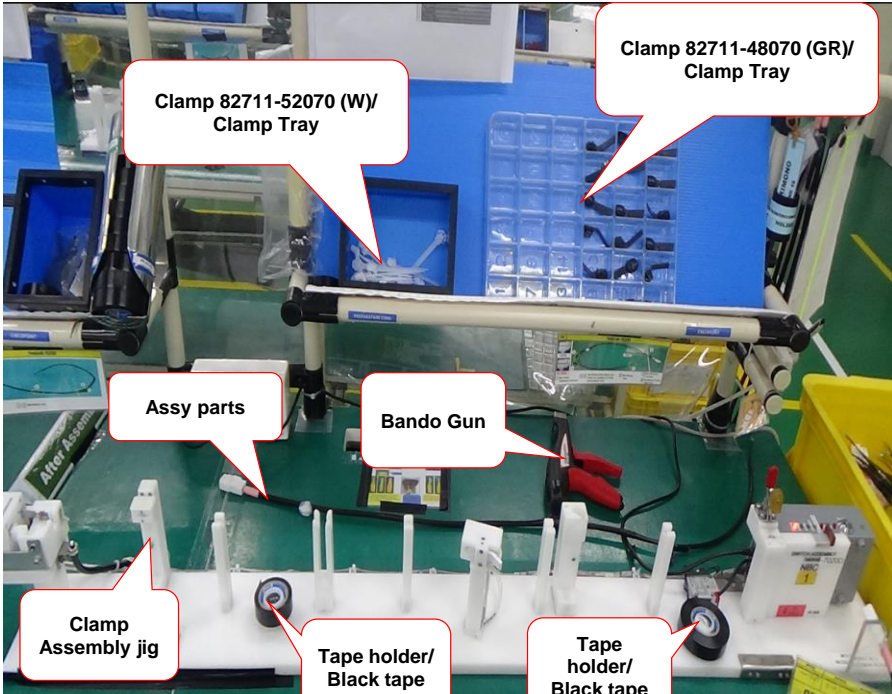
	WORK INSTRUCTION				Effectivity Date:	January 22, 2025		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:	WI-ENG-PDE-1187		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	0	Page No.:	1 of 5


PARTS:	1. Assy parts; Black tape; Clamp 82711-52070 (W); Clamp 82711-48070 (GR)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<p style="text-align: center;">TABLE LAY-OUT</p> 		<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>Document reference/s: 1. Refer to WI-ENG-PDE-095A-D for the Taping assembly process.</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>




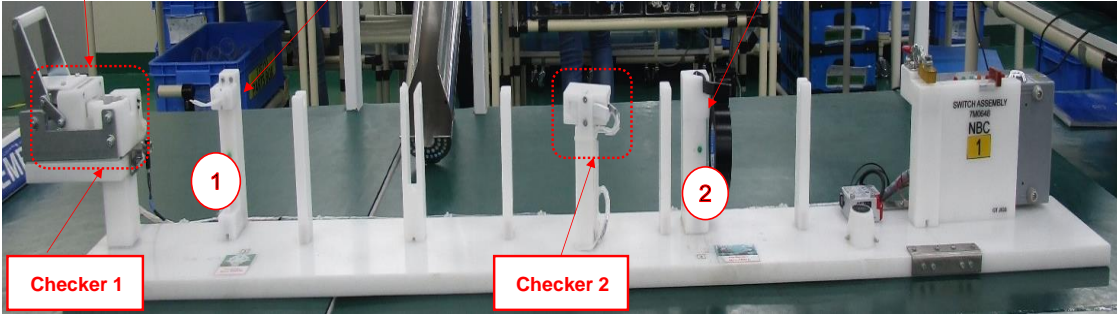



Revision History				Prepared by	Reviewed by	Approved by	Noted by
01/22/25	0	Initial issue. Separate process from Taping assembly porcess.	D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: January 22, 2025

