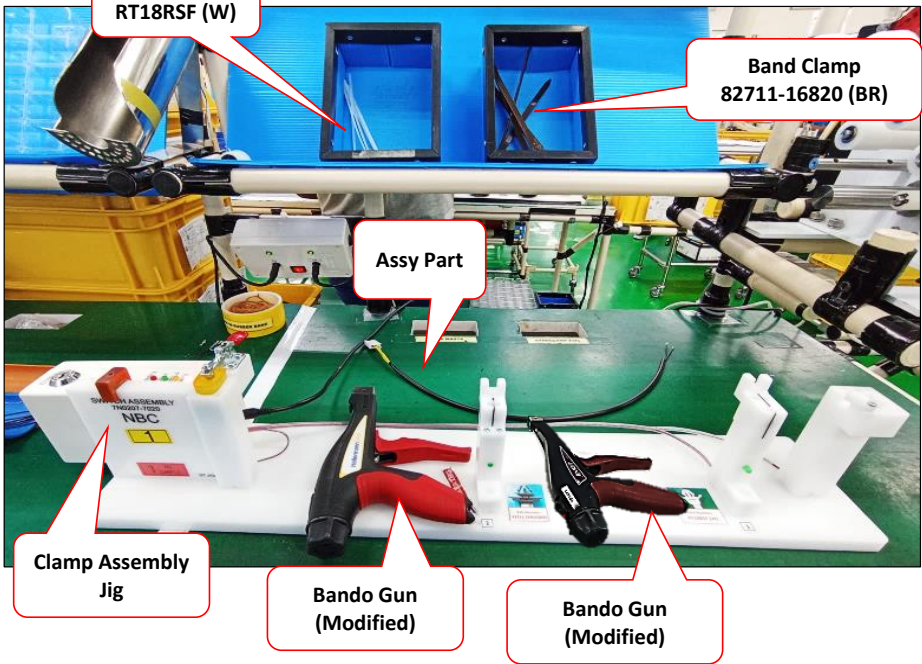


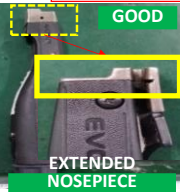













	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS						Effectivity Date: May 08, 2025																																						
	Process Name/Title:						Validity Date: n/a																																						
	Model code/Part number: NB8 / 7N0207-7021		Customer: TRJ		Car Model: SUBARU-LEGACY		Document No.: WI-ENG-PDE-1225																																						
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.: 2																																						
PARTS: 1. Assy part 2. Band Clamp RT18RSF (W)		3. Band Clamp 82711-16820 (BR)						JIG: 1. Clamp Assembly Jig 2. Bando Gun (Not Modified)																																					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	QUALITY POINTERS																																				
1	Clamp Assy	<div> <div>TABLE LAY OUT</div>  </div>						<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1.No missing parts/tools 2.No excess parts/tools</p> <div> <div>BAND CLAMP ILLUSTRATION</div> <div> <div>GOOD</div>  <div>82711-26380 (BR)</div> </div> <div> <div>NG</div>  <div>82711-16820 (BR)</div> </div> </div> <div> <div>BANDO GUN ILLUSTRATION</div> <div> <div>GOOD</div>  <div>EXTENDED NOSEPIECE</div> </div> <div> <div>NG</div>  <div>FLAT NOSEPIECE</div> </div> </div>																																				
<div> <div>Revision History</div> <table border="1"> <thead> <tr> <th>Eff. Date</th> <th>Rev. No</th> <th>Details of Change</th> <th>Revised</th> <th>Reviewed</th> <th>Approved</th> <th>Approved</th> <th>Prepared by</th> <th>Checked by</th> <th>Reviewed by</th> <th>Approved by</th> </tr> </thead> <tbody> <tr> <td>05/08/25</td> <td>2</td> <td>Correction of measurement of overall harness length from L=610mm to L=620mm;Terminal pointed tip to Band Clamp 82711-16820 (BR) from L=281mm to L=291mm</td> <td>A.Buban</td> <td>J. Loterte</td> <td>C.Villanueva</td> <td>A. Arañes</td> <td rowspan="3">  A. Buban </td> <td rowspan="3">  J. Loterte </td> <td rowspan="3">  C. Villanueva </td> <td rowspan="3">  A. Arañes </td> </tr> <tr> <td>05/05/2025</td> <td>1</td> <td>Update Work procedure/Illustration; Inclusion of Bando gun for Band Clamp RT18RSF (W) due to encountered maximum tolerance of bandclamp cut. Additional illustration of correct position of bando gun.</td> <td>A.Buban</td> <td>n/a</td> <td>C.Villanueva</td> <td>A. Arañes</td> </tr> <tr> <td>03/04/2025</td> <td>0</td> <td>Initial issue separate process from taping process</td> <td>A.Buban</td> <td>J. Loterte</td> <td>C.Villanueva</td> <td>A. Arañes</td> </tr> </tbody> </table> </div>										Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Approved	Prepared by	Checked by	Reviewed by	Approved by	05/08/25	2	Correction of measurement of overall harness length from L=610mm to L=620mm;Terminal pointed tip to Band Clamp 82711-16820 (BR) from L=281mm to L=291mm	A.Buban	J. Loterte	C.Villanueva	A. Arañes	 A. Buban	 J. Loterte	 C. Villanueva	 A. Arañes	05/05/2025	1	Update Work procedure/Illustration; Inclusion of Bando gun for Band Clamp RT18RSF (W) due to encountered maximum tolerance of bandclamp cut. Additional illustration of correct position of bando gun.	A.Buban	n/a	C.Villanueva	A. Arañes	03/04/2025	0	Initial issue separate process from taping process	A.Buban	J. Loterte	C.Villanueva	A. Arañes
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**WORK INSTRUCTION**Process Name/Title: **CLAMP ASSEMBLY PROCESS**

