

	WORK INSTRUCTION				Effectivity Date:		September 30, 2022	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:				Document No.:		WI-ENG-PDE-562	
	Model Code/Part Number: 220D / 7R0127-7021		Customer: TRMX		Revision No.:		2	Page No.: 1 of 3
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						

PARTS:	1. All parts: Connector 6098-6663 (B); AVSSf 0.3 B wires L=256±2mm; Black COT (no slit) ø5 L=188±3mm			JIG:	1. Terminal cover jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
1	n/a	Table Lay-out	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 2 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/30/22	2	Improve quality pointers: Reminders/notes and references in process no.1,2 and 3 due to document improvement. Work procedure/illustration in process no.3 - connector lock.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
07/19/22	1	Change document purpose from pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
07/15/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 15, 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.	<div style="border: 2px solid green; padding: 5px; display: inline-block;"> NBC (Philippines) MASTER COPY </div>	
--	---	--

DCC Stamp

**WORK INSTRUCTION**

Effectivity Date:

September 30, 2022

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number:

220D

/

7R0127-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-562

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:


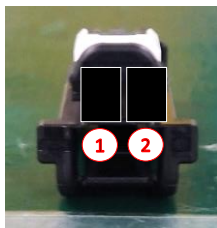

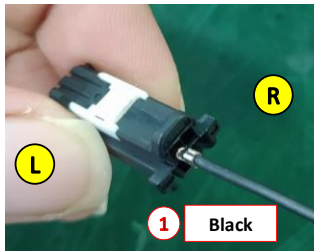
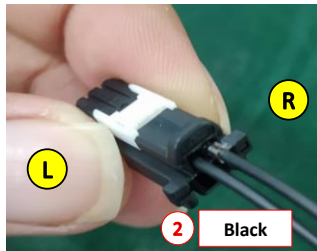
2 of 3

PARTS:

1. Connector 6098-6663 (B)
2. AVSSf 0.3 B wires L=256±2mm [2pcs.]

JIG

n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Wire insertion to connector 6098-6663 (B)	<div><div><p>CONNECTOR ORIENTATION</p></div><div><p>VISUAL REFERENCE</p></div><div><p>Wire facing</p></div><div><p>1 Black</p></div><div><p>2 Black</p></div><div><p>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion. <i>Note: Insertion of wire must be from left to right.</i></p><p>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</p></div></div>	n/a	<div><p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p><p>2</p><p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></div>

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:

September 30, 2022

Process Name/Title:

Validity date

n/a

Model Code/Part Number: **220D / 7R0127-7021**

Customer: **TRMX**

Document No.:

WI-ENG-PDE-562

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:


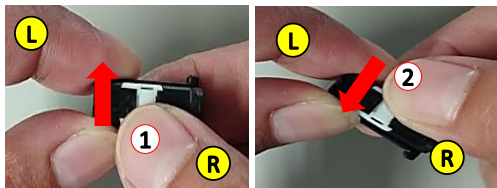
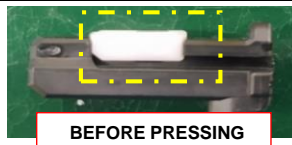
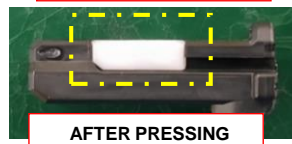





3 of 3

PARTS:

1. Assy parts
2. Black Corrugated tube $\phi 5$ L=188 \pm 3mm (no slit)

JIG

1. Terminal cover jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Connector lock	 <p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector lock if properly locked.</p>  <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>  <p>BEFORE PRESSING</p>  <p>AFTER PRESSING</p>	<p>LOCKING JIG</p> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided jig per connector</p> <p>2. No unlock/half-locked connector</p>
4	Wire insertion to Black corrugated tube $\phi 5$ L=188 \pm 3mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the B-B wires.</p>  <p>2. Get the Corrugated tube $\phi 5$ L=188\pm3mm (no slit) using right hand then insert the B-B wires.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<p>TERMINAL COVER JIG</p> 	<p>1. No deformed terminal</p> <p>2. No wrong usage of parts</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