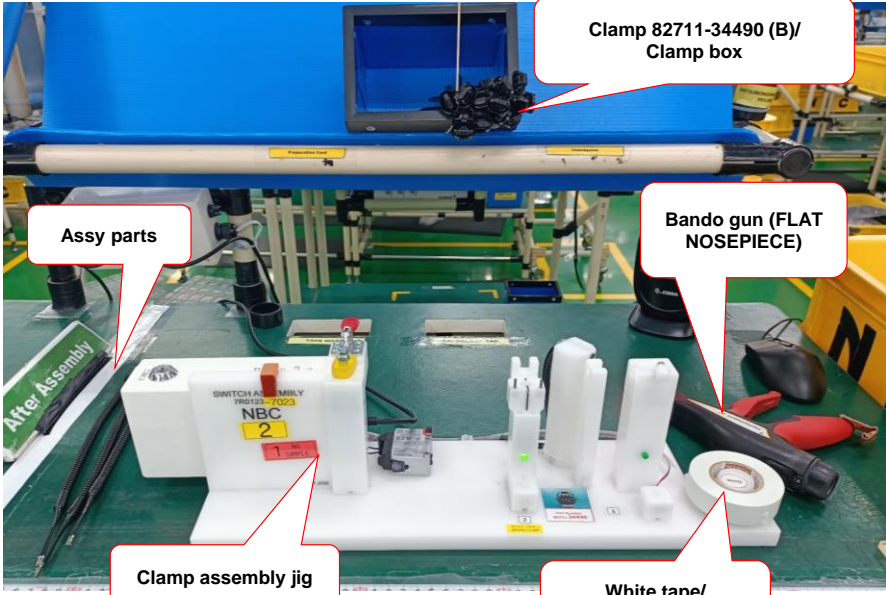


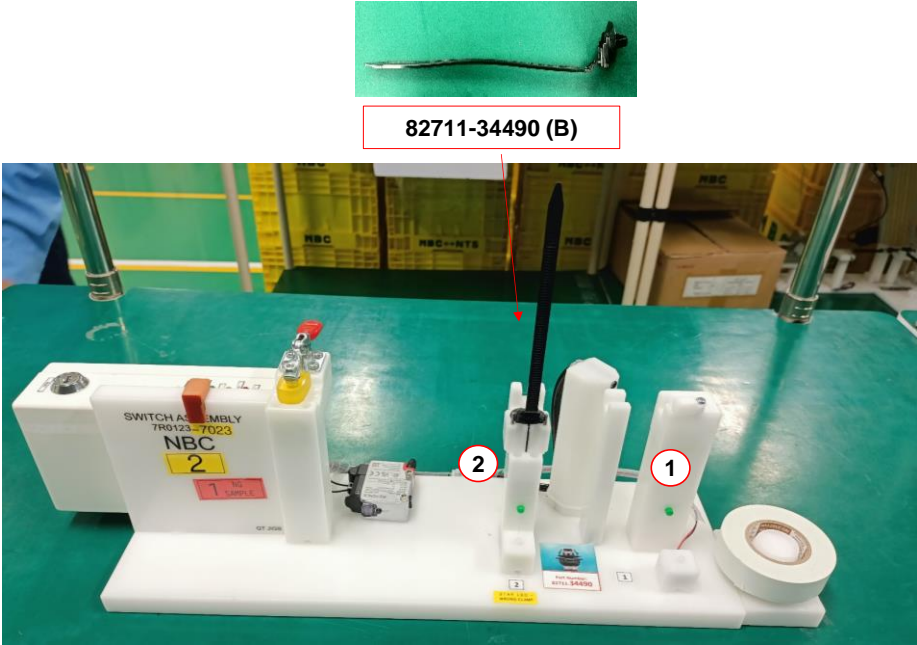






	WORK INSTRUCTION			Effectivity Date:	April 4, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0123-7023	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-864		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	1 of 6

PARTS:		1. Assy parts; Clamp 82711-34490 (B); White tape				JIG:		1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div> <div>TABLE LAY-OUT</div>  </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>		Document references: 1. Refer to WI-ENG-PDE-862 Taping assembly process 1. No missing parts/tools. 2. No excess parts/tools.	
Revision History									
						Prepared by	Reviewed by	Approved by	Noted by
04/04/24	0	Initial issue. Separate from Taping assembly to Clamp assembly. Change from Pre-launch to Masspro. Improve assembly jig. Change Quality checkpoint to Visual inspection. Remove By two's inspection.				D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	April 4, 2024		

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 6


PARTS:	1. Clamp 82711-34490 (B)			JIG:	1. Clamp assembly jig								
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS								
2	Clamp Assy	Clamp Setting	<div><p>82711-34490 (B)</p><p>1. Get 1pc of band clamp 82711-34490 (B) using right hand and set to clamp location ① using both hands.</p></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p> <div><p>BAND CLAMP ILLUSTRATION</p><table><tr><td>GOOD</td><td>NG</td></tr><tr><td></td><td></td></tr><tr><td>82711-34490 (B)</td><td>82711-16830 (B)</td></tr></table></div>			GOOD	NG			82711-34490 (B)	82711-16830 (B)
GOOD	NG												
													
82711-34490 (B)	82711-16830 (B)												

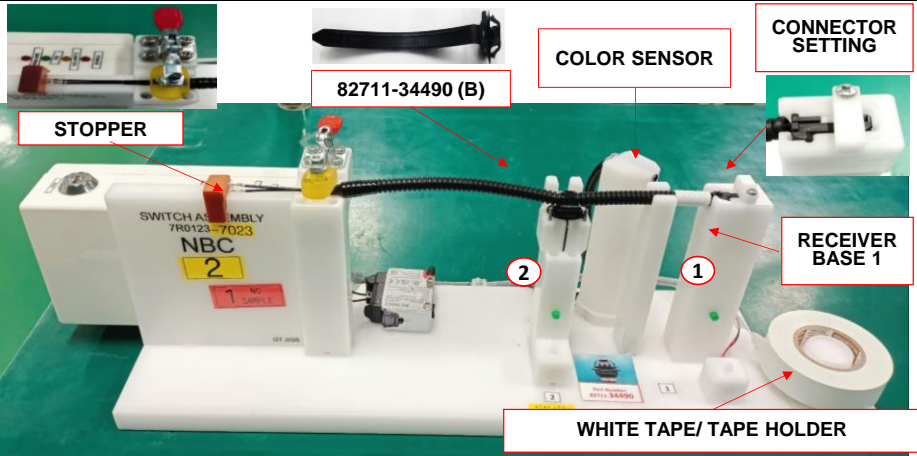
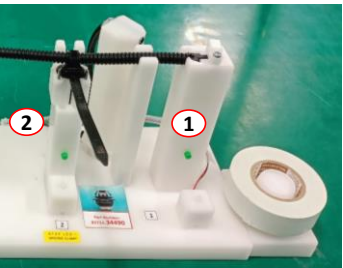
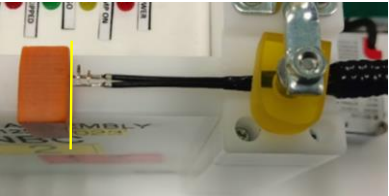


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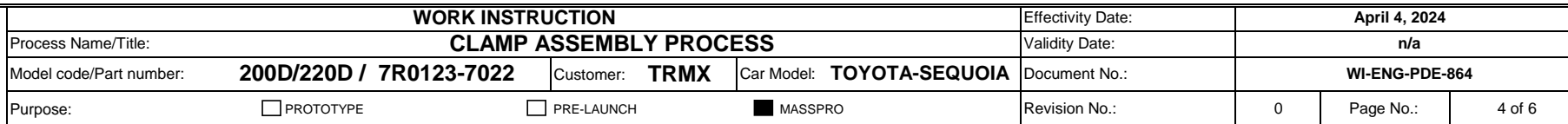
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	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 200D/220D / 7R0123-7022		Customer: TRMX	Car Model: TOYOTA-SEQUOIA		Document No.:	WI-ENG-PDE-864	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	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	Clamp Assy	<div></div> <div>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6098-6663 (B) in Receiver base 1 then lock using right hand. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</div> <div>2. Check if LED light for POWER, CLAMP, and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction.</div> <div><div>3. Initially tighten the band clamp 82711-34490 on clamp location 2 using right hand. Note: Do not cut</div></div>			n/a	<div>Important reminders/note/s:</div> <div>1. Make sue no gap between stopper jig and terminal.</div>  <div>1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun</div> <div>BAND CLAMP ILLUSTRATION</div> <div></div>		

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**WORK INSTRUCTION**

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

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200D/220D / 7R0123-7022

Customer:

