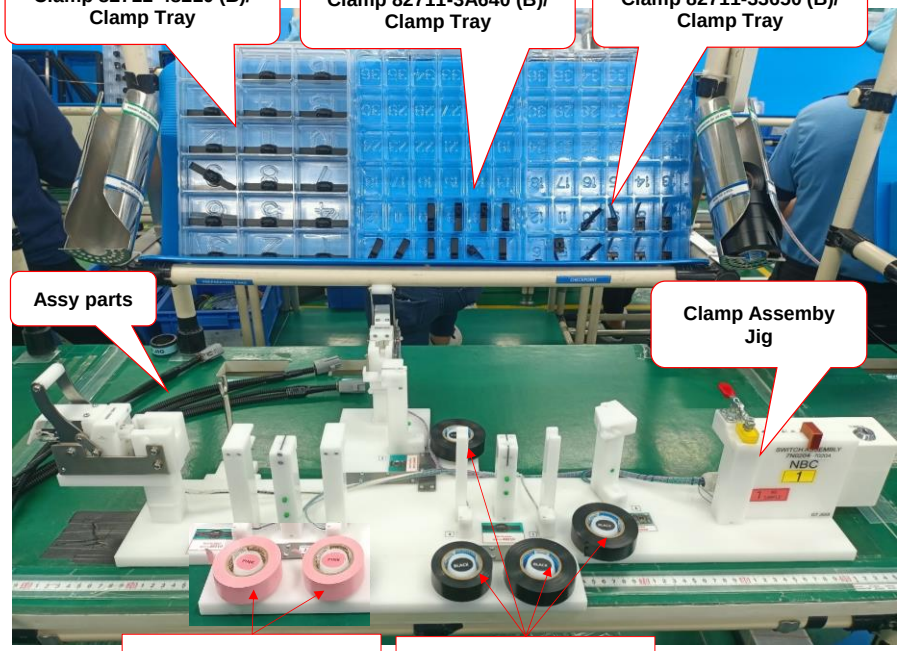
	WORK INSTRUCTION			Effectivity Date:	April 30, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020Ca	Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-881		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	1 of 7

PARTS:	1. All parts: Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-33650 (B); Black tape [4pcs]; Pink tape [2pcs]	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.	***Document references:*** ***1. Refer to WI-ENG-PDE-875 for Taping assembly process*** 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
04/30/24	1	Change Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a
04/26/24	0	Initial issue	D.Castillo	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	April 26, 2024		

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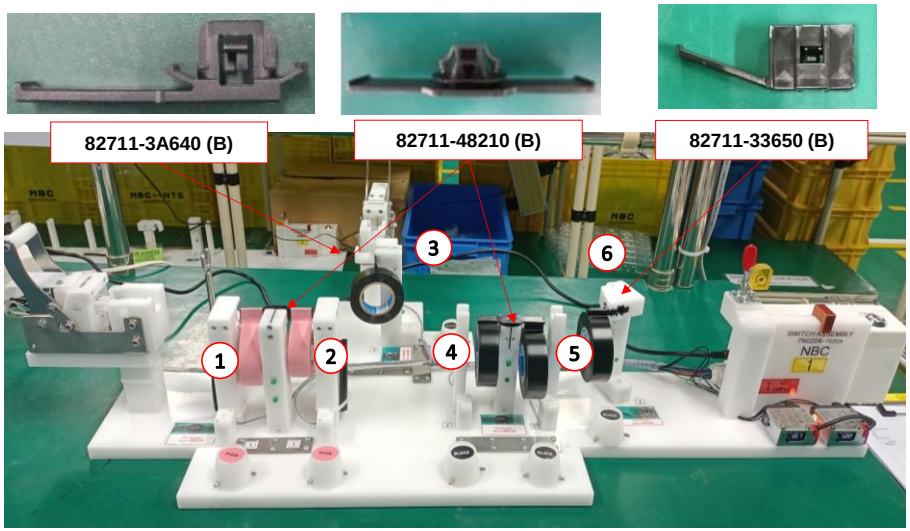
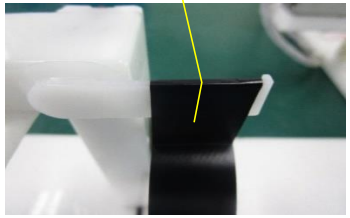
	WORK INSTRUCTION			Effectivity Date:	April 30, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0204-7020Ca	Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-881	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 7

PARTS:	1. Black tape [4pcs] 2. Clamp 82711-33650 (B) 3. Clamp 82711-3A640 (B) 4. Clamp 82711-48210 (B) [2pcs] 5. Pink tape [2pcs]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp Setting	 1. Get 2pcs of clamp **82711-48210 (B)** using right hand and set to clamp location **1,2,4 and 5** using both hands. 2. Get 1pc of clamp **82711-3A640 (B)** using right hand and set to clamp location **3** using both hands. 3. Get 1pc of clamp **82711-33650 (B)** using right hand and set to clamp location **6** using both hands. 4. Initially attach **Pink tape** to clamp location **1 and 2** using both hands. 5. Initially attach **Black tape** to clamp location **3, 4, 5 and 6** using both hands.	n/a	***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 parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position One wind for under tape 

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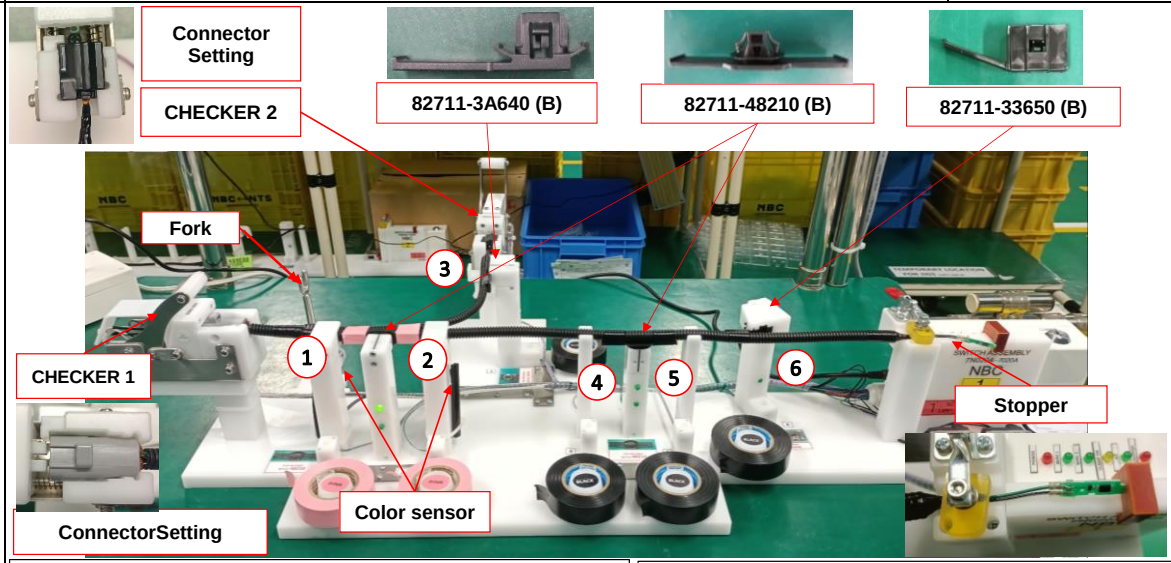
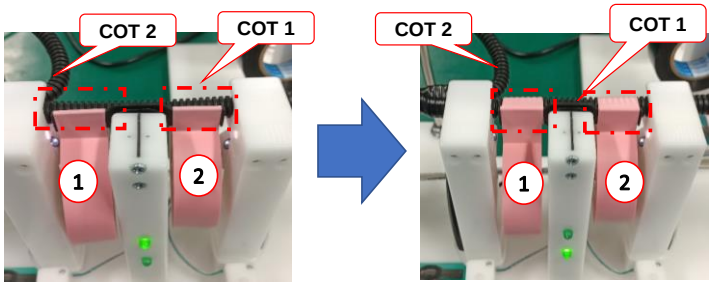
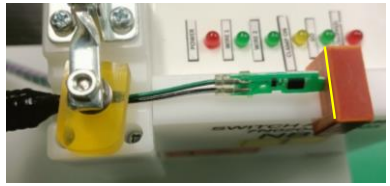
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0204-7020Ca	Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-881	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 3 of 7

PARTS:	1. Assy parts 2. Black tape [6pcs]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly	 1. Put the assy into jig. ***(See above picture for the correct setting).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture. Second, set the connector **6189-1161 (B)** to hook then continue to set the harness in jig. Last, set the **hotmelted** within stopper then press by toggle clamp. 2. Check if all **LED light** for **POWER ON, 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. Hold the tape in clamp location **1**, make **2 windings** of tape using both hands. Color sensor will **ON**, if color sensor detected the Pink tape. Press the switch button. Continue if the sequence light of location **2** was **ON**. Repeat the process to location 2. Press the switch button. Sequence light will **OFF**. *NOTE: DO NOT CUT THE TAPE*		 ***Important reminders/Note/s:*** ***1. Make sure no gap between terminal and stopper jig*** 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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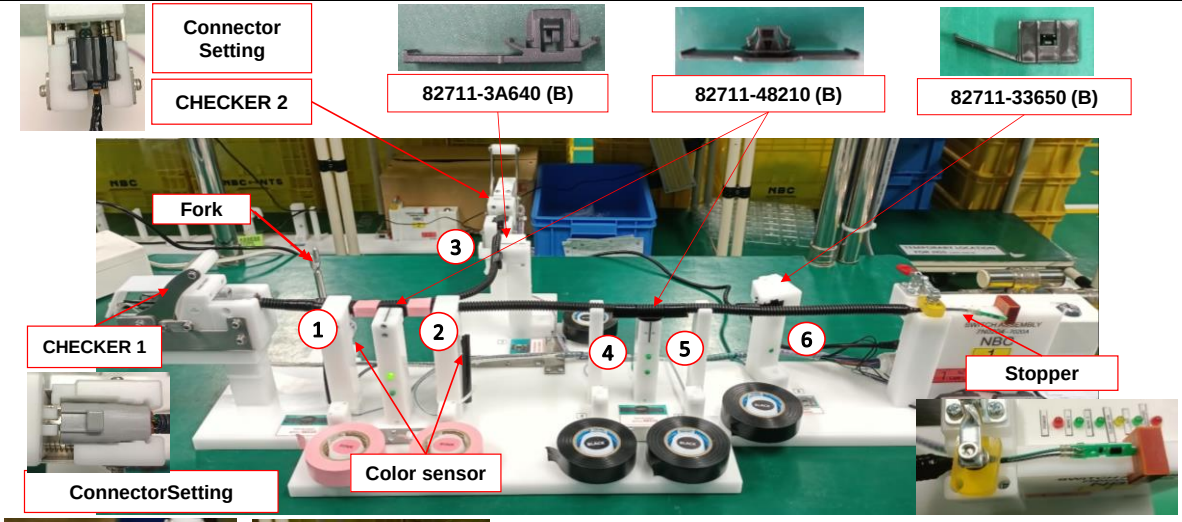
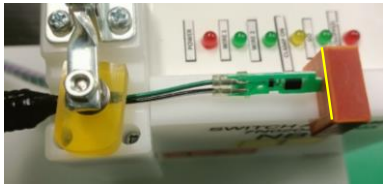
	WORK INSTRUCTION				Effectivity Date:	April 30, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	930B / 7N0204-7020Ca	Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-881		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	4 of 7

PARTS:	1. Assy parts 2. Black tape [4pcs]	3. Pink tape [2pcs]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)	 4. After taping of clamp location **1** and **2**. Get the COT 2 and set the connector in **Checker 2** then pull the checker fixture for Continuity testing. 5. Check if all **LED light** for **Wire 1 and Wire 2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process. Continue the process if the sequence light on location **1** was **ON**. 6. Hold the tape in clamp location **1**, make **2 windings** of tape using both hands then cut the tape.Color sensor will **ON**, if color sensor detected the Pink tape. Press the switch button. Continue if the sequence light of location **2** was **ON.** 7. Hold the tape in clamp location **2**, make **2 windings** of tape using both hands then cut the tape. Color sensor will **ON**, if color sensor detected the Pink tape. Press the switch button. Continue if the sequence light of location **3** was **ON.** 8. Hold the tape in clamp location **3**, make **2 windings** of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location **4** was **ON.**		 ***Important reminders/Note/s:*** ***1. Make sure no gap between terminal and stopper jig*** 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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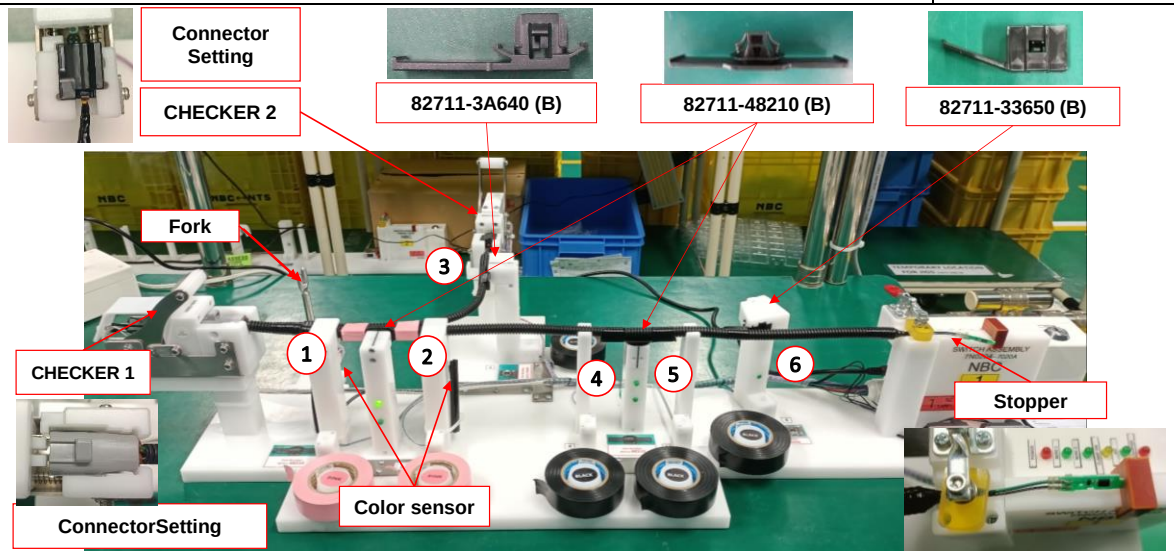
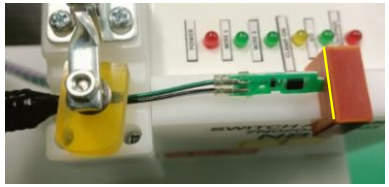
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO				Revision No.:	1	Page No.:	5 of 7

PARTS:	1. Assy parts 2. Black tape [4pcs]	3. Pink tape [2pcs]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)	 9. Hold the tape in clamp location **4**, make **2 windings** of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location **5** was **ON.** 10. Hold the tape in clamp location **4**, make **2 windings** of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location **5** was **ON.** 11. Hold the tape in clamp location **5**, make **2 windings** of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location **6** was **ON.** 12. Hold the tape in clamp location **6**, make **2 windings** of tape using both hands then cut the tape. Press the switch button. **GO** buzzer will be heard**.** 13. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.		 ***Important reminders/Note/s:*** ***1. Make sure no gap between terminal and stopper jig*** 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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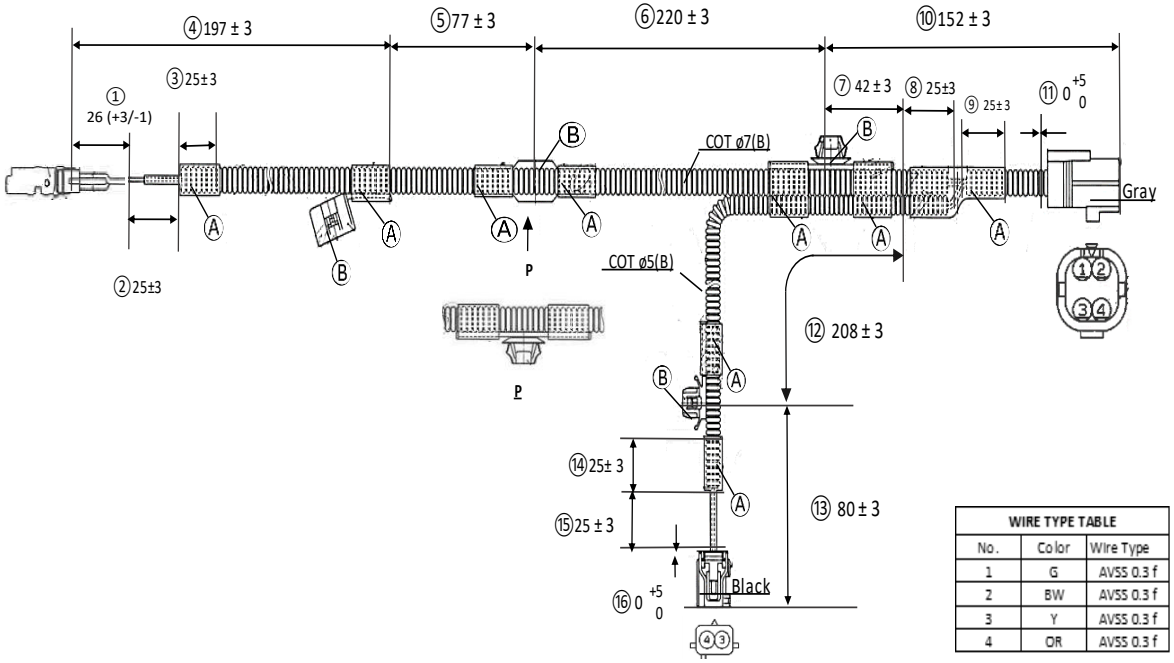
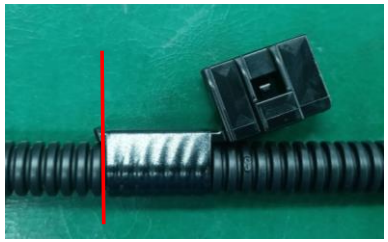
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO				Revision No.:	1	Page No.:	6 of 7

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 **Note: Measurement should be on END TAPE** 

WIRE TYPE TABLE		
No.	Color	Wire Type
1	G	AVSS 0.3 f
2	BW	AVSS 0.3 f
3	Y	AVSS 0.3 f
4	OR	AVSS 0.3 f

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PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION

CLAMP ASSY	7N0204-7020C

① Check the alignment

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