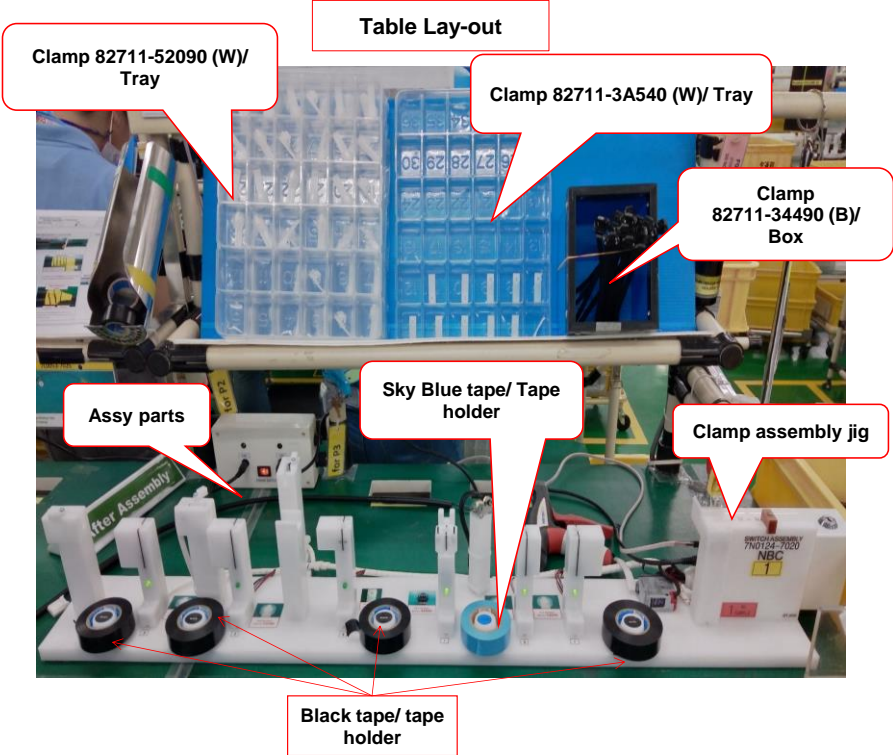




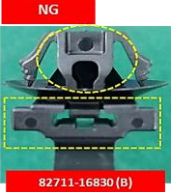
	WORK INSTRUCTION				Effectivity Date:	September 25, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 300D / 7N0124-7020		Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:	WI-ENG-PDE-1012		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 7

PARTS:		1. Clamp 82711-52090 (W); Clamp 82711-34490 (B); Clamp 82711-3A540 (W); Black tape [4pcs]; Sky blue tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy			<p>Safety Instruction Be sure to wear required 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>Bando Gun </p>	<p>Document reference/s: 1. Refer to WI-ENG-PDE-604A-B for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p> <p>CLAMP ILLUSTRATION</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  GOOD 82711-52090 (W) </div> <div style="text-align: center;">  NG 82711-12A80 (W) </div> </div> <p>BAND CLAMP ILLUSTRATION</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  GOOD 82711-34490 (B) </div> <div style="text-align: center;">  NG 82711-16830 (B) </div> </div>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
09/25/24	0	Initial issue. Separate Clamp setting and Clamp assembly from Taping assembly process		D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted

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WORK INSTRUCTION

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 25, 2024

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n/a

Model code/Part number:

300D / 7N0124-7020

Customer:

TRJ

Car Model:

