

**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**Model Code/Part Number: **220D / 7R0128-7020** Customer: **TRMX**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

September 27, 2022

Validity Date:

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Document No.:

WI-ENG-PDE-544

Revision No.:

2

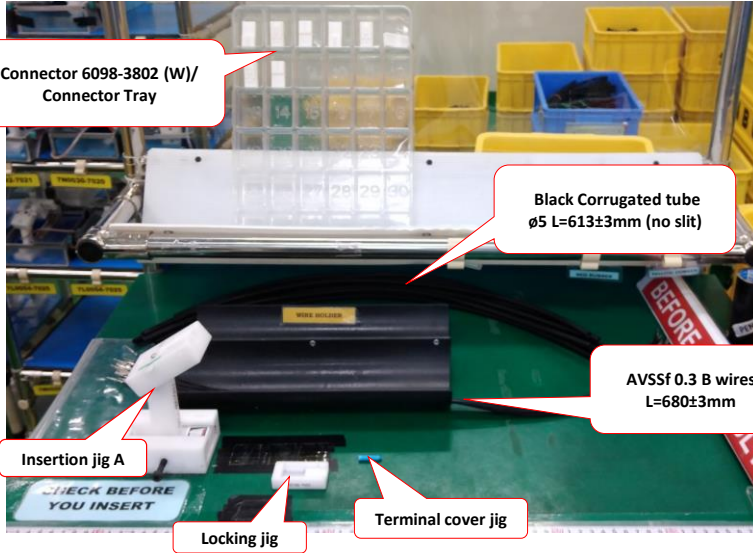
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1 of 5**PARTS:**

1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B wires L=680±3mm; Black Corrugated tube ø5 L=613±3mm (no slit)

JIG:

1. Insertion jig
2. Locking jig
3. Terminal cover jig

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

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
09/27/22	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
06/14/22	1	Change document purpose from pre-launch to masspro. Additional table layout	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
06/10/22	0	Initial issue. Excluded from WI-ENG-PDE-436	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
			Est. Date:	June 10, 2022		

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OFFLINE ASSEMBLY PROCESS

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Model Code/Part Number:	220D / 7R0128-7020	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<p>Connector Setting to Insertion jig 6098-3802 (W)</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock.</p> <p>3. Check the holes/terminal slot for B-B wires.</p>		n/a	<p>Connector Orientation Illustration</p> <p>GOOD</p> <p>NG</p> <p>CONNECTOR ILLUSTRATION</p> <p>2 GOOD NG</p> <p>6098-3802 (W) 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>

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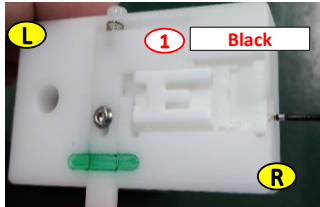
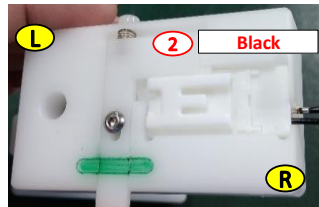
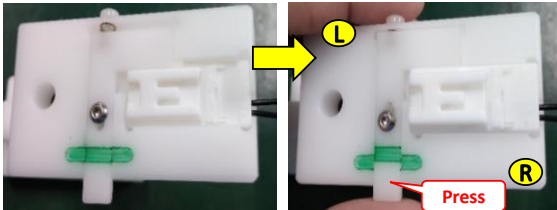
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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. AVSSf 0.3 B-B wires L=680±3mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3802 (W)	<div> WIRE FACING</div> <div><p>1. Get the 1st B wire then insert to connector using right hand. Note: Insertion of wire must be from left to right.</p></div> <div><p>2. Get the 2nd B wire then insert to connector using right hand.</p></div> <div><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></div>		n/a	<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>2 Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>2 Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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PARTS:

n/a

JIG

1. Locking jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

n/a

2

Connector Lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



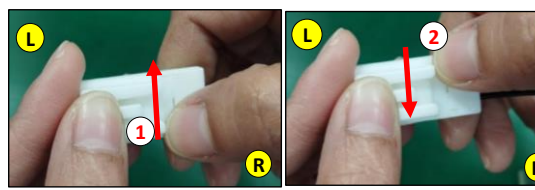
Right thumb-upper
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



GOOD

NG



2

Important reminders/Note/s:

1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR

1. Use the provided jig tool to lock the connector.

2. No unlock/half-locked connector

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5 of 5**PARTS:**

1. Assy parts
2. Black Corrugated tube $\phi 5$ L=613 \pm 3mm (no slit)

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to corrugated tube (no slit) $\phi 5$ L=613 \pm 3mm	<div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) $\phi 5$ L=613\pm3mm using right hand then insert the B-B wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal

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