



WORK INSTRUCTION

KITTING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: 370B / 7L0045-7022

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 26, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-157

Revision No.:

2

Page No.:

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PARTS: 2		1. Connector 6098-5677 (W)				2		JIG:	1. Insertion jig								
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS							
1		2		<div><div><div>INSERTION JIG</div><div><div>I-MARK</div><div>LOCK</div><div>GUIDE</div><div>Visual REFERENCE</div><div>Button</div></div><div><div>Visual REFERENCE</div><div>CONNECTOR ORIENTATION</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div><div>Press</div></div></div><div><div>2. Insert the connector 6098-5677 (W) into jig using right hand and release the lock.</div><div><div>Release</div></div></div><div><div>3. Push wire guide using left thumb. The slot for B/B wires will be opened.</div></div></div></div> <div><div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div><div><div>Housekeeping</div><div>1. Maintain and always practice 5's.</div><div>2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div>				<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>2 holes are open.</div><div>NG</div></div></div> <div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div>									
Revision History										Prepared by		Reviewed by		Approved by		Noted by	
02/26/21		2		Revise due to standardize the color of connector in accordance with color standardization of plastic parts. (Please refer to GL-COM-003 for Color standardization of plastic parts). Apply some improvements. Removal of cycle time.				M. Catapang		C. Villanueva		A. Shimamura		A. Arañes			
08/06/20		1		Transferred process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-097 to WI-ENG-PDE-157. Changed part number from 7L0045-7021A to 7L0045-7022 due to removal of vinyl tube Ø4 L=25mm and changed vinyl tube dimension from Ø4 L=65mm to Ø4 L=45mm. Include cycle time				M. Catapang		R. Peñaloza		A. Shimamura		A. Arañes			
Eff. Date		Rev. No		Details of Change				Revised		Checked		Approved		Noted		Est. Date:	
																October 23, 2018	

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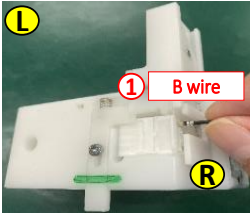
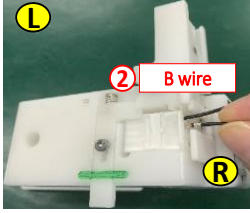

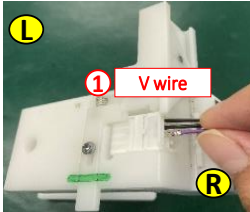
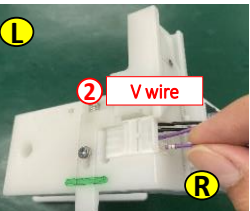

☒ MASSPRO

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PARTS:		1. AVSSf 0.3 B wires L=272±2mm [2pcs]; V wires L=312±2mm [2pcs.]		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div><div><div>2</div></div><div>Wire insertion to connector 6098-5677 (W)</div></div>	<div><div><div><div><div>L</div><div>1</div><div>B wire</div></div><div></div></div><div><div>1. Get the 1st B wire using right hand and then insert to terminal slot 1.</div></div></div><div><div><div><div>L</div><div>2</div><div>B wire</div></div><div></div></div><div><div>2. Get the 2nd B wire using right hand and then insert to terminal slot 2.</div></div></div><div><div><div><div>L</div><div>1</div><div>V wire</div></div><div></div></div><div><div>3. Press the button using right thumb. The slot for V/V wires will be opened.</div></div></div><div><div><div><div>L</div><div>1</div><div>V wire</div></div><div></div></div><div><div>4. Get the 1st V wire using right hand and then insert to terminal slot 3.</div></div></div><div><div><div><div>L</div><div>2</div><div>V wire</div></div><div></div></div><div><div>5. Get the 2nd V wire using right hand and then insert to terminal slot 4.</div></div></div><div><div><div><div>L</div><div>2</div><div>V wire</div></div><div></div></div><div><div>6. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div></div></div>		n/a	<div><div><div>2</div></div><div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div></div></div>

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PARTS:

1. Assy parts
2. Black Corrugated tube (no slit) $\phi 7$ L=71 \pm 3mm

JIG

1. Locking jig
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div>2</div> <div>Connector Lock</div>	<div><div></div><div><div></div><div><div>Before Pressing</div><div>After Pressing</div></div><div><div></div><div><div>GOOD</div><div>NG</div></div><div><div>Fully Locked</div><div>UnLocked</div></div></div></div><div><div>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked. NOTE: Please refer to GL-PRO-ASY-017 for the Verification of Connector lock</div></div></div>	<div><div>LOCKING JIG</div></div>	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED CONNECTOR LOCK</div> <div>1. Use the provided locking jig per model No unlocked/half-locked connector</div>
4	<div>2</div> <div>Wire insertion to Black corrugated tube (no slit) ø7 L=71±3mm</div> <div>2</div>	<div><div></div><div></div><div><div>1. Get the terminal cover jig using right hand and then insert the B/B wires and V/V wires using left hand.</div></div><div><div></div><div></div><div><div>2. Get the Black corrugated tube (no slit) ø7 L=71±3mm using right then insert the wires using left hand.</div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div><div></div></div></div>	<div><div>TERMINAL COVER JIG</div></div>	<div>1. No wrong use of parts 2. No deformed terminal</div>