NBC	**WORK INSTRUCTION**				Effectivity Date:		**December 21, 2023**
	Process Name/Title:	**CLAMP ASSEMBLY PROCESS**			Validity Date:		**n/a**
	Model code/Part number:	**200D/220D /7R0126-7021**	Customer: **TRMX**	Car Model: **TOYOTA-SEQUIOA**	Document No.:		**WI-ENG-PDE-760**
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0 Page No.:	1 of 6

PARTS:	1. All parts: Assy parts; Clamp 82711-16830 (B)		JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Layout	**Table Lay-out** Clamp 82711-16830 (B)/ Clamp box; Clamp assembly jig; Assy parts; Bando dun	**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 references:* *1. Refer to WI-ENG-PDE-568 7R0126-7021 - Taping Assembly Process* 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
12/21/23	0	Initial issue. Transfer Clamp setting to Measurement process from Taping assembly process (WI-ENG-PDE-568)					D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change					Revised D. Castillo	Reviewed C. Villanueva	Approved A. Arañes	Noted n/a
							Est. Date:	**December 21, 2023**		

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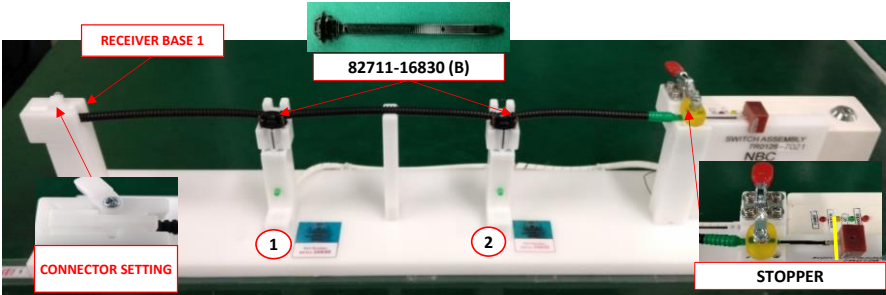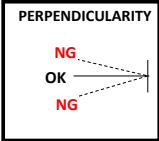
PARTS:	1. Clamp 82711-16830 (B) [2pcs.]		JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Clamp setting	**82711-16830 (B)** ① ② 1. Get 2pcs. of clamp **82711-16830 (B)** using right hand and set to clamp location **1 and 2** 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 damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp **BAND CLAMP ILLUSTRATION** GOOD NG 82711-16830 (B) 82711-34490 (B)

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Model code/Part number:	**200D/220D /7R0126-7021**	Customer: **TRMX** Car Model: **TOYOTA-SEQUIOA**	Document No.:	**WI-ENG-PDE-760**
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PARTS:	1. Assy parts		JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Clamp assembly	RECEIVER BASE 1 — 82711-16830 (B) — STOPPER — CONNECTOR SETTING — ① ② **1.** Get the assy parts and set into jig. *(See above picture for correct setting).* First, set the connector **6098-3802 (W)** to **Receiver base 1**. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of **location ①** was on. **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.** Initially tighten the band clamp on location **1 and 2** using both hands. **4.** Get the bando gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cut. Continue the process if sequence light on clamp location **2** was **ON.** **5.** Cut the band clamp on location **2** using both hands. Press the **SW button** after cut. **Go** sound will be heard. PROPER CUTTING POSITION OF BANDO GUN — GOOD / IMPROPER CUTTING POSITION OF BANDO GUN — NG **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4** PERPENDICULARITY — NG / OK / NG — Fixed setting of band clamp cutter: 1~ 2 **6.** Conduct **POINT CHECKING** before removing the harness from jig.	**BANDO GUN**	***Important reminders/Note/s:*** ***1. Make sure no gap between stopper and terminals*** 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts **BANDO GUN ILLUSTRATION** GOOD / NG FLAT NOSEPIECE EXTENDED NOSEPIECE

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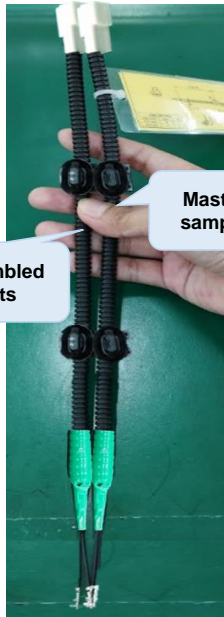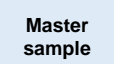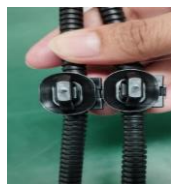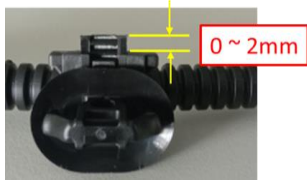
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PARTS:	1.Assy parts	JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 — Visual/By Two's Inspection	**ACTUAL PRODUCT** Master sample Assembled parts 2. Check the **terminal, connector lock** condition and **insertion.** 3. Check the **presence of clamp attachment.** 1. Conduct alignment of harness **(Master sample vs. assembled parts)** using both hands. 4. Check the **taping condition** and **terminal appearance.** Must be **no deformed terminal.**		**MASTER SAMPLE** 1.No skip process 0 ~ 2mm **Important reminders/Note/s:** *1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.*

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PARTS:	n/a		JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5 P1	Measurement	**MEASURING TAPE** 196±5mm 185±3mm 185±3mm 0~5mm		**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

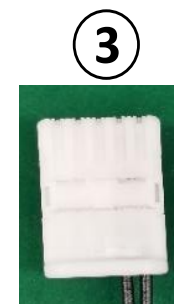| | **WORK INSTRUCTION** | | Effectivity Date: | | **December 21, 2023** |
NBC	Process Name/Title:	**CLAMP ASSEMBLY PROCESS**	Validity Date:		**n/a**
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| **PARTS:** | n/a | | **JIG:** | n/a |

QUALITY CHECKPOINTS

P1 — 7R0126-7021
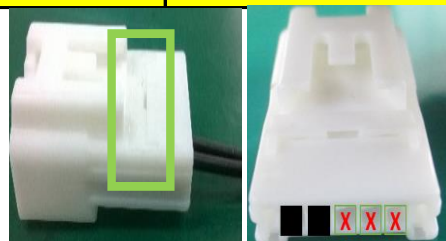
GOOD

GOOD
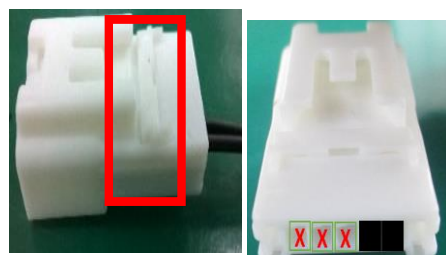
NO GOOD

NO GOOD

GOOD

NO GOOD

① No **Unlock connector**

② No **Wrong insert**
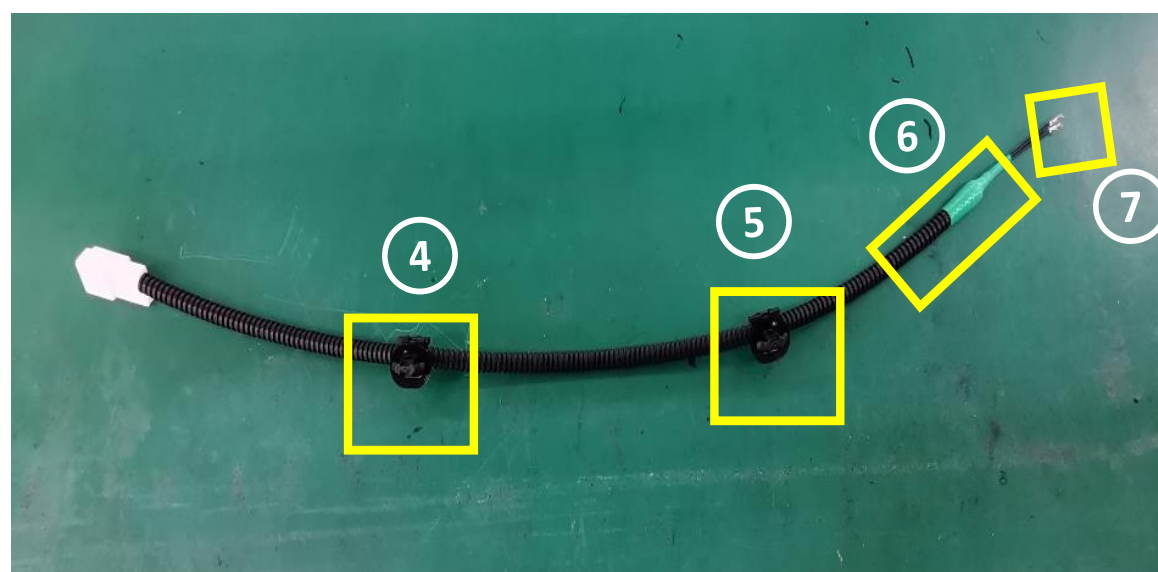
③ No **Terminal Backