><b>Lock</b></p> <p><b>Holes</b></p> <p><b>I-mark</b></p> <p><b>Insertion jig orientation</b></p> <p><b>Connector orientation</b></p> <p><b>Connector Lock</b></p> <p><b>Press</b></p> <p><b>Release</b></p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector <b>6098-3802 (W)</b> and insert into jig using right hand and release the lock using left hand.</p> <p>3. Check the holes/terminal slot for B/B wires.</p>	<p><b>Safety Instruction</b></p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <ol style="list-style-type: none"><li>1. Maintain and always practice 5's.</li><li>2. Personal things on the workplace is prohibited. Keep it in your locker.</li></ol> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Connector Orientation Illustration</b></p> <p><b>I-mark is align</b></p> <p><b>2 Holes are open.</b></p> <p><b>I-mark is not align</b></p> <p><b>All Holes are open.</b></p> <ol style="list-style-type: none"><li>1. Use provided jig per model</li><li>2. No wrong usage of parts</li><li>3. No wrong orientation of connector</li><li>4. No damaged connector</li></ol>

## Revision History

Prepared by:

Checked by:

Approved by:

Noted by:

05/20/21	0	Transfer process from Sub-assy to Kitting. Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003.	D.Castillo	C.Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	May 22, 2021		

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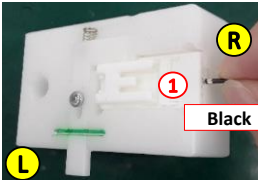
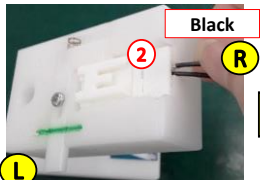







☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	n/a			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the first <b>Black wire</b> and insert to <b>Slot 1</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></p></div> <div><p>2. Get the second <b>Black wire</b> and insert to <b>Slot 2</b> of connector using right hand.</p></div> <div><p>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</p></div>		N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.
3	Connector lock	<div><p>Put the connector into locking jig using both thumb then press to lock <b>2x</b>. Check the connector lock to confirm if properly pressed. <b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>GOOD Full Lock</p></div> <div><p>NG Half Lock</p></div>		<div>Locking jig</div> 	<p><b>Note:</b> Use provided jig tool to lock the connector. Manual locking may cause damaged lock.</p> <p>1. No unlock/half-locked connector 2. Use provided jig tool to lock the connector</p>

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