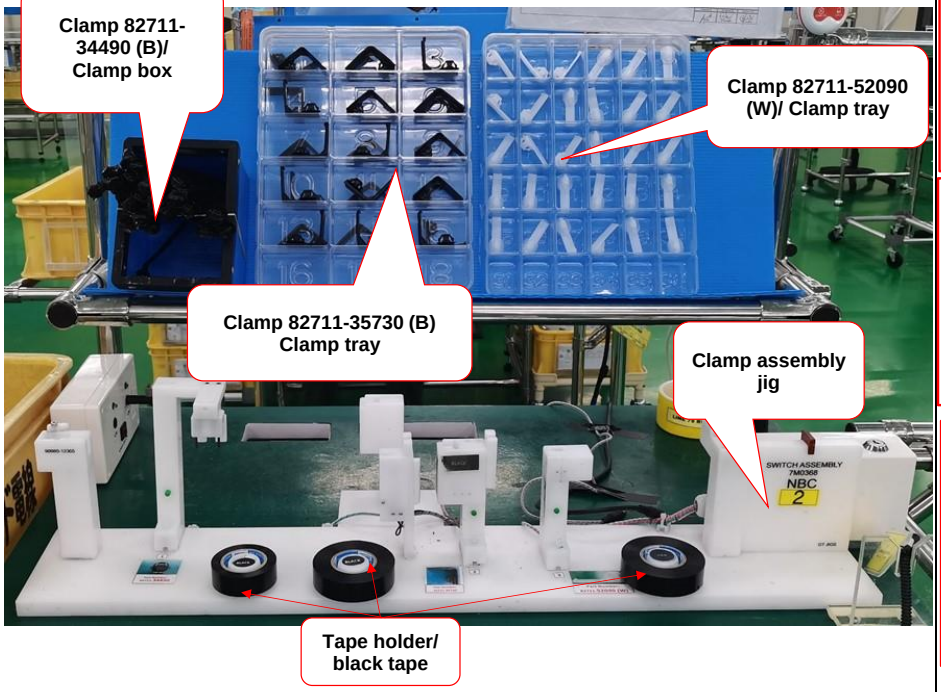
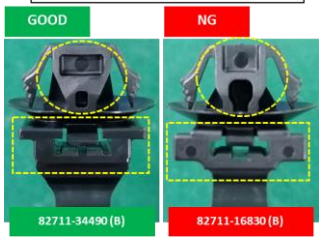
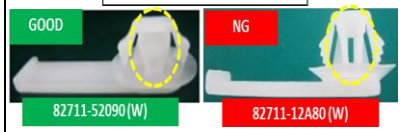
NBC	WORK INSTRUCTION			Effectivity Date:	July 18, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 011B / 7M0368-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-894
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 0	Page No.: 1 of 7

PARTS:	1. Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clamp 82711-35730 (B) ; Black tape(3PCS) ; Assy Parts	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.	1. No Missing parts/tools. 2. No excess parts/tools. ***Document reference/s:*** *1. Refer to **WI-ENG-PDE**-for Offline assemmbly process* BAND CLAMP ILLUSTRATION  CLAMP ILLUSTRATION 

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/18/24	0	Initial issue.	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:	July 18, 2024		

