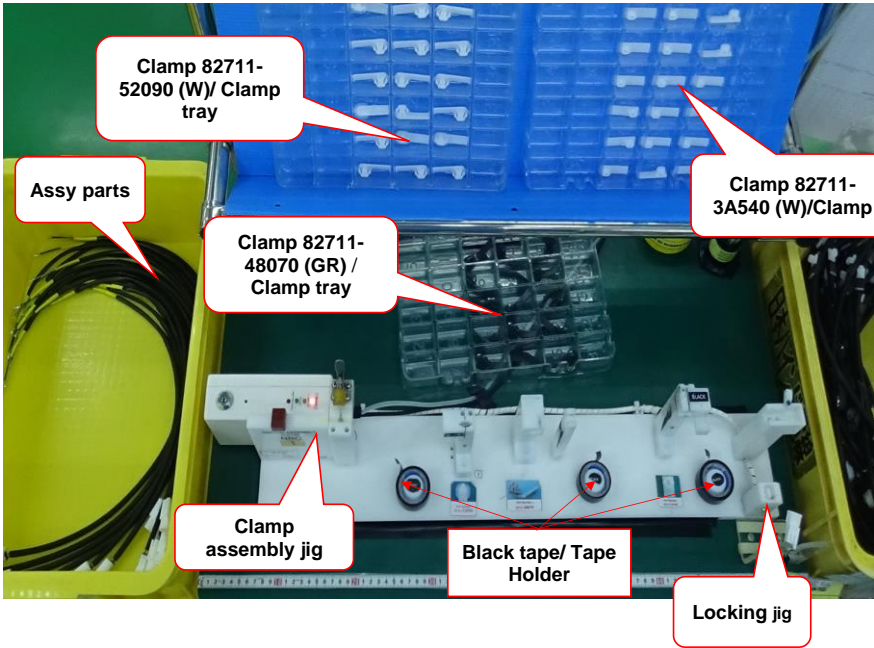
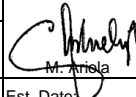
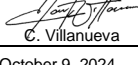
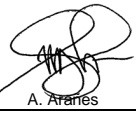
	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:	096D / 7L0120-7023A	Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-1090	
	Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.: 1 of 6

PARTS:		1. Assy parts ; Clamp 82711-52090 (W) ;Clamp 82711-48070 (GR) ; Clamp 82711-3A540 (W) ; Black tape (4pcs)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div>TABLE LAY OUT</div> 		<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	Document reference/s: 1. Refer to WI-ENG-PDE-243 for Offline assembly process

Revision History							Prepared by	Reviewed by	Approved by	Noted by	
										n/a	
10/14/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a					
10/09/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date	October 9, 2024	

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**WORK INSTRUCTION****CLAMP ASSEMBLY PROCESS**

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096D / 7L0120-7023A

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TRQSS

Car Model:

TOYOTA-HIGHLANDER

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PARTS:		1. Black tape [3pcs.] 2. Clamp 82711-52090 (W)		3.Clamp 82711-48070 GR) 4.Clamp 82711-3A540 (W)		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	CLAMP ASSY	Clamp setting	<div><div> 82711-52090 (W)</div><div> 82711-48070 (GR)</div><div> 82711-3A540 (W)</div><div></div></div> <div>1. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.</div> <div>2. Get 1pc. of clamp 82711-48070 (GR) using right hand and set to clamp location 2 using both hands.</div> <div>3. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</div> <div>4. Get black tape and put pre-tape on clamp location 1, 2 and 3 using both hands.</div>				<div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</div><div></div></div> <div>Important reminders/Note/S: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>	

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☐ PRE-LAUNCH




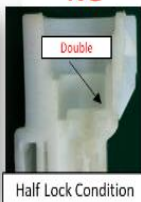
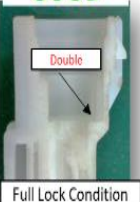



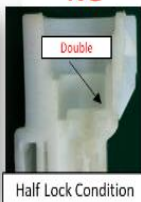
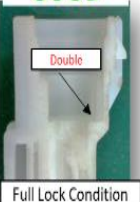


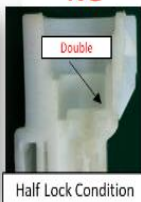
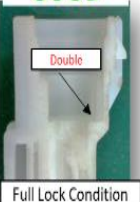
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PARTS:		1. Assy parts		JIG:	1. Locking jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS									
3	CLAMP ASSY	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</p></div><div><div><p>Coupler Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock Condition</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div><div></div><div><p>Before lock</p><p>After lock</p></div></div></div>		NG	NG	GOOD				Unlock Condition	Half Lock Condition	Full Lock Condition	<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</p>
NG	NG	GOOD												
														
Unlock Condition	Half Lock Condition	Full Lock Condition												

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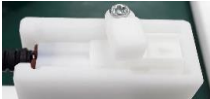
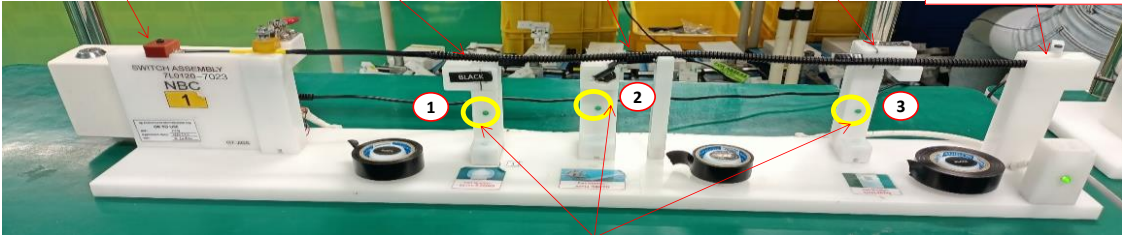

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Clamp assembly			
		<div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div><div>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness)</i>. First, set the connector 6098-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Last, set the terminal end together (with direct contact terminal to terminal to avoid sensor malfunction of clamp) within the stopper then press by Toggle clamp. Continue if the sequence light in location 1 was ON.</div><div>2. Check the LED light for POWER, CLAMP and SEQUENCE light on clamp location 1 is ON. If encountered abnormality, STOP the process, CALL the attention of LEADER and WAIT for instruction.</div><div>3. Hold the tape on clamp location 1, make 3 windings then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 2 was ON.</div><div>4. Hold the tape on clamp location 2, make 3 windings then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</div><div>5. Conduct POINT CHECKING before removal from jig.</div></div>		<div></div> <div>Important reminders/Note/s: <i>1. Make sure no GAP between terminal and stopper jig</i> <i>2. Make 2-3 windings for Clamp taping</i></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No missing tape</div>	

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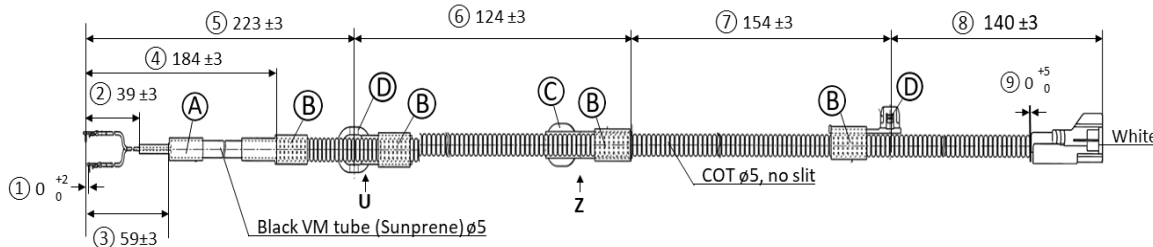
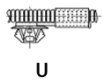
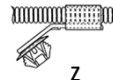
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PARTS:		1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (Y) B - Taping (B) C - Clamp (GR) D - Clamp (W)</div>  		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

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0120-7023A****1** No Wrong facing of clamp**2 3** No Missing Tape (Black tape)

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