



# WORK INSTRUCTION

Effectivity Date:

May 19, 2022

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

715W

/

7H0332W7020A

Customer:

NBS

Document No.:

WI-ENG-PDE-509

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

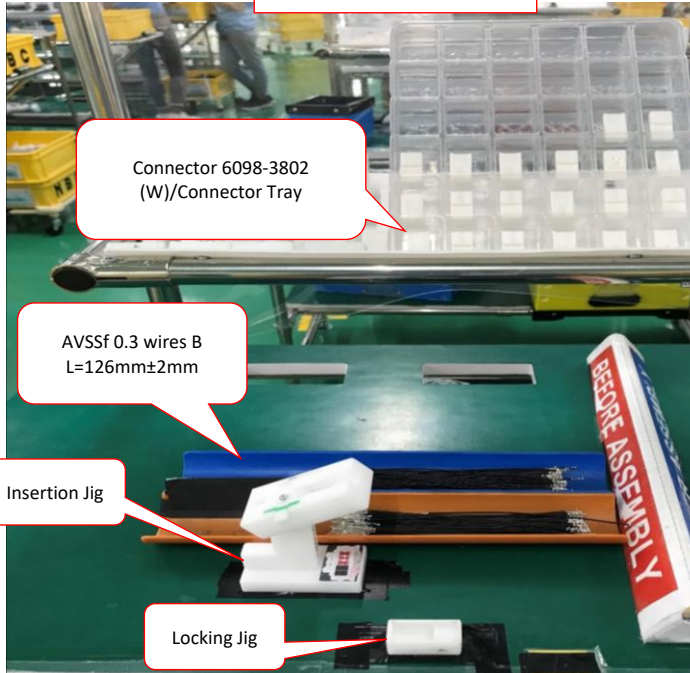
1 of 3

### PARTS:





1. Connector 6098-3802 (W); AVSSf 0.3 wires B L=126mm±2mm

### JIG:

1. Insertion jig
2. Locking jig

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

### Revision History

| Eff. Date | Rev. No | Details of Change                                       | Revise   | Check      | Approve       | Noted     | Prepared by   | Reviewed by   | Approved by   | Noted by  |
|-----------|---------|---|----------|------------|---------------|-----------|---|---|---|---|
| 05/19/22  | 1       | Change Pre-launch to Masspro. Additional Table Lay-out. | K. Doria | J. Loterte | C. Villanueva | A. Arañes |   |   |   |   |
| 04/29/22  | 0       | Initial Issue.  | K. Doria | J. Loterte | C. Villanueva | A. Arañes |  |  |  |  |
| Eff. Date | Rev. No | Details of Change                                       | Revise   | Check      | Approve       | Noted     | Est. Date:  | April 29, 2022  |   |   |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp




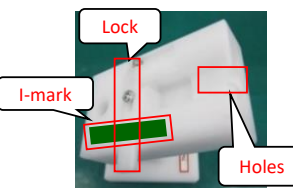
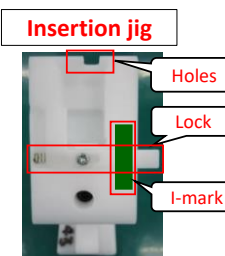
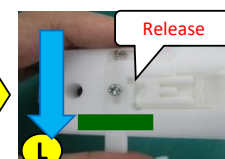
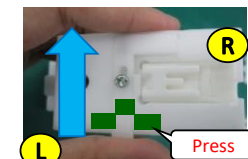
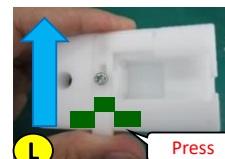
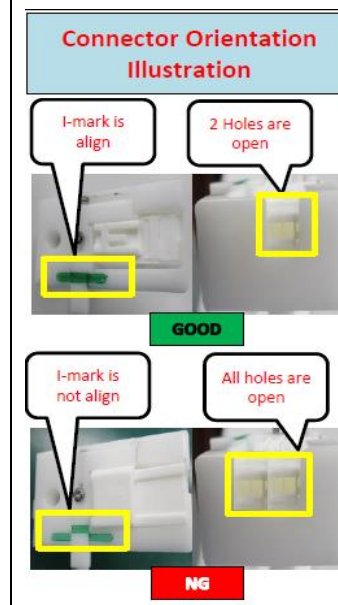
# WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

|                   |                |           |        |
|-------------------|----------------|-----------|--------|
| Effectivity Date: | May 19, 2022   |           |        |
| Validity Date:    | n/a            |           |        |
| Document No.:     | WI-ENG-PDE-509 |           |        |
| Revision No.:     | 1              | Page No.: | 2 of 3 |

Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Model Code/Part Number: **715W / 7H0332W7020A** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

| PARTS: |   | 1. Connector 6098-3802 (W)  |  | JIG       | 1. Insertion jig  |
|--------|---|---|--|-----------|---|
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE | QUALITY POINTERS  |
| 2      | n/a<br>Connector Setting to Insertion jig 6098-3802 (W) | <div><p><b>CONNECTOR ORIENTATION</b></p><p><b>INSERTION JIG ORIENTATION</b></p></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the Connector <b>6098-3802 (W)</b> into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for 2 Black wires.</p></div> |  | n/a       | <div><p><b>Connector Orientation Illustration</b></p><p><b>GOOD</b></p><p>I-mark is align<br/>2 Holes are open</p><p><b>NG</b></p><p>I-mark is not align<br/>All holes are open</p></div> <p>1. Use the provided jig per model<br/>2. No wrong orientation of connector</p> |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



## WORK INSTRUCTION

Process Name/Title:

### OFFLINE ASSEMBLY PROCESS

Model Code/Part Number: **715W / 7H0332W7020A**

Customer:

**NBS**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**May 19, 2022**

Validity Date:

**n/a**

Document No.:


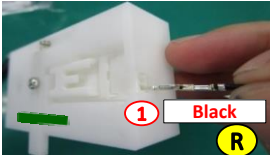
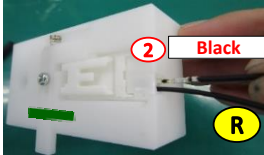
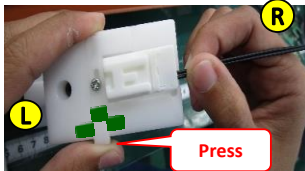






**WI-ENG-PDE-509**

Revision No.:

**1**

Page No.:

**3 of 3**

| PARTS: |   | 1. AVSSf 0.3 wires B L=126mm±2mm [2pcs.]   |  |  | JIG   | 1. Insertion jig<br>2. Locking jig   |
|--------|---|--|--|--|---|--|
| NO.    | PROCESS NAME                              | WORK PROCEDURE/ ILLUSTRATION   |  |  | TOOLS/PPE   | QUALITY POINTERS   |
| 3      | Wire insertion to connector 6098-3802 (W) | <div><b>WIRE FACING</b></div> <div><b>1</b> <b>Black</b> <b>R</b></div> <div><b>2</b> <b>Black</b> <b>R</b></div> <div><b>Press</b></div> <div><p>1. Get the <b>1st B wire</b> then insert to connector using right hand.<br/><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></div>                              |  |  | n/a   | <p><b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</b></p> <ol style="list-style-type: none"><li>No wrong orientation of connector</li><li>No wrong use of connector</li><li>No damaged connector</li><li>No wrong insertion of wires</li><li>No loose insertion</li><li>No wrong insertion</li><li>One by one insertion</li><li>No deformed terminal</li><li>No wrong wire facing</li></ol> <div><b>Note: Make sure wires are properly inserted.</b><br/><b>Conduct Pull-Push-Pull-Push after insertion.</b><br/><b>Do not exert extra force.</b></div> <p><b>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p> |
| 4      | Connector lock                            | <div><b>L</b> <b>R</b></div> <div><b>Before pressing</b></div> <div><b>After pressing</b></div> <div><b>GOOD</b><br/><b>Full Lock</b></div> <div><b>NG</b><br/><b>Half Lock</b></div> <div><p>Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Touch the connector lock to confirm if properly locked.<br/><b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p></div> |  |  | <div><b>LOCKING JIG</b></div>  | <div><b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b></div> <ol style="list-style-type: none"><li>Use the provided jig per connector</li><li>No unlock/half-locked of connector lock</li></ol>  |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp