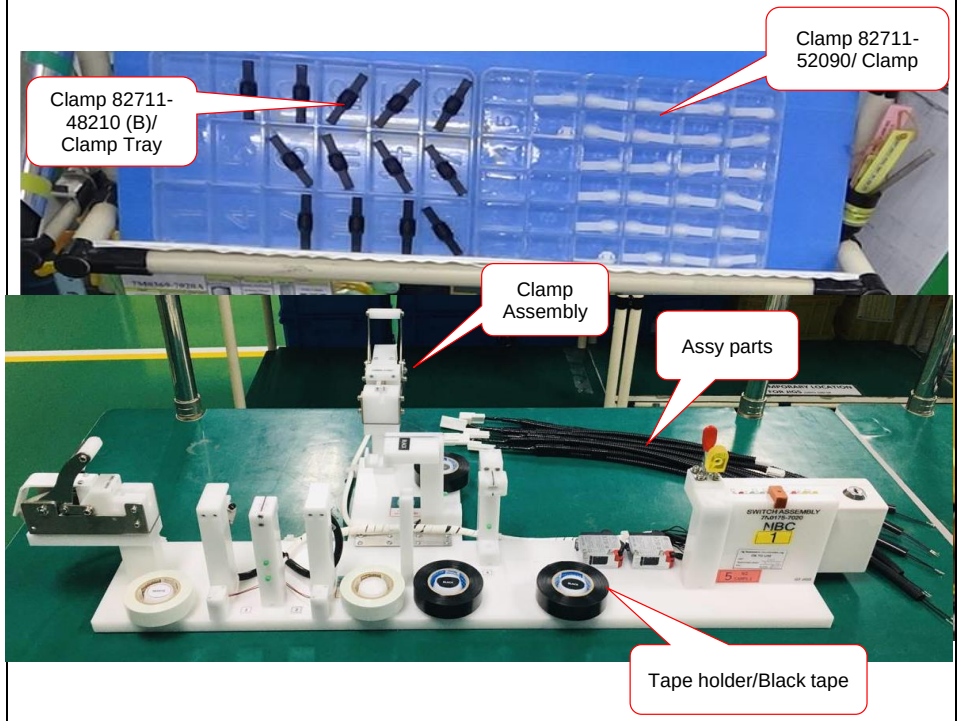
	WORK INSTRUCTION				Effectivity Date:	September 21, 2023	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS			Validity Date:	n/a	
	Model code/Part number:	382D / 7N0175-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-728	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 8

PARTS:	1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-52090 (W); Black tape [3pcs]; White tape [2pcs]	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out			1. No missing parts/tools 2. No excess parts/tools. *Important reminders/Note/s:* *1. Please check the clamp before start of assembly to avoid wrong use of clamp*

Revision History							Prepared by	Reviewed by	Approved by	Noted by
09/21/23	1	Change purpose from pre-launch to mass pro								
09/15/23	0	Initial Issue	M. Mañalac	J. Loterte	C.Villanueva	A. Arañes	M. Mañalac	J. Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 15, 2023		

