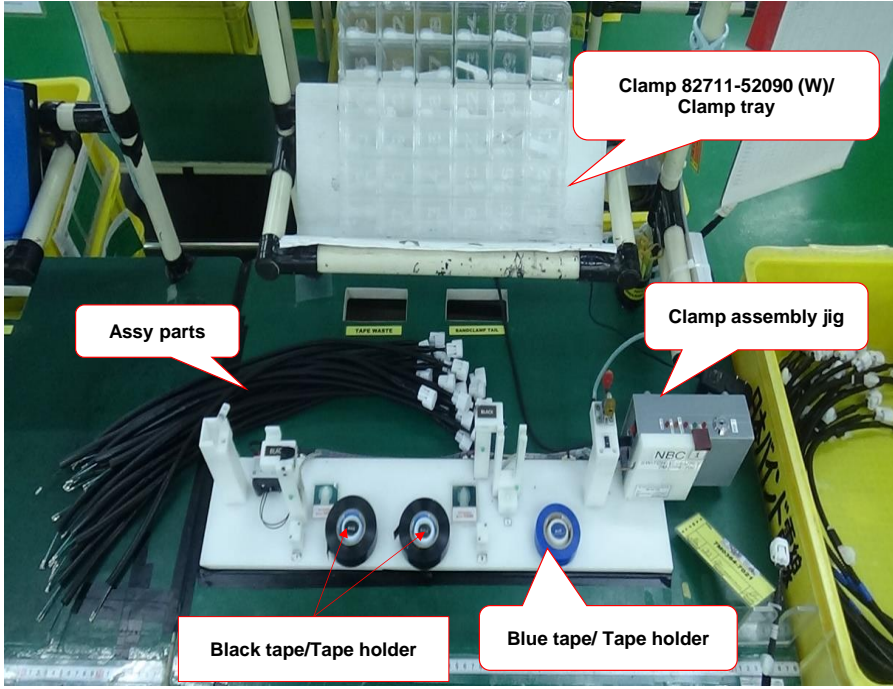

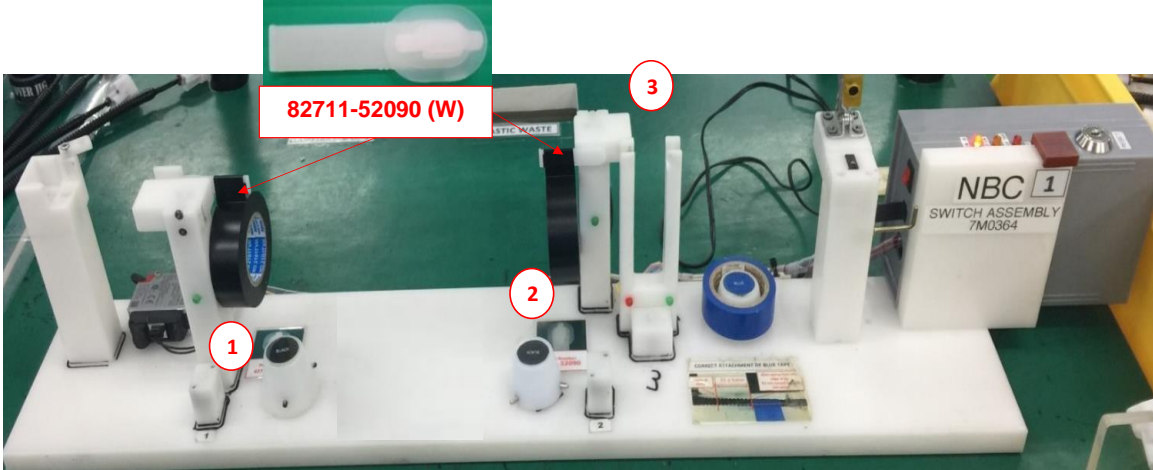



	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>October 30, 2024</b>		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>011B / 7M0364-7021B</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.:	<b>WI-ENG-PDE-1153</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 5

<b>PARTS:</b>		1. Assy parts; Clamp 82711-52090 (W); Black tape [2pcs]; Blue tape				JIG:		1. Clamp assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	Clamp assy	<div> <div>TABLE LAY-OUT</div>  </div>				<div> <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> </div>		<p><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-1144A-B</b> for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	
Revision History									
						Prepared by	Reviewed by	Approved by	Noted by
10/30/24	1	Change from Pre-launch to Masspro.				D.Castillo	C.Villanueva	A. Arañes	N/A
10/22/24	0	Initial issue. Separate Clamp assembly proceess from Taping assembly process due to process improvement.				D.Castillo	C.Villanueva	A. Arañes	N/A
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	October 22, 2024		

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 5


<b>PARTS:</b>	1. Clamp 82711-52090 (W) 2. Black tape[ 2pcs]			3. Blue tape	JIG:	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Clamp assy	<div>Clamp setting</div> <div></div> <div>1. Get <b>2pcs.</b> of clamp <b>82711-52090 (W)</b> using both hands then set to location <b>1</b> and <b>2</b> using both hands.</div> <div>2. Initially attach <b>Black tape</b> on clamp location <b>1</b> and <b>2</b> using both hands.</div>				<div><b>STANDARD TAPING FOR CLAMP</b></div> <div>One wind for uder clamp</div> <div></div> <div><b>Important reminders/Note/s:</b> 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</div> <div><b>CLAMP ILLUSTRATION</b></div> <div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div> <div><div>NG</div><div></div><div>82711-12A80 (W)</div></div>

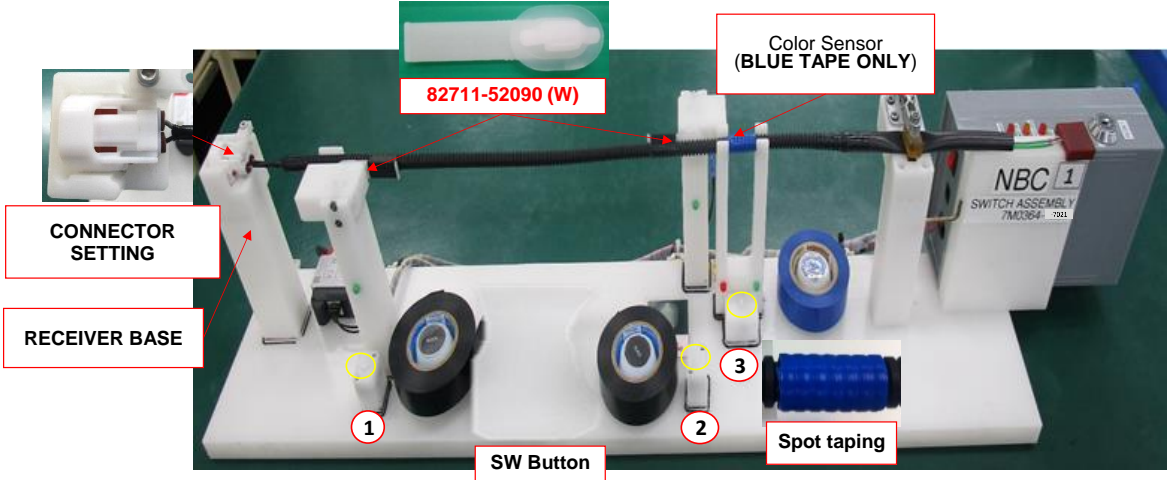

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 30, 2024</b>		
	<b>CLAMP ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>011B / 7M0364-7021B</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.:	<b>WI-ENG-PDE-1153</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:

<b>PARTS:</b>	1. Assy parts 2. Blue tape		JIG:	1. Clamp assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	Clamp assy	Clamp assembly			 <p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. Make sure no gap between stopper and terminals.</li><li>2. Make 2-3 windings for clamp taping</li></ul> <ul style="list-style-type: none"><li>1. No loose attachment of clamp</li><li>2. No damage clamp</li><li>3. No missed tape</li><li>4. No missing parts</li><li>5. No wrong use of tape</li></ul>
		<p>1. Get the assy parts and set into jig. (See above picture for the correct setting). First, set the connector <b>6189-0451 (W)</b> to <b>Receiver base 1</b> and lock. Last, set the <b>G-B/W wires</b> together within the stopper then press by toggle clamp. Continue the process if sequence light in <b>location 1</b> was <b>ON</b>.</p> <p>2. Check if <b>LED light</b> for <b>POWER ON, CLAMP ON</b> was <b>ON</b>. Check also if <b>clamp location 1</b> sequence light is <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process. Continue if the sequence light of location <b>1</b> was <b>ON</b>.</p> <p>3. Hold the tape on clamp location <b>1</b> and start taping using both hands. Make <b>3 windings</b> then cut the tape. Press the <b>SW button</b> after taping. Continue the process if sequence light on location <b>2</b> was <b>ON</b>.</p>	<p>4. Hold the tape on clamp location <b>2</b> and start taping using both hands. Make <b>3 windings</b> then cut the tape. Press the <b>SW button</b> after taping. Continue the process if sequence light on location <b>3</b> was <b>ON</b>.</p> <p>5. Get <b>Blue tape</b> and conduct spot taping on <b>location 3</b> using both hands. <b>Go</b> sound will be heard if the <b>color sensor</b> detected the <b>Blue tape</b>.</p> <p>6. Conduct <b>POINT CHECKING</b> before removing of harness from jig.</p> <p>7. After point checking. Remove the harness from toggle clamp up to connector receiver base.</p>		

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# WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 30, 2024

Validity Date:

n/a

Model code/Part number:

011B / 7M0364-7021B

Customer:

TRJ

Car Model:

TOYOTA CAMRY

Document No.:

WI-ENG-PDE-1153

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

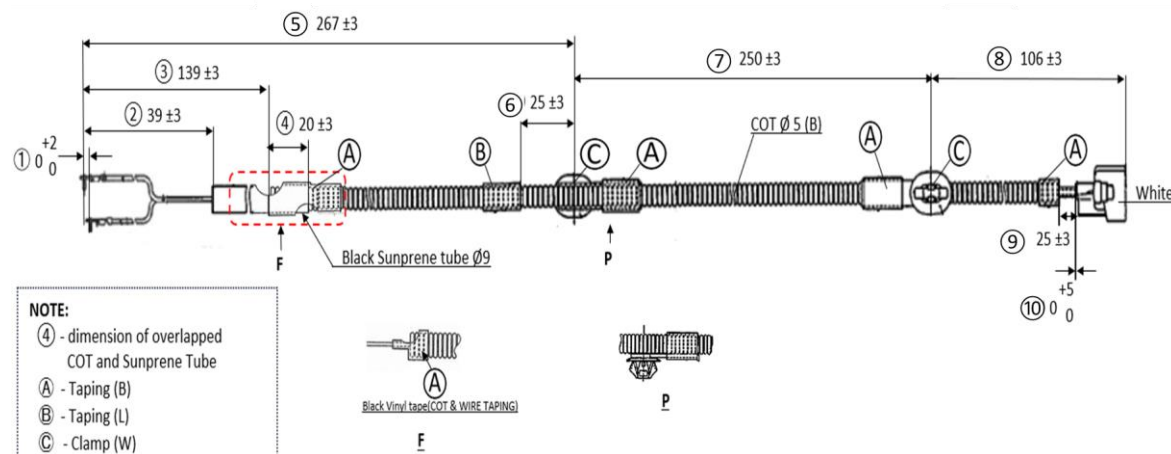
TOOLS/PPE

QUALITY POINTERS

4

Clamp  
assy

Measurement



**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

**Document reference/s:**

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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**WORK INSTRUCTION**

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**CLAMP ASSEMBLY PROCESS**

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n/a

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**011B / 7M0364-7021B**

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Document No.:

**WI-ENG-PDE-1153**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7M0364-7021B**

1

**No Wrong Facing of Clamp**

2

3

**No Missing Tape ( Black Tape )**

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