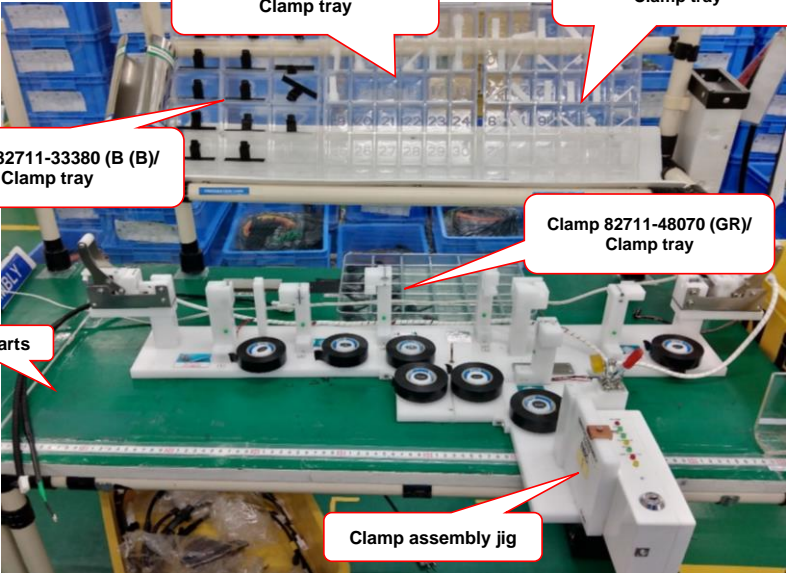

	WORK INSTRUCTION					Effectivity Date:		July 02, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS					Validity Date:		n/a	
	Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS		Car Model: TOYOTA-HIGHLANDER	Document No.:		WI-ENG-PDE-819	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		0	Page No.:

PARTS:		1. Assy parts; Clamp 82711-33380 (B); Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-3A540 (W); Black tape [7pcs.]				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</div> <div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping</div> <div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level</div> <div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
															
								D. Castillo		C. Villanueva		A. Arañes		n/a	
07/02/24 0 Initial issue.								D. Castillo		C. Villanueva		A. Arañes		n/a	
Eff. Date Rev. No Details of Change								Revised		Reviewed		Approved		Noted	
								Est. Date:		July 02, 2024					

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PARTS:		1. Clamp 82711-33380 (B) 2. Clamp 82711-52090 (W) [3pcs.] 3. Clamp 82711-3A540 (W) 4. Clamp 82711-48070 (GR) 5. Black tape [7pcs.]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp Setting	<div><div></div><div></div><div></div><div></div><div></div></div> <div></div> <div><div><p>1. Get 1pc. of clamp 82711-33380 (B) using right hand then set to clamp location 1 and 2 using both hands. <i>(See below illustration for correct setting)</i></p><div><div><p>Guide</p></div><div></div></div><p>2. After setting of clamp 82711-33380 (B), hold the guide lock then lock using right hand.</p></div><div><p>3. Get 3pcs. of clamp 82711-52090 (W) using right hand then set to clamp location 4, 6 and 7 using both hands.</p></div><div><p>4. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to clamp location 5 using both hands.</p></div><div><p>5. Get 1pc. of clamp 82711-48070 (GR) using right hand then set to clamp location 3 using both hands.</p></div><div><p>6. Initially attach Black tape on clamp location 1, 2, 3, 4, 5, 6 and 7 using both hands.</p></div></div> <td>n/a</td> <td><div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</div><div></div></div><div><p>Important reminders/Note/s:</p><p>1.Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p><ol style="list-style-type: none">1. No wrong use of parts2. No wrong use of tape3. No damaged clamp4. No wrong clamp position</div><div><div>CLAMP ILLUSTRATION</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></div></td>		n/a	<div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</div><div></div></div> <div><p>Important reminders/Note/s:</p><p>1.Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p><ol style="list-style-type: none">1. No wrong use of parts2. No wrong use of tape3. No damaged clamp4. No wrong clamp position</div> <div><div>CLAMP ILLUSTRATION</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></div>

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Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

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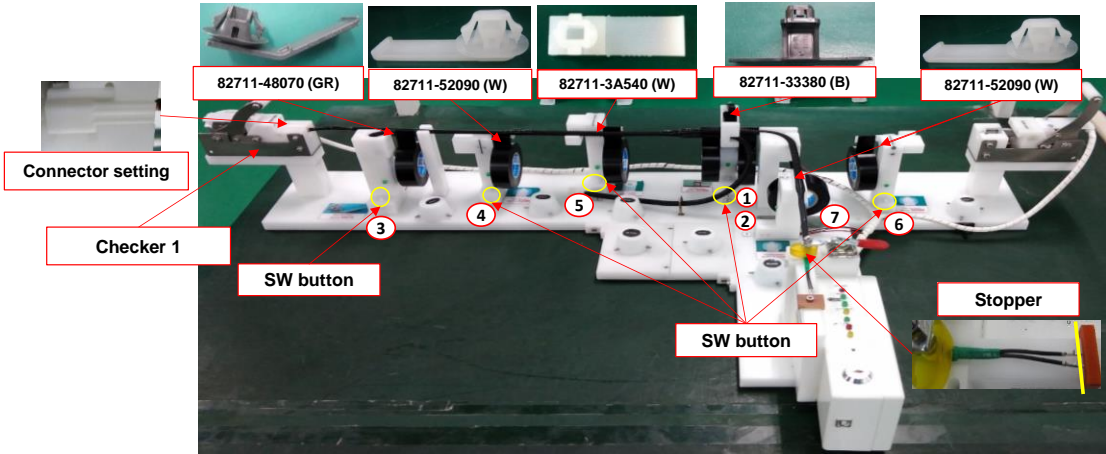
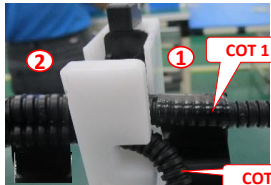
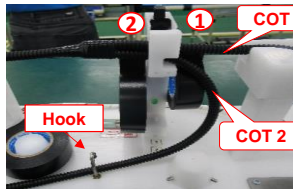

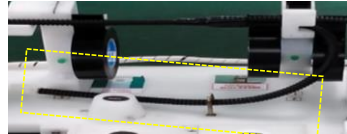
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 6098-3802 (W) to Receiver base 1 then pull the checker fixture. Continue to set the harness in jig. Second, set the terminal end together within the stopper then press by Toggle clamp. Initially put the other side of harness (COT with connector 6098-2220 (W)) in Hook.</p><p>2. Check if all LED light for Power On was On. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p></div> <div><div></div><div><p>3. Hold the tape on clamp location 1, make 2 windings on COT 1 and do not cut the tape. Press the SW button. (<i>See illustration.</i>)</p></div></div>			<div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper jig and terminals</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><div><p>Assy parts reference in Hook</p></div></div>

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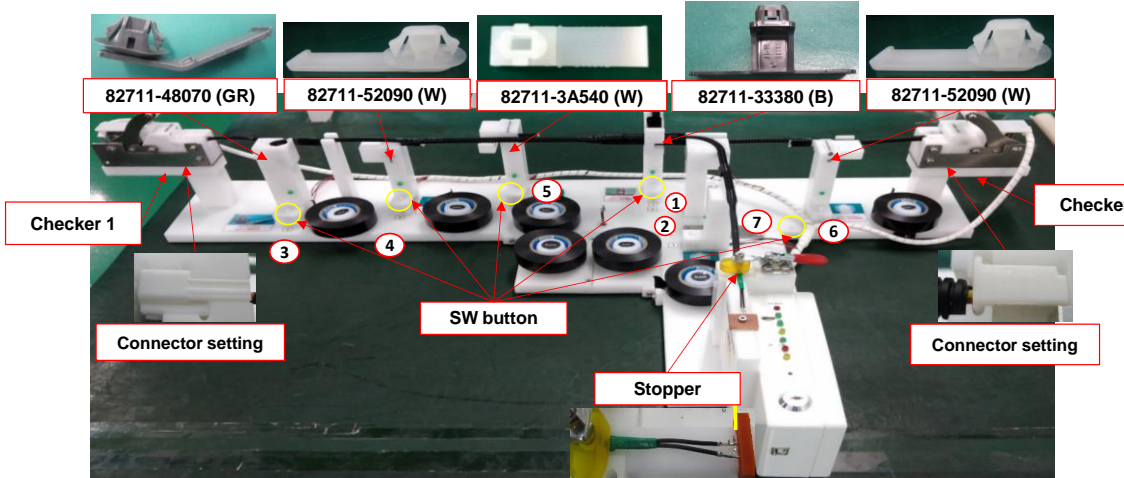
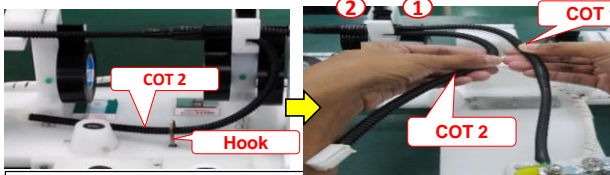
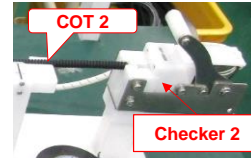
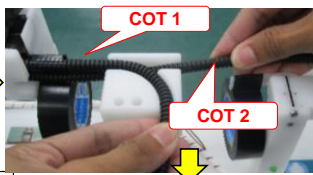

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp Assembly (Continuation)	<div></div> <div><p>4. Remove the assy parts from toggle clamp then remove the assy parts with connector 6098-2220 (W) in Hook using right hand then set the connector 6098-2220 (W) to Receiver base 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig then set the terminal end together within the stopper then press by Toggle clamp.</p></div> <div><p>5. Check if all LED light for Power On, Wire1 was On. Continue the process if sequence light in clamp location 1 was ON.</p></div>			<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper jig and terminals</p> <p>2. Make 2-3 windings for clamp taping</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>

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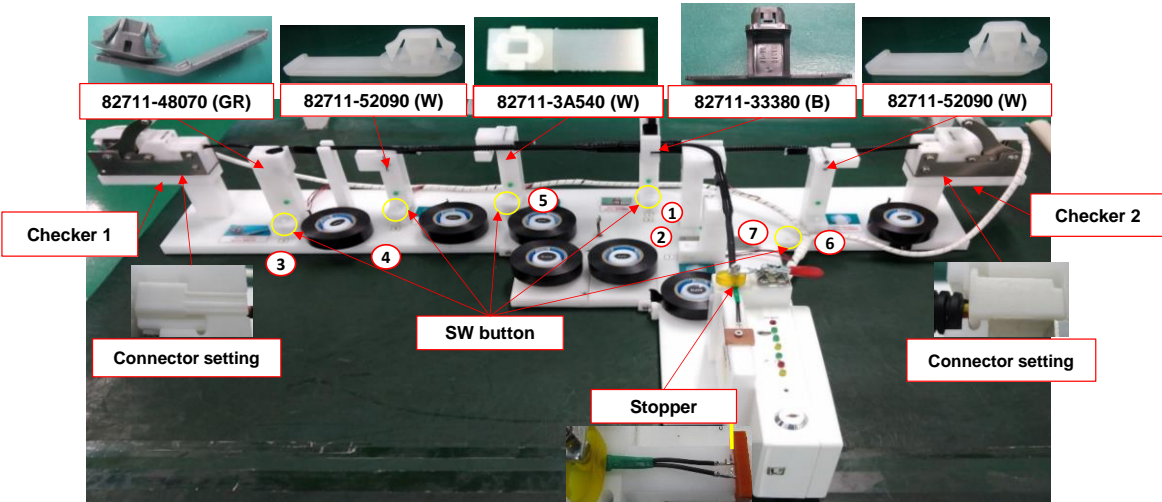
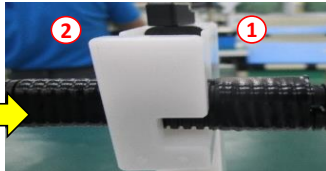


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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp Assembly (Continuation)	<div></div> <div></div> <div>6. Hold the tape on clamp location 1, make 3 windings of tape on combined COT 1 and COT 2 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.</div> <div>7. Hold the tape on clamp location 2, make 3 windings then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 3 was ON.</div>			<div></div> <div>Important reminders/Note/s:</div> <div>1. Make sure no gap between stopper jig and terminals</div> <div>2. Make 2-3 windings for clamp taping</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>

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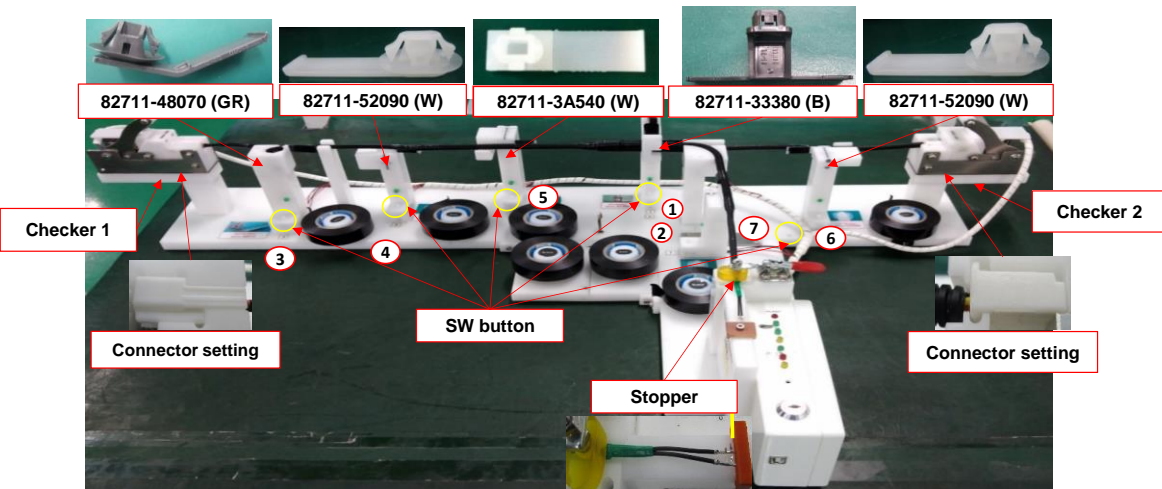

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp Assembly (Continuation)	<div></div> <div>8. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</div> <div>9. 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 in clamp location 5 was ON.</div> <div>10. 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 in clamp location 6 was ON.</div> <div>11. 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. Continue the process if sequence light in clamp location 7 was ON.</div> <div>12. Hold the tape on clamp location 7. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</div> <div>13. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>			<div></div> <div>Important reminders/Note/s:</div> <div>1. Make sure no gap between stopper jig and terminals</div> <div>2. Make 2-3 windings for clamp taping</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>

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PARTS:

1. Assy parts

JIG:

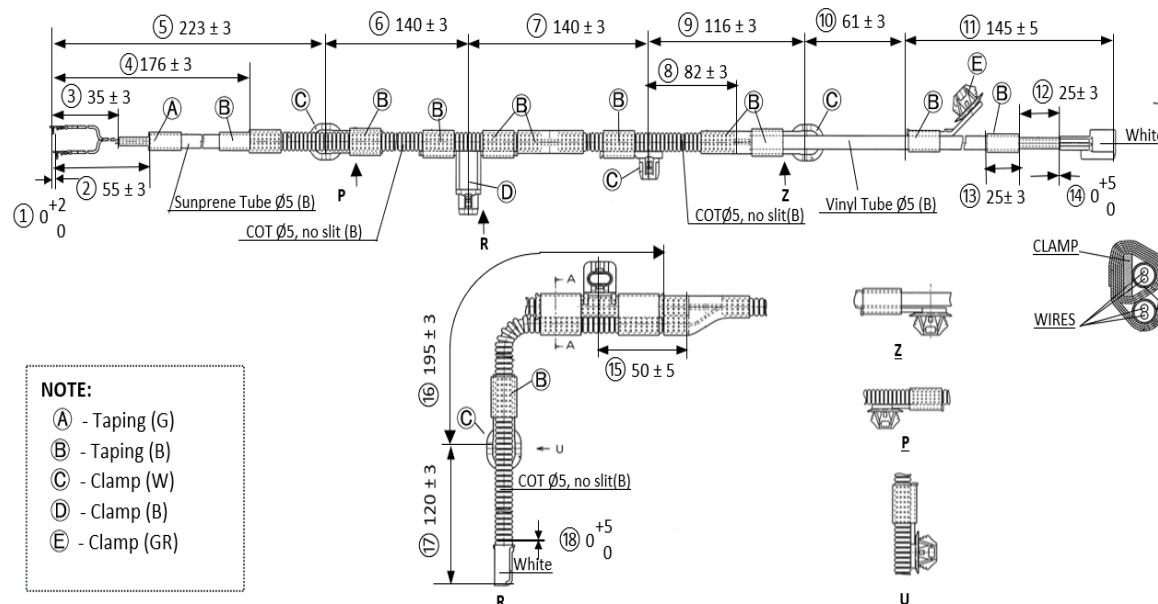
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

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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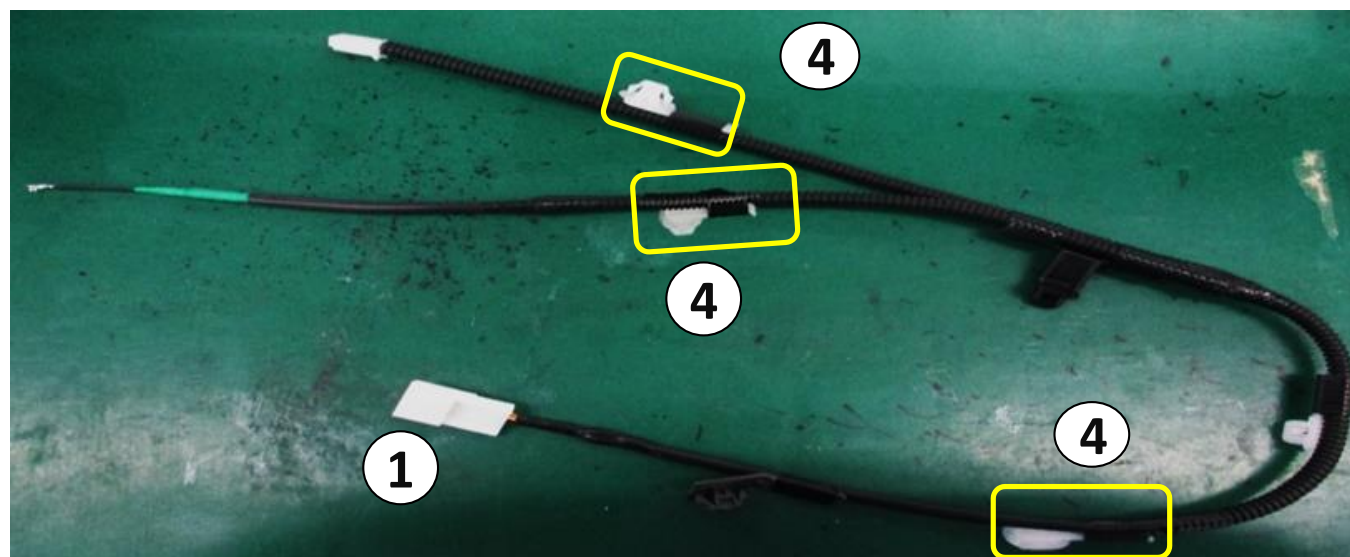
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**CLAMP ASSY****7L0119-7021A****CLAMP ILLUSTRATION****GOOD****82711-52090 (W)****NG****82711-12A80 (W)****1 No Deformed Terminal****2 Check the Alignment****3 Conduct BENDING of 2 sides of wing clamp****4 Check the Clamp appearance**

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