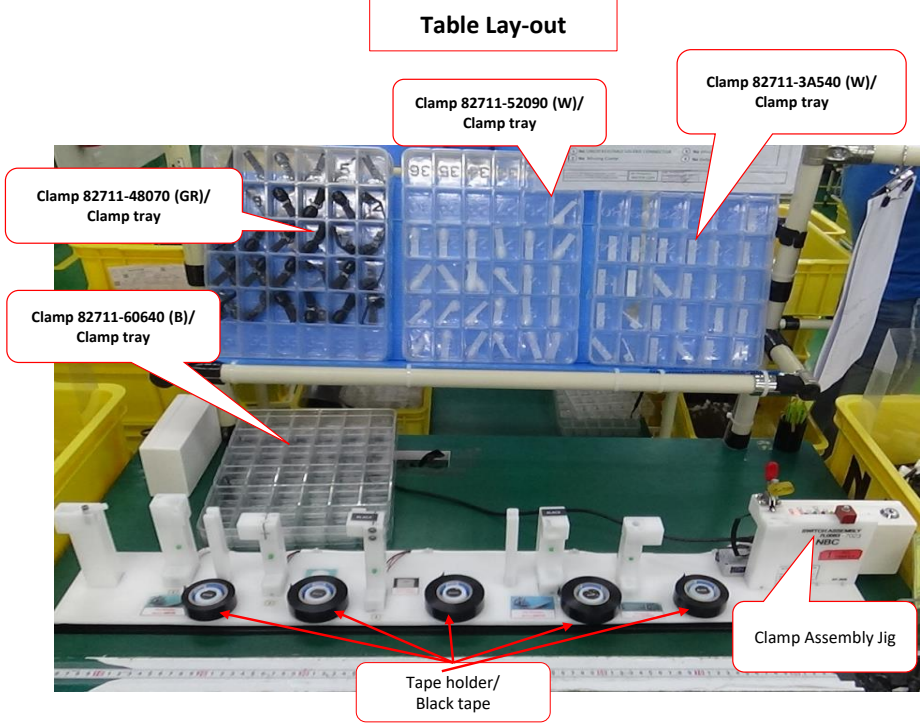
	WORK INSTRUCTION				Effectivity Date:	June 11, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 550B / 7L0083-7023		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-799		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5

PARTS:		1. All parts: Assy parts; Black tape [5pcs]; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-60640 (B); Clamp 82711-3A540 (W)		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY			<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>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <p>Document references: 1. Refer to WI-ENG-PDE-447A-B 7L0083-7023 - Taping Assembly Process</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-52090 (W) 82711-12A80 (W)</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-60640 (B) 82711-21020 (B)</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.		D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted

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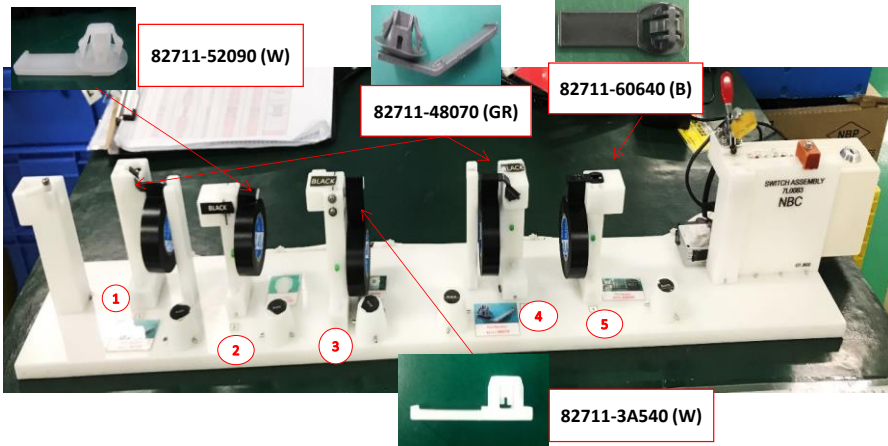


