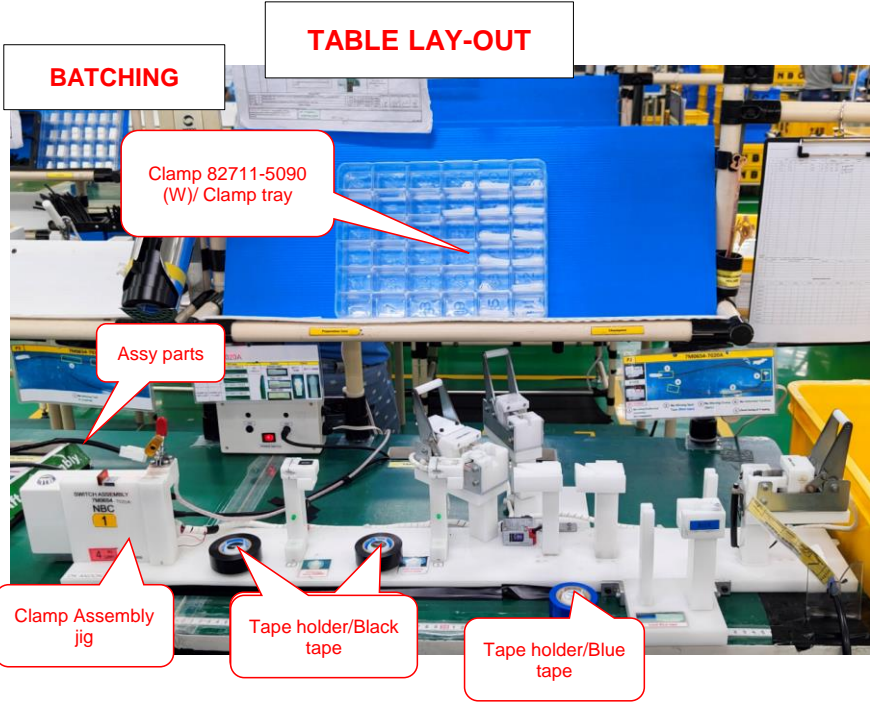


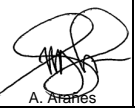
	WORK INSTRUCTION				Effectivity Date: July 12, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: D10L / 7M0654-7020A		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.: WI-ENG-PDE-685	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 1		Page No.: 1	of 6

PARTS: 1. Assy part; Clamp 82711-52090 (W); Black tape [2pcs]; Blue tape		JIG: 1. Clamp Assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div style="text-align: center;"> <p>BATCHING</p> <p>TABLE LAY-OUT</p>  </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Housekeeping</p> <ol style="list-style-type: none"> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>Document reference/s:</p> <p>1. Refer to WI-ENG-PDE-156A-C for Taping assembly process</p> <ol style="list-style-type: none"> 1. No missing parts/tools 2. No excess parts/tols

Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/12/24	1	Inclusion of car model "DAIHATSU-TANTO". Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes
06/05/23	0	Initial issue. Change Process Name/Title from TAPING ASSEMBLY PROCESS to CLAMP ASSEMBLY PROCESS; Document control no. from WI-ENG-PDE-156C to WI-ENG-PDE-685 due to separation of process.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 05, 2023	

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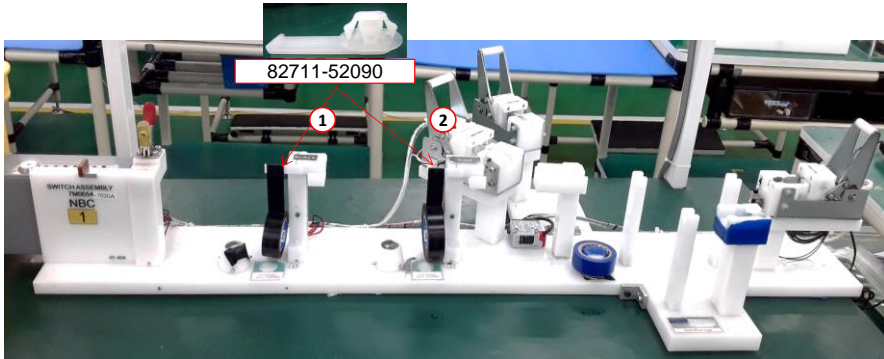



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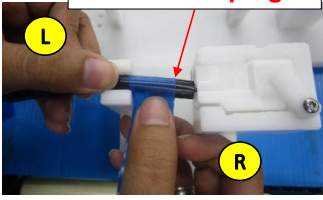
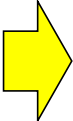
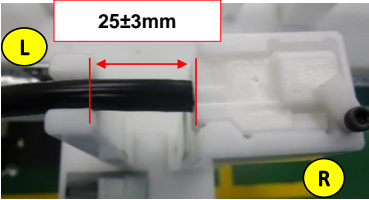
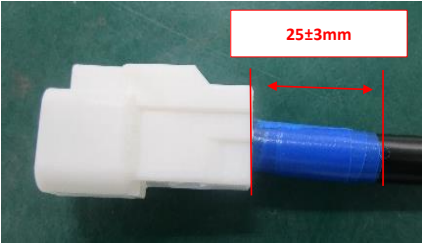

PARTS:		1. Clamp 82711-52090 (W) [2pcs] 2. Black tape [2pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	<div></div> <div>1. Get 2pcs. of clamp 82711-52090 (W) using left and right hand then set to jig location ① and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

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	WORK INSTRUCTION				Effectivity Date:	July 12, 2024		
	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: D10L / 7M0654-7020A	Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:	WI-ENG-PDE-685	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:

PARTS:	1. Blue tape 2. Assy parts			JIG:	1. Clamp Assembly jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	CLAMP ASSY	<div><p>1. Get the assy parts using both hands and set to spot taping jig. Measurement of spot tape is 25±3mm.</p><p>2. Get the Blue tape using right hand. Start the taping process from left side going to right using both hands. Conduct 1/3 shifting going to connector then cut the tape.</p><p>3. After taping, check the measurement and taping condition.</p></div>			<div></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use BLUE TAPE only</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</p>		

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PARTS:

1. Assy parts

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

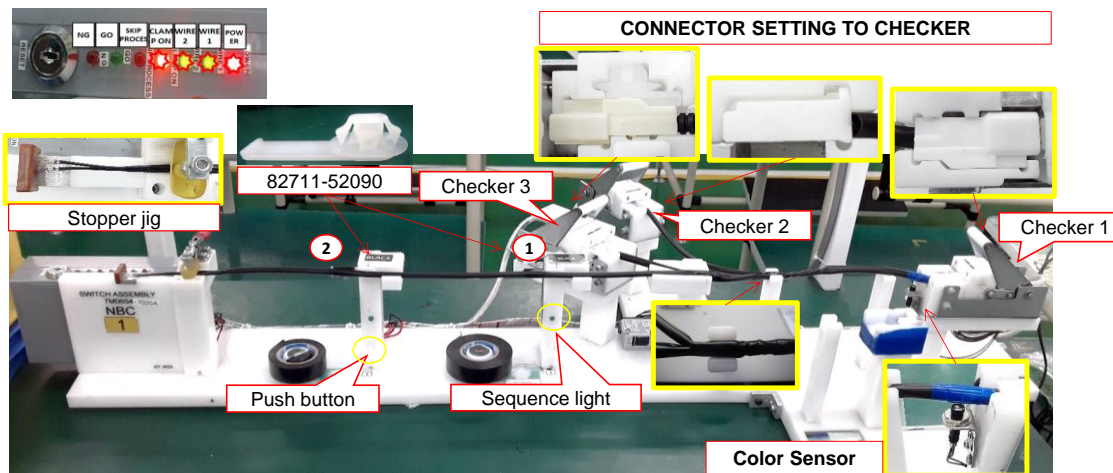
TOOLS/PPE

QUALITY POINTERS

4

CLAMP
ASSY

Clamp assembly



1. Get the assy parts using both hands. First, set the Connector 4G5400-0000 (N) to **checker 1** then pull the checker fixture for continuity checking. Color sensor light will on if the **Blue tape** was detected. 2nd, set the connector 6098-2220 (N) to **checker 2** then pull the checker fixture for continuity checking. 3rd, set the connector 7282-1027 (N) to **checker 3** then pull the checker fixture for continuity checking. Lastly, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then pull down the **Toggle clamp**.

2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was **On**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader and **WAIT** for instructions.

3. Wait the sequence light to turn **ON** to the next process.

4. Start the taping process on location ①. Hold the tape and tape the clamp into vinyl **make 3 winds**. Press the SW button after taping. Wait the sequence light to move on to location ②.

5. Hold the tape and begin taping on location ② (3 winds). Press the SW button after taping and Go buzzer will be heard.

6. Conduct **POINT CHECKING** before removing to Clamp Assy Jig.



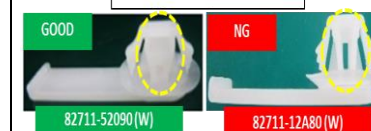
Important reminders/Note/s:

1. **No gap between terminal and stopper.**

2. **Make 2-3 windings for clamp taping.**

1. No loose attachment of clamp
2. No missed tape
3. No wrong use of tape
4. No missing parts
5. Check the correct orientation, avoid wrong facing
6. Make sure no clearance between terminal and stopper jig.