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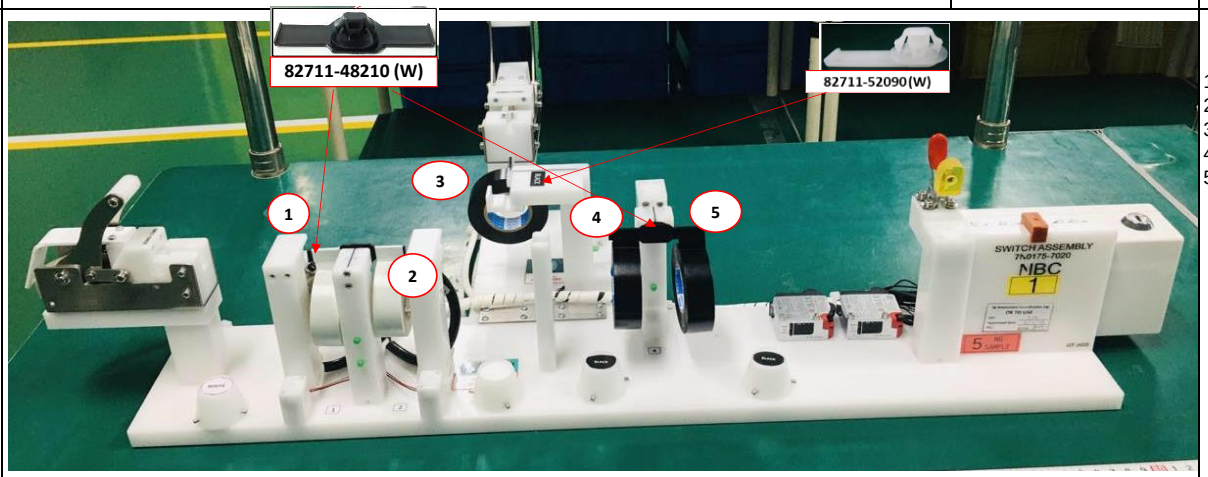
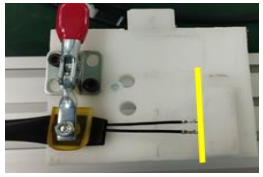
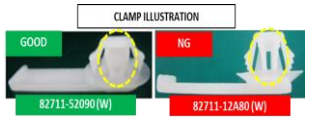
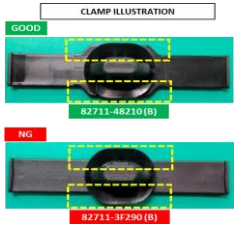
	WORK INSTRUCTION			Effectivity Date:	September 21, 2023	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 382D / 7N0175-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-728	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 8

PARTS:	1. Clamp 82711-48210 (B) [2pcs] 2.Clamp 82711-52090 (W) [1pc]	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Clamp setting	 1. Get [2pcs] of Clamp 82711-48210 (B) then set to location 1 and 2 using both hands. 2. Get the white tape then initially attach to location 1 using both hands 3. Get [1pc.] of Clamp 82711-52090 (W) then set to location 3 using both hands. 4. Get the Black tape then initially attach to location 4 and 5 using both hands		1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process *Important reminders/Note/s:* *1. Please check the clamp before start of assembly to avoid wrong use of clamp*   

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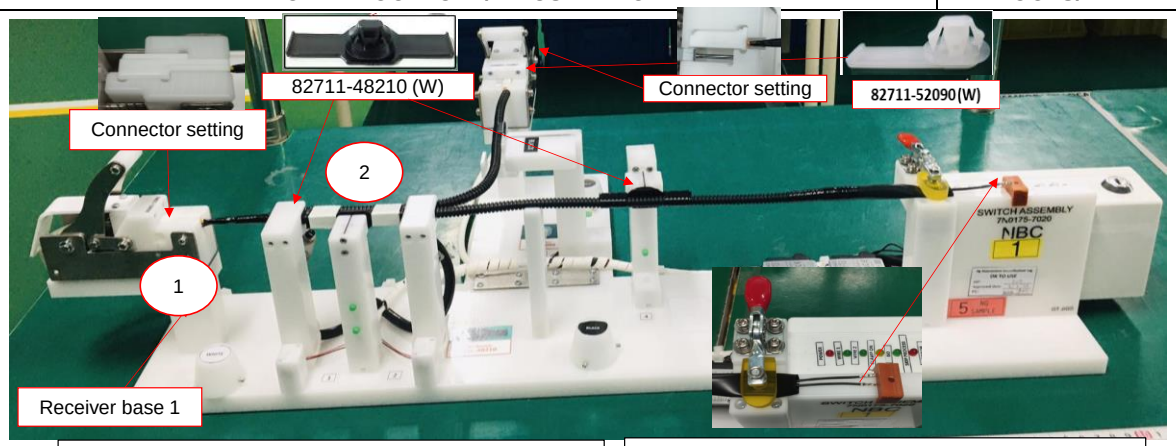
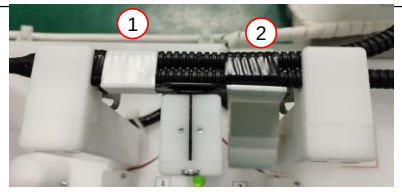
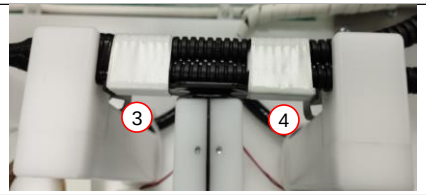
	WORK INSTRUCTION			Effectivity Date:	September 21, 2023	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 382D / 7N0175-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-728	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 3 of 8