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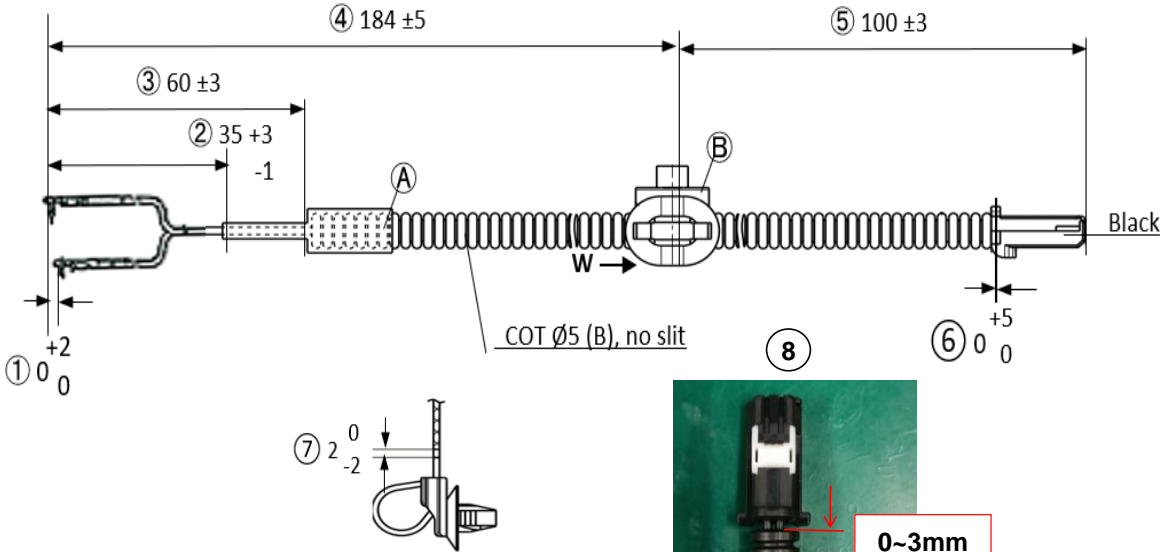
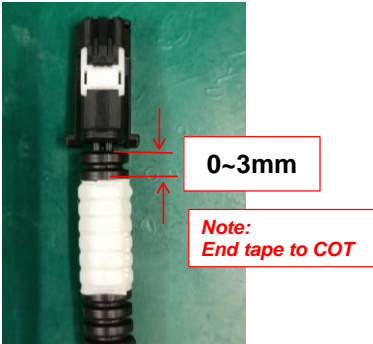
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement	<div><div>MEASURING TAPE</div></div> <div><div>NOTE: (A) - Taping (B) (B) - Clamp (B)</div></div> <div></div>		<div>1.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

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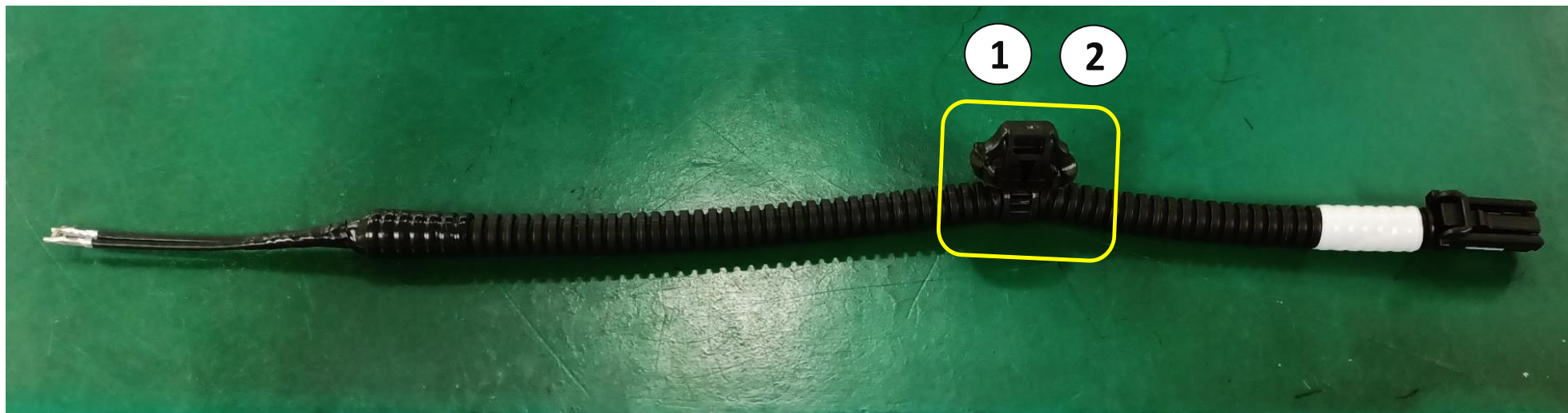
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**CLAMP ASSEMBLY****7R0123-7023**

①

No Loose clamp

②

No NG cut

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