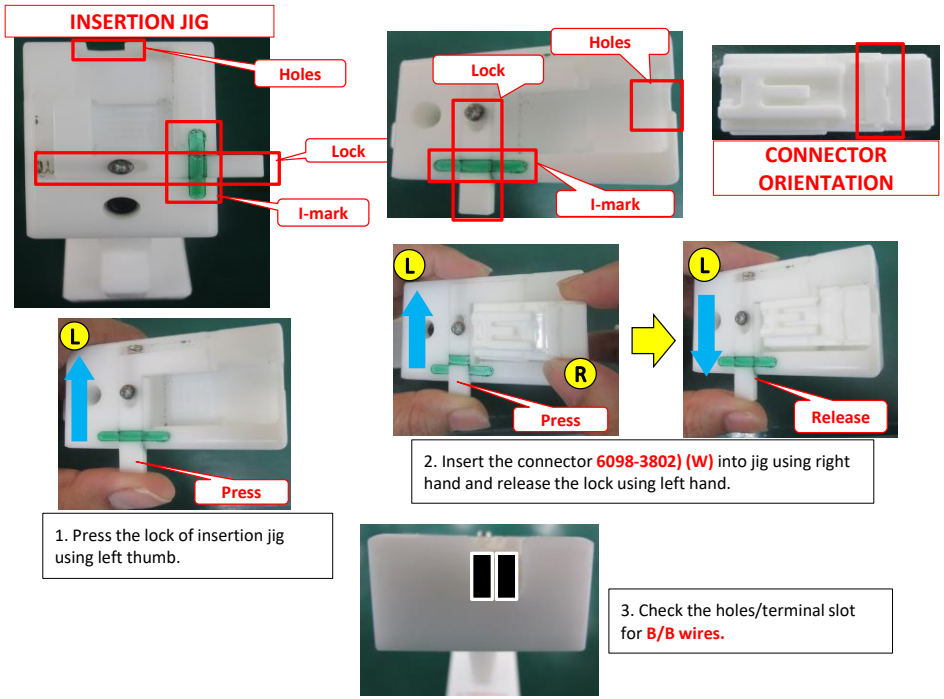
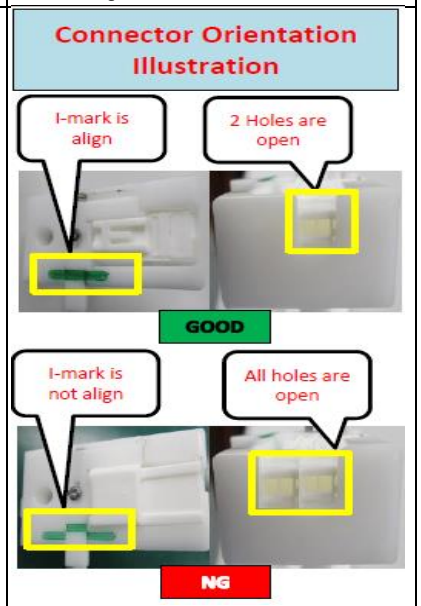
	WORK INSTRUCTION			Effectivity Date:	May 20, 2021
	Process Name/Title:	KITTING ASSEMBLY PROCESS		Validity Date:	n/a
	Product Name/Code:	550B / 7L0081-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-254
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0 / Page No.: 1 of 3

PARTS:	1. Connector 6098-3802 (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Connector setting to insertion jig 6098-3802 (W)	 1. Press the lock of insertion jig using left thumb. 2. Insert the connector **6098-3802) (W)** into jig using right hand and release the lock using left hand. 3. Check the holes/terminal slot for **B/B wires.**	**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.	 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

Revision History

			Prepared by	Reviewed by	Approved by	Noted by
05/20/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted

Est. Date: May 22, 2021

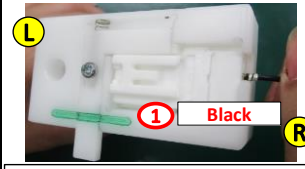
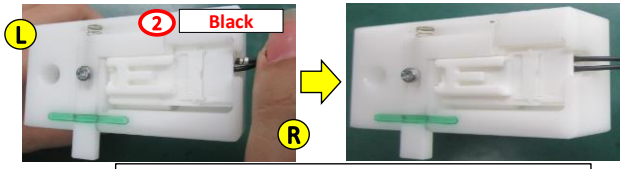
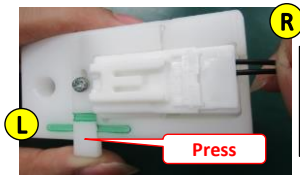
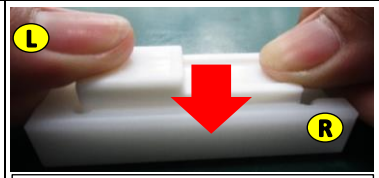
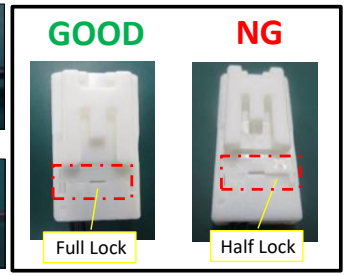
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	May 20, 2021
	Process Name/Title:	KITTING ASSEMBLY PROCESS		Validity Date:	n/a
	Product Name/Code:	550B / 7L0081-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-254
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0 Page No.: 2 of 3

PARTS:	1. AVSSf 0.3 B wires L=652±3mm [2pcs.]	**JIG**	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6098-3802 (W)	WIRE FACING  1. Get the **1st B wire** then insert to connector using right hand. ***Note: Insertion of wire must be from left to right.***  2. Get the **2nd B wire** then insert to connector using right hand.  3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.	n/a	1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing **Note: Make sure wires are properly inserted.** **Conduct Pull-Push-Pull-Push after insertion.** **Do not exert extra force.**
3	Connector Lock	 1. Put the connector into locking jig both hands then press **2x** to lock 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.*** 	LOCKING JIG 	***NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK*** 1. Use the provided jig per model 2. No unlock/half-locked connector

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		Effectivity Date:	**May 20, 2021**	
	Process Name/Title:	**KITTING ASSEMBLY PROCESS**	Validity Date:	**n/a**	
	Product Name/Code: **550B / 7L0081-7022**	Customer: **TRQSS**	Document No.:	**WI-ENG-PDE-254**	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0	Page No.: 3 of 3

PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) ø5 L=460±3mm	**JIG**	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4		Wire Insertion to Black Corrugated tube (no slit) ø5 L=460±3mm	 1. Get the terminal cover jig using right hand and insert the **B/B wires** using left hand. 2. Get the corrugated tube (no slit) **Ø5 L=460±3mm** using right hand and insert the wires using left hand. 3. Remove the terminal cover jig after insertion using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts. 2. No deformed terminal.

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