



## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

March 4, 2022

Process Name/Title:

Model Code/Part Number: 550B / 7L0083-7023

Customer:

TRQSS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-448

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

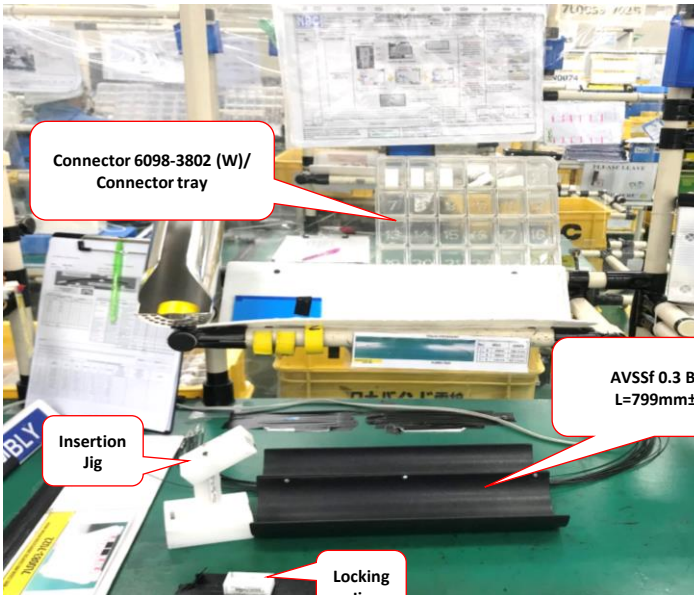
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## PARTS:

1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B wires L=799mm±3mm

## JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Table Lay-out	<p><b>Table Lay-out</b></p> 	<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	Prepared by:	Checked by:	Approved by:	Noted by:
03/4/22	0	Initial Issue.						K. Doria	J. Loterte	C. Villanueva	A. Arañes
03/4/22	0	Initial Issue.						K. Doria	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Connector 6098-3802 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

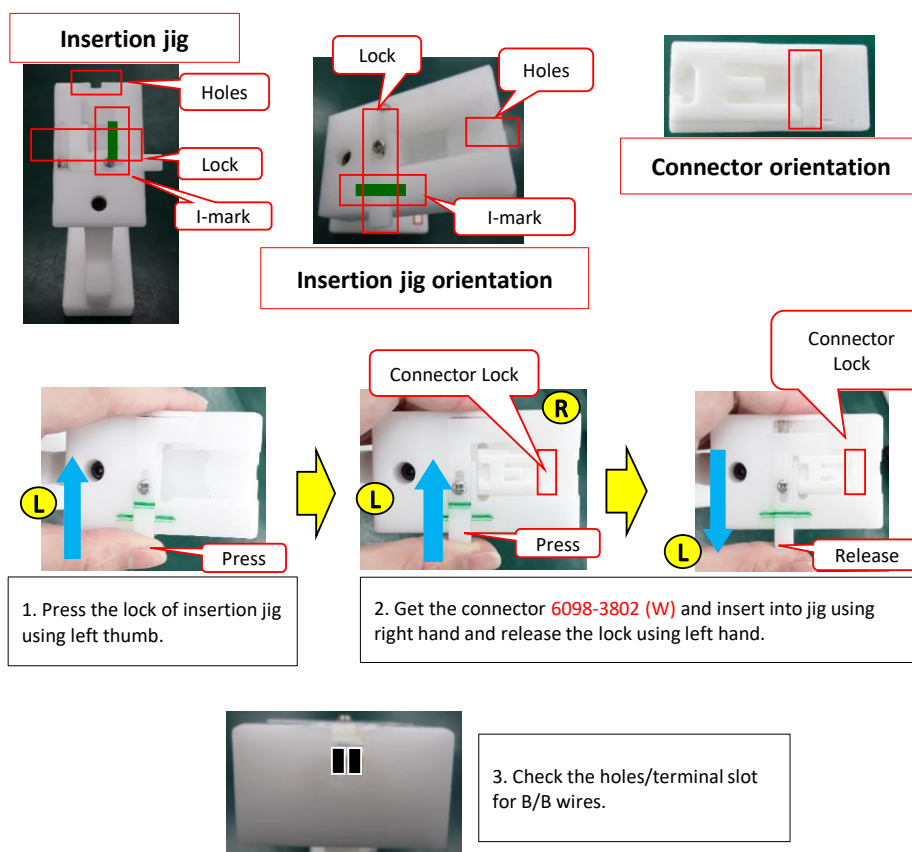
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Connector setting to  
insertion jig  
6098-3802 (W)



