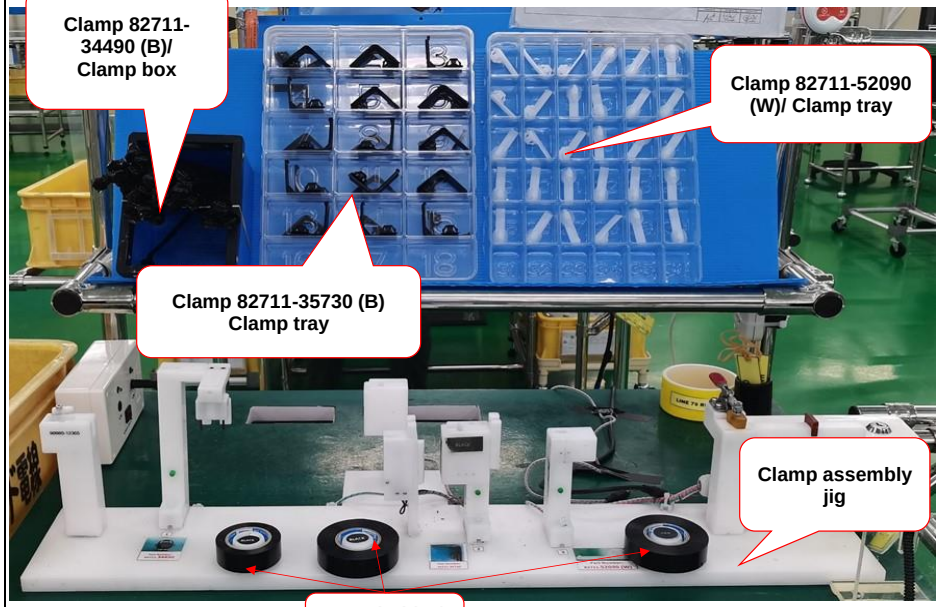
	WORK INSTRUCTION			Effectivity Date:	October 22, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 890B / 7L0098-7020	Customer: TRQSS	Car Model: TOYOTA- C-SUV	Document No.:	WI-ENG-PDE-935	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 1 of 7

PARTS:	1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-34490 (B); Clamp 82711-35730 (B); Black tape [3pcs.]	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	Table Lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. **BANDO GUN**	***Document reference/s:*** *1. Refer to **WI-ENG-PDE-126** for Taping assemmbly process* 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/22/24	0	Initial issue. Separate Clamp assy to Clamp assembly process.	D.Castillo	C.Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 22, 2024		

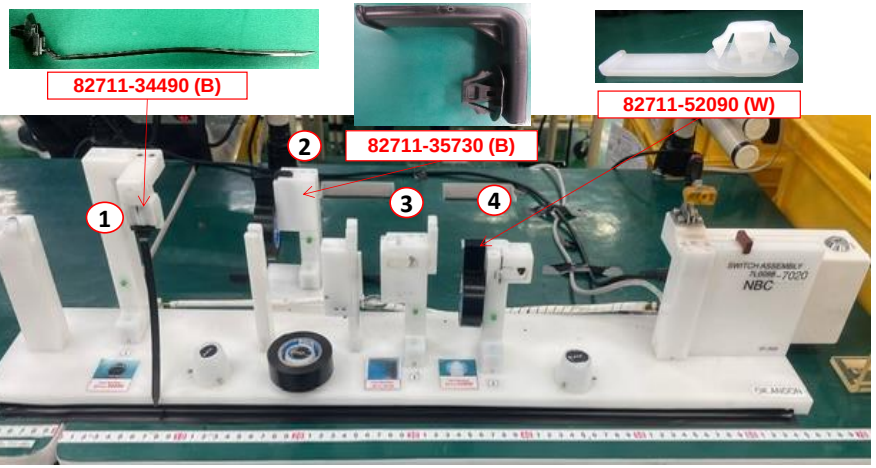
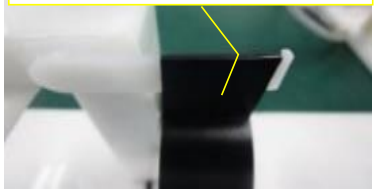
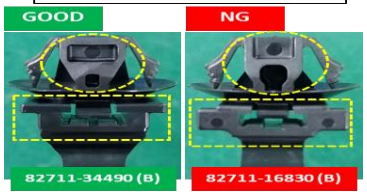
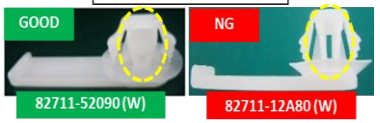
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	890B / 7L0098-7020	Customer: TRQSS	Car Model: TOYOTA- C-SUV	Document No.:	WI-ENG-PDE-935	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 2 of 7