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly	 1. Get the assy parts and set into jig. *(See above picture for correct setttng of harness).* First, set the connector 6098-3802 (W) to checker 1 then pull the checker fixture for continuity checking. Second, set the connector to checker 2 then pull the checker fixture for continuity checking, Last set the terminal into stopper jig then pull the toggle clamp using right hand. 2. Check all the LED light for Power ON, clamp ON, Wire 1 and Wire 2 was ON. If encountered abnormality , STOP and immedately CALL the attention of the leader. WAIT for the further instruction then continue the process. Continue if the sequence light in location 1 was ON.  3. Hold the tape on location 1 then start taping using both hands. Make 3 windings of tape and then cut the tape. Press the SW button after taping. Continue if the sequence light on location 2 was ON  4. Hold the White tape on location 2 then start taping using both hands. Make 3 windings of tape and then cut the tape. Press the SW button after taping. Continue if the sequence light on location 3 was ON		1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process *Important reminders/Note/s:* *1. Make sure no gap between stopper and terminals*

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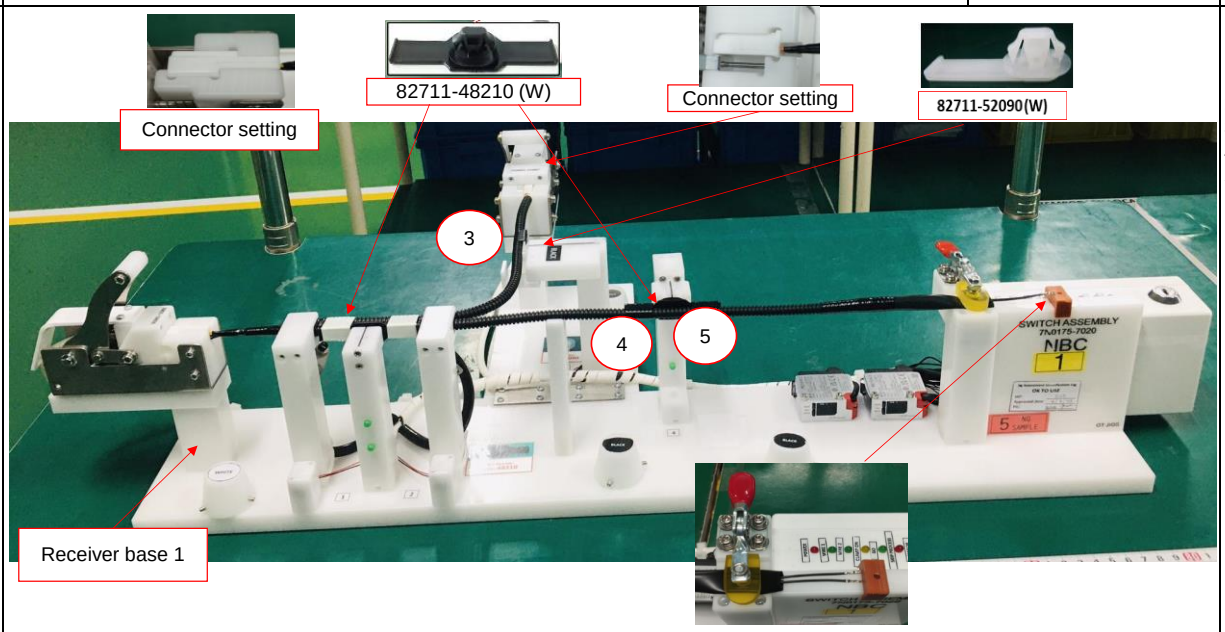
PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly (Continuation)	 5. Hold the tape on location 3 then start taping using both hands. Make 3 windings of tape then cut the tape. Press SW button after taping. Continue if the sequence light on location 4 was ON. 6. Hold the tape on location 4 then start taping using both hands. Make 3 windings of tape then cut the tape. Press SW button after taping. 7. After taping, CONDUCT POINT CHECKING before removing the harness from jig.		1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process *Important reminders/Note/s:* *1. Make sure no gap between stopper and terminals*

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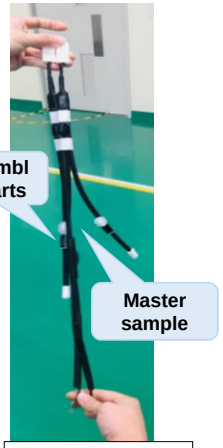
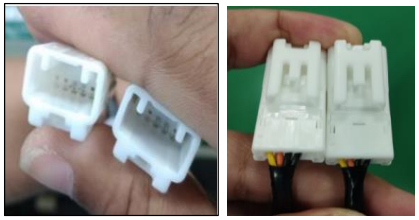
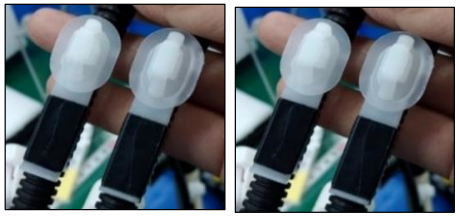
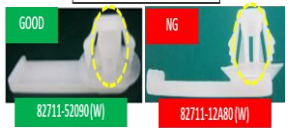
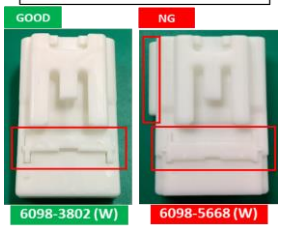
	WORK INSTRUCTION				Effectivity Date:	September 21, 2023	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS			Validity Date:	n/a	
	Model code/Part number: 382D / 7N0175-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY		Document No.:	WI-ENG-PDE-728	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.: 5 of 8

PARTS:	1. Assembled parts 2. Master sample	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Visual/By two's inspection	 1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.  2. Check the **connector lock**, **terminal**, **insertion** and **taping condition**.  3. Check the **presence of all clamp attachment, taping condition, color of tape condition.** 4. Check the **Y-Taping condition.**		1. No skip checking during inspection **MASTER SAMPLE** CLAMP ILLUSTRATION  CONNECTOR ILLUSTRATION 

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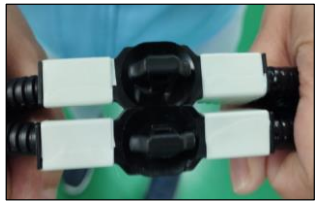
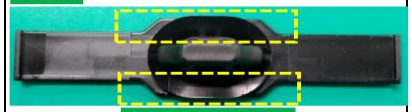
	Model code/Part number: 382D / 7N0175-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY		Document No.:	WI-ENG-PDE-728	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO				Revision No.:	1	Page No.: 6 of 8

PARTS:	1. Assembled parts 2. Master sample	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	Visual/By two's inspection	 ACTUAL PRODUCT  5. Check the presence of clamp attachment, taping condition, color of tape (Must be white tape). Conduct slightly bending of parts with wing type-clamp. Check the inside spot taping. 6. Check the taping condition of COT to sunprene tube. Conduct slightly bending. 7. Check the terminal appearance		1. No skip checking during inspection MASTER SAMPLE CLAMP ILLUSTRATION GOOD  82711-48210 (B) NG 82711-3F290 (B)

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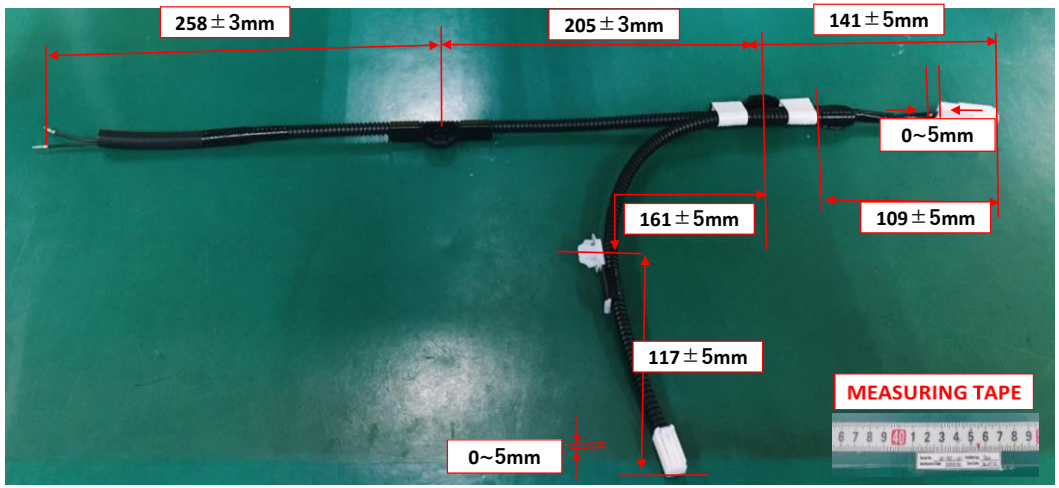
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 7 of 8

PARTS:	n/a	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a	Measurement			1. No wrong dimension. ***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono and Owarimono.***

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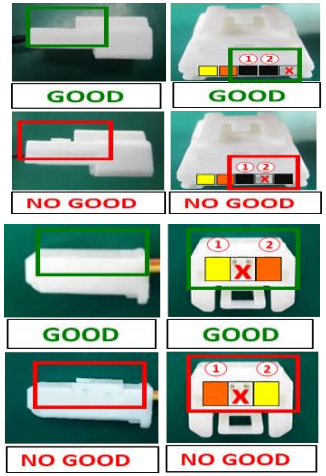
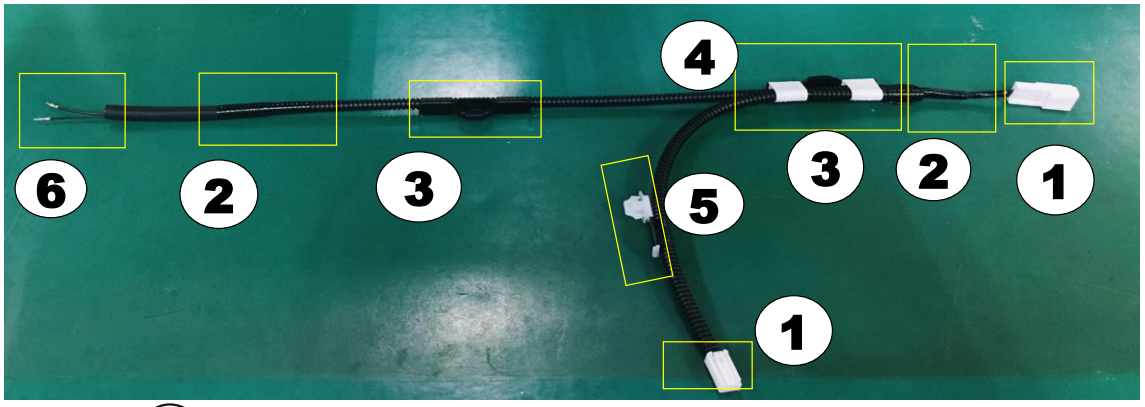
PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

P1 7N0175-7020A





1. No Unlock/ Halflocked Connector
   No Wrong Insert (no wrong slot)
2. No Missing Tape
3. No Missing Clamp and BENDING of 2 sides of wing clamp
4. No wrong color of tape (White tape
5. No Missing Common Clamp [1PC]
6. No deformed terminal
7. Checking of clamp alignment.

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