



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Model code/Part number:

750B / 7M0681-7020A

Customer: TRJ

Car Model: TOYOTA-HARRIER

Document No.:

WI-ENG-PDE-916

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 5

PARTS:		1. All parts: Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape (5pcs.)				JIG:		1. Clamp assembly jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	Clamp Assy	<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>Document reference/s: 1. Refer to WI-ENG-PDE-215A-B for Offline assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>							
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
07/31/24 0 Initial issuance. Separate Clamp setting and Clamp assembly process from Taping assembly process (WI-ENG-PDE-215B).						D.Castillo		C.Villanueva		A. Arañes		n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		July 31, 2024	

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**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number:

750B / 7M0681-7020A

Customer:

TRJ

Car Model:

TOYOTA-HARRIER

Document No.:

WI-ENG-PDE-916

Purpose:





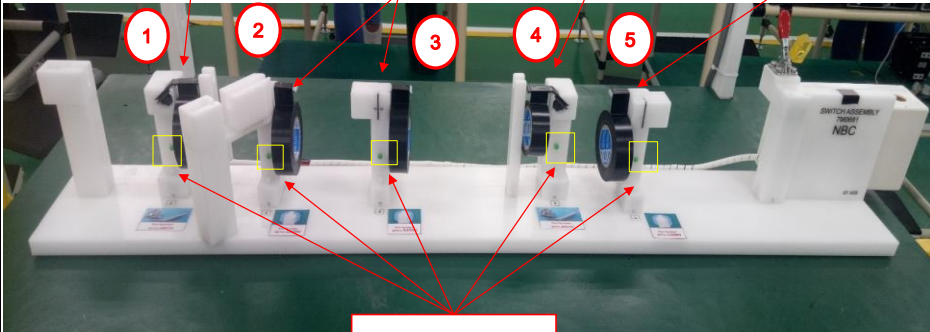
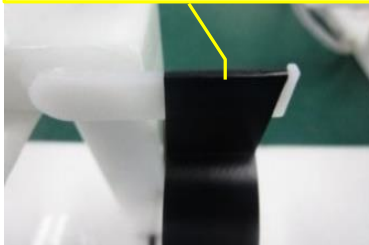


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:		1. Clamp 82711-52090 (W) [3pcs.] 2. Clamp 82711-48070 (GR) [2pcs.] 3. Black Tape [5pcs.]		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Clamp Setting	<div></div> <div><div>82711-48070 (GR)</div><div>82711-52090 (W)</div><div>82711-48070 (GR)</div><div>82711-52090 (W)</div></div> <div><div>Sequence light</div></div> <div><div>1. Get 2pcs. of clamp (82711-48070) using right hand then set to location 1 & 4 using both hands.</div><div>2. Get 3pcs. of clamp (82711-52090) using right hand then set to location 2, 3 & 5 using both hands.</div><div>3. Get Black tape using right hand and conduct pre-taping from location 1,2,3,4,5 using both hands.</div></div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s:</div> <div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div>82711-52090 (W)82711-12A80 (W)</div></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

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number:

750B / 7M0681-7020A

Customer:

TRJ

Car Model:

TOYOTA-HARRIER

Document No.:

WI-ENG-PDE-916

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

3 of 5

PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div>Receiver base A</div><div>82711-48070</div><div>82711-52090</div><div>82711-48070</div><div>82711-52090</div><div>2</div><div>1</div><div>3</div><div>4</div><div>5</div><div>Receiver base B</div><div>Connector(1) setting</div><div>Connector(2) setting</div><div>Sequence light</div><div>Stopper</div></div> <div><p>1. Get the assy parts and set to jig using both hands. First, put the 6098-3802 connector to Receiver base A then lock. Second, put the 6098-3810 connector to Receiver base B then lock. Last, set the terminal to stopper jig then pull down the toggle clamp. . Refer to the above illustration for the correct setting.</p><p>2. Check if all LED light for POWER ON and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light of Location 1 is ON</p><p>3. Start the taping process (3 windings) on clamp location 1 using both hands. Press the switch button after taping. Sequence light will ON to the next process.</p><p>4. Continue the taping process until you finished the location 2,3,4 & 5. Press the SW button after taping. Go sound will be heard.</p><p>5. Conduct Point Checking using right hand and slowly remove the harness from jig.</p></div> <div><div>GOOD CONDITION</div><div>NO GOOD CONDITION</div></div>	n/a	<div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals.</p><p>2. Make 2-3 windings for clamp taping</p></div> <div><p>Y-taping orientation</p></div> <div><p>1. No loose attachment of clamp</p><p>2. No damage clamp</p><p>3. No missed tape</p><p>4. No missing parts</p><p>5. No wrong use of tape</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**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number:

750B / 7M0681-7020ACustomer: **TRJ**Car Model: **TOYOTA-HARRIER**

Document No.:

WI-ENG-PDE-916

Purpose:

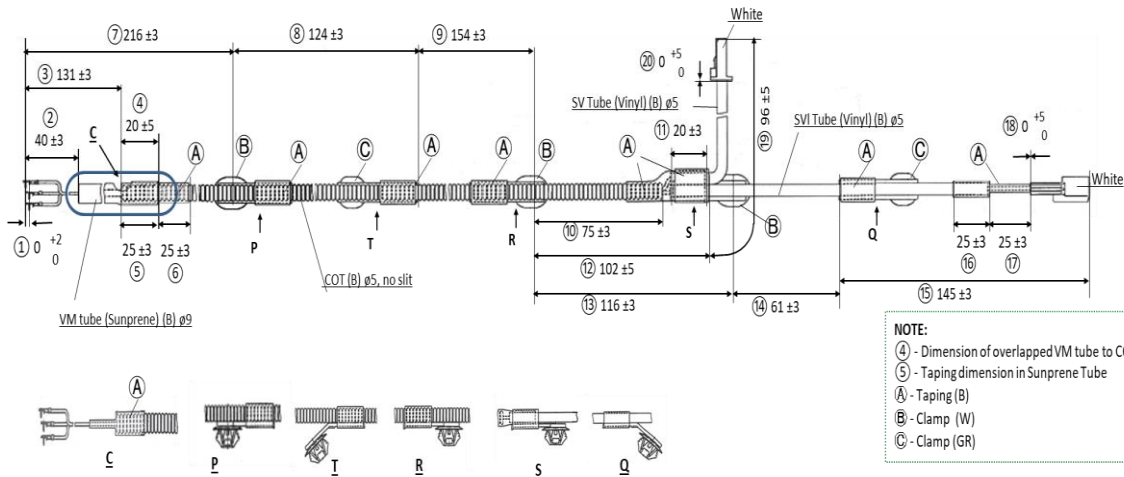

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

4 of 5

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement	<div></div>	<div><div>MEASURING TAPE</div></div> <div><p>NOTE:</p><p>④ - Dimension of overlapped VM tube to COT</p><p>⑤ - Taping dimension in Sunprene Tube</p><p>A - Taping (B)</p><p>B - Clamp (W)</p><p>C - Clamp (GR)</p></div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</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



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number:

750B / 7M0681-7020A

Customer: TRJ

Car Model: TOYOTA-HARRIER

Document No.:

WI-ENG-PDE-916

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

5 of 5

PARTS:

1. Assy parts

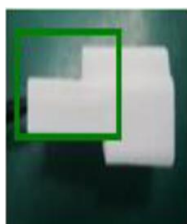
JIG:

n/a

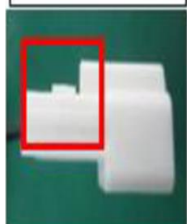
VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

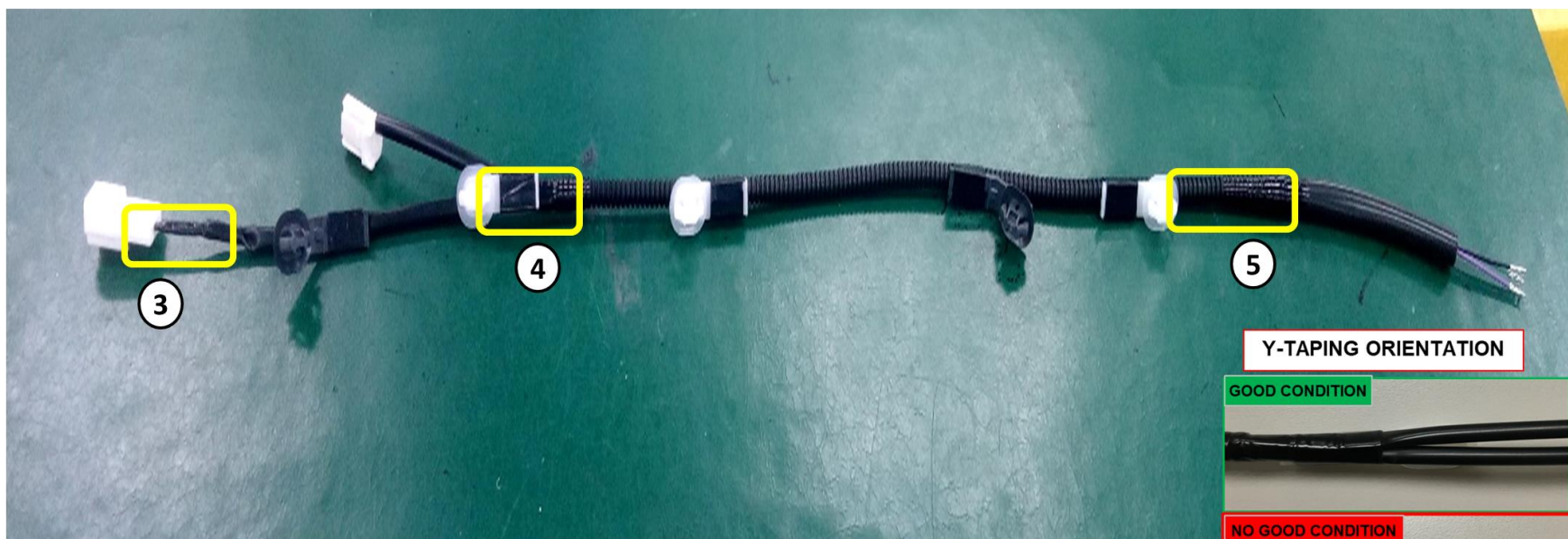
7M0681-7020A



GOOD



NO GOOD



- 1 No Wrong facing of clamp
- 2 No Unlock/Halflock connector

- 3 4 5 No Missing Tape (Black tape)

Y-TAPING ORIENTATION

GOOD CONDITION

NO GOOD CONDITION

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