PARTS:	1.Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W)	3. Black tape [3pcs.]	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	 1. Get 1 pc. of band clamp **82711-34490 (B)** then set to clamp location **1** using both hands. 2. Get 1 pc. of clamp **82711-35730 (B)** then set to clamp location **2** using both hands. 3. Get 1 pc. of clamp **82711-52090 (W)** then set to clamp location **4** using both hands. 4. Initially attach **Black tape** on clamp location **2 and 4** using both hands.	n/a	1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp **STANDARD TAPING FOR CLAMP** One wind for under tape  ***Important reminders/Note/s:*** *1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.* BAND CLAMP ILLUSTRATION  CLAMP ILLUSTRATION 

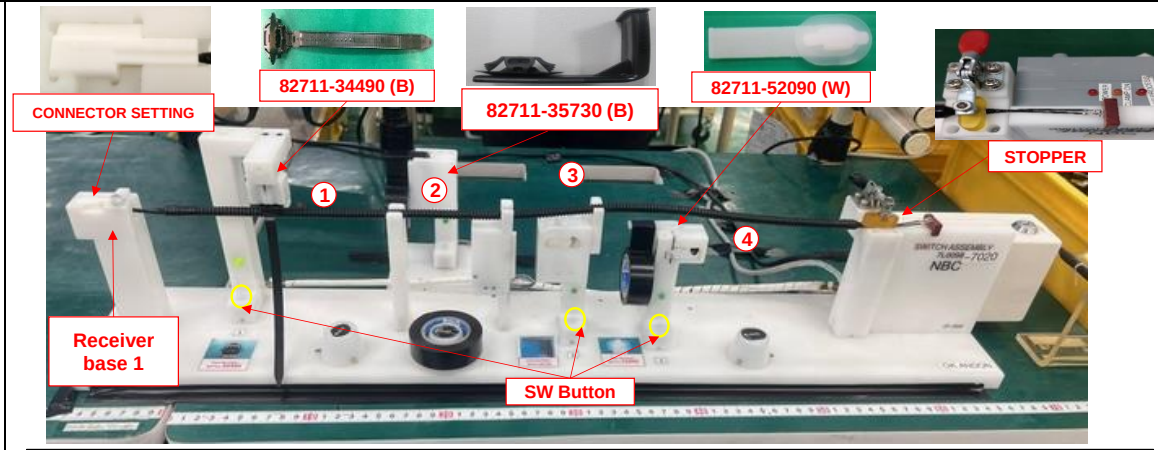
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	890B / 7L0098-7020	Customer: TRQSS / Car Model: TOYOTA- C-SUV	Document No.:	WI-ENG-PDE-935		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0	Page No.:	3 of 7

PARTS:	1. Assy parts			JIG:	1. Clamp Assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	Clamp Assy	Clamp Assembly			

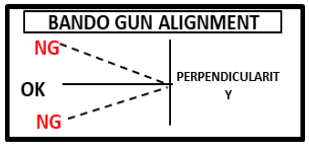


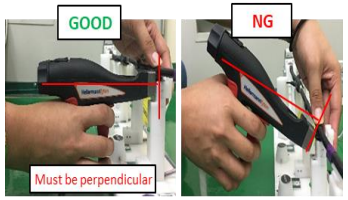
1.Get the assy parts and set into jig. *(See above picture for correct setting).* First, set the connector **6098-3802 (W)** to **Receiver base 1**. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of **location** ① was on.