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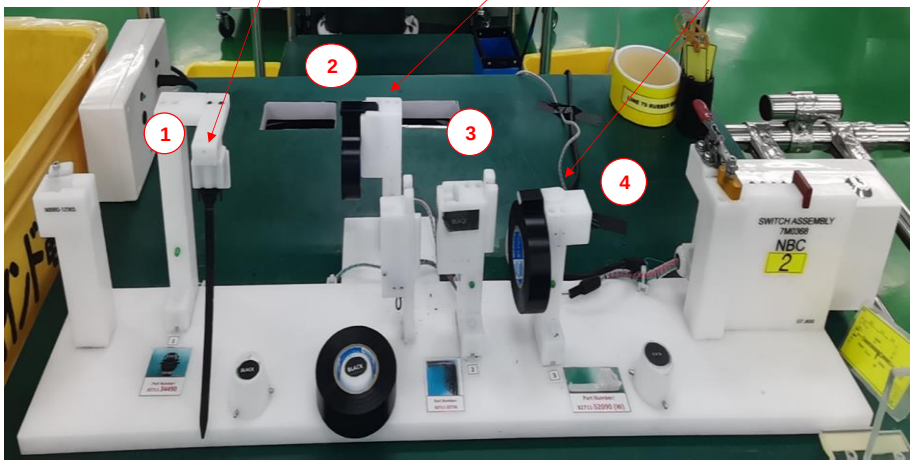
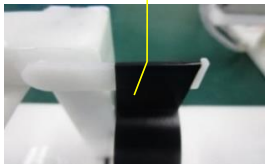
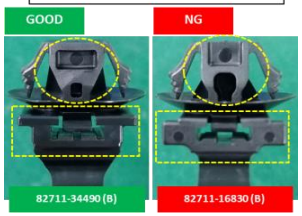
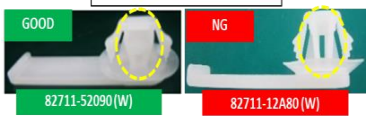
	WORK INSTRUCTION			Effectivity Date:	July 18, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	011B / 7M0368-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-894	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 2 of 7

PARTS:	1. Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W)	3. Black tape	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	 82711-34490 (B) 82711-35730 (B) 82711-52090 (W)  1. Get 1 pc. of band clamp **82711-34490 (B)** then set to clamp location **1** using both hands. 3. Get 1 pc. of clamp **82711-52090 (W)** then set to clamp location **4** using both hands. 2. Get 1 pc. of clamp **82711-35730 (B)** then set to clamp location **2** using both hands. 4. Initially attach **Black tape** on clamp location **2 and 4** using both hands.	n/a	**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.*** 1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp **BAND CLAMP ILLUSTRATION**  **CLAMP ILLUSTRATION** 

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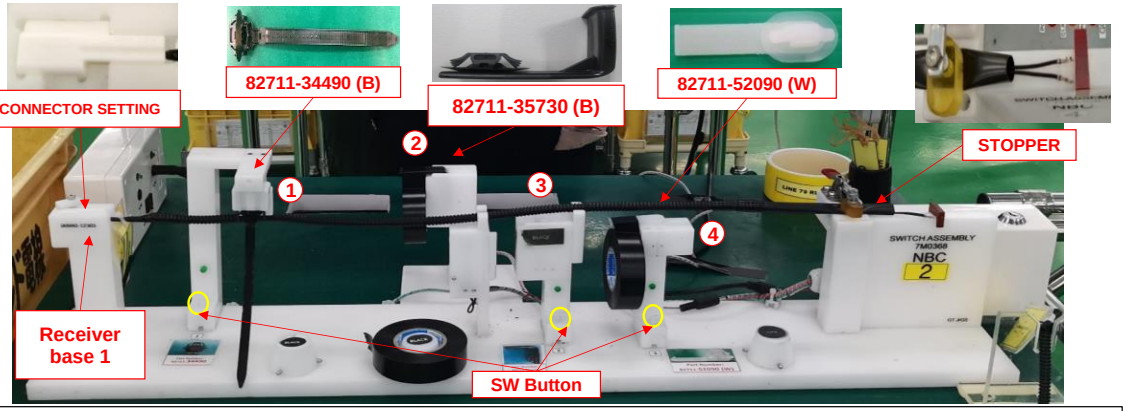
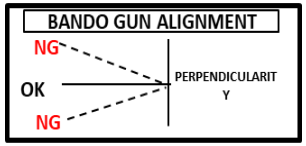
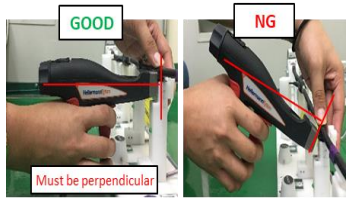
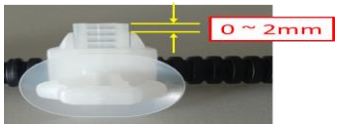
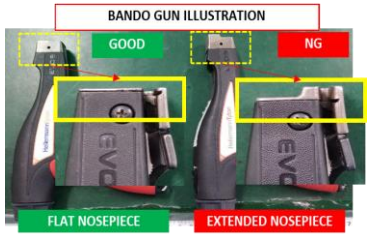
	Model code/Part number:	011B / 7M0368-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-894	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 3 of 7

