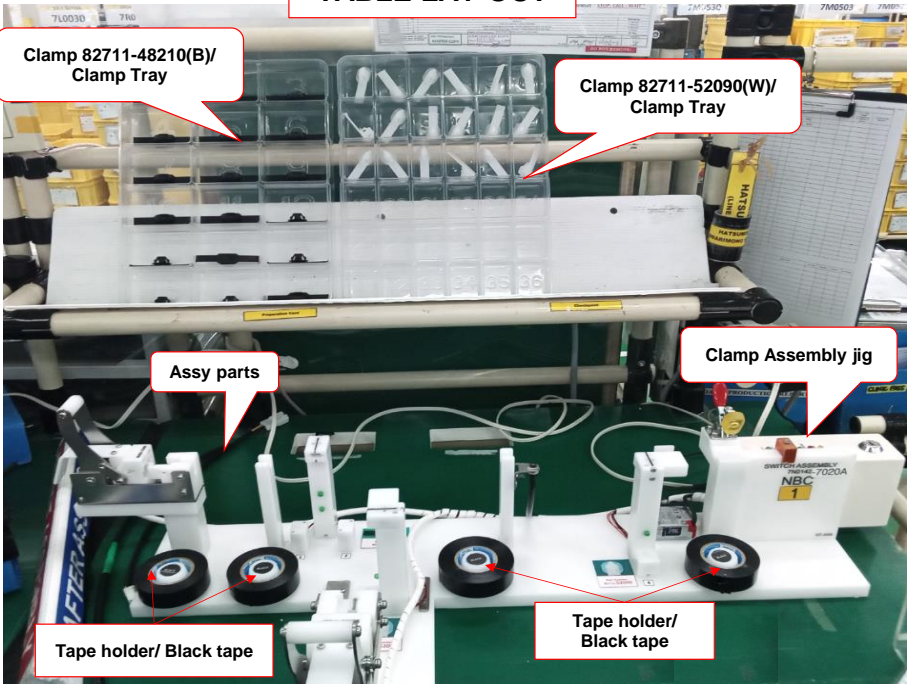



	WORK INSTRUCTION			Effectivity Date:	May 20, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 990B / 7N0142-7020A	Customer: TRJ	Car Model: TOYOTA-PRIUS	Document No.:	WI-ENG-PDE-687		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 5

PARTS:		1. Assy part; Clamp 82711-52090(W);Clamp 82711-48210 (B); Black tape [4pcs]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy Table Lay-out			<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/ tools. 2. No excess parts/ tools.

Revision History							Prepared by	Reviewed by	Approved by	Noted by		
05/20/24	1	Transfer to new format and inclusion of Car model "TOYOTA-PRIUS". Change measurement sequence due to process improvement. Update work procedure/illustration Process 5. Improve measurement and visual inspection.			A.Hernandez	C. Villanueva	A.Arañes	n/a				
06/16/23	0	Initial Issue. Excluded process from P2; Changed Part Name/Title from "TAPING ASSEMBLY PROCESS" to CLAMP ASSEMBLY PROCESS ; Changed Document control number from WI-ENG-PDE-453B to WI-ENG-PDE-687 due to new process distribution.			M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	June 16, 2023		

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WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 20, 2024

Validity Date:

n/a

Document No.:


