					STRUCTION					Effect	ivity Date:		February 26, 20)25	
		Process Name/Title: CLAMP ASSEMBLY PROCESS								Validit	Validity Date:		n/a		
		Model code/Part number:	559D /	7N0242-7020A	Customer:	TRJ	Car Model:	TOYO	TA HI-ACE	Docur	ment No.:		WI-ENG-PDE-1	217	
		Purpose:	☐ PROTOTY	PE .	PRE-LAUNCH		MASSP	rRO		Revis	ion No.:	0	Page No.:	1 of 6	
PARTS: 1. Assy parts; Clamp 82711-16830 (B); Clamp 82711-16820 (BR); Brown tape								JIG: 1. Clamp assembly jig 2. Bando gun							
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUA						QUALITY POIN	TERS							
	Clamp Assy			Clamp 82711-16830 (B)	TABLE LAY-O		Clamp I-16820 (B	R)		pre	Be sure to wear required persona otective equipme during operation gloves, finger cot etc.)	l ent s, Docui 1. Refe	nent reference/ r to WI-ENG-PDE-1	182A-B for	
1		Table lay-out	Assy parts							1. l 2.	Housekeeping Maintain and alw practice 5's. Personal things the workplace is rohibited. Keep it your locker.	ays on in 1. No miss	Taping assembly processs 1. No missing parts/tools 2. No excess parts/tools		
			Clamp As				(E	ando Gui EXTENDE OSEPIECI	D	the S Le	Alert level r any trouble, info Assembly Assis Supervisor or Lineader for immedia corrective action	tant e ate			
				Revision History					_,		Dropored by	Chapland by	Povioued by	Approved by	
											Prepared by	Checked by	Reviewed by	Approved by	
												\bigcap Λ	}		
									0.1/11		Jestus	(Xh	Month Tillow		
02/26/25 0	Initial iss	ue.					D.Castillo	J. Loterte	C.Villanuev a	Arañes	D. Castillo	J. Lone te	C. Villanueva	A. Arañes	
Eff. Date Rev. No	,		Details	of Change			Revised	Checked	Reviewed Ap	oroved	Est. Date:	February 26, 2025			

MASTER COPY

	_		WORK INST	FRUCTION		Effectivity Date:		February 26,	2025	
		Process Name/Title:		P ASSEMBLY PRO	OCESS	Validity Date:	n/a			
		Model code/Part number:	559D / 7N0242-7020A	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:	WI-ENG-PDE-1217			
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.:	2 of 6	
PARTS:	1. Clam 2. Clam	p 82711-16830 (B) p 82711-16820 (BR)				JIG:	1. Clamp as	sembly jig		
NO.	F	PROCESS NAME	WORK P	ROCEDURE/ ILLUS	TOOLS/PPE	QUALITY POINTERS				
2	Clamp	Clamp Setting	82711-16830 (B) 1. Get 1pc of band clamp 82711-attach to clamp location 1.	2	82711-16820 (BR) 3 2. Get 1pc of band clamp 82711-16 then attach to clamp location 2.	SMITCH ASSEMBLY THOSE AND NBC	Impor 1. Plea before wrong 1. No dam 2. No wron 3. No missi	tant reminderse check the constant of assemble use of clamp. aged clamp gruse of clamping clamp gruse of clamping clamp	ers/Notes/:	

				ORK INSTRUCT	-1211			I			
		Process Name/Title:		CLAMP ASSI		COESS		Effectivity Date: Validity Date:		February 26, 20 n/a	<u>J25</u>
							TOYOTA UL ACI				· · · - ·
		Model code/Part number:	559D / 7N0242-7	<u> </u>	stomer: TRJ		TOYOTA HI-ACE			WI-ENG-PDE-12	1
		Purpose:	PROTOTYPE	PRE-	E-LAUNCH	■ MASSPRO	(O	Revision No.:	0	Page No.:	3 of 6
PARTS: 1. Assy pa 2. Brown to		vn tape	JIG:	2. Bando gu							
NO.	F	PROCESS NAME		WORK PROCED	JURE/ ILLUS	STRATION		TOOLS/PPE	T	QUALITY POIN	TERS
3	Clamp		Connector Setting Connector receiver base	82711-17830 (C	with	ping guide switch	Stopper SMITCH ASSEMBLY NBC NBC	1. Using measure dimensic allowable (0~2mm, 2. Make terminal 3. Settin on the si For: ø5 1. No wron 2. No wron 3. No Loos 4. No wron 5. No miss	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 1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No missing Spot tape 6. No wrong color of tape	
			1. Put the assy into jig. (See a correct setting). First, set the 3802 (W) with Clip to Receiv Last, set the terminals togeth then press by toggle clamp. sequence light of location 1 w	ne connector 6098- ever base 1 then lock ther within stopper . Continue if the	k. ON, COL was ON. and imm leader. V	cked if all LED light DLOR SENSOR and I. IF encountered primediately CALL the WAIT for further inside the process.	ad CLAMP ON problem, STOP e attention of astruction nad	Initially tighten the band amp 1 and band clamp 2 sing both hands			
			4. Get the Bando Gun using right hand and cut the band clamp on location 1 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 2 was on.	5. Cut the band clack clamp location 2 u hands. Press the button after cuttin clamp. Continue the process if clamp lows on.	using both SW ng of band the	BAND CLAMP CL FOR LOCATI	TION 1 & 2	PERPENDICULARITY NG OK NG	GOOD	BANDO GUN ILLUSTRATI	FLAT NOSEPIECE

				STRUCTION IP ASSEMBLY PROC		Effectivity Date:		February 26, 20	025		
		Process Name/Title:	Validity Date:	n/a							
		Model code/Part number:	559D / 7N0242-7020A	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-12	217		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.:	4 of 6		
PARTS:	2. Brown tape							1. Clamp assembly jig			
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE						QUALITY POINTERS				
4	Clamp	Clamp Assembly (Continuation)	Spot taping guide with switch 6. Get the Brown tape and start taping sound will be heard. Note: Jig will alram if lacking and excent and start taping sound will be heard. 7. Conduct POINT CHECKING, before the harness from jig. Start and start taping sound with switch.	ore removing of harness from		ton after taping. Go	1. Using measure dimensicallowab. (0~2mm 2. Make terminal 2. No wror 2. No wror 3. No Loos 4. No wror 5. No miss	retant reminders I steel rule, check it bement is within the con and should not be range i). Sure no gap betwee and stopper jig. In g setting of clamp ge use of clamp se attachment of cla g setting of Bando sing Spot tape ig color of tape	f the band cut required exceed the een the		

			WORK INS	TRUCTION		Effectivity Date:		February 26, 202	25
		Process Name/Title:	CLAM	Validity Date:	n/a				
		Model code/Part number:	559D / 7N0242-7020A	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-121	17
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.:	5 of 6
PARTS:	1. Assy į	parts				JIG:	n/a		
NO.	Р	ROCESS NAME	WORK P	PROCEDURE/ ILLUSTI	TOOLS/PPE	(QUALITY POINT	ERS	
NO.	Clamp	Measurement	(3) 609 (2) 35 ±3 (3) 609 (4) (2) 35 ±3 (5) Tube (B) Ø5 (6) NOTE: (6) - Taping (BR) (7) (B) (B) (B) (C) - Taping (B) (8) - Clamp (BR) (9) - Clamp (BR) (10) - Clamp (BR) (10) - Clamp (BR) (10) - Clamp (BR)	5±3 (4) 335±5 (5) 30±5	(8) 340 ±5	MEASURING TAPE 6 7 8 9 (1 2 3 4 5 6 7 8 9) (9 50 ±3	Importa 1. Pleas measur measur 2. For H Docur 1. Refer assemb Owarim	ant reminders and a se use calibrated/v ing tape when gett	note/s: erified ting the varimono.

			Effectivity Date: February 26, 2025									
		Process Name/Title: CLAMP ASSEMBLY PROCESS							Validity Date:	n/a		
		Model code/Part number:	559D / 7N0242-7020A	Cı	ustomer:	TRJ	Car Model:	TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-12	:17
		Purpose:	☐ PROTOTYPE	☐ PF	RE-LAUNCH		MASSPE	RO	Revision No.:	0	Page No.:	6 of 6
PARTS: 1	1 Assv	narts							.IIG:	n/a		

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7N0242-7020A



- No Wrong
 Facing of Clamp
- No Mis-aslign
 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.