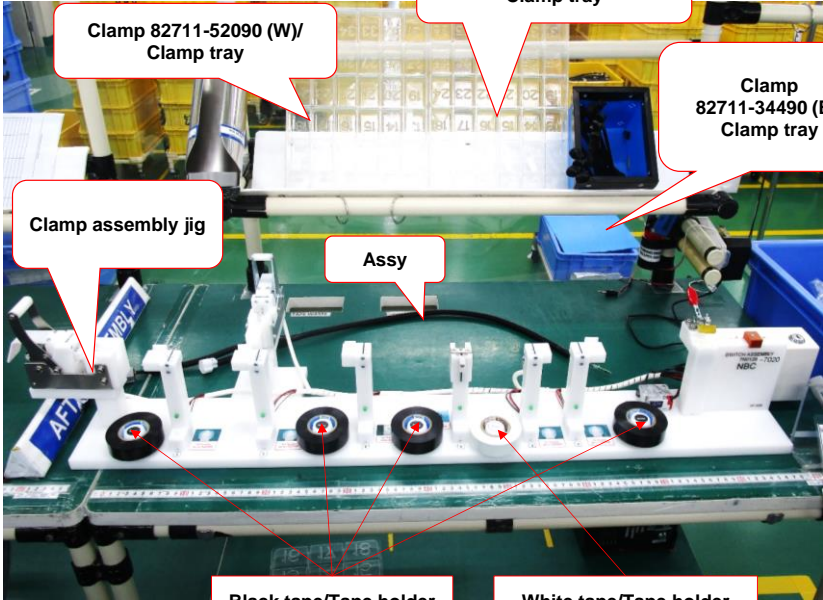




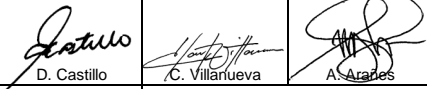
	WORK INSTRUCTION				Effectivity Date:		October 15, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 177D / 7L0128-7020B		Customer: TRQSS	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-1098C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 6

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [4pcs.]; White tape			JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
1	P3	<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>CLAMP ILLUSTRATION</div> <div>GOOD  82711-52090 (W)</div> <div>NG  82711-12A80 (W)</div> <div>BAND CLAMP ILLUSTRATION</div> <div>GOOD  82711-16830 (B)</div> <div>NG  82711-34490 (B)</div>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.				D.Castillo	C. Villanueva	A. Arañes	n/a	
10/11/24	0	Initial issue.				D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

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177D / 7L0128-7020B

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-1098C

Purpose:

☐ PROTOTYPE

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PARTS:

1. Clamp 82711-52090 (W) [4pcs.]
2. Clamp 82711-3A540 (W)
3. Clamp 82711-34490 (B)

4. Black tape [4pcs]
5. White tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

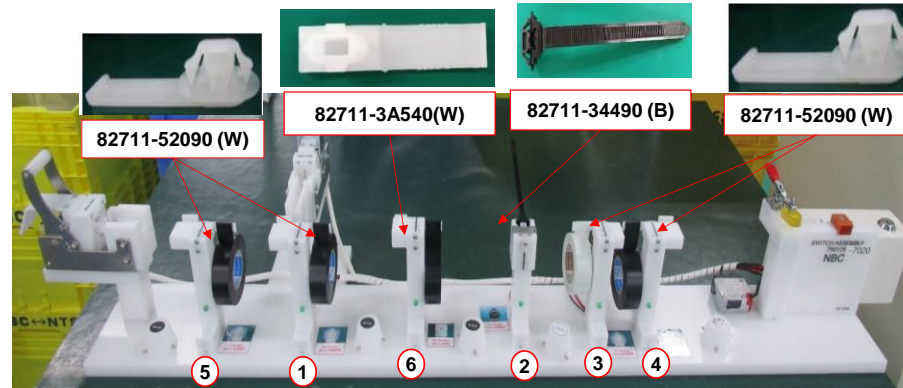
TOOLS/PPE

QUALITY POINTERS

2

P3

Clamp setting



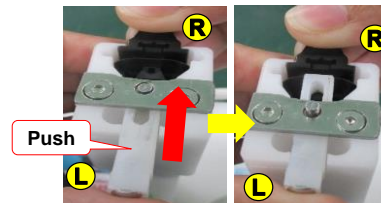
1. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **5 and 1** using both hands.

2. Get 2 pcs. of clamp **82711-52090 (W)** using both hands then insert to clamp location **3 and 4** using both hands.

3. Get 1 pc. of clamp **82711-3A540 (W)** using right hand then insert to clamp location **6** using both hands.

5. Get the **Black tape** then initially attach to clamp location **5, 1, 6 and 4** using both hands.

4. Get 1 pc. of clamp **82711-34490 (B)** using right hand then insert to clamp location **2** using both hands. *(See below illustration for clamp setting)*



6. Get the **White tape** then initially attach to clamp location **3** using both hands.

n/a

STANDARD TAPING FOR CLAMP

One wind for under tape



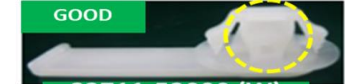
Important reminders/Note/s:

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

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

CLAMP ILLUSTRATION

GOOD



82711-52090 (W)

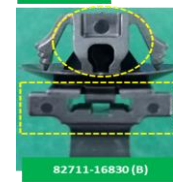
NG



82711-12A80 (W)

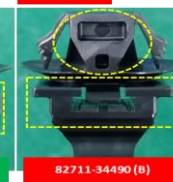
BAND CLAMP ILLUSTRATION

GOOD



82711-16830 (B)

NG




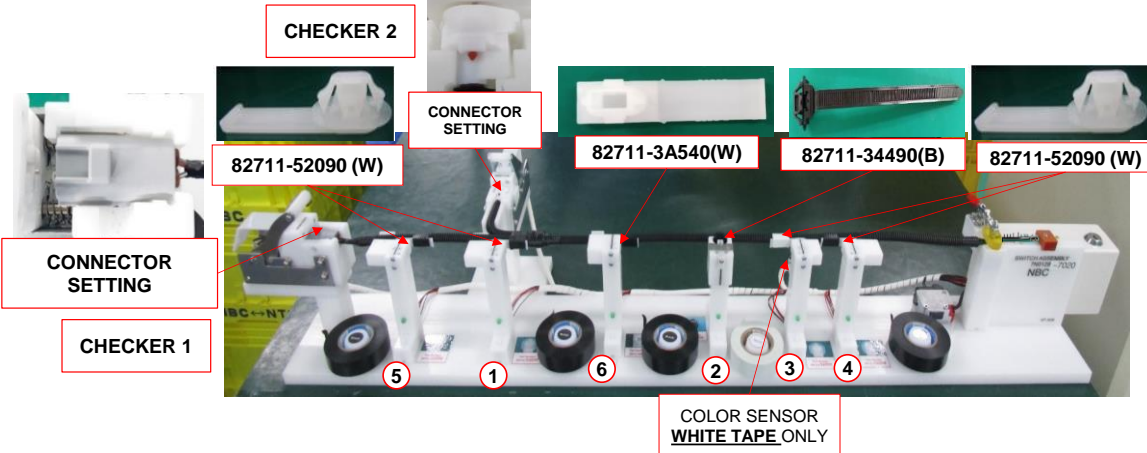
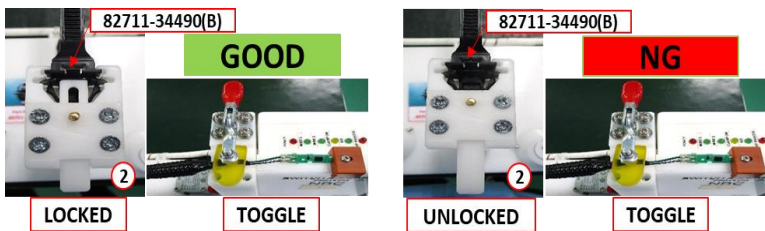
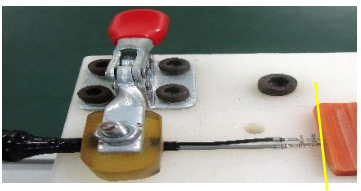
82711-34490 (B)

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	Model code/Part number: 177D / 7L0128-7020B		Customer: TRQSS		Car Model: TOYOTA-COROLLA		Document No.: WI-ENG-PDE-1098C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 3 of 6


PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
3	P3	Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the terminal within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 2 was ON.</p><div></div><p>NOTE: On clamp location 2, if clamp 82711-34490 (B) is locked and the toggle clamp is set, the proces will proceed. If clamp 82711-34490 (B) is unlock and the toggle clamp is set, the process will not proceed and NG buzz will be heard.</p></div> <div><p>Important reminders/Note/s:</p><p>1. Make sue no gap between stopper jig and terminal.</p><p>2. Make 2-3 windings for clamp taping.</p><p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance terminal and stopper jig 6. No wrong use of bando gun</p></div>				

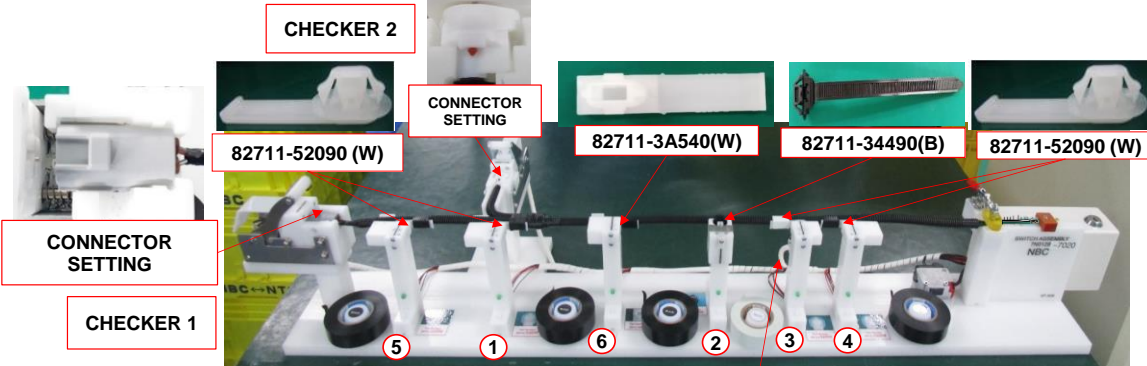


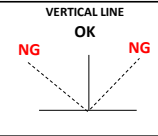

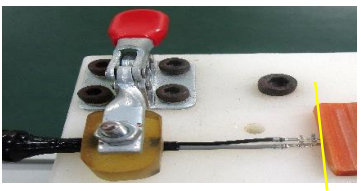

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 4 of 6

PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	P3	<div><div><p>CHECKER 2</p><p>CONNECTOR SETTING</p><p>82711-52090 (W)</p><p>82711-3A540(W)</p><p>82711-34490(B)</p><p>82711-52090 (W)</p><p>CONNECTOR SETTING</p><p>CHECKER 1</p><p>COLOR SENSOR WHITE TAPE ONLY</p></div><div><p>4. Initially tighten the band clamp on clamp location 2 using both hands.</p><p>5. Get the bando gun using right hand then cut the band clamp on location 2 using both hands. Press the SW button after cut. Continue the process if sequence light on clamp location 3 was ON.</p><p>Note:</p><div><div><p>GOOD</p></div><div><p>NG</p></div></div><p>Note: Setting of band clamp cutter depends on the size of the COT/SV/VM tube. For: ø5 - 1~2, ø7 - 3~4</p><div><p>VERTICAL LINE OK NG NG</p><p>Fixed setting of band clamp cutter: 1~ 2</p></div></div><div><p>6. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Color sensor light will beep/buzz if sensor detects White tape. Press the SW button after taping. Continue the process if sequence light on clamp location 4 was ON.</p><p>7. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 5 was ON.</p><p>8. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 6 was ON.</p><p>9. Hold the tape on clamp location 6, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</p><p>10. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p><p>11. After point checking, remove the harness from toggle clamp. Unlock the clamp lock, release checker 1 to Checker 2.</p></div></div> <div><p>Important reminders/Note/s:</p><p>1. Make sue no gap between stopper jig and terminal.</p><p>2. Make 2-3 windings for clamp taping.</p><p>1. No loose/tight clamp attached</p><p>2. No damage clamp</p><p>3. No missed tape</p><p>4. No missing parts</p><p>5. Make sure no clearance terminal and stopper jig</p><p>6. No wrong use of bando gun</p><div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p><p>NO WRONG USE OF BANDO GUN</p></div></div>					

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WORK INSTRUCTION

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177D / 7L0128-7020B

Customer:

TRQSS

Car Model:

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Document No.:

WI-ENG-PDE-1098C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

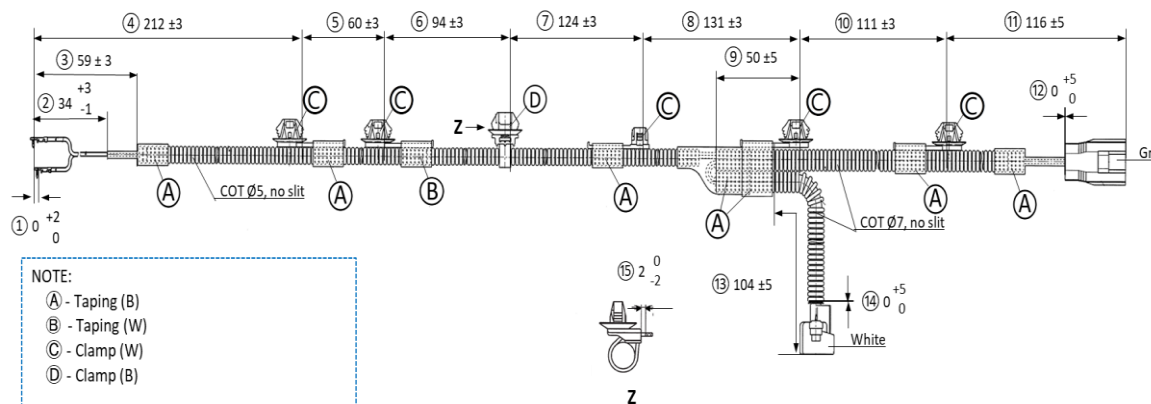
QUALITY POINTERS

4

P3

Measurement

Measuring tape



NOTE:

- (A) - Taping (B)
- (B) - Taping (W)
- (C) - Clamp (W)
- (D) - Clamp (B)

*Unit of measurement is in millimeter (mm)

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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PARTS:

1. Assy parts

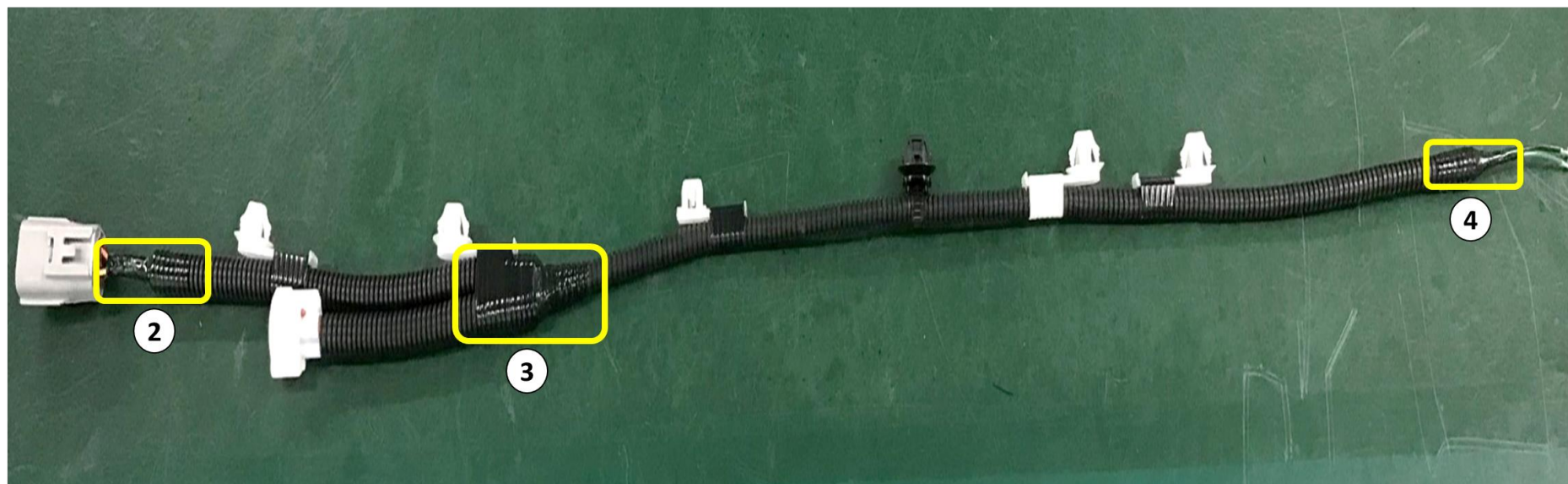
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P3

7L0128-7020B



① No Wrong facing of clamp

② ③ ④ No Missing Tape (Black tape)

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