TOYOTA-CROWN

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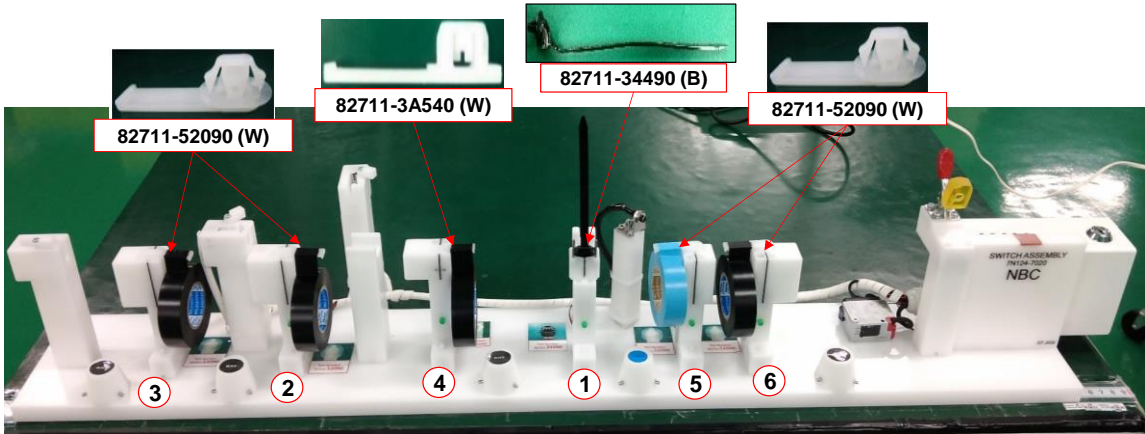
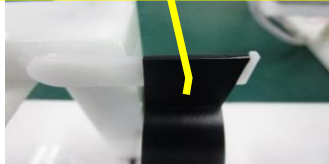
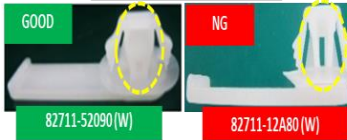
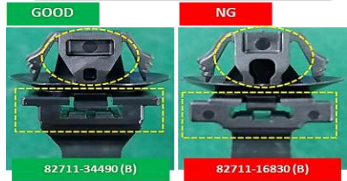
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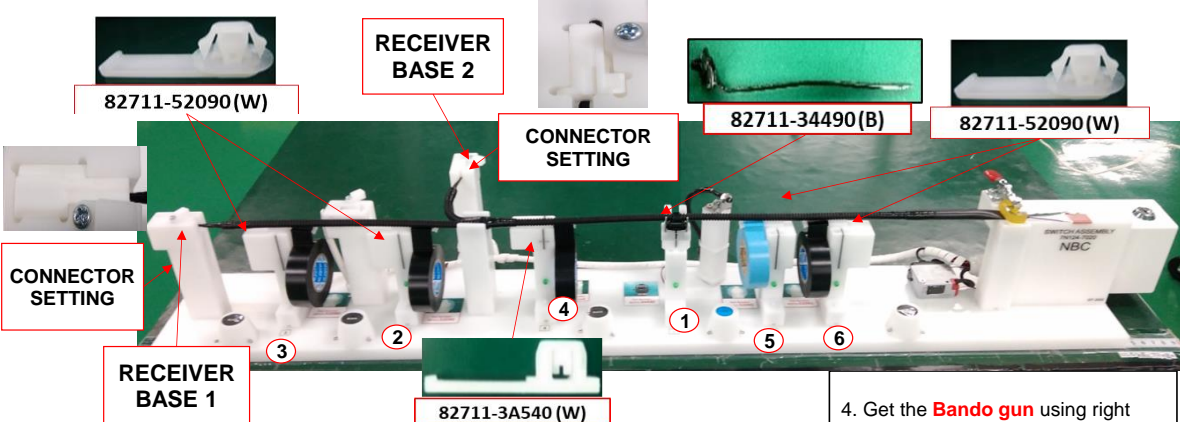


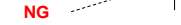

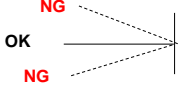

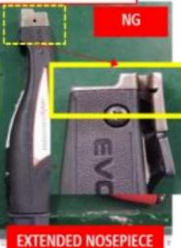



PARTS:		1. 82711-52090 (W) [4pcs] 2. Black tape [5pcs]		3. 82711-3A540 (W) 4. 82711-34490 (B) 5. Sky blue tape		JIG:	Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting					<p>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>STANDARD TAPING FOR CLAMP</p> <p>One wind for under tape</p> 
			1. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 3 and 2 using both hands..		4. Get the clamp 82711-34490 (B) using right hand and insert to clamp location 1 using both hands..		<p>CLAMP ILLUSTRATION</p> 
			2. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 5 and 6 using both hands..		5. Get Sky Blue tape using right hand and conduct pre-taping on clamp location 1		<p>BAND CLAMP ILLUSTRATION</p> 
			3. Get the 1pc of clamp 82711-3A540 (W) using right hand and insert to clamp location 4 using both hands..		6. Get Black tape using right hand and conduct pre-taping on clamp location 2, 3, 4, 5 and 6.		<p>1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp</p>

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DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	September 25, 2024		
	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 300D / 7N0124-7020	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:	WI-ENG-PDE-1012	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	0	Page No.:

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	<div></div> <div><p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness)</i>. First, set the connector 6098-3802 (W) to Receiver Base 1 then lock. Continue to set the harness in jig. Set the connector 6098-3810 (W) to Receiver Base 2 then lock. Continue to set the harness in jig then set the terminal end within the stopper then press by Toggle clamp. Continue if the sequence light on clamp location 1 was ON.</p><p>2. Check if all LED light for POWER ON, CLAMP ON, 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.</p><p>3. Initially tighten the band clamp on clamp location 1 using both hands. <i>Note: Make sure to conduct correct position of Y-Taping to eliminate the wrong alignment of clamp</i></p><p>4. Get the Bando gun using right hand then cut the clamp on location 1 using both hands. Press the SW button after cut. Continue the process if sequence light in clamp location 2 was ON.</p></div> <div><p>BANDO GUN POSITION ON CLAMP LOCATION 1</p><div></div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><div></div><p><i>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</i></p><div></div><p>Fixed setting of band clamp cutter: 1~2</p></div> <div><p>BANDO GUN ILLUSTRATION</p><div></div><p>Y-TAPING POSITION</p><div></div></div>			


Important reminders/note/s:

1. Make sure no gap between stopper jig and terminals.
2. Make 2-3 windings for clamp taping

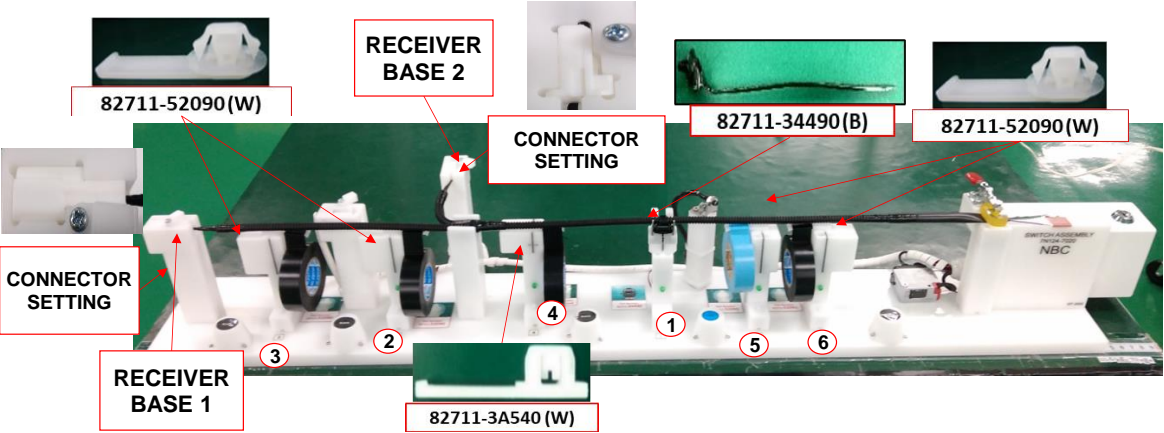
1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape
5. No loose attachment of clamp

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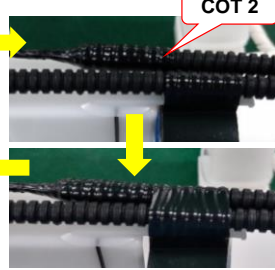
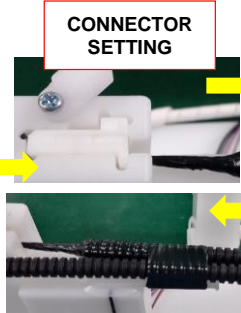

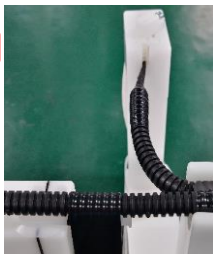
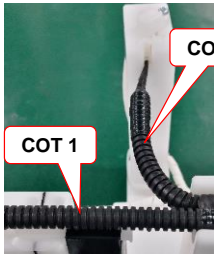
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	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 300D / 7N0124-7020		Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:	WI-ENG-PDE-1012		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 7


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)		




5. On clamp location **2**, conduct **2 windings** of tape on **COT 1** using both hands. (**Do not cut the tape**). Press the **SW button** spot taping. (*See below illustration*)

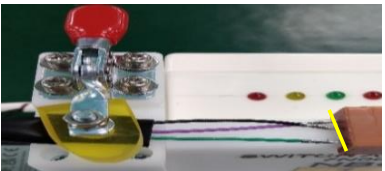
6. After spot taping, remove the connector **6098-3810 (W)** to **Receiver base 2** then combine to **COT1** and set to **Receiver base 3**. (*See below illustration*). Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **3** was **ON**.





Y-TAPING POSITION





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
5. No loose attachment of clamp

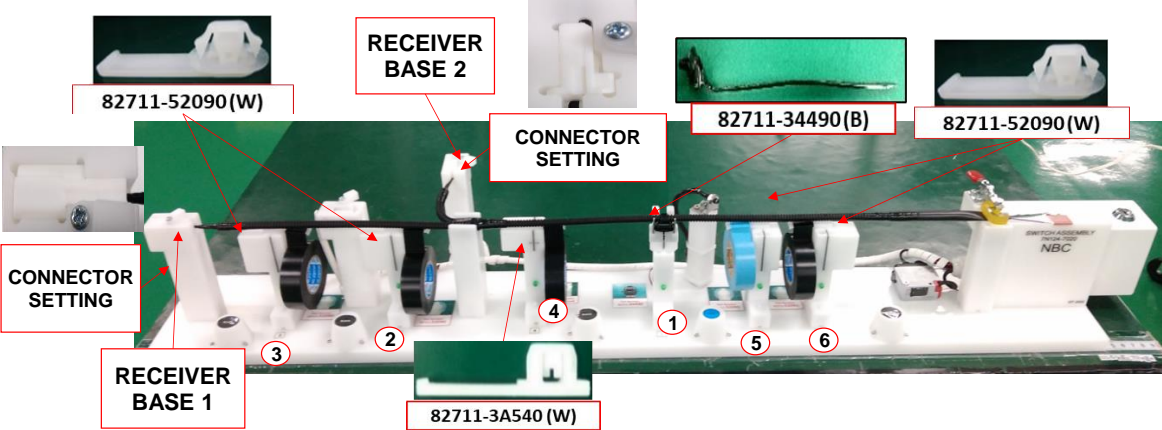


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	WORK INSTRUCTION				Effectivity Date:	September 25, 2024		
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	Model code/Part number: 300D / 7N0124-7020		Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:	WI-ENG-PDE-1012		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	5 of 7

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><p>Important reminders/note/s:</p><ol style="list-style-type: none">1. Make sure no gap between stopper jig and terminals.2. Make 2-3 windings for clamp taping<p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape 5. No loose attachment of clamp</p><div><p>BANDO GUN ILLUSTRATION</p><p>Y-TAPING POSITION</p></div></div> <div><p>7. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</p><p>8. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 5 was ON.</p><p>9. Hold the tape on clamp location 5. Make 3 windings of tape then cut the tape using both hands. Color sensor will beep/buzz if sensor detects Sky Blue tape. Press the SW button after r taping. ntinue the process if sequence light in clamp location 6 was ON.</p><p>10. Hold the tape on clamp location 6. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</p><p>11. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div>

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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>			

MEASURING TAPE

NOTE:

- (A) - Taping (B)
- (B) - Taping (Sky blue)
- (C) - Clamp (W)
- (D) - Clamp (B)
- (6) - dimension of overlapped COT and Sunprene Tube

MEASURING TAPE

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 25, 2024

Validity Date:

n/a

Model code/Part number:

300D / 7N0124-7020Customer: **TRJ**Car Model: **TOYOTA-CROWN**

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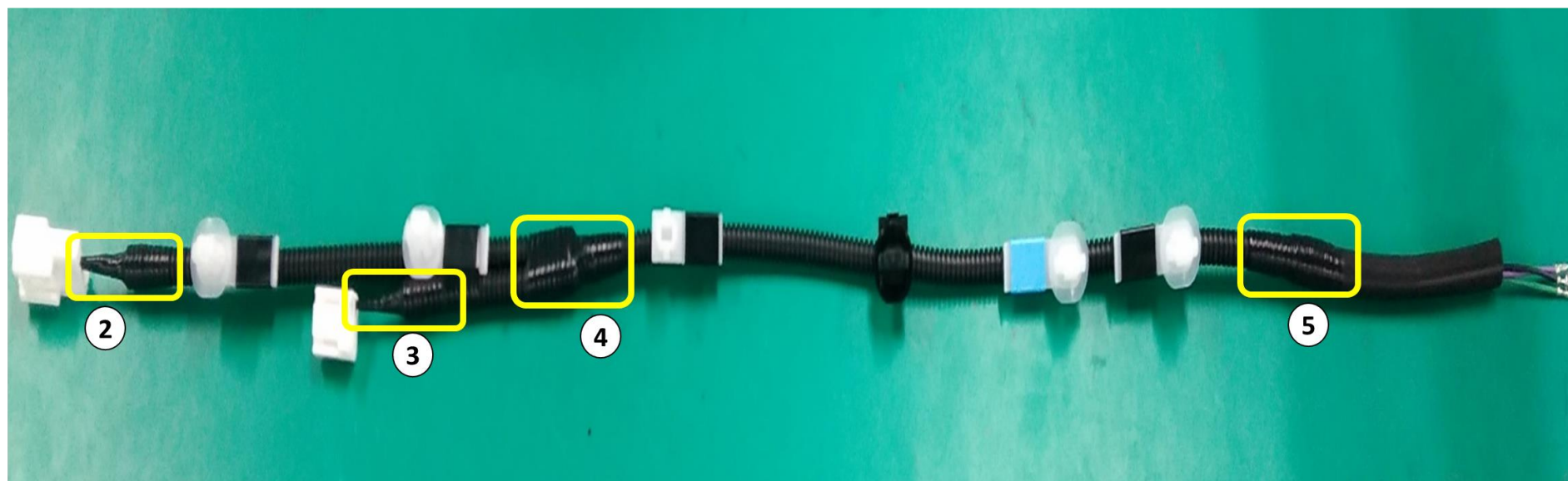
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0124-7020****1 No Wrong facing of clamp****2 3 4 5 No Missing Tape (Black tape)**

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