Effectivity Date:

May 08, 2025Model code/Part number: **NB8 / 7N0207-7021**Customer: **TRJ**Car Model: **SUBARU-LEGACY**

Document No.:

WI-ENG-PDE-1225

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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1. Band Clamp RT18RSF (W)
2. Band Clamp 82711-16820 (BR)

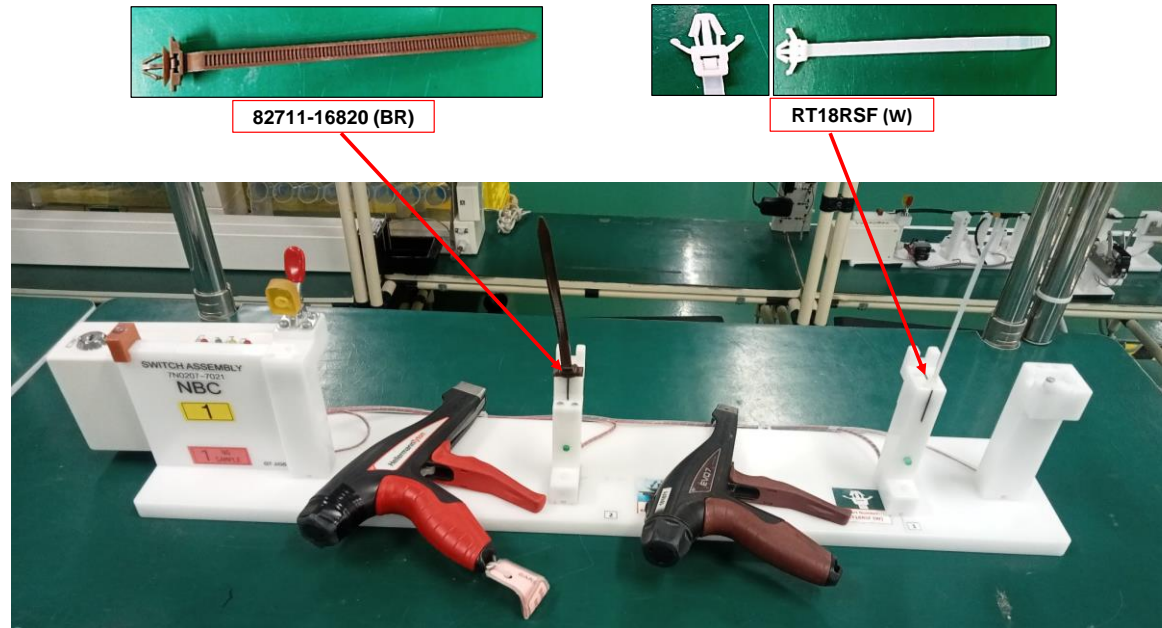
JIG:

Clamp Assembly Jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2**

Clamp Assy

Clamp Setting



1. Get 1 pc of clamp **RT18RSF (W)** using right hand and set in to clamp **location 1** using both hands.

2. Get 1 pc of clamp **82711-16820 (BR)** using right hand and set in to clamp **location 2** using both hands.

1. No damaged clamp
2. No wrong use of clamp
3. No missing clamp

Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

2. Make sure no gap between the terminal and stopper jig. use of tape and missing tape.

3. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.

For: ø5 - 1~2, ø7 - 3~4

BANDO GUN

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DCC Stamp



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

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PARTS:				JIG:	1.Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><p>82711-16820 (BR)</p></div> <div><p>RT18RSF (W)</p></div> <div></div> <div></div> <div></div> <div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 4F5260-0000 (W) in Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp.</p><p>2. Initially tighten the band clamp on location 1 and location 2 using both hands.</p><p>3. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Follow the illustration below.</p></div> <div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div> <div><div><p>GOOD</p></div><div><p>NG</p></div></div> <div><p>BANDO GUN ALIGNMENT</p></div> <div><p>Fixed setting of band clamp cutter: 1</p></div> <div></div>		<p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp</p> <div><p>0~2mm</p></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals.</p> <p>2. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p>	

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Car Model: SUBARU-LEGACY

Purpose:



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May 08, 2025

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	<div><div></div><div></div><div></div><div></div><div></div><div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 4F5260-0000 (W) in Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp.</p><p>2. Get the bando gun using right hand then cut the band clamp on location 2 using both hands.</p><p>3. Conduct POINT CHECKING before removing the harness from jig.</p></div><div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div><div></div><div><div><p>BANDO GUN ALIGNMENT</p></div><div></div></div></div><div><div></div><div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals.</p><p>2. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p></div><div><div><p>BANDO GUN</p></div></div></div></div>		

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PRE-LAUNCH



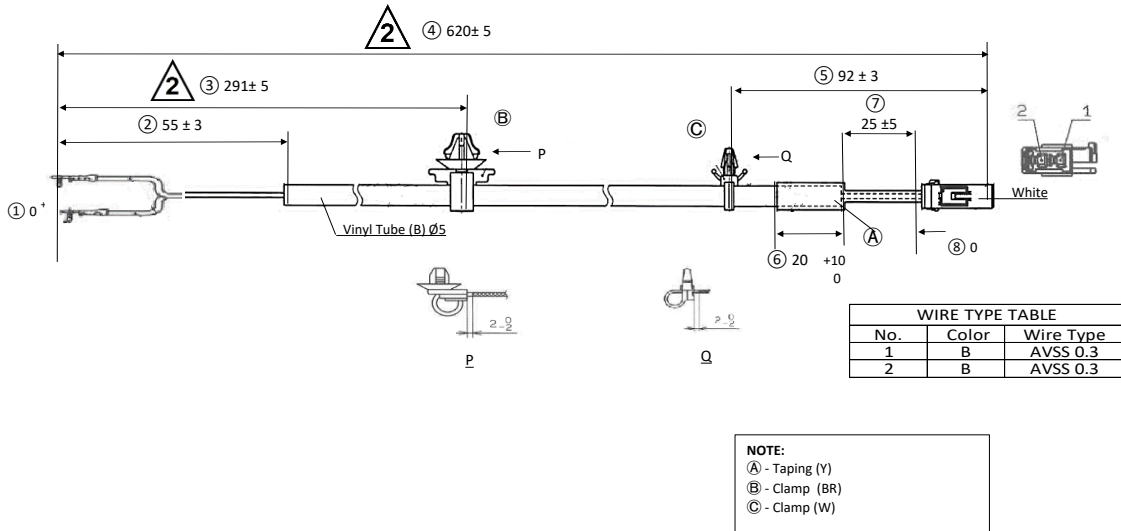
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PARTS:		1.Assy parts		JIG:	1.Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
5	Clamp Assy	Measurement	<div></div>				1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp

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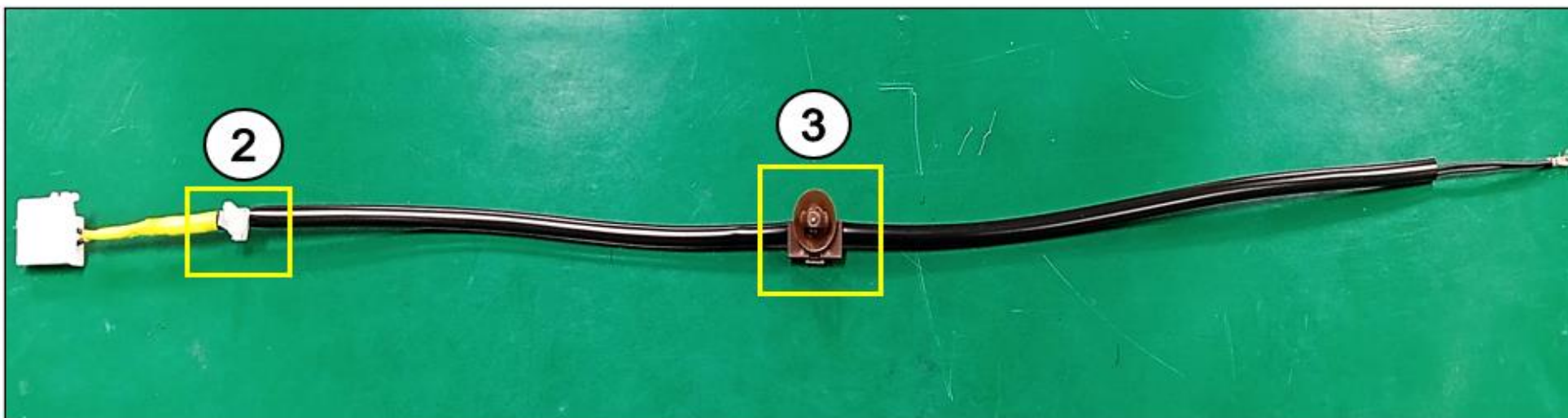
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0207-7021**

① Check the **Alignment of clamp**

② ③ **No Wrong Used of Clamp**

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