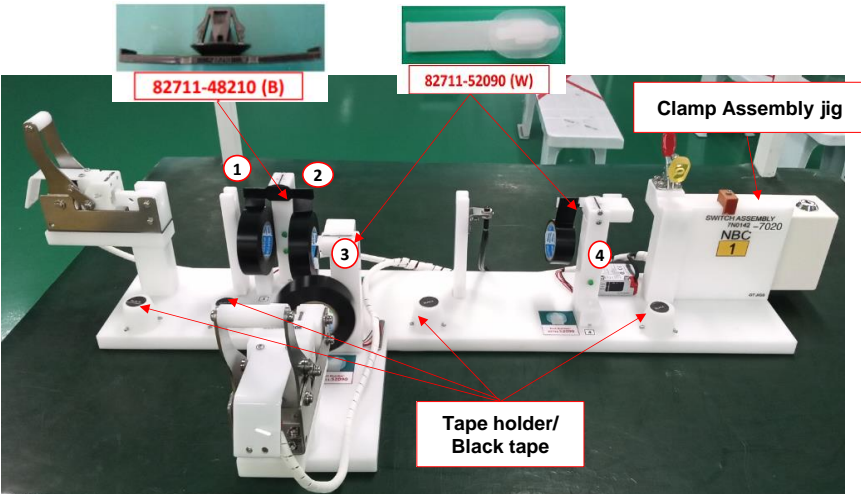

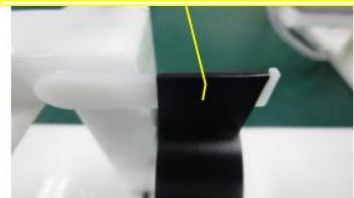

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PARTS:	1. Clamp 82711-52090 (W) [2pcs] 2. Clamp 82711-48210 (B)	3. Black tape [4pcs]	JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1.  QUALITY POINTERS
2	Clamp Assy Clamp Setting	 <div data-bbox="555 975 987 1098">1. Get 1 pc. of clamp 82711-48210 (B) using right hand then set to clamp location 1 and 2 using both hands.</div> <div data-bbox="1016 975 1469 1098">2. Get 2 pcs. of clamp 82711-52090 (W) using right hand then set to clamp location 3 and 4 using both hands.</div> <div data-bbox="763 1145 1196 1257">3. Initially attach BLACK TAPE to location 1, 2, 3 and 4 using both hands</div>	n/a	<div data-bbox="1733 395 1944 544">1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div data-bbox="1733 564 2130 655">STANDARD TAPING FOR CLAMP 1.  One wind for under Tape</div> <div data-bbox="1749 660 2101 858"></div> <div data-bbox="1733 858 2130 1098">1.  Important reminders/Note/s: <i>1. Check the clamp first before start of assembly to avoid wrong use of clamp.</i> <i>2. Must be no gap between terminal and stopper jig.</i> <i>3. Make 2-3 windings for clamp taping</i></div>

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CLAMP ASSEMBLY PROCESS

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Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

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Purpose:

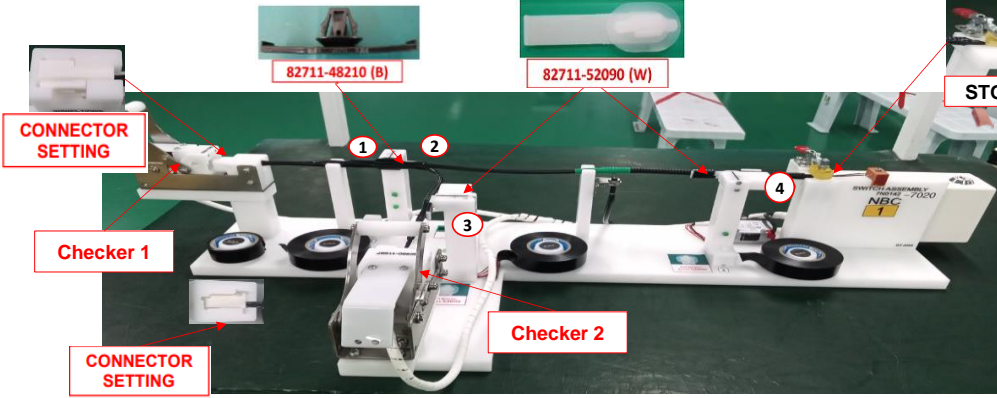



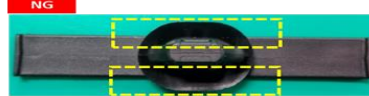
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [4pcs]		JIG:	1.Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp Assembly	<div></div> <div>1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Checker 1. Then, set the connector 6098-2220 (W) to Checker 2. Continue to set the harness in jig. Last, set the end of B-B wire together within the stopper then press by Toggle clamp.</div> <div>3. Combine the Vinyl 1 and Vinyl 2 using both hands. On clamp location 1 and 2, hold the tape then make 3 windings of tape then cut the tape. Press the SW button using both hands. Continue if the sequence light on clamp Location 3 was ON.</div> <div>5. Hold the tape on clamp location 4 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after every taping.</div> <div>2. Check if all LED light for Power On, Clamp On, Sequence in clamp location 1 is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div> <div>4. On clamp location 3, hold the tape then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after every taping. Proceed to location 4 after taping.</div> <div>6. After taping, conduct POINT CHECKING before removing the harness from jig.</div>		<div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-52090 (W)</div></div> <div><div>NG</div><div>82711-12A80 (W)</div></div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-48210 (B)</div></div> <div><div>NG</div><div>82711-3F290 (B)</div></div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>	

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**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

March 20, 2024

Validity Date:

n/a

Model code/Part number:

990B / 7N0142-7020ACustomer: **TRJ**Car Model: **TOYOTA-PRIUS**

Document No.:

WI-ENG-PDE-687

Purpose:

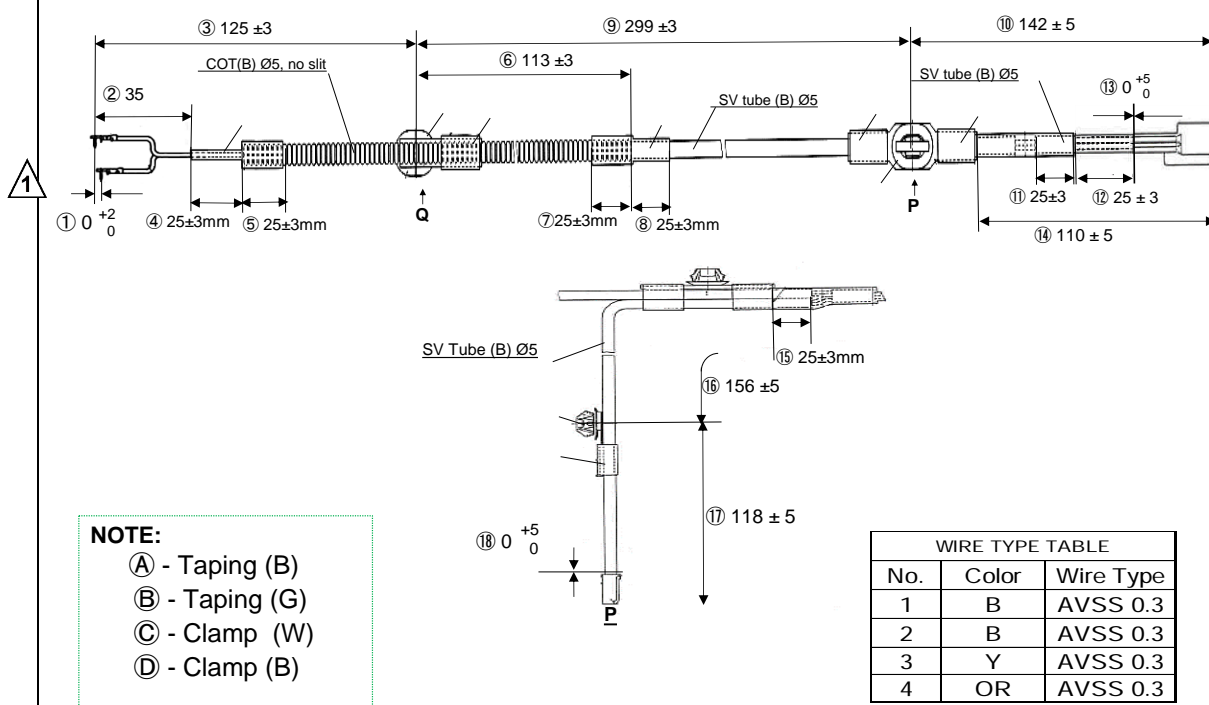
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PARTS:		1.Assy parts		JIG:	n/a																		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION 1		TOOLS/PPE	1 QUALITY POINTERS 1																		
4	Clamp Assy	Measurement	<div>Measuring tape</div>  <div>NOTE: A - Taping (B) B - Taping (G) C - Clamp (W) D - Clamp (B)</div> <table><tr><th colspan="3">WIRE TYPE TABLE</th></tr><tr><th>No.</th><th>Color</th><th>Wire Type</th></tr><tr><td>1</td><td>B</td><td>AVSS 0.3</td></tr><tr><td>2</td><td>B</td><td>AVSS 0.3</td></tr><tr><td>3</td><td>Y</td><td>AVSS 0.3</td></tr><tr><td>4</td><td>OR</td><td>AVSS 0.3</td></tr></table>			WIRE TYPE TABLE			No.	Color	Wire Type	1	B	AVSS 0.3	2	B	AVSS 0.3	3	Y	AVSS 0.3	4	OR	AVSS 0.3
WIRE TYPE TABLE																							
No.	Color	Wire Type																					
1	B	AVSS 0.3																					
2	B	AVSS 0.3																					
3	Y	AVSS 0.3																					
4	OR	AVSS 0.3																					
<div>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</div>																							

