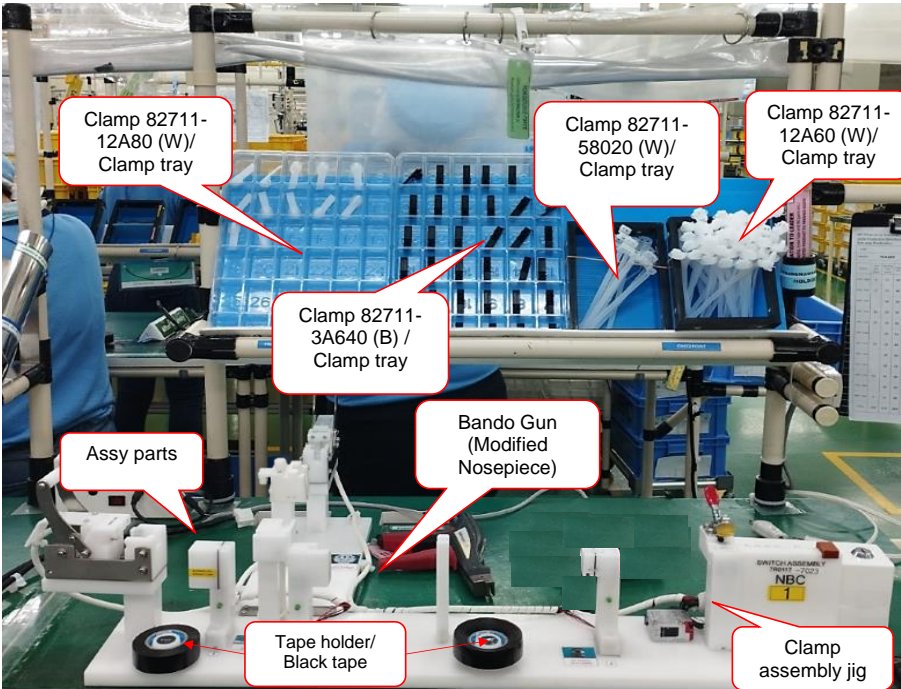




	<b>WORK INSTRUCTION</b>				Effectivity Date:		June 24, 2024	
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>920B / 7R0117-7023</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>	Document No.:		<b>WI-ENG-PDE-917</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 7

<b>PARTS:</b>	1. Assy parts; Clamp 82711-12A80 (W); Clamp 82711-58020 (W);Clamp 82711-3A640 (B); Clamp 82711-12A60 (W); Black tape [2pcs];			JIG:	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	CLAMP ASSY	<div><div>Table Lay-out</div></div>		<div><div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-653A-C</b> for Offline assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div> <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> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-12A60 (W)</div></div><div><div>NG</div><div>82711-52070 (B)</div></div></div>

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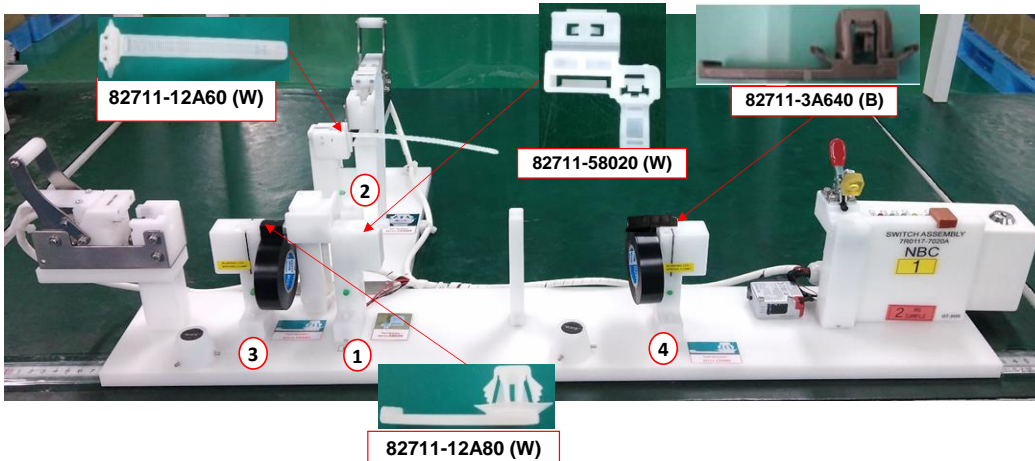
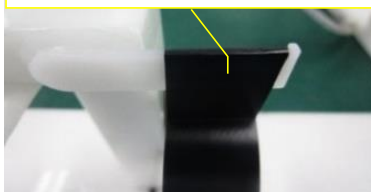




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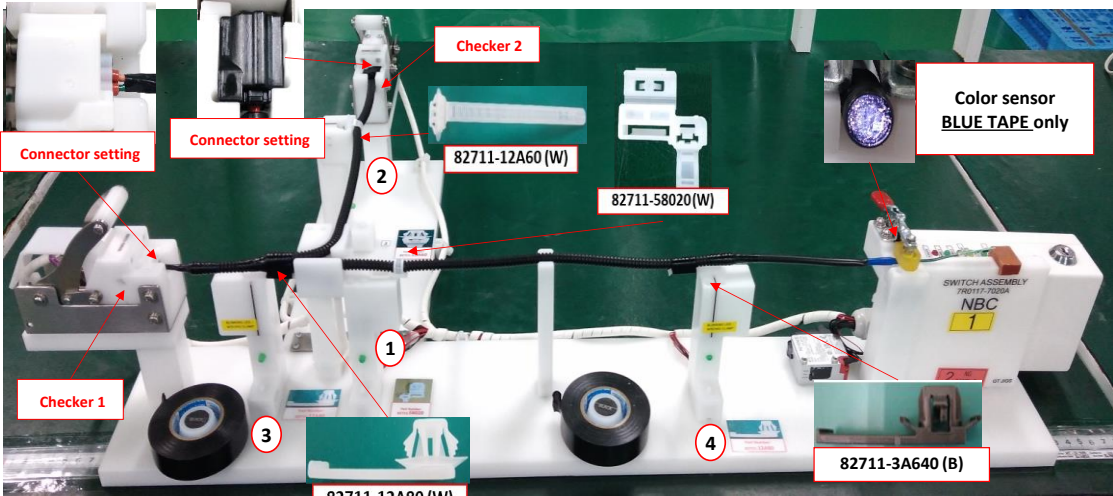

<b>PARTS:</b>	1. Clamp 82711-12A80 (W) 2. Clamp 82711-58020 (W) 3. Clamp 82711-3A640 (B)	4. Clamp 82711-12A60 (W) 5. Black tape (2pcs.)	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY  Clamp setting	 <div>1. Get 1pc. of clamp 82711-12A80 (W) then set to clamp location 3 using both hands.</div> <div>2. Get 1pc. of clamp 82711-3A640 (B) then set to clamp location 4 using both hands.</div> <div>3. Get 1pc. of clamp 82711-58020 (W) then set to clamp location 1 using both hands.</div> <div>4. Get 1pc. of clamp 82711-12A60 (W) then set to clamp location 2 using both hands then lock.</div> <div>5. Initially attach <b>Black tape</b> on clamp location 3 and 4 using both hands.</div>		<div><b>STANDARD TAPING FOR CLAMP</b></div> <div>One wind for under tape</div>  <div>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</div> <div><i>Important reminders/Note/s:</i> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div> <div><b>CLAMP ILLUSTRATION</b></div> <div><b>GOOD</b>  <b>NG</b> </div> <div><b>82711-12A80 (W)</b> <b>82711-52090 (W)</b></div> <div><b>BAND CLAMP ILLUSTRATION</b></div> <div><b>GOOD</b>  <b>NG</b> </div> <div><b>82711-12A60 (W)</b> <b>82711-52070 (B)</b></div>

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>June 24, 2024</b>		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>920B / 7R0117-7023</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>	Document No.:		<b>WI-ENG-PDE-917</b>
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<b>PARTS:</b>	1. Assy parts		JIG:	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	CLAMP ASSY  Clamp assembly	<div></div> <div>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector <b>6189-1142 (W)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Continue to set the harness in jig. <b>Clamp assembly jig</b> will beep/buzz if sensor detects <b>Blue tape</b>. Set the end of PCB within the stopper jig then press the toggle clamp. Last, set the connector <b>6189-1161 (B)</b> to <b>Checker 2</b> then pull the checker fixture for continuity checking. Continue if the clamp location <b>1</b> was <b>ON</b>.</div> <div>2. Check if all LED light for <b>Power On, Clamp On, Wire1 &amp; Wire2, Color sensor</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</div> <div>3. Initially tighten the band clamp on clamp location <b>1 and 2</b> using both hands.</div>		<div>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</div> <div></div> <div><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between stopper and PCB</b></div>

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### PARTS:

1. Assy parts

JIG:

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

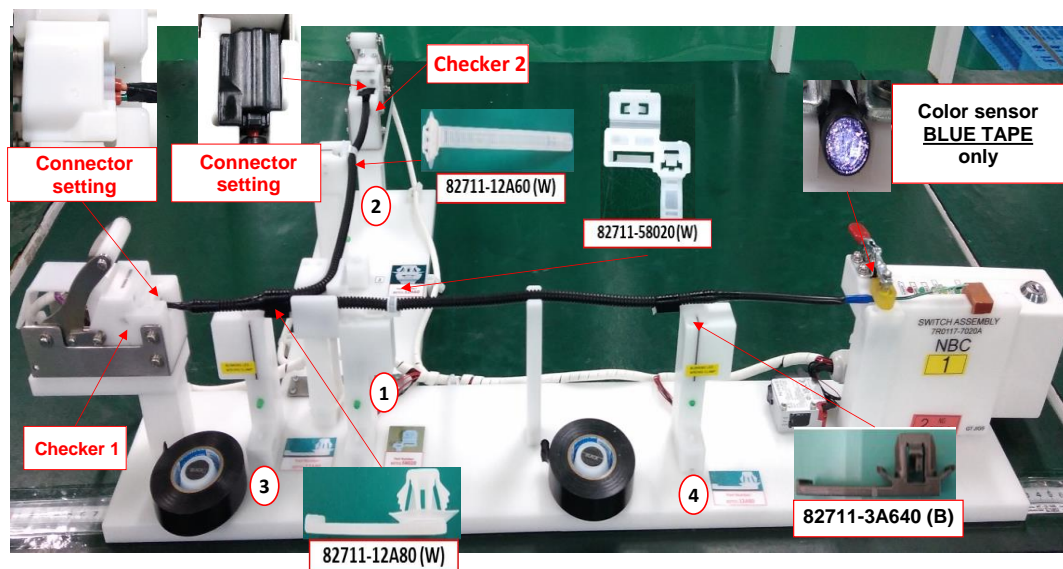
### TOOLS/PPE

### QUALITY POINTERS

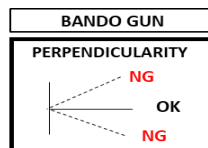
3

CLAMP  
ASSY

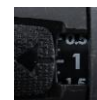
Clamp assembly  
(Continuation)



4. Get the Bando gun (**MODIFIED NOSEPIECE**) using right hand then cut the clamp on location **1** using both hands. Press the **SW button** after cut. Continue if the clamp location **2** was **ON**.



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For:  $\phi 5 - 1 \sim 2$ ,  $\phi 7 - 3 \sim 4$



Fixed setting  
of band clamp  
cutter: 1~ 2



### Important reminders/Note/s:

1. Make sure no gap between stopper and PCB

1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

### BANDO GUN ILLUSTRATION



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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY  Clamp assembly (Continuation)	<div></div>			

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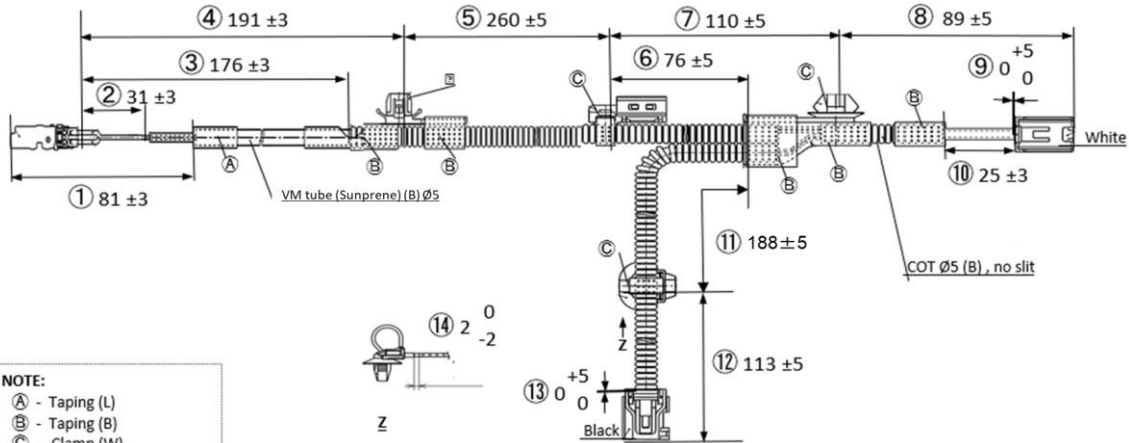

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div>Measurement</div> <div></div> <div><p>NOTE:</p><ul style="list-style-type: none"><li>A - Taping (L)</li><li>B - Taping (B)</li><li>C - Clamp (W)</li><li>D - Clamp (B)</li></ul></div>		<div>MEASURING TAPE</div> <div></div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7R0117-7023****① No Wrong facing of clamp****② ③ ④ No Missing Tape (Black tape)**

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