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).***  

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	WORK INSTRUCTION			Effectivity Date:	July 18, 2024		
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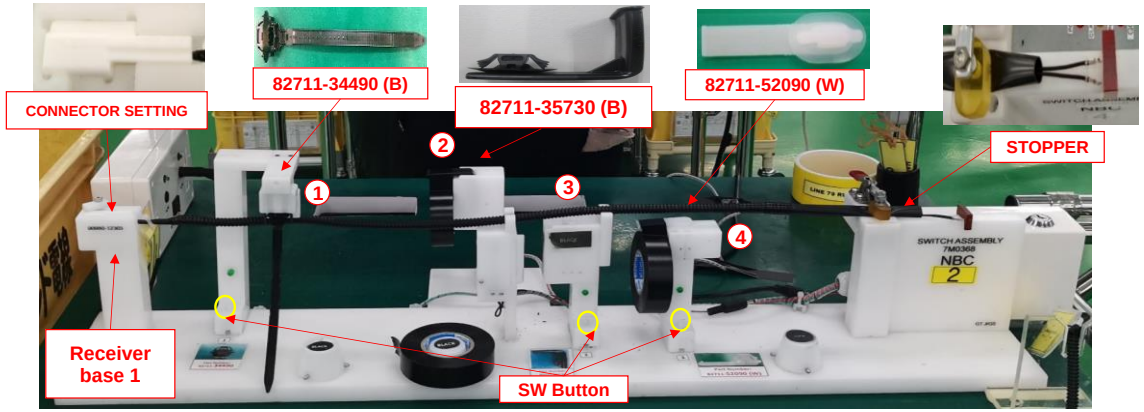
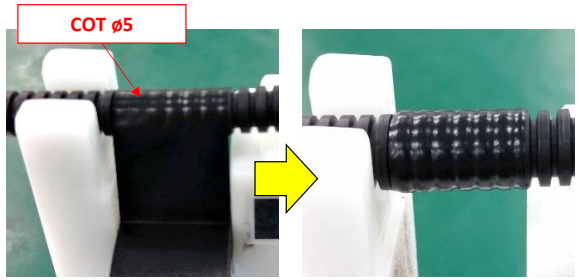
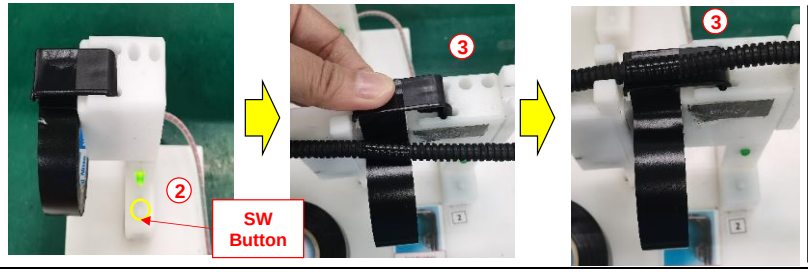
	Model code/Part number: 011B / 7M0368-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-894		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	4 of 7

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.***
			 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***		1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape
			 6. Press the **SW button** and get the clamp **(82711-35730 (B))** in location **2** then put in location **3.**		

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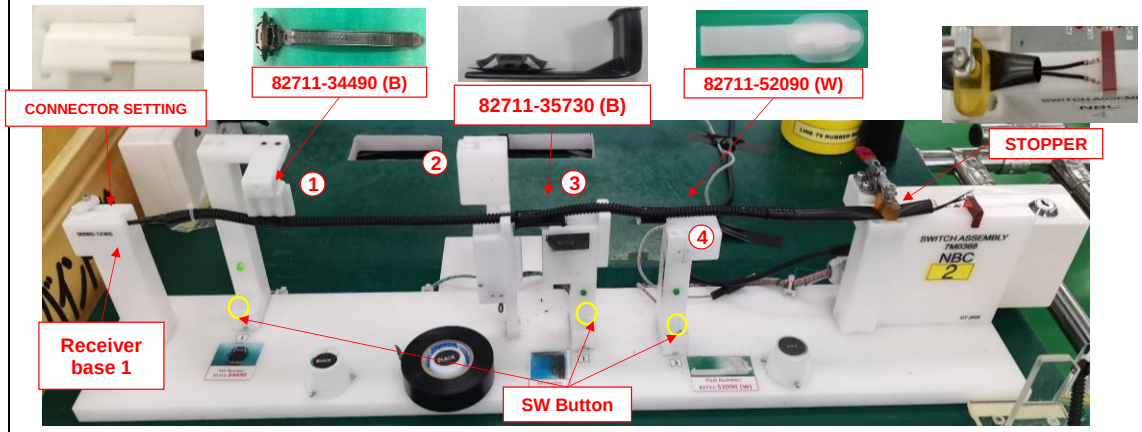
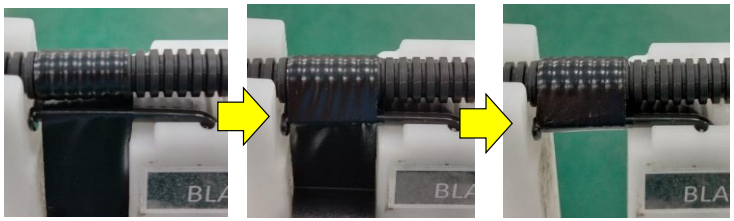
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	5 of 7

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 damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape

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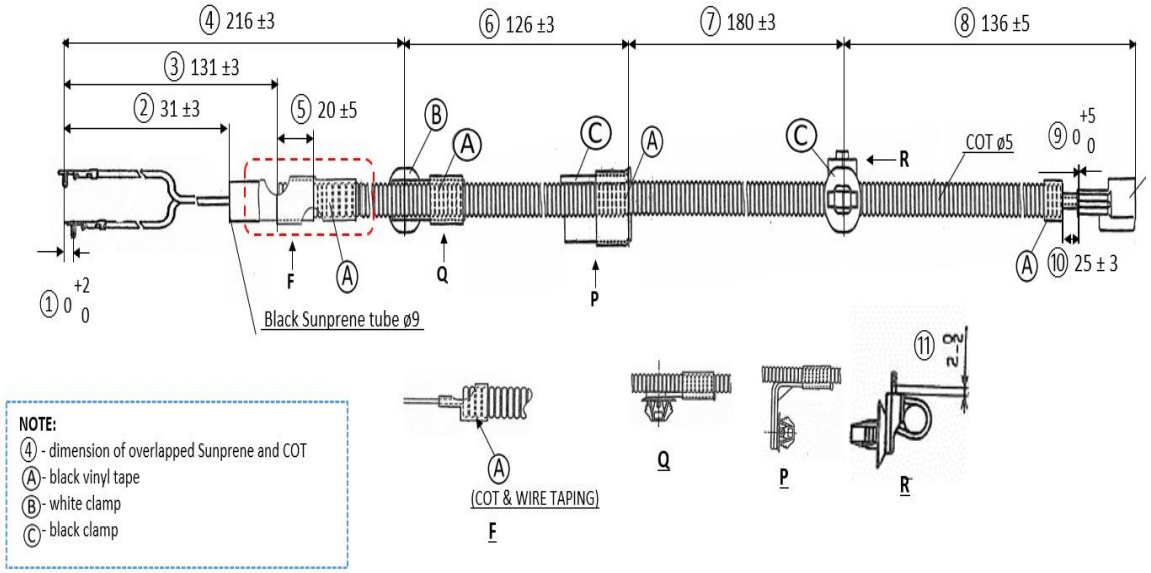
PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	CLAMP ASSY	Measurement		**MEASURING TAPE** 	***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For 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.

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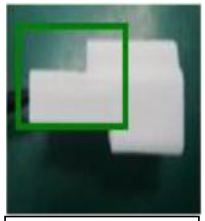
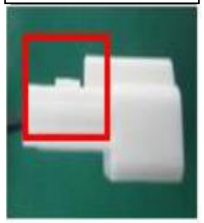
PARTS:	1.Assy parts	JIG:	n/a

QUALITY CHECKPOINTS

CLAMP ASSY	7M0368-7020A



GOOD



NO GOOD

1 No Wrong Facing of Clamp

2 No Unlock/Halflock connector

3 4 No Missing Tape (Black Tape)

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