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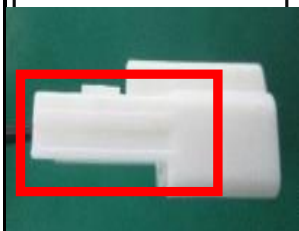
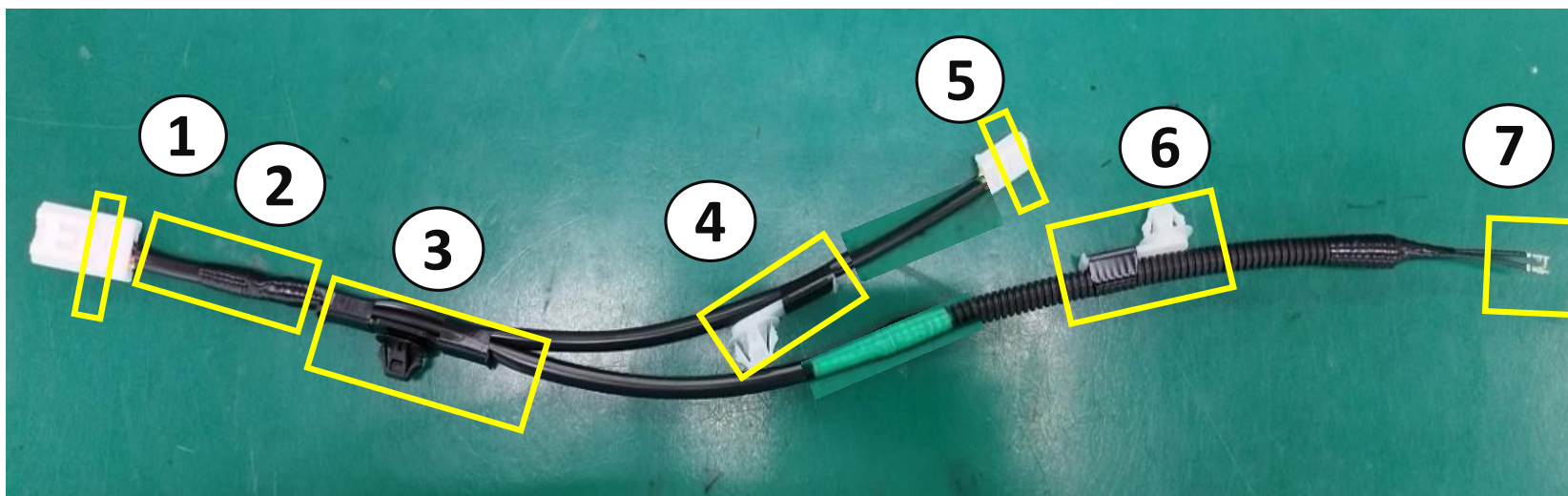
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP ASSY****7N0142-7020A****GOOD****NO GOOD**

① ⑤ No Unlock/Halflocked
Connector

② No Missing Tape

③ ④ ⑥ No Missing Clamp

⑦ No Deformed Terminal

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