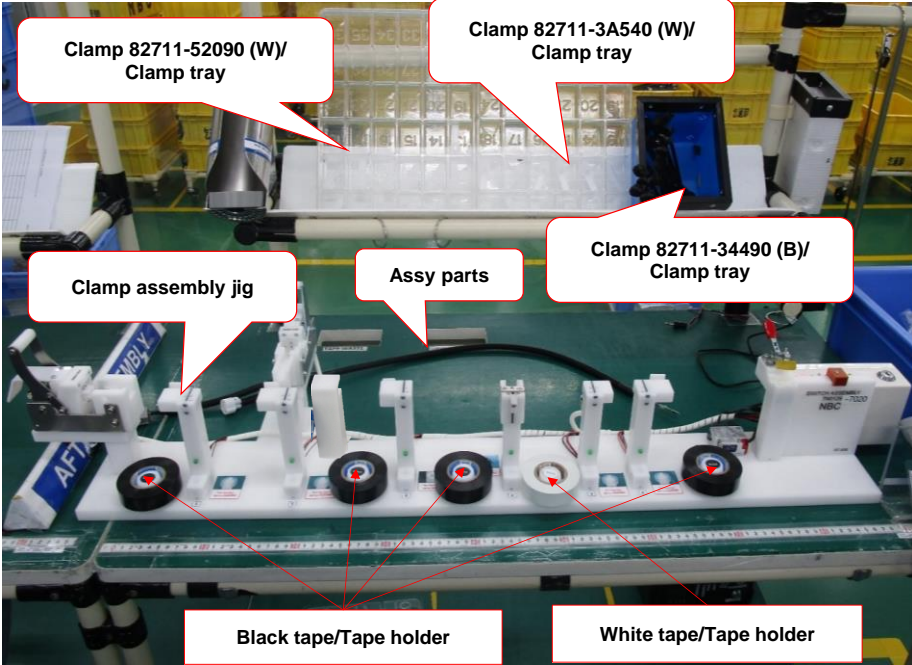



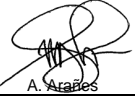
	WORK INSTRUCTION					Effectivity Date:		July 18, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS					Validity Date:		n/a	
	Model code/Part number: 178D / 7N0129-7021A		Customer: TRJ	Car Model: TOYOTA COROLLA	Document No.:		WI-ENG-PDE-973		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		0	Page No.:

PARTS:		1.Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape [4pcs.]; White tape [1pc.]			JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div><div>TABLE LAY-OUT</div></div>			<div><div>Safety Instruction Be sure to wear prescribed 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><div>BANDO GUN </div></div>		<div>Document reference/s: 1. Refer to WI-ENG-PDE-463A-B for Taping assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
07/18/24	0	Initial issue. Separate clamp assy from Taping assembly process.					D.Castillo	C.Villanueva	A. Arañes	N/A				n/a	
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	Est. Date:	July 18, 2024			

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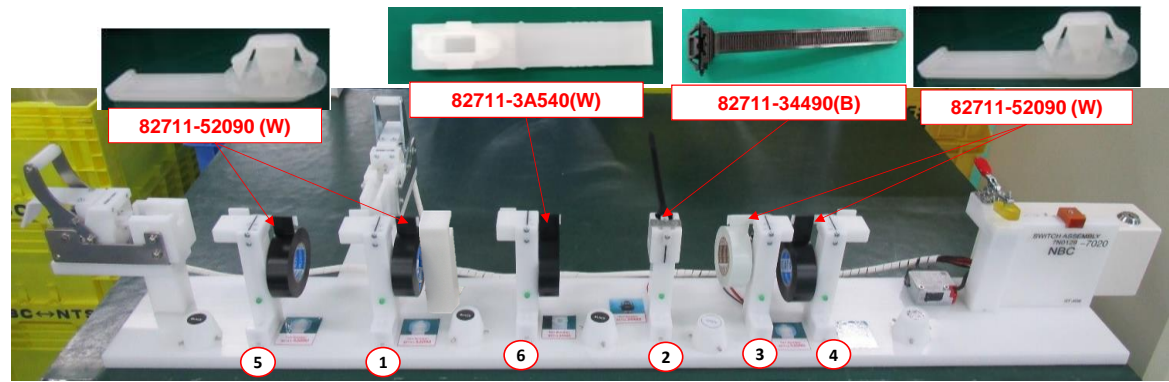
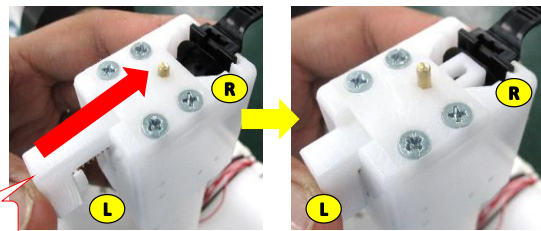
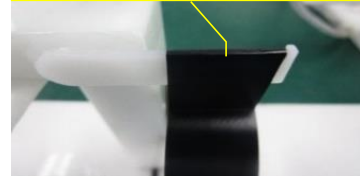


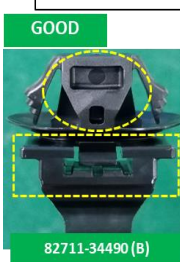
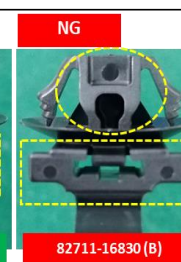
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Revision No.:

0

Page No.:

2 of 7

PARTS:	1. Clamp 82711-52090 (W) [4pcs.] 2. Clamp 82711-3A540 (W) 3. Clamp 82711-34490 (B)	4. Black tape [4pcs.] 5. White tape	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div data-bbox="548 375 1713 758"></div> <div data-bbox="571 805 1713 1332"><div><p>1. Get 2 pcs. of clamp 82711-52090 (W) using both hands then insert to clamp location 5 and 1 using both hands.</p><p>2. Get 2 pcs. of clamp 82711-52090 (W) using both hands then insert to clamp location 3 and 4 using both hands.</p><p>3. Get 1 pc. of clamp 82711-3A540 (W) using right hand then insert to clamp location 6 using both hands.</p><p>4. Get 1 pc. of clamp 82711-34490 (B) using right hand then insert to clamp location 2 using both hands.</p><p>5. Get the White tape then initially attach to clamp location 3 using both hands.</p><p>6. Get the Black tape then initially attach to clamp location 5, 1, 6 and 4 using both hands.</p><div data-bbox="1164 1101 1702 1332"></div></div></div>		<div data-bbox="1736 375 2094 486"><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div> <div data-bbox="1736 486 2094 534"><p>STANDARD TAPING FOR CLAMP</p></div> <div data-bbox="1736 534 2094 774"><p>One wind for under tape</p></div> <div data-bbox="1736 790 2094 869"><p>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p></div> <div data-bbox="1736 869 2094 1029"><p>CLAMP ILLUSTRATION</p><div><div>GOOD </div><div>NG </div></div><p>82711-52090 (W) 82711-12A80 (W)</p></div> <div data-bbox="1736 1029 2094 1332"><p>BAND CLAMP ILLUSTRATION</p><div><div>GOOD </div><div>NG </div></div><p>82711-34490 (B) 82711-16830 (B)</p></div>

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Effectivity Date:

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Validity Date:

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Model code/Part number:

178D / 7N0129-7021A

Customer:

TRJ

Car Model:

TOYOTA COROLLA

Document No.:

WI-ENG-PDE-973

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:


3 of 7

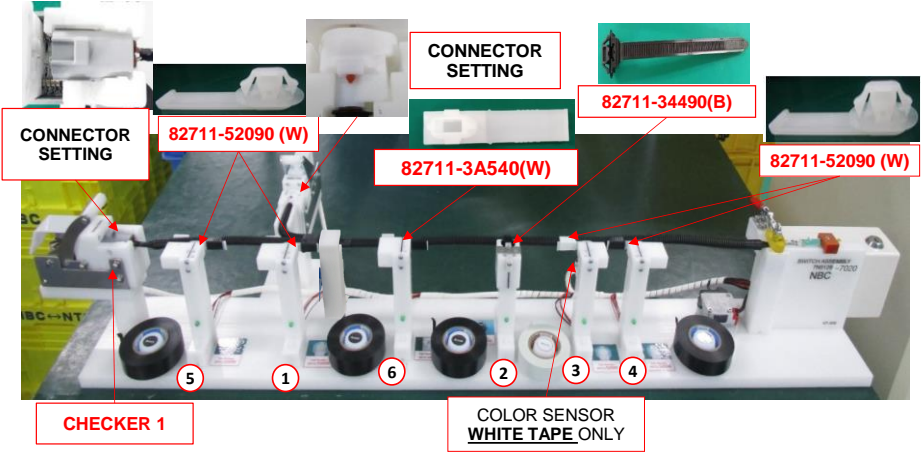





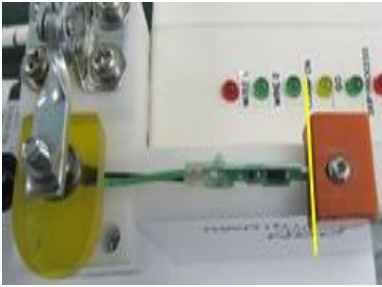
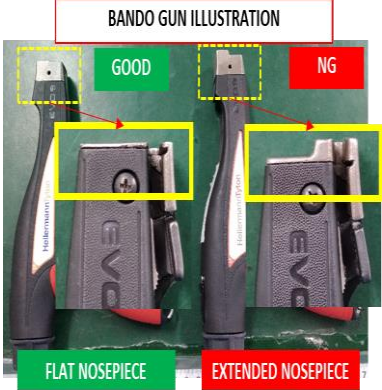
PARTS:		1. Assy parts 2. Black tape 3. White tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp assembly			
		<div><p>CONNECTOR SETTING</p><p>CHECKER 1</p><p>COLOR SENSOR WHITE TAPE ONLY</p></div> <div><p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p></div> <div><div><p>82711-34490(B)</p><p>GOOD</p><p>LOCKED</p><p>TOGGLE</p><p>UNLOCKED</p><p>TOGGLE</p><p>82711-34490(B)</p><p>NG</p></div><div><p>NOTE: On clamp location 2, if clamp 82711-34490 (B) is locked and the toggle clamp is set, the process will proceed. If clamp 82711-34490 (B) is unlock and the toggle clamp is set, the process will not proceed and NG buzz will be heard.</p></div></div>			<div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div> <div></div> <div><p>Important reminders/Note/s: 1. <i>Make sure no gap between stopper jig and PCB.</i></p></div> <div><p>CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div> <div><p>BAND CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-16830 (B)</div></div></div>

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		Model code/Part number: 178D / 7N0129-7021A		Customer: TRJ		Car Model: TOYOTA COROLLA		Document No.: WI-ENG-PDE-973	
		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 3. White tape		JIG:		1. Clamp assembly jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
3		Clamp Assy Clamp assembly (Continuation)		<div>  </div> <div> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>3. Hold the tape on clamp location 1, make 3 windings of tape 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.</p> <p>4. Initially tighten the band clamp on clamp location 2 using both hands.</p> <p>5. Get the bando gun using right hand then cut the band clamp on location 2 using both hands. Press the SW button after cut. Continue the process if sequence light on clamp location 3 was ON.</p> <div>   </div> <p>NOTE: Pin must be hit during cutting of bando gun.</p> <div>   <p>Fixed setting of band clamp cutter: 1~2</p> </div> <p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p> </div> <div>  </div>		<div>  <p>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB.</p> </div> <div>  </div>			

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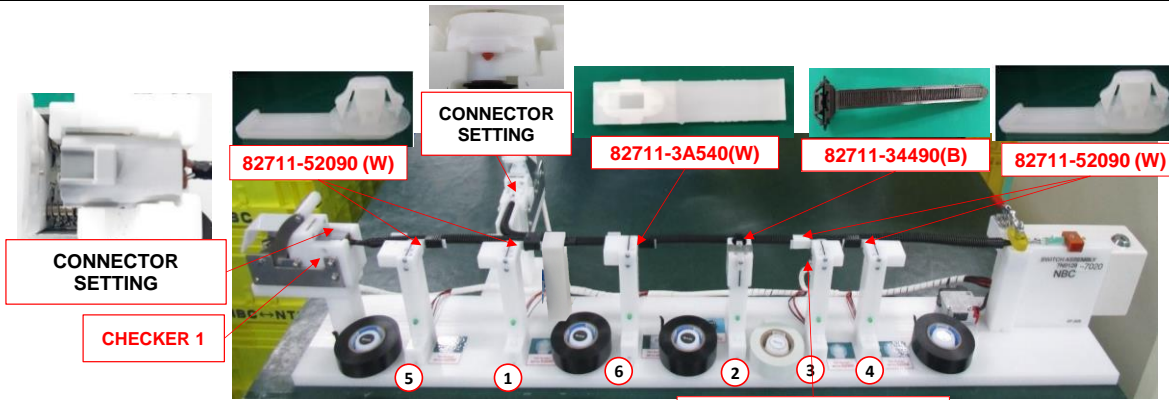



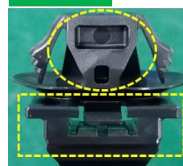

☒ MASSPRO

Revision No.:

0

Page No.:

5 of 7

PARTS:		1. Assy parts 2. Black tape 3. White tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp assembly (Continuation)	<div><div></div><div><div><p>6. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Color sensor light will beep/buzz if sensor detects White tape. Press the SW button after taping. Continue the process if sequence light on clamp location 4 was ON.</p></div><div><p>7. 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 on clamp location 5 was ON.</p></div><div><p>8. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 6 was ON.</p></div><div><p>9. 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></div><div><p>10. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div></div></div> <div><div><p>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB. 2. Make 2-3 windings for clamp taping.</p></div><div><div><p>CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div><div><p>BAND CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-16830 (B)</div></div></div></div></div>			

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Document No.:

WI-ENG-PDE-973

Purpose:


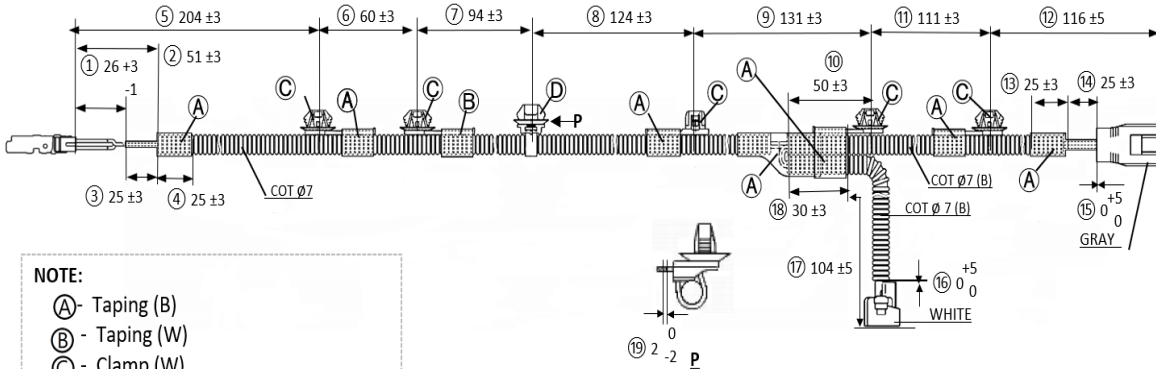
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Revision No.:

0

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	<div><div>MEASURING TAPE</div></div>  <div><p>NOTE:</p><ul style="list-style-type: none">Ⓐ - Taping (B)Ⓑ - Taping (W)Ⓒ - Clamp (W)Ⓓ - Clamp (B)① - Dimension tolerance is internal control only</div>		<p>Important reminders/Note/s:</p> <p>1. FOR HATSUMONO AND OWARIMONO.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</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 dimension</p>

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Document No.:

WI-ENG-PDE-973

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

7 of 7

PARTS:

1. Assy parts

JIG:

N/A

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0129-7021A****1** No Wrong facing of clamp**2 3 4** No Missing Tape
(Black tape)

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