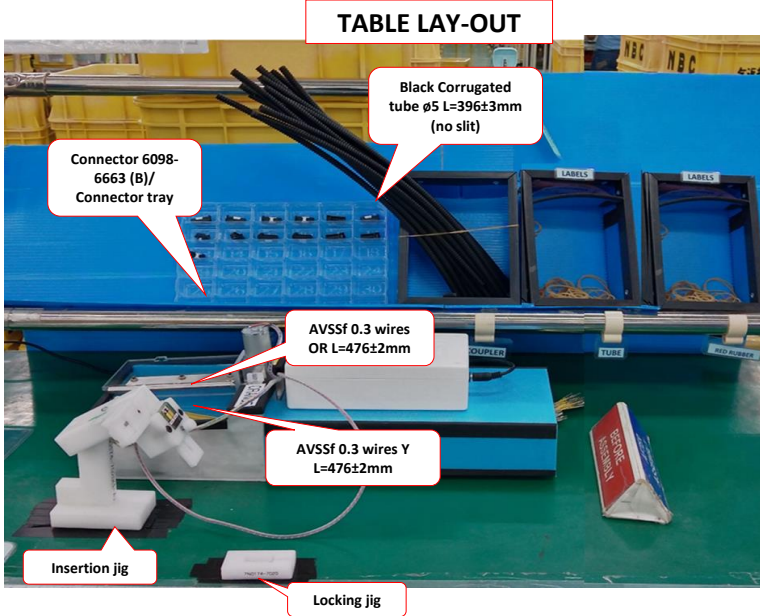




	WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS						Effectivity Date: May 19, 2023	
	Process Name/Title:						Validity Date: n/a	
	Model Code/Part Number: 373D / 7N0172-7020			Customer: TRJ			Document No.: WI-ENG-PDE-631	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.: 1		Page No.: 1 of 5		

PARTS:		1. All parts: Connector 6098-6663 (B) ; AVSSf 0.3 wires Y-OR L=476±2mm; Black Corrugated tube ø5 L=396±3mm (no slit)				JIG:		1. Insertion jig with switch cover 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	n/a	<div style="text-align: center;">  </div>				<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<p>Document references:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
05/19/23	1	Work Instruction improvement from Genba check audit. Transfer process of Wire Insertion to Black SV tube (Vinyl) ø5 L=28±3mm process from Offline Assembly Process to Taping Assembly Process (P1) to prevent missing SV tube (Vinyl). Inclusion of Quality Checkpoints on pg. 5. Change table lay-out illustration.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
01/30/23	0	Initial issue						M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Prepared	Reviewed	Approved	Noted	Est. Date:	January 30, 2023		

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PARTS:

1. Connector 6098-6663 (B)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

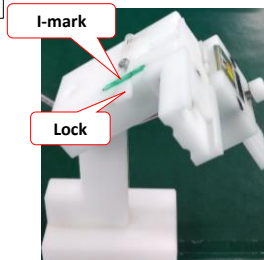
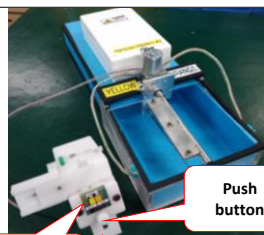
QUALITY POINTERS

2

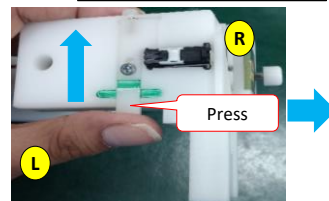
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Connector setting to insertion jig 6098-6663 (B)

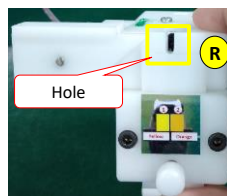
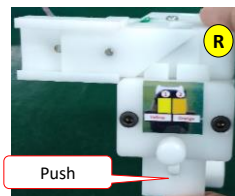
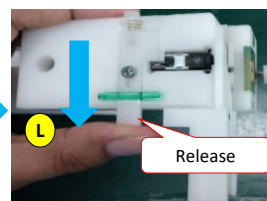
INSERTION JIG WITH SWITCH COVER



1. Press the insertion jig lock using left hand.



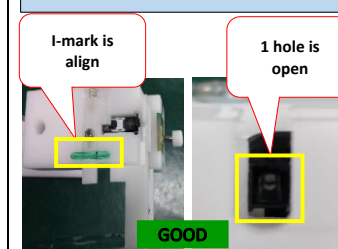
2. Get the Connector **6098-6663 (B)** and insert to insertion jig using right hand. Release the lock after insertion.
Note: Follow the connector orientation.



3. Press the lower wire guide using right hand. Slot for **Yellow wire** will be opened.

n/a

Connector Orientation Illustration



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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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH


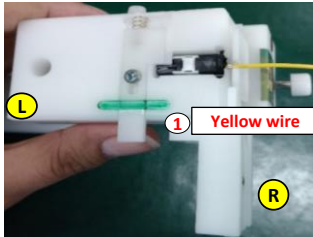
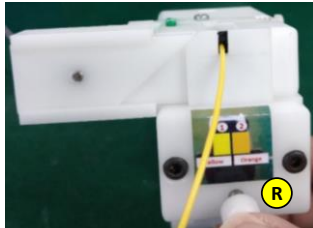
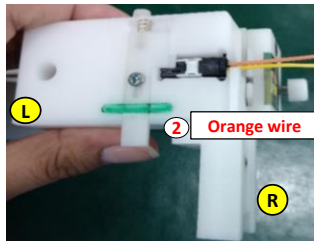
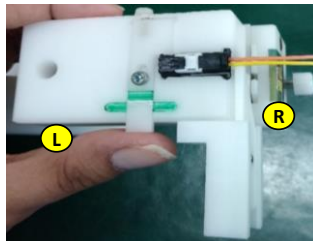
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PARTS:		1. AVSSf 0.3 wires Y-OR L=476±2mm		JIG	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to connector 6098-6663 (B)	<div><div>Wire facing</div></div> <div><div>1 Yellow wire</div><div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. Press the button using right thumb. The slot for Orange wire will be opened.</div></div> <div><div>2 Orange wire</div><div>3. Get the Orange wire then insert to terminal slot 2 using right hand.</div></div> <div><div>4. 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>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deform terminal</p> <p>5. No wrong wire facing.</p>

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☐ PRE-LAUNCH


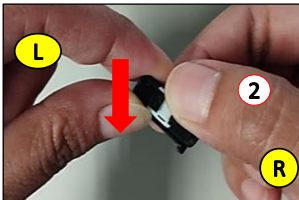



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PARTS:		1. Assy parts 2. Black Corrugated tube $\varnothing 5$ L=396 \pm 3mm (no slit)		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands.</p></div><div></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div> <div><div></div><div><p>BEFORE PRESSING</p></div><div></div><div><p>AFTER PRESSING</p></div></div>		<p>LOCKING JIG</p> 	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use provided jig tool per model 2. No unlock/half-locked connector</p>
		5	Wire insertion to Black corrugated tube $\varnothing 5$ L=396 \pm 3mm (no slit)		

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Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.: 5 of 5

PARTS:	n/a	JIG	n/a
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1 QUALITY CHECKPOINTS

OFFLINE INSERTION

7N0172-7020



GOOD



GOOD



GOOD



NO GOOD



NO GOOD



NO GOOD

- 1 No Unlock/Halflock Connector
- 2 No Wrong Insert
- 3 No Terminal Backing Out
- 4 No Deformed Terminal

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