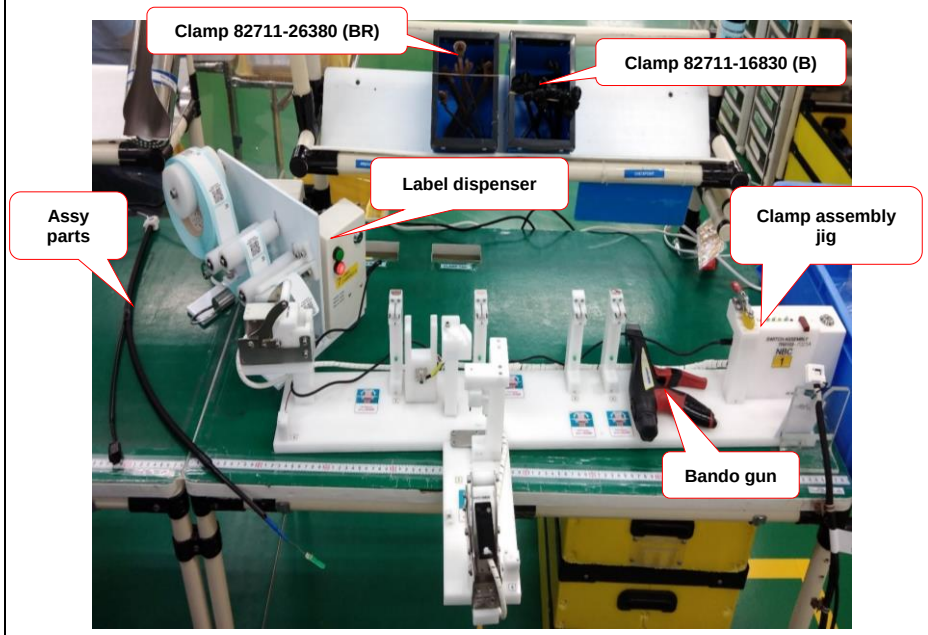
	WORK INSTRUCTION			Effectivity Date:	October 1, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 780B / 7R0103-7023B	Customer: TRMX	Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-1079		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	1 of 8

PARTS:	1. Assy parts; Clamp 82711-26380 (BR); Clamp 82711-16830 (B)	JIG:	1. Clamp assembly jig 2. Label dispenser

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. BANDO GUN	***Document reference/s:*** *1. Refer to **WI-ENG-PDE-542A-C** for Taping assembly process* 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
09/24/24	0	Separate Clamp assy from Taping assembly proces.	D.Castillo	C.Villanueva	A. Arañes	N/A				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2024		

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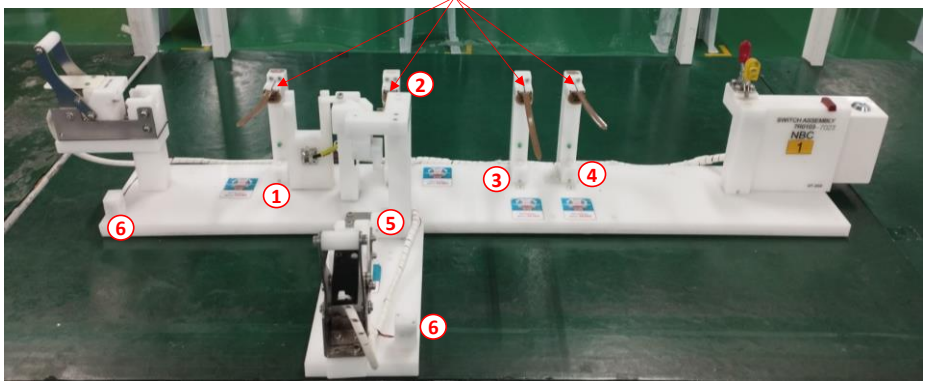
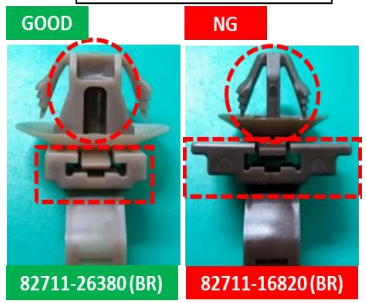
DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 1, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	780B / 7R0103-7023B	Customer: TRMX / Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-1079
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 2 of 8

PARTS:	1. Assy parts 2. Clamp 82711-26380 (BR) [4pcs.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	 82711-26380 (BR)  1. Get 2pcs. of clamp **82711-26380 (BR)** using right hand and set to clamp location **1 and 2** using both hands. 2. Get 2pcs. of clamp **82711-26380 (BR)** using right hand and set to clamp location **3 and 4** using both hands.	n/a	1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts ***Important reminders/Note/s:*** *1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.* BAND CLAMP ILLUSTRATION  GOOD / NG 82711-26380 (BR) / 82711-16820 (BR)

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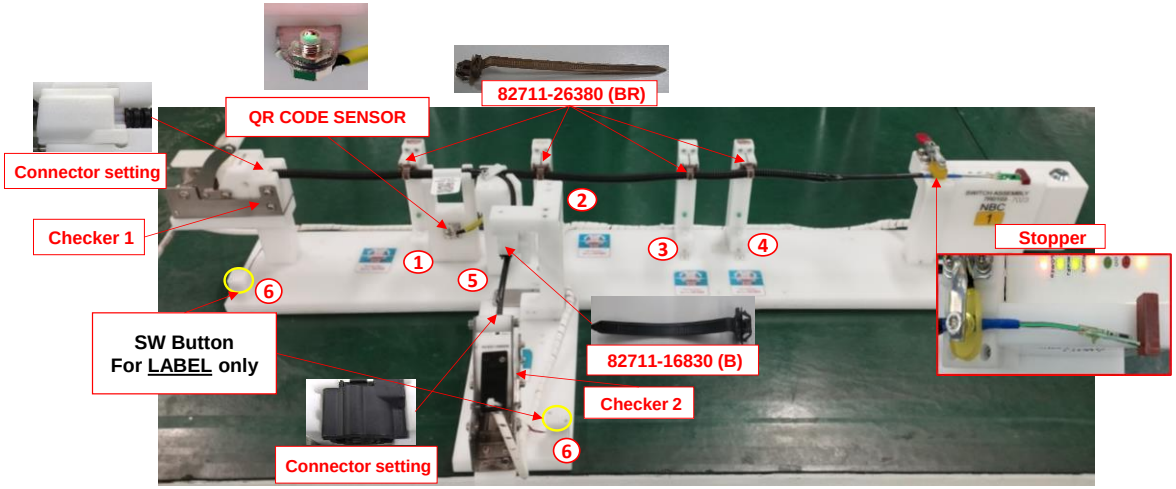
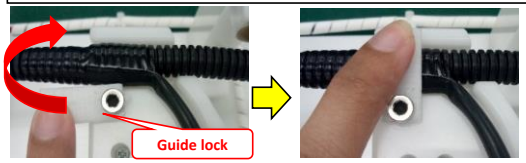
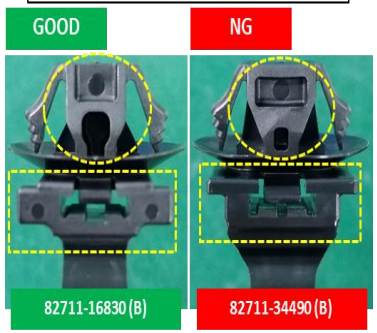
	Process Name/Title:	**CLAMP ASSEMBLY PROCESS**		Validity Date:	**n/a**
	Model code/Part number: **780B / 7R0103-7023B**	Customer: **TRMX**	Car Model: **TOYOTA-TUNDRA**	Document No.:	**WI-ENG-PDE-1079**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 / Page No.: 3 of 8

PARTS:	1. Assy parts 2. Clamp 82711-16830 (B)	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly	 1. Hold the assy parts and then set to jig. ***(See above picture for correct setting).*** First, set the connector **6189-1142 (W)** to **Checker 1** then pull the checker fixture for continuity checking. Continue to set the harness in jig. *(See below illustration for Y-Taping lock.)* Second, set the **PCB** to stopper jig and push down the toggle clamp. Last, set the connector **6189-1161 (B)** to **Checker 2** then push the checker fixture for continuity checking.  2. Using left index finger, push the guide lock to lock the Y-taping portion. 3. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **5** using both hands.		 ***Important reminders/Note/s:*** *1. Make sure no gap between the **PCB** and **stopper jig.*** 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts BAND CLAMP ILLUSTRATION 

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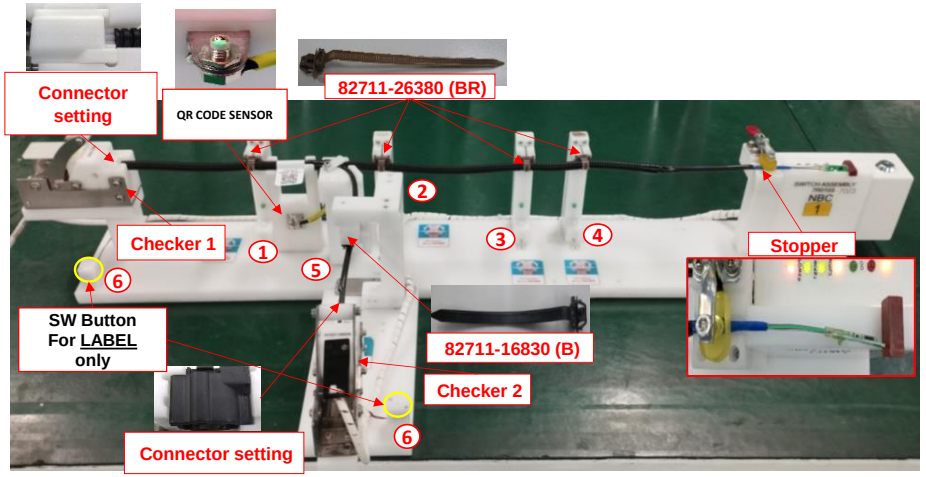
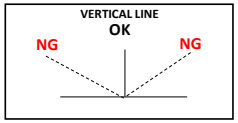
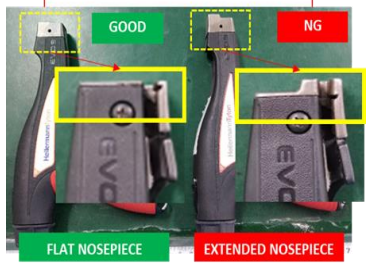
	WORK INSTRUCTION			Effectivity Date:	October 1, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	780B / 7R0103-7023B	Customer: TRMX / Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-1079
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 4 of 8

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)	 5. Initially tighten the band clamp on clamp location **1, 2, 3, 4, and 5** using both hands. 6. Get the Bando Gun using right hand then 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**. 7. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was **ON**. 8. Cut the band clamp on clamp location **3** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **4** was **ON**.  Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4	BANDO GUN 	1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig 6. No wrong use of bando gun ***Important reminders/Note/s:*** *1. Make sure no gap between the **PCB** and **stopper jig.*** BANDO GUN ILLUSTRATION  NO WRONG USE OF BANDO GUN

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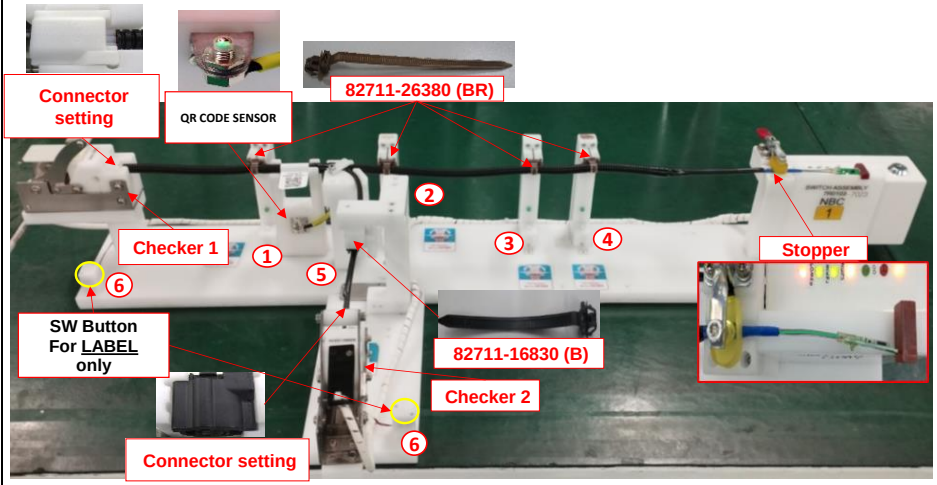
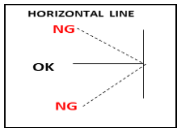
	Model code/Part number: 780B / 7R0103-7023B	Customer: TRMX	Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-1079
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 / Page No.: 5 of 8

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

9. Cut the band clamp on clamp location **4** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **5** was **ON**.



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: ø5 - 1~2, ø7 - 3~4

10. Cut the band clamp on clamp location **5** using both hands. *(See below illustration)*. Press the **SW button** after cutting of band clamp. Continue on label attachment *(Refer to next page for label attachment procedure).*

11. For label attachment, **label sensor** will beep/buzz if detects the **label code**. After attachment, press the **SW button** using both index finger **(same timing). Go** sound will be heard.

BAND CLAMP CUT POSITION FOR 82711-16830 (B)

12. Conduct **POINT CHECKING** before removing the harness from jig.

13. After point checking, remove the harness from toggle clamp, unlock the y-taping guide, remove Cheker 2 up to Checker 1.

Important reminders/Note/s:

*1. Make sure no gap between the **PCB** and **stopper jig.***

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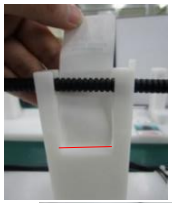
	Model code/Part number:	780B / 7R0103-7023B	Customer: TRMX / Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-1079
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 6 of 8

PARTS:	1. Assy parts 2. Label 7V4020-0020	JIG:	1. Clamp Assembly jig 2. Label Dispenser

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Label attachment		n/a	1. No bubbles 2. No damage 3. No peel off 4. No wrong use of label 5. No missing parts 6. No loose attachment 7. No wrong usage of label

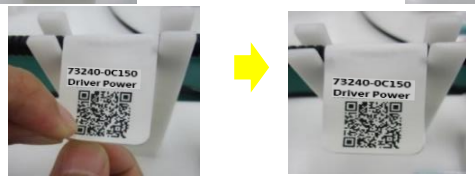
Model	Items	Item Name
7R0102	73240-0C140	Driver Manual
7R0103	73240-0C150	Driver Power
7R0104	73240-0C160	Driver PWR-MEM
7R0105	73230-0C170	Passenger Manual
7R0106	73230-0C180	Passenger Power

1. Get the label.
Note: Check the model code, item no. & name

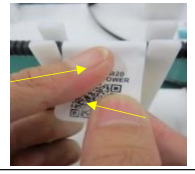


2.Align the end part of label in the jig.

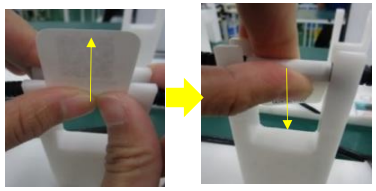
3.Fold the center part of the label.



4. Align both end part of label.



5.After alignment , Press the label with both fingers .



6. Press the label upside down using finger.

GOOD

Acceptable overlap
0~1mm

NG

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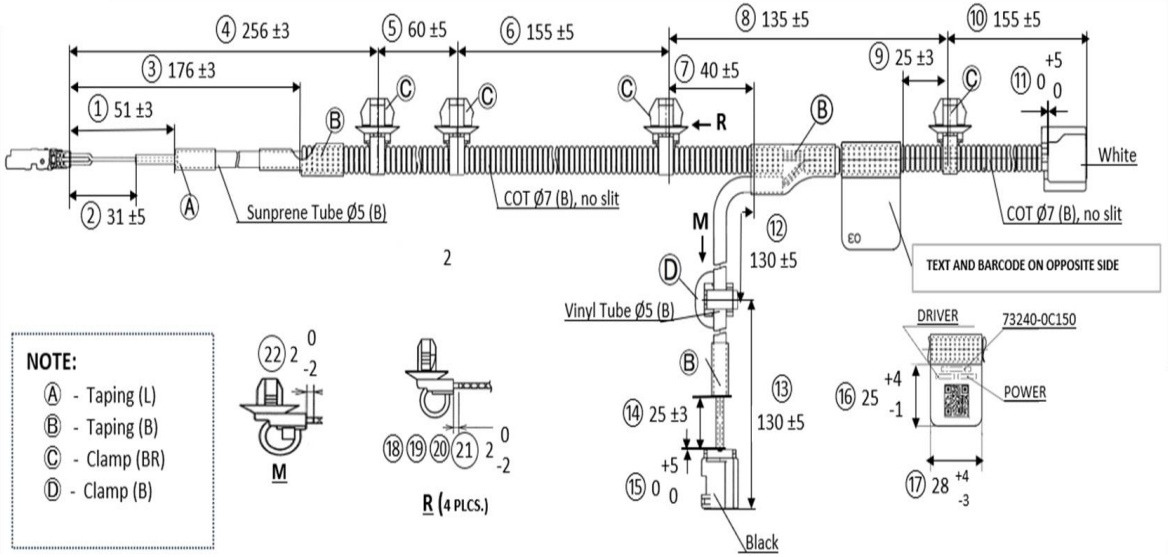
	Model code/Part number: 780B / 7R0103-7023B	Customer: TRMX	Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-1079
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 1	Page No.: 7 of 8

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	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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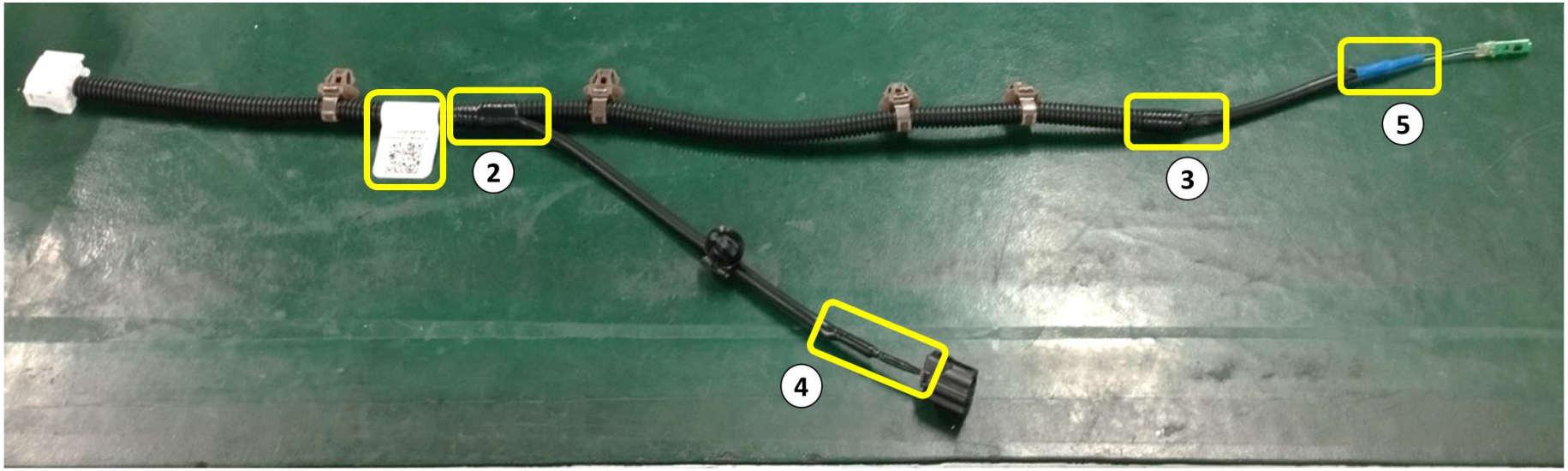
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY	7R0103-7023B



1 No Wrong facing of QR code label

2 3 4 No Missing Tape (Black tape)

5 No Missing Tape (Blue tape)

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