CLAMP ILLUSTRATION



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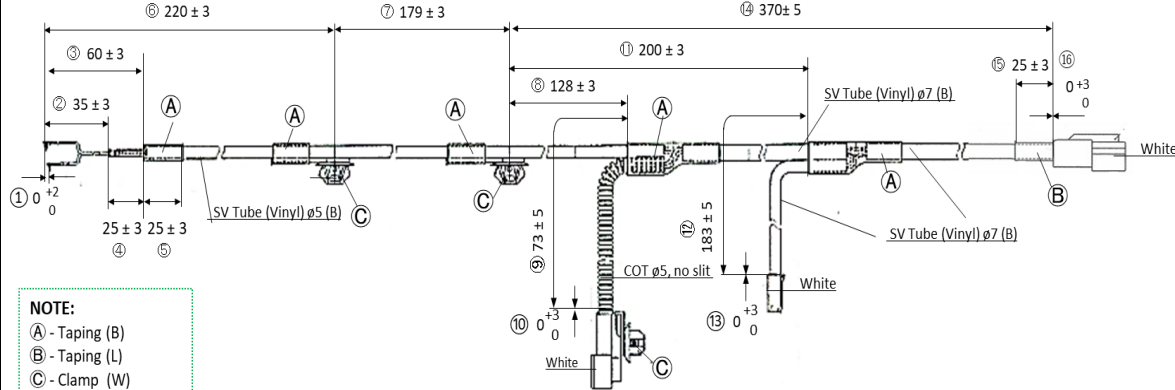
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div>1</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	<div>Measurement</div> <div><div>MEASURING TAPE</div></div> <div><div>NOTE: (A) - Taping (B) (B) - Taping (L) (C) - Clamp (W)</div></div>	<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></div>	1. No wrong dimension

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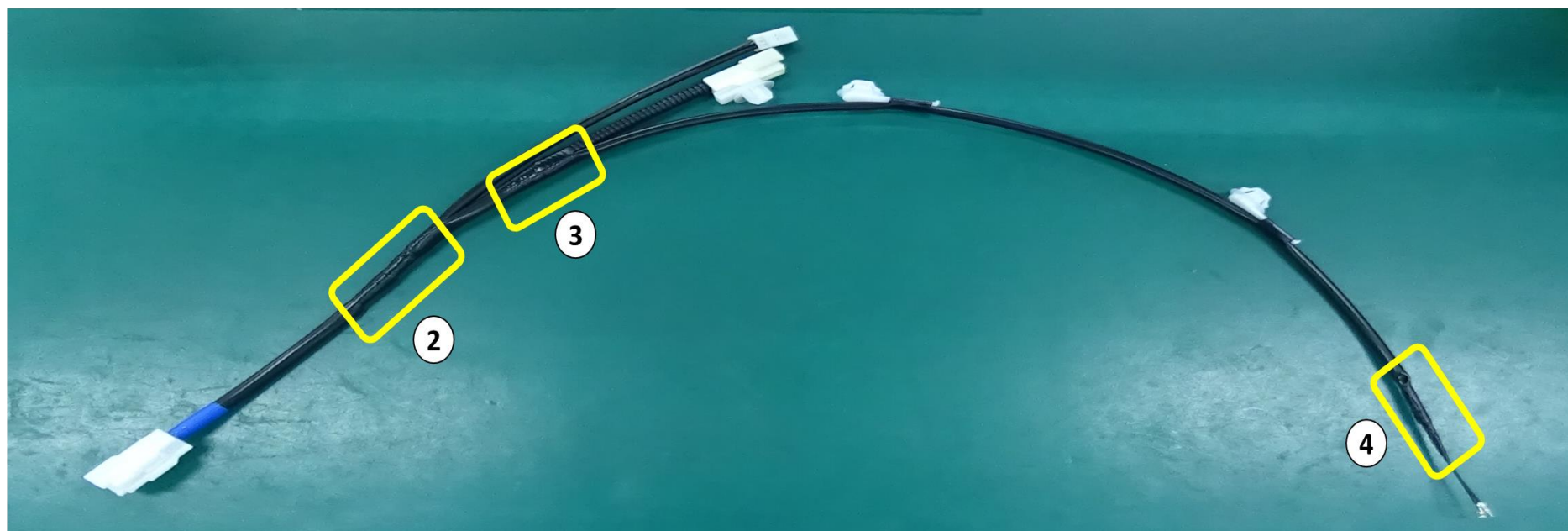
PARTS:

1. Assy parts

JIG:

n/a

1

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0654-7020A**

① No Wrong facing of clamp

② ③ ④ No Missing Tape (Black tape)

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