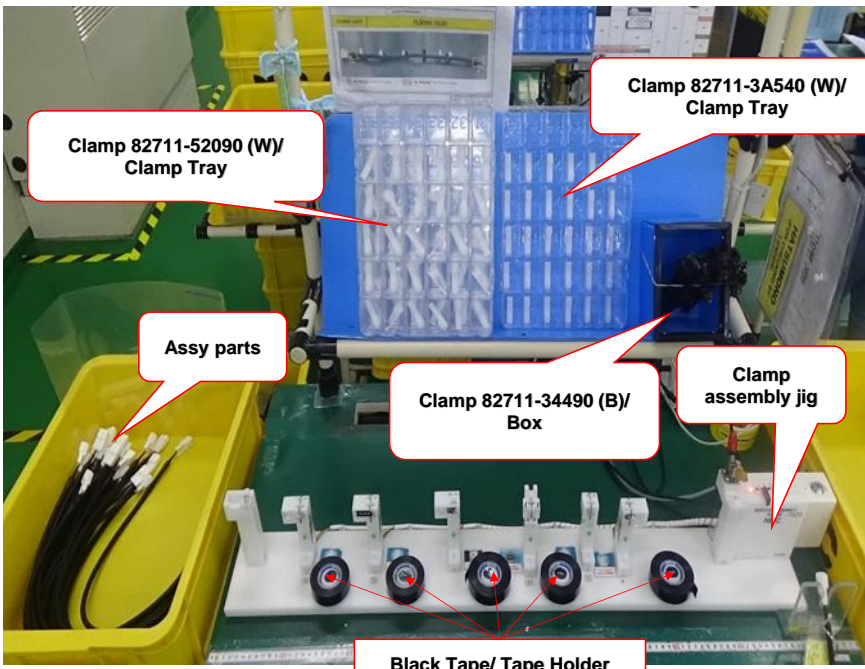

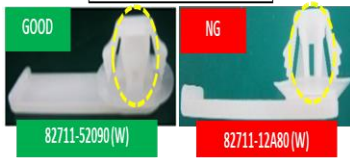
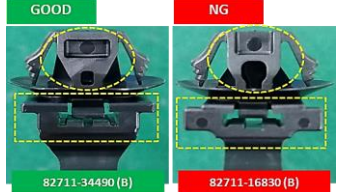
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	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 890B / 7L0099-7020		Customer: TRQSS	Car Model: TOYOTA C-SUV	Document No.:	WI-ENG-PDE-1007		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 6

PARTS:		1. Clamp 82711-52090 (W); Clamp 82711-34490 (B); Clamp 82711-3A540 (W); Black tape [5pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	<div style="text-align: center;"> TABLE LAY-OUT </div> 		<div> Safety Instruction Be sure to wear required 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> Bando Gun  </div>	<div> Document reference/s: 1. Refer to WI-ENG-PDE-127 for Taping assembly process </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div> <div> CLAMP ILLUSTRATION  </div> <div> BAND CLAMP ILLUSTRATION  </div>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
10/16/24	0	Initial issue. Separate Clamp setting and Clamp assembly from Taping assembly process	D. Castillo	C. Villanueva	A. Arañes	n/a	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: October 16, 2024

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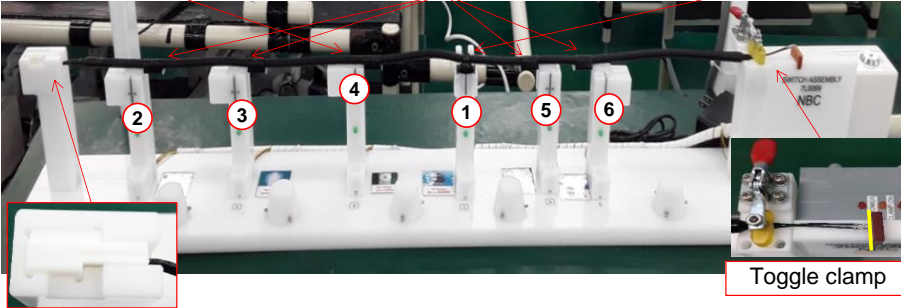
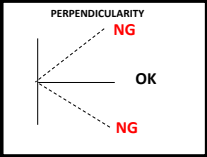


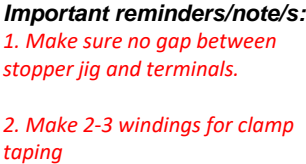

PARTS:		1. 82711-52090 (W) [4pcs] 2. Black tape [5pcs]		3. 82711-3A540 (W) 4. 82711-34490 (B)		JIG:	Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting	<div><div></div><div></div><div></div><div></div><div><div>1. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 1, and 2 using both hands..</div><div>2. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 5 and 6 using both hands..</div><div>3. Get the 1pc of clamp 82711-3A540 (W) using right hand and insert to clamp location 3 using both hands..</div></div><div><div>3. Get the clamp 82711-34490 (B) using right hand and insert to clamp location 4 using both hands..</div><div>4. Get Black tape using right hand and conduct pre-taping on clamp location 1, 2, 3, 5 and 6.</div></div></div>			n/a	<div><div>Important reminders/Note/s: 1.Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div><div>STANDARD TAPING FOR CLAMP One wind for under tape </div><div>CLAMP ILLUSTRATION <div><div>GOOD 82711-52090 (W)</div><div>NG 82711-12A80 (W)</div></div><div>BAND CLAMP ILLUSTRATION <div><div>GOOD 82711-34490 (B)</div><div>NG 82711-16830 (B)</div></div><div>1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp</div></div></div></div>

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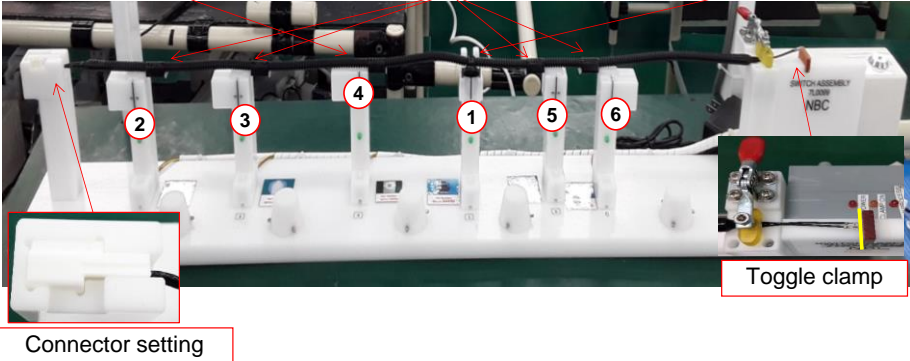
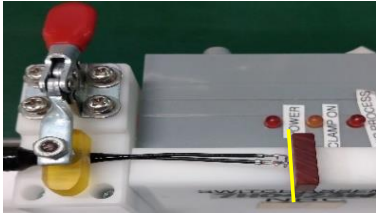
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	Process Name/Title:		Model code/Part number: 890B / 7L0099-7020	Customer: TRQSS	Car Model: TOYOTA C-SUV	Document No.:	WI-ENG-PDE-1007	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	0	Page No.:

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	<div><div><p>82711-3A540 (W)</p></div><div><p>82711-52090 (W)</p></div><div><p>82711-34490 (B)</p></div><div><p>Connector setting</p><p>Toggle clamp</p><div><p>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1 then lock. Continue to set the B-B wires together 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, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p><p>3. Initially tighten the band clamp on location 1 using both hands.</p><p>4. Get the bando gun using right hand then cut the band clamp on clamp location 1. Continue the process if sequence light button on location 2 was on.</p></div><div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>NG</p><p>OK</p><p>NG</p></div><div><p>GOOD</p><p>NG</p></div><div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.</p><p>For: ø5 - 1~2, ø7 - 3~4</p></div></div></div> <div><p>Bando Gun</p></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></div> <div><p>BANDO GUN ILLUSTRATION</p><p>GOOD</p><p>NG</p><p>FLAT NOSEPIECE</p><p>EXTENDED NOSEPIECE</p></div>						

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 6

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	<div><div> 82711-3A540 (W)</div><div> 82711-52090 (W)</div><div> 82711-34490 (B)</div><div>Connector setting</div><div>Toggle clamp</div></div> <div><div>5. Hold the tape on clamp location 2. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 3 was on.</div><div>6. Hold the tape on clamp location 3. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 4 was on.</div><div>7. Hold the tape on clamp location 4. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 5 was on.</div><div>8. Hold the tape on clamp location 5. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 6 was on.</div><div>9. Hold the tape on clamp location 6. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Go sound will be heard.</div><div>10. After taping, CONDUCT POINT CHECKING . Remove the harness from jig start from toggle clamp up to connector receiver base.</div></div>			N/A	 Important reminders/note/s: <i>1. Make sure no gap between stopper jig and terminals.</i> <i>2. Make 2-3 windings for clamp taping</i> 1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape

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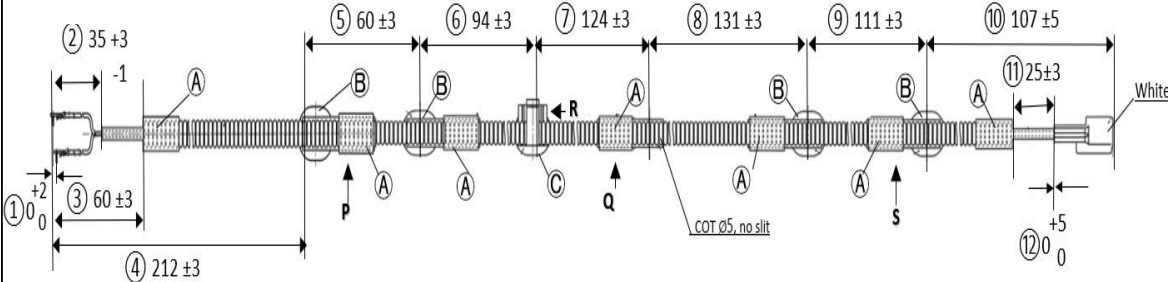
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement	<div><div>MEASURING TAPE</div></div>  <div><div>NOTE:</div><div><div>A - Taping (B)</div><div>B - Clamp (W)</div><div>C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

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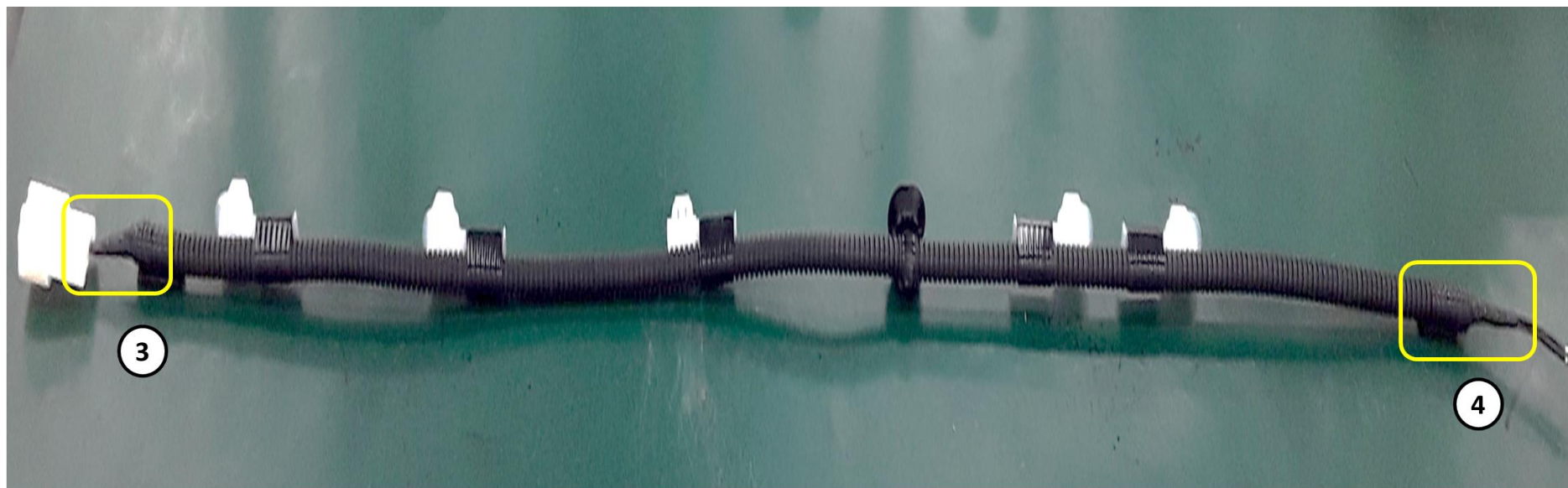
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0099-7020****1****No Wrong Facing of Clamp****2****No Unlocked/Halflocked
connector****3****4****No Missing Tape (Black Tape)**

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