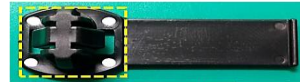

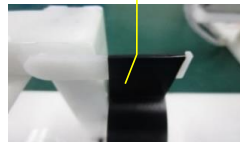


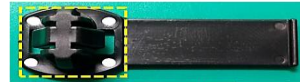

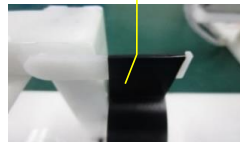
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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-48070 (GR) [2pcs] 3. Clamp 82711-60640 (B)		3. Clamp 82711-3A540 (W) 4. Black tape [5pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp Assembly setting	<div></div> <div><div><div>1. Get 2pcs of clamp 82711-48070 (GR) using right hand and set to clamp location 1 and 4 using both hands.</div><div>2. Get 1pc of clamp 82711-52090 (W) using right hand and set to clamp location 2 using both hands.</div><div>3. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</div></div><div><div>4. Get 1pc of clamp 82711-60640 (B) using right hand and set to clamp location 5 using both hands.</div><div>5. Get Black tape and initially attach black tape on clamp location 1, 2, 3, 4 and 5.</div></div></div> <td>n/a</td> <td><div>1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape</div><div>Important reminders/Note/s: 1. Please check the clamp before start of assembly to avoid wrong use of clamp.</div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</div></div></td>			n/a	<div>1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Please check the clamp before start of assembly to avoid wrong use of clamp.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div></div><div><div>NG</div></div></div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div></div><div><div>NG</div></div></div> <div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</div></div>

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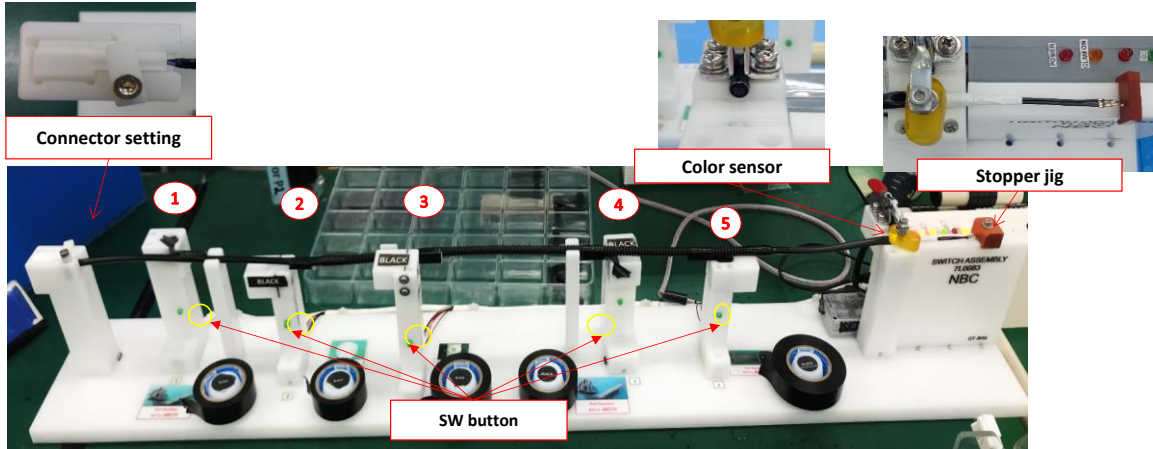
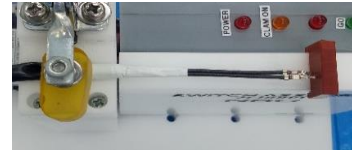
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PARTS:	1. Assy parts			JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set to jig using both hands. <i>(see above picture for correct setting)</i> First, put the white connector to receiver base then lock. Second, put the terminal to stopper jig and pull the toggle clamp.</p><p>2. Check if all LED light for POWER, CLAMP ON and COLOR SENSOR 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 in location 1 is ON. <i>Note: Sequence light of Location 1 will ON if the sensor detect the White tape.</i></p><p>3. Hold the tape on clamp location 1 and start taping (3 windings) using both hands. Press the switch button after taping. Continue to location 2 if light was ON.</p><p>4. Repeat the process of location 1 to clamp location 2,3 and 4. Continue to location 5 if light was ON.</p><p>5. Hold the tape on clamp location 5, and start taping (3 windings) using both hands. Press the switch button after taping. Go sound will be heard.</p><p>6. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div>		<div></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> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No tight/loose clamp attachment</p>

