



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

January 26, 2024

Validity Date:

n/a

Model code/Part number:

ES1

/

7M0515-7021

Customer:

TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-818

Purpose:

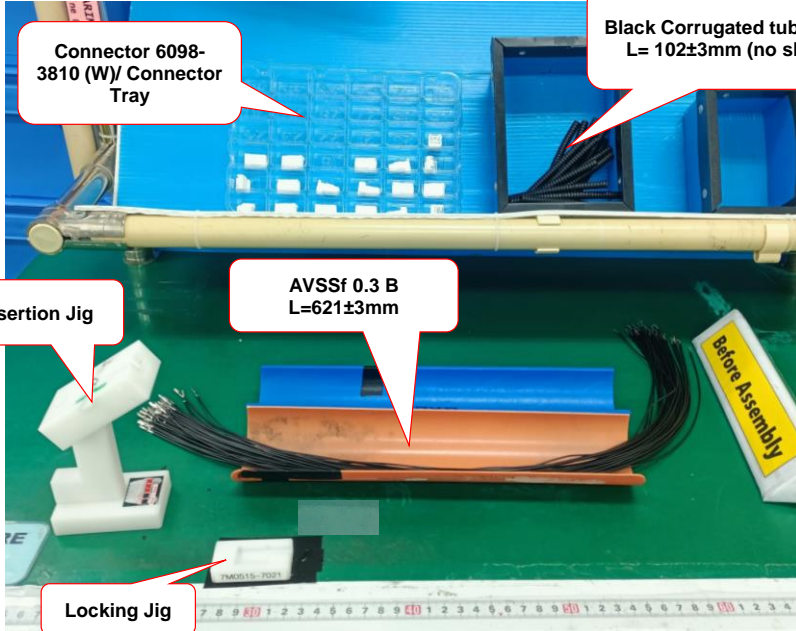
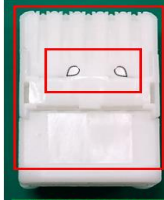
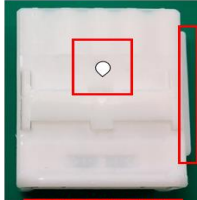
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 6

PARTS:	1. All parts: Connector 6098-3810 (W); AVSSf 0.3 B L=621±3mm; Black Corrugated tube ø5 L=102±3mm (no slit)				JIG:	1. Insertion Jig 2. Locking Jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	n/a	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No missing parts/tools 2. No excess parts/tools</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div> <div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div>6098-3810 (W)</div><div>NG</div><div>6098-5677 (W)</div></div>			
Revision History						Prepared by	Reviewed by	Approved by	Noted by	
01/26/24	0	Initial issue. COT tube length from L=104±3mm to L=102±3mm (no slit) due to encountered maximum dimension in harness.				D. Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Est. Date:	January 26, 2024			

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Revision No.:

0

Page No.:


2 of 6


PARTS:	1. Connector 6098-3810 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	<div><div><div><div>Insertion Jig</div><div></div></div><div><div>Insertion Jig Orientation</div><div></div></div><div><div>Connector Orientation</div><div></div></div></div><div><div><div><div><div>L</div><div>Press</div><div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div></div><div><div><div><div>L</div><div>Press</div><div></div></div><div><div>2. Insert the connector 6098-3810 into jig using right hand and release the lock.</div></div></div><div><div><div><div>L</div><div>Release</div><div></div></div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div></div></div><div><div><div><div>GOOD</div><div></div><div>6098-3810 (W)</div></div><div><div>NG</div><div></div><div>6098-5677 (W)</div></div></div></div></div></div>	n/a	<div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div> <div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are widely open</div><div></div><div>GOOD</div></div><div><div>I-mark is not align</div><div>2 holes are partially open.</div><div></div><div>NG</div></div></div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>6098-3810 (W)</div></div><div><div>NG</div><div></div><div>6098-5677 (W)</div></div></div></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 0		Page No.: 3 of 6			

PARTS:		1. Black Corrugated tube ø5 L= 102±3mm (no slit) 2. AVSSf 0.3 B L=621±3mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div>1. Get Black corrugated tube ø5 L=102±3mm (No slit) using left hand and get 2pcs of Black wire L=621±3mm then insert using right hand.</div></div>		n/a	1. No Wrong use of parts 2. No deformed terminal

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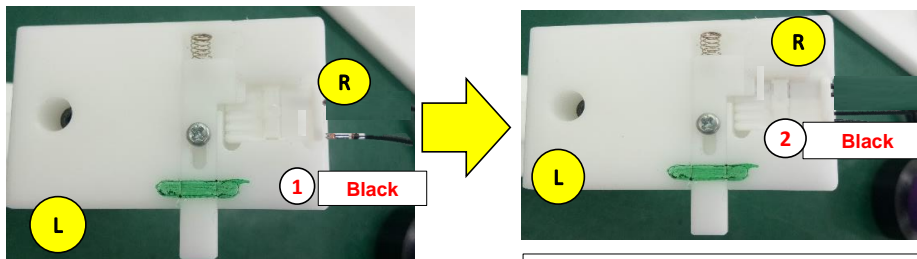
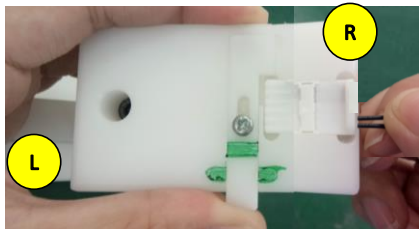
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Revision No.:

0

Page No.:

4 of 6

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div>Wire facing</div></div> <div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</div><div>2. Get the 2nd Black wire and insert to Slot 2 of connector using right hand.</div></div> <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></div>		n/a	<div>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

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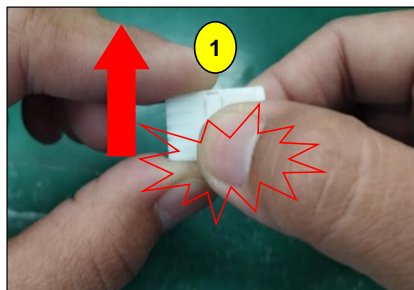

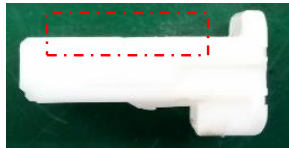



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 6

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	Connector lock	<div><div><div></div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</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>Before Pressing</div><div></div><div>After Pressing</div></div><div><div>LOCKING JIG</div><div></div></div></div>	<div>1. Use provided jig tool per model to avoid damaged lock.</div> <div>2. No Unlock and half-locked connector</div> <div>3. No damaged lock</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock.</div> <div><div>LOCK CONDITION</div><div><div><div>GOOD</div><div></div><div>Fully Locked</div></div><div><div>NG</div><div></div><div>UnLocked</div></div></div></div>	

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PARTS: n/a

JIG: n/a

QUALITY CHECKPOINTS

OFFLINE INSERTION

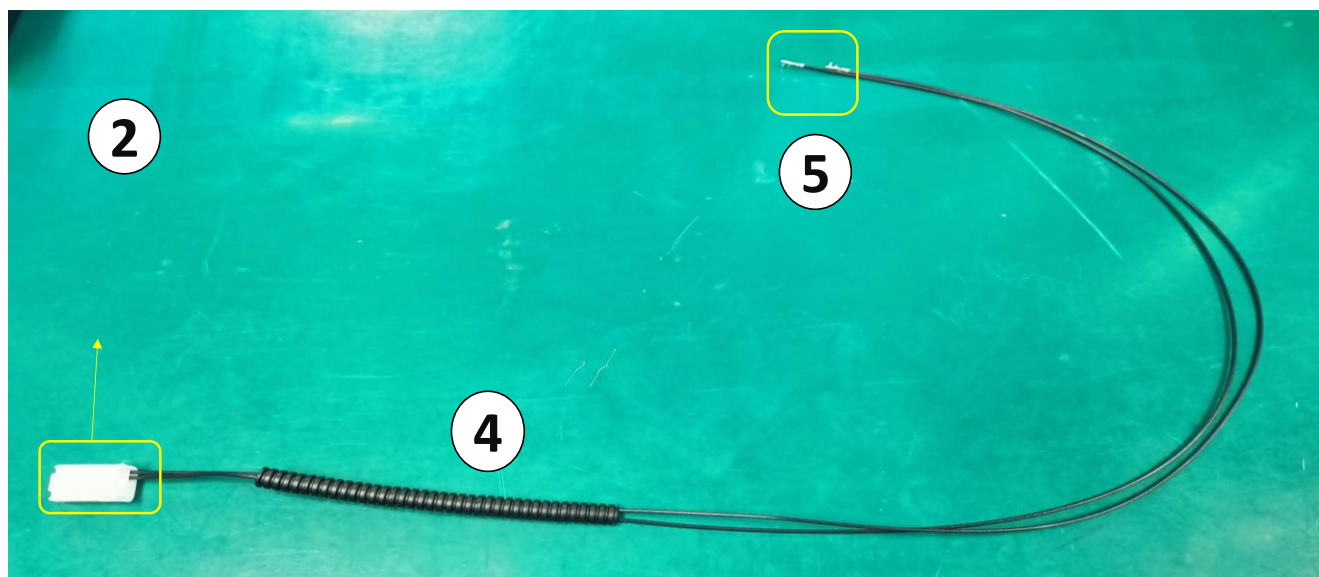
7M0515-7021



GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock connector

3 No Terminal Backing Out

5 No Deformed terminal

2 No Wrong insert

4 No Missing COT

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