Connector Orientation  
Illustration

I-mark is  
align

2 Holes are  
open.

I-mark is  
not align

All Holes are  
open.

1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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## PARTS:

2. AVSSf 0.3 B wires L=799mm±3mm [2 pcs]

## JIG

1. Insertion jig
2. Locking jig

## NO.

## PROCESS NAME

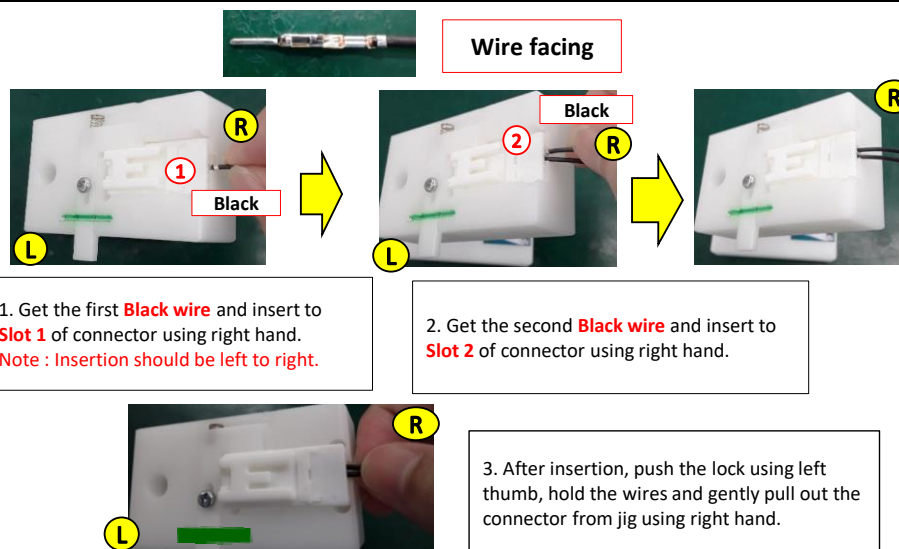
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

3

Wire insertion to connector 6098-3802 (W)



N/A

Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

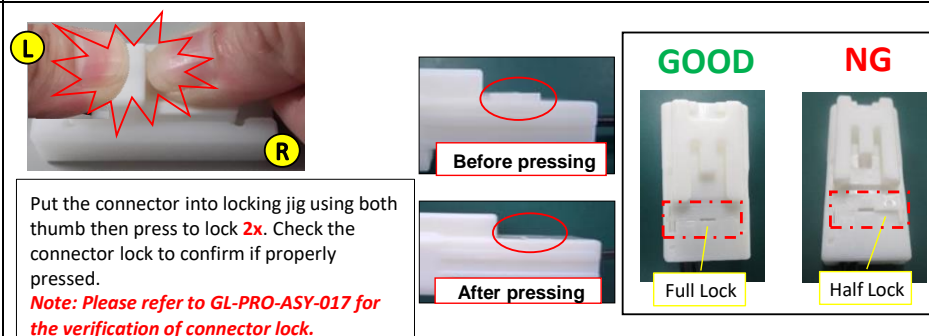
Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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 **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

4

Connector lock



## Locking jig



Note: Use provided jig tool to lock the connector. Manual locking may cause damaged lock.

1. No unlock/half-locked connector
2. Use provided jig tool to lock the connector

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