2. Check if all **LED light** for **POWER ON, WIRE1, WIRE 2 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.

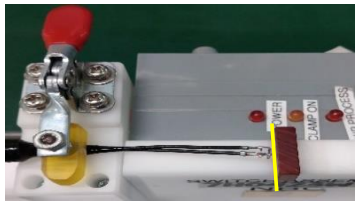
3. Initially tighten the band clamp on **location 1** using both hands.

4. Get the bando gun using right hand then cut the band clamp on location **1.** Continue the process if sequence light button on location **2** was on.



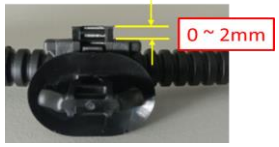


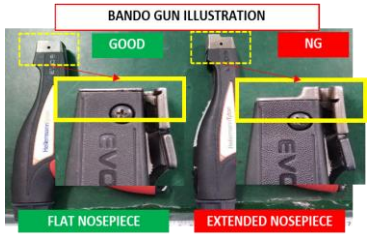
1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape
5. No loose/tight clamp attachment



Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).



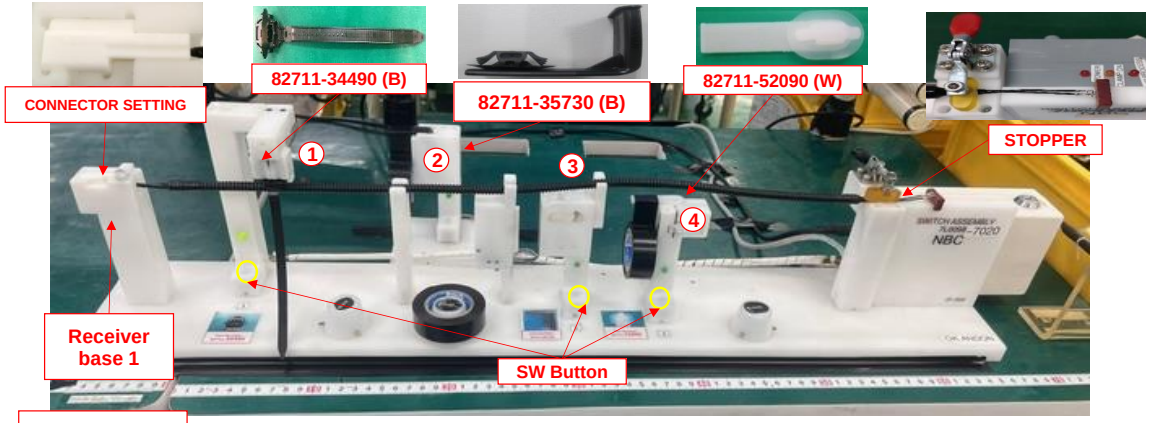
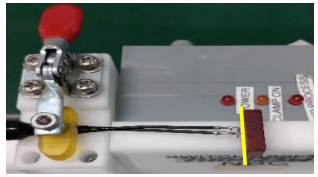
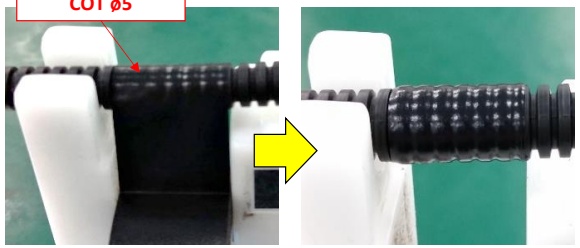
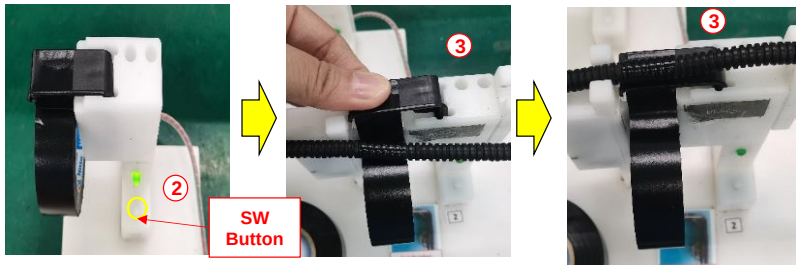


CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	890B / 7L0098-7020	Customer: TRQSS	Car Model: TOYOTA- C-SUV	Document No.:	WI-ENG-PDE-935	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 4 of 7

PARTS:	1. Assy parts			JIG:	1. Clamp Assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	Clamp Assy	Clamp Assembly (Continuation)			 ***Important reminders/Note/s:*** ***1.Make sure no gap between stopper jig and terminals.*** ***2. Make 2-3 windings for clamp taping.*** 1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape
			 5. Conduct spot taping on COT in clamp location **3.** Make **2 winds** only then cut the tape .Press the SW button after taping . ***Note: No exessive windings of tape***		
			 6. Press the **SW button** and get the clamp **(82711-35730 (B))** in location **2** then put in location **3.**		

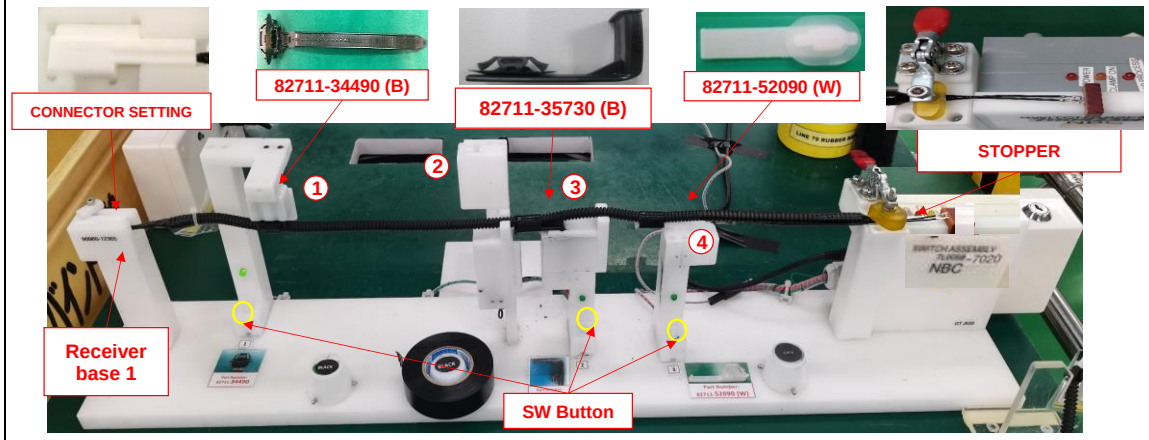
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

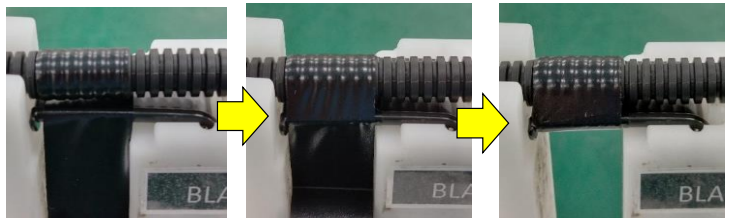
NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	890B / 7L0098-7020	Customer: TRQSS	Car Model: TOYOTA- C-SUV	Document No.:	WI-ENG-PDE-935	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 5 of 7

PARTS:	1. Assy parts			JIG:	1. Clamp Assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	Clamp Assy	Clamp Assembly (Continuation)			

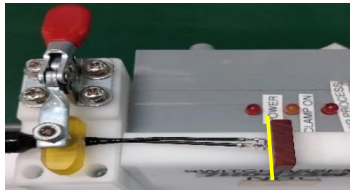




7. Tape the clamp on location **3** using both hands. Make **3 winds** then cut the tape. Press the SW button after taping. Continue the process if sequence light in location **4** was **on**.
Note: Controller will alarm if detect excessive windings of tape.

8. Tape the clamp on location **4** using both hands. Make **3 winds** then cut the tape. Press the **SW button** after taping. **Go** sound will be heard .

9. Conduct **POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.

2. Make 2-3 windings for clamp taping

1. No wrong setting of the clamp
2. No wrong use of clamp
3. No Loose attachment of the clamp
4. No loose tape
5. No peel-off tape
6. No damaged clamp
7. No wrong use of tape
8. No missing clamp

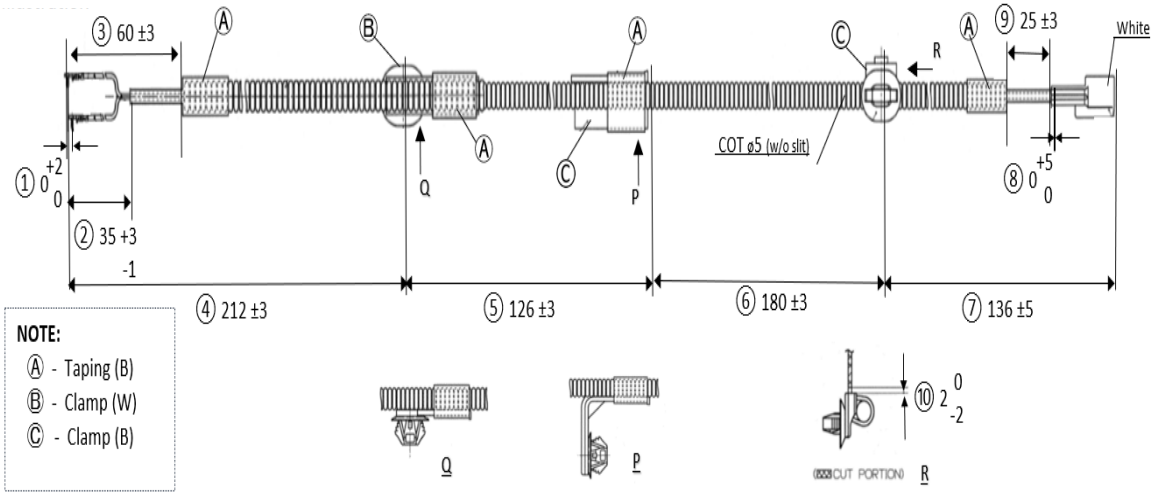
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 22, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 890B / 7L0098-7020	Customer: TRQSS	Car Model: TOYOTA- C-SUV	Document No.:	WI-ENG-PDE-935	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 6 of 7

PARTS:	1.Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement		MEASURING TAPE	***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

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

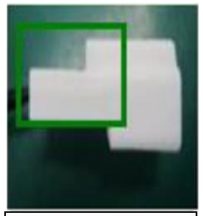
NBC (Philippines)
MASTER COPY

DCC Stamp

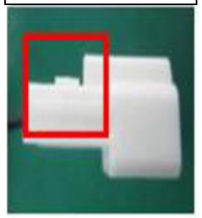
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY	**7L0098-7020**



GOOD



NO GOOD

1 **No Wrong Facing of Clamp** 2 **No Unlock/Halflock connector** 3 4 **No Missing Tape (Black Tape)**

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp