



WORK INSTRUCTION  
OFFLINE ASSEMBLY PROCESS

Effectivity Date:

May 17, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0122-7021A

Customer: TRMX

Document No.:

WI-ENG-PDE-674

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

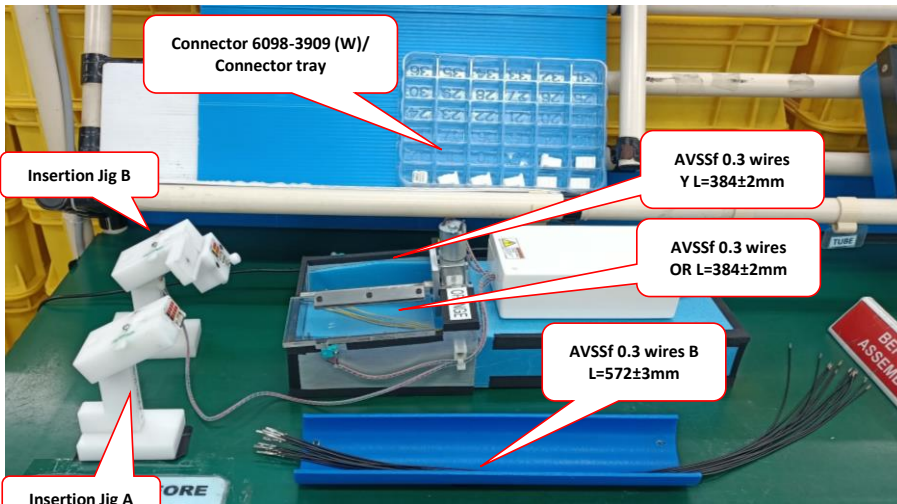
☒ MASSPRO

Revision No.:





0

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PARTS:	1. All parts; Connector 6098-3909 (W); AVSSf 0.3 wires B L=572±3mm; AVSSf 0.3 wires Y-OR L=384±2mm			JIG:	1. Insertion jig with switch cover 2. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<p>Table Lay-out</p> 		<p><b>Safety Instruction</b> Be sure to wear prescribed 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><b>Document reference/s:</b> 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
										
05/17/23	0	Initial issue.		D. Castillo	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: May 17, 2023

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### PARTS:

1. Connector 6098-3909 (W)

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

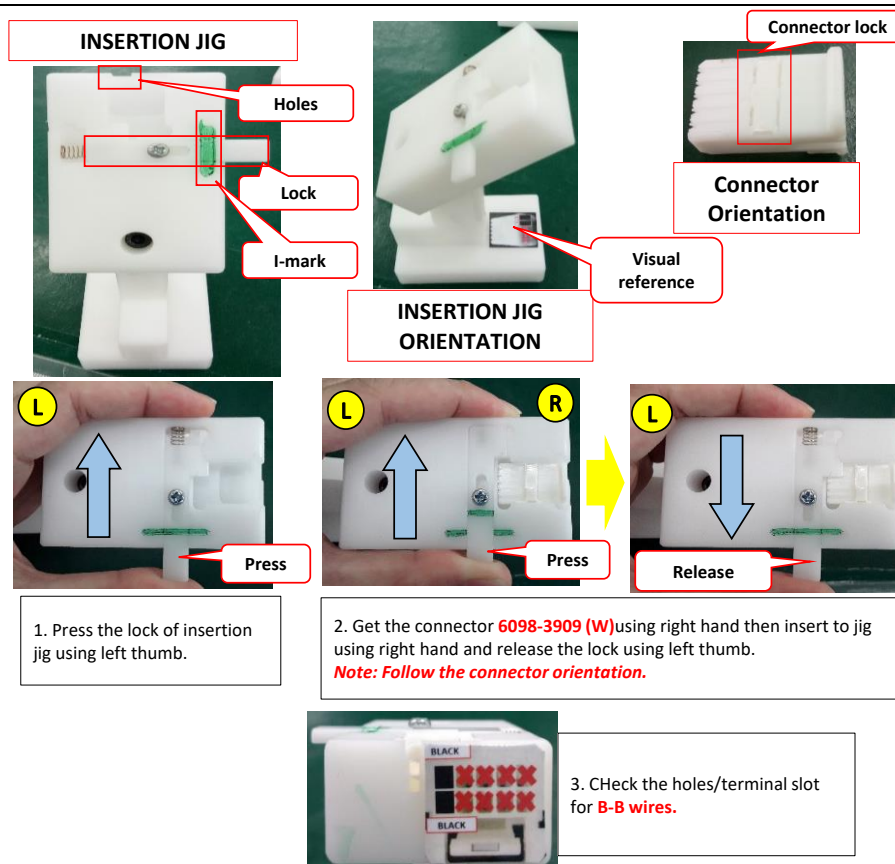
### TOOLS/PPE

### QUALITY POINTERS

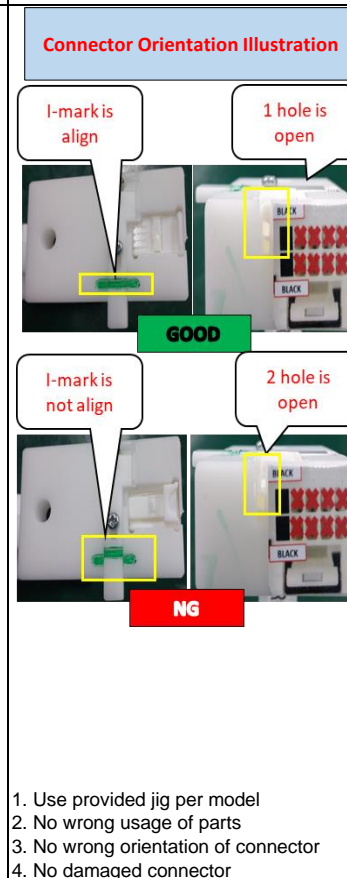
2

n/a

Connector setting to  
insertion jig  
6098-3909 (W)



n/a



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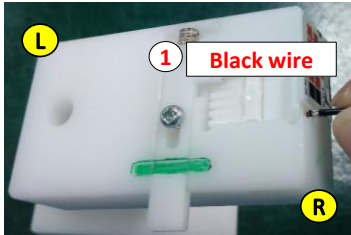

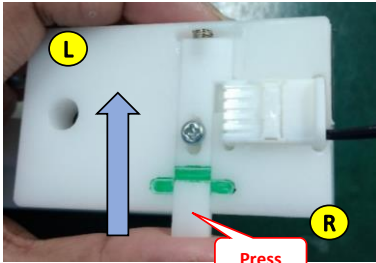
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**3 of 6****PARTS:**

1. AVSSf 0.3 wires B L=572±3mm [2pcs]

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3909 (W)	<div><b>Wire facing</b></div> <div><b>1 Black wire</b></div> <div><b>2 Black wire</b></div> <div><b>Press</b></div> <div>1. Get <b>1st black wire</b> then insert to terminal slot <b>①</b> using right hand. <b>Note: Insertion of wires must be from up to down direction.</b></div> <div>2. Get <b>2nd Black wire</b> then insert to terminal slot <b>②</b> using right hand.</div> <div>3. 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>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