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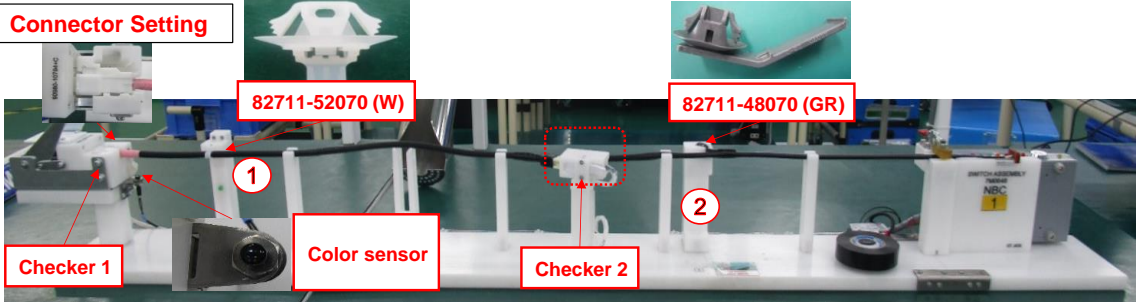
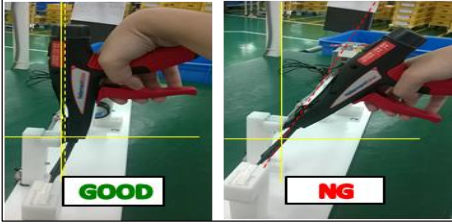
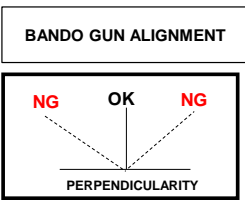
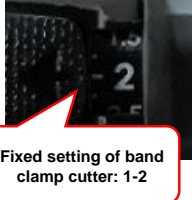
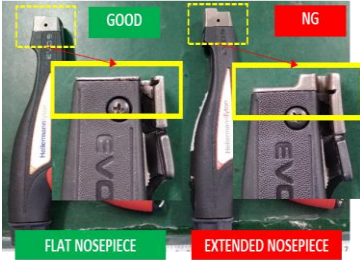
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	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS			Effectivity Date:	January 22, 2025		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	D01L / 7M0648-7020D	Customer:	TRJ	Car Model:	DAIHATSU-TANTO	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.:	WI-ENG-PDE-1187	
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PARTS:	1. Clamp 82711-52070 (W) 2. Clamp 82711-48070 (GR) 3. 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>  <div> <div>Checker 1</div> <div>Checker 2</div> </div> </div> <div> <div> 1. Get the clamp 82711-52070 (W) and set to the clamp location 1 using both hands. </div> <div> 2. Get the clamp 82711-48070 (GR) and set to the clamp location 2 using both hands. </div> <div> 3. Initially attach tape to location 2 using right hand. </div> </div>		<div> One wind for under tape  </div> <p>Important reminders/Note/s:</p> <p>1. Please check the clamp before start of assembly to avoid the wrong use of clamp.</p> <p>1. No wrong use of tape 2. No wrong clamp position 3. No wrong use of parts 4. No wrong use of clamp.</p> <div> <p>BAND CLAMP ILLUSTRATION</p> <div> <div>GOOD</div>  <div>82711-52070 (B)</div> </div> <div> <div>NG</div>  <div>82711-12A60 (W)</div> </div> </div>	

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	WORK INSTRUCTION			Effectivity Date:	January 22, 2025		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:	WI-ENG-PDE-1187	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 5

PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	CLAMP ASSY	<div><div>Connector Setting</div><div></div><div>1. Put the assy. First, set the connector to Checker 1 then pull the checker fixture for continuity checking. Color sensor light will beep/buzz if sensor detect the Pink tape. Second, set the connector to Checker 2 then clip the connector using clip type checker. Last, set the B-B wires with terminal end together within the stopper then press by Toggle clamp.</div><div>2. Check if all LED light for POWER ON, WIRE1 and WIRE2 and CLAMP ON and COLOR SENSOR was ON. Check also if clamp location ① sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div><div><div>3. Initially tighten the band clamp on location 1 using right hand.</div><div>4. Get the bando gun and cut the band clamp (82711-52070) using right hand. Press the sequence light button after cutting. Continue to location 1 if light was ON.</div></div><div>5. Hold the tape on clamp location 2 and start taping using both hands. Press the sequence light button. GO buzzer will be heard.</div><div>6. CONDUCT POINT CHECKING before removing from jig.</div><div>7. After point checking. Remove the harness, start from toggle clamp and clamp up to Checker 1 then band clamp. Last, release the connector from Checker 2. Press the lock and remove the harness.</div></div> <div><div></div><div></div><div></div></div>			<div>Important reminders/Note/s: 1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm). 2. Make sure no gap between the terminal and stopper jig. 3. Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</div> <div><div>1. No loose attachment of clamp</div><div>2. No damaged clamp</div><div>3. No missed tape</div><div>4. No missing parts</div><div>5. No wrong use of tape</div><div>6. No wrong use of clamp</div></div> <div><div>BANDO GUN ILLUSTRATION</div><div></div></div>		

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Car Model:

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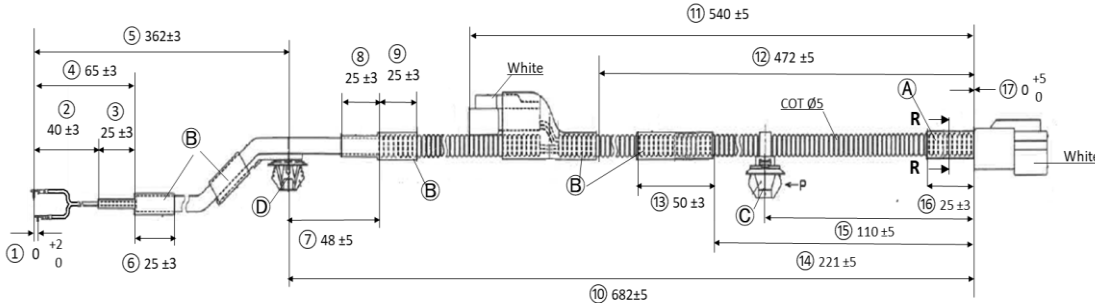

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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

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Customer:

TRJCar Model: **DAIHATSU-TANTO**

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PROTOTYPE



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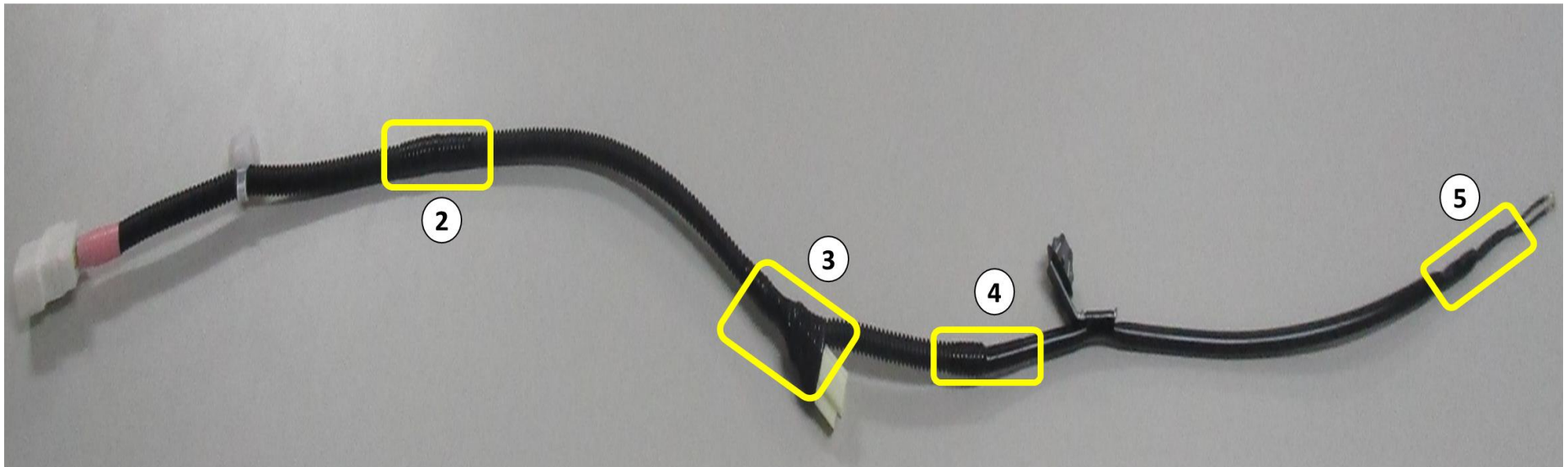
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0648-7020D****1** No Wrong facing of clamp**2 3 4 5** No Missing Tape (Black tape)

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