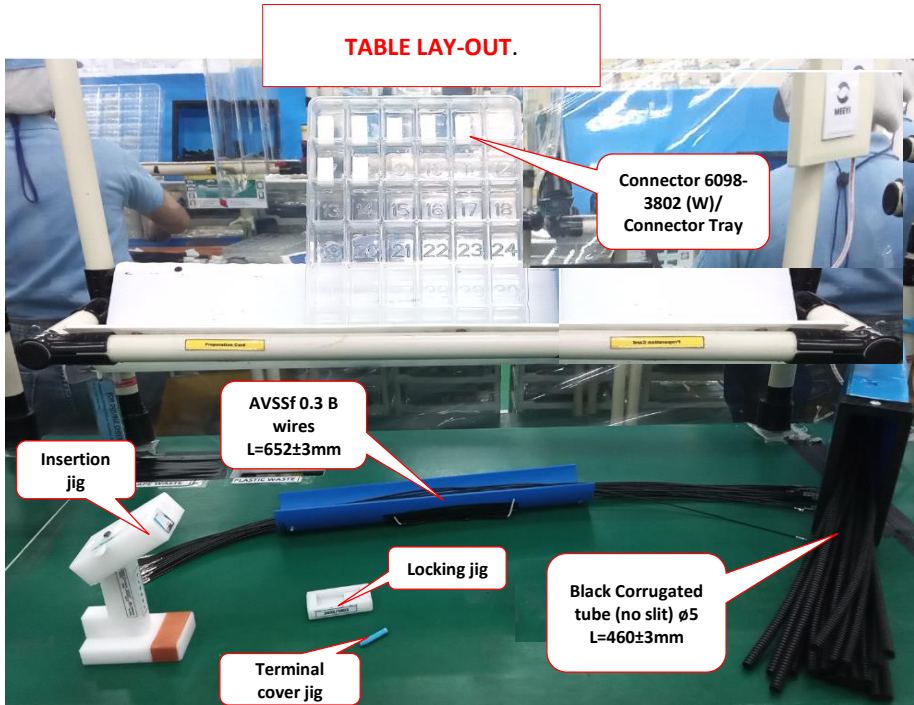
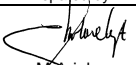

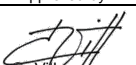

	<b>WORK INSTRUCTION</b> <b>OFFLINE ASSEMBLY PROCESS</b>				Effectivity Date: <b>February 14, 2022</b>	
	Process Name/Title:				Validity Date:	
	Model Code/Part Number: <b>550B / 7L0081-7023</b>		Customer: <b>TRQSS</b>		Document No.: <b>WI-ENG-PDE-407</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 0         Page No.: 1 of 4	

<b>PARTS:</b> 1.All parts; Connector 6098-3802 (W); AVSSf 0.3 B wires L=652±3mm;Black Corrugated tube (no slit) ø5 L=460±3mm		<b>JIG:</b> 1. Insertion jig 2. Locking jig 3.Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	Table Lay-out		<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>
		<b>QUALITY POINTERS</b>	
		<b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</b>  1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/14/22	0	Initial Issue.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	February 14, 2022			

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## WORK INSTRUCTION

### OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **550B / 7L0081-7023**

Customer:

**TRQSS**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**February 14, 2022**

Validity Date:

**n/a**

Document No.:

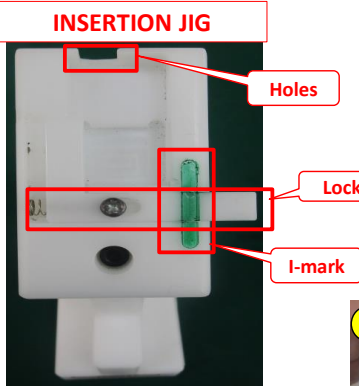
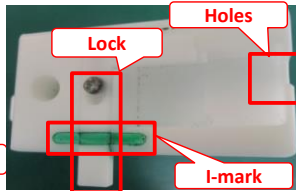
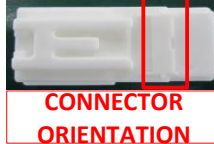
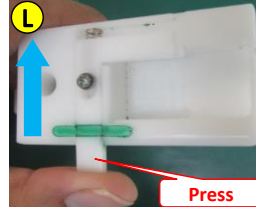
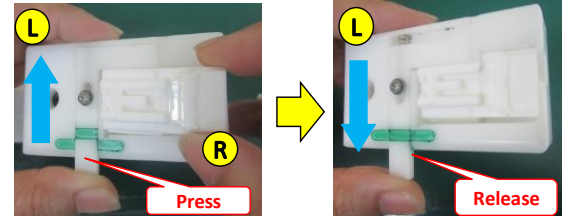





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PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector setting to insertion jig 6098-3802 (W)	<div><div><div></div><div></div><div></div></div><div><div></div><div></div></div><div><div></div><div>2. Insert the connector <b>6098-3802 (W)</b> into jig using right hand and release the lock using left hand.</div><div>3. Check the holes/terminal slot for <b>B/B wires</b>.</div></div></div>		n/a	<div><div><div></div><div></div><div></div><div></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></div>

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## WORK INSTRUCTION

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Effectivity Date:

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Model Code/Part Number: **550B / 7L0081-7023**

Customer:

**TRQSS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

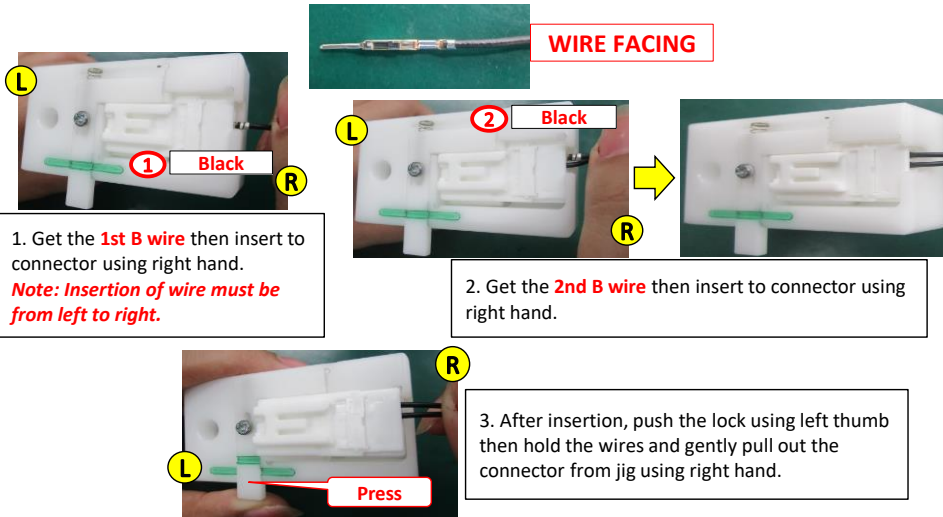
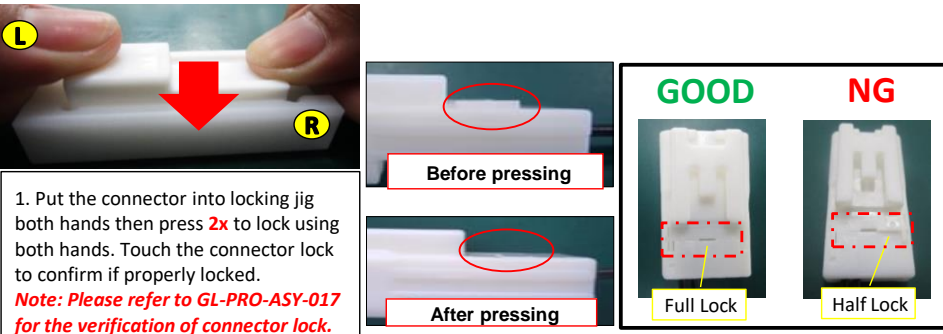

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PARTS:		1. AVSSf 0.3 B wires L=652±3mm [2pcs.]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3802 (W)	 <p>1. Get the <b>1st B wire</b> then insert to connector using right hand. <b>Note: Insertion of wire must be from left to right.</b></p> <p>2. Get the <b>2nd B wire</b> then insert to connector using right hand.</p> <p>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p>			n/a	<p><b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</b></p> <p>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Note: Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</b></p>
4	Connector Lock	 <p>1. Put the connector into locking jig both hands then press <b>2x</b> to lock using both hands. Touch the connector lock to confirm if properly locked. <b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p> <p><b>Before pressing</b></p> <p><b>After pressing</b></p> <p><b>GOOD</b> Full Lock</p> <p><b>NG</b> Half Lock</p>			<p><b>LOCKING JIG</b></p> 	<p><b>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b></p> <p>1. Use the provided jig per model 2. No unlock/half-locked connector</p>

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**WORK INSTRUCTION**

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**n/a**Model Code/Part Number: **550B / 7L0081-7023**

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**PARTS:**

1. Assy parts
2. Black Corrugated tube (no slit)  $\varnothing 5$  L=460 $\pm$ 3mm

**JIG**

1. Terminal cover jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

Wire Insertion to  
Black Corrugated tube  
(no slit)  
 $\varnothing 5$  L=460 $\pm$ 3mm



1. Get the terminal cover jig using right hand and insert the **B/B wires** using left hand.



2. Get the corrugated tube (no slit)  **$\varnothing 5$  L=460 $\pm$ 3mm** using right hand and insert the wires using left hand.



3. Remove the terminal cover jig after insertion using right hand.

**TERMINAL COVER JIG**

1. No wrong usage of parts.
2. No deformed terminal.

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