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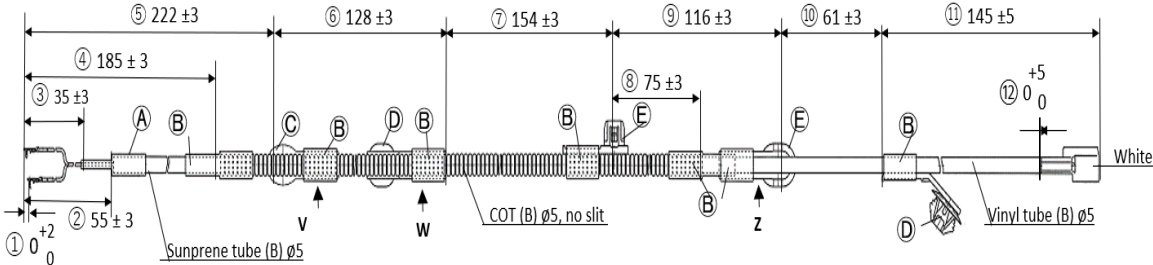
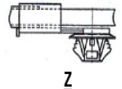
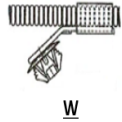
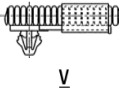
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PARTS:		1. Asshy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div>Measurement</div> <div><div>Measuring tape</div></div> <div><div>NOTE: A - Taping (W) B - Taping (B) C - Clamp (B) D - Clamp (GR) E - Clamp (W)</div><div></div></div>		<div>Tools/PPE</div>	<div>Quality Pointers</div> <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></div>

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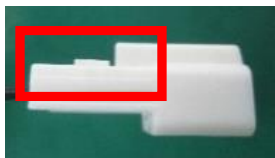
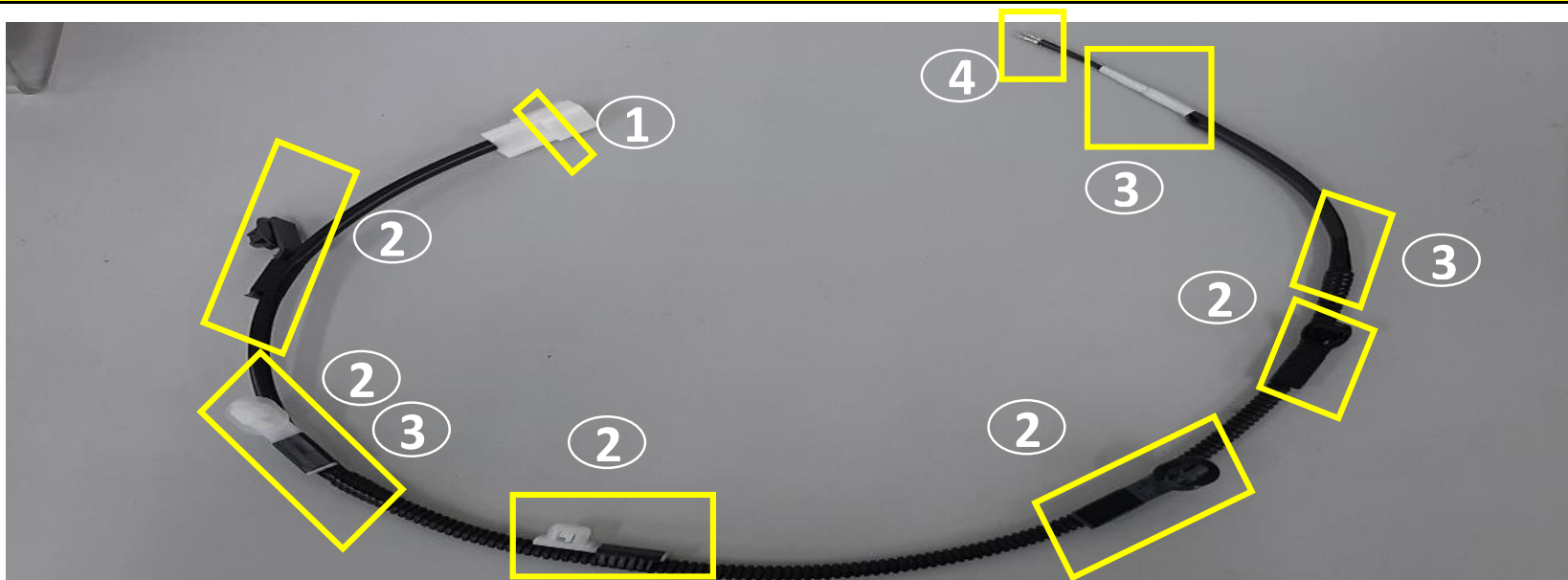
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**7L0083-7023****GOOD****NO GOOD****1 No UNLOCKED/HALF LOCKED CONNECTOR****2 No Missing Clamp****3 No Missing tape****4 No Deformed Terminal**

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