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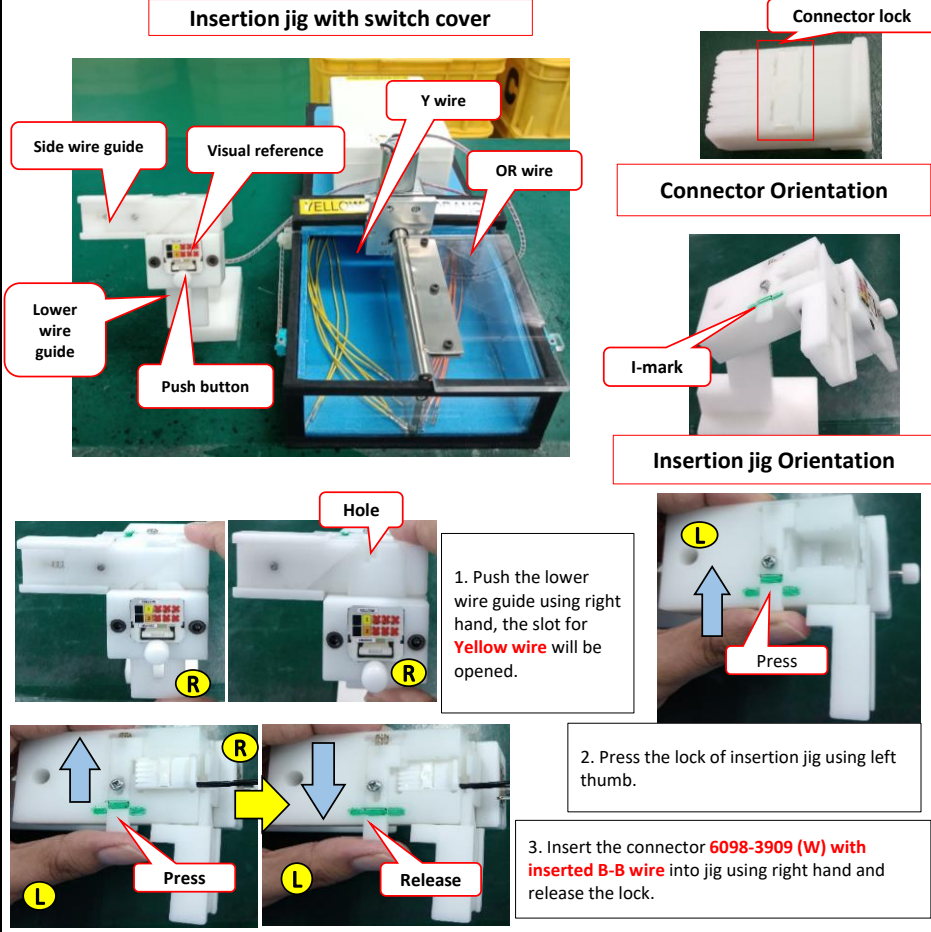
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# WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

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Process Name/Title:	OFFLINE ASSEMBLY PROCESS		
Model Code/Part Number:	920B / 7R0122-7021A	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a  Connector setting to insertion jig 6098-3909 (W)	<div><p>Insertion jig with switch cover</p><p>1. Push the lower wire guide using right hand, the slot for <b>Yellow wire</b> will be opened.</p><p>2. Press the lock of insertion jig using left thumb.</p><p>3. Insert the connector <b>6098-3909 (W)</b> with inserted <b>B-B wire</b> into jig using right hand and release the lock.</p></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Follow the connector orientation</li><li>2. Cannot insert the inverted connector.</li></ol> <ol style="list-style-type: none"><li>1. Use provided jig per model</li><li>2. No wrong usage of parts</li><li>3. No wrong orientation of connector</li><li>4. No damaged connector</li></ol>

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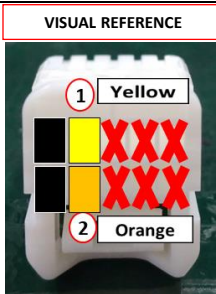
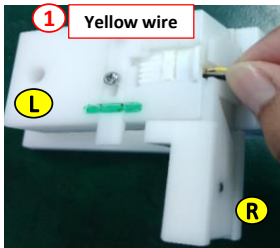
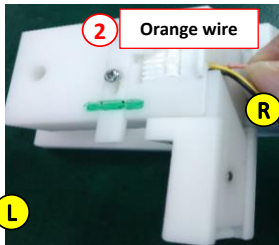
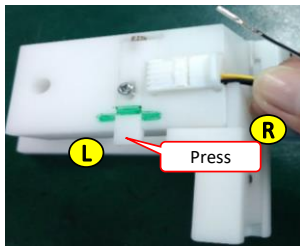

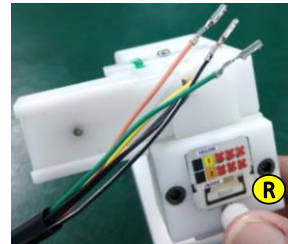
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## PARTS:

1. Assy parts
2. AVSSf 0.3 wires Y-OR L=384±2mm

## JIG

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	<div>Wire insertion to Connector 6098-3909 (W)</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div><p>1. Get the <b>Yellow wire</b> using right hand then insert to terminal <b>slot 1</b> using right hand.</p><p>2. Press the button using left hand, the slot for <b>Orange wire</b> will be opened.</p><p>3. Get the <b>Orange wire</b> using right hand then insert to terminal <b>slot 2</b> using right hand.</p><p>4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>5. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b></div> <div><b>1. Please hold the wire near terminal.</b></div> <div><b>2. Make sure wires are properly inserted.</b></div> <div><b>Conduct Pull-Push-Pull-Push after insertion.</b></div> <div><b>Do not exert extra force.</b></div> <div><b>Document references:</b></div> <div><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

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**PARTS:**

1. Assy parts

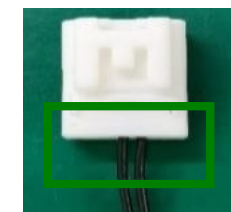
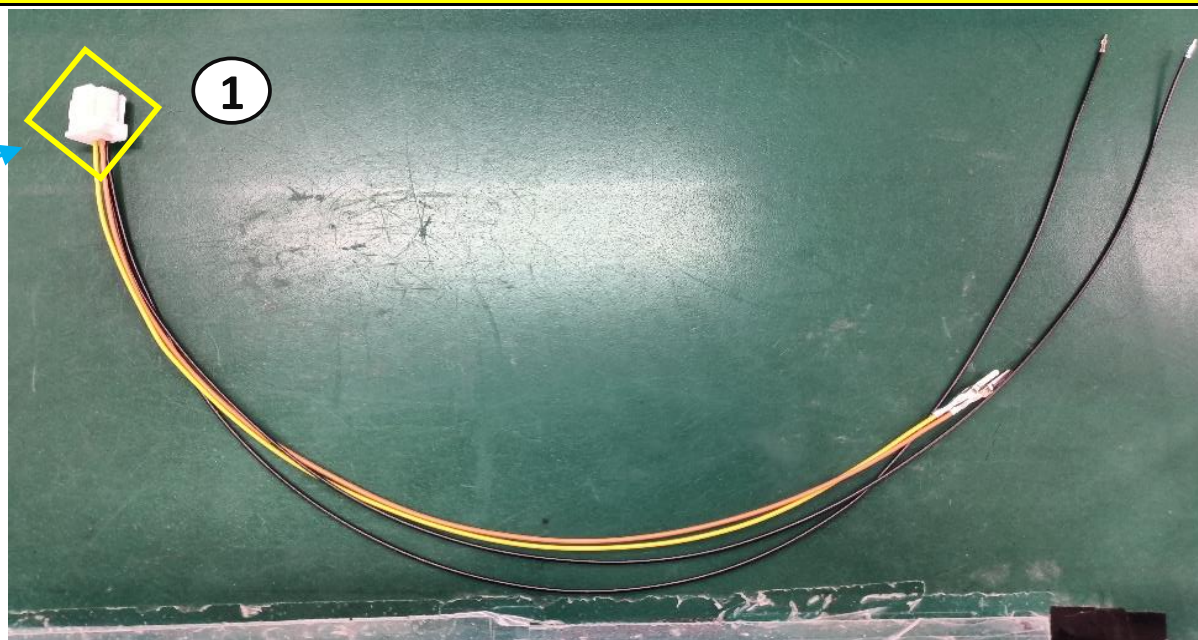
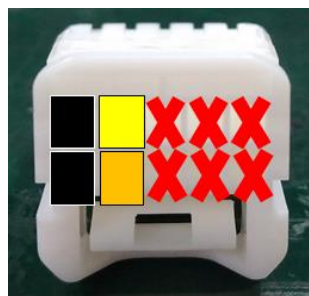
**JIG**

n/a

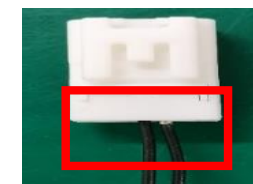
## QUALITY CHECKPOINTS

**n/a**

**7R0122-7021A**



**GOOD**



**NO GOOD**

**① No Wrong Insert**

**② No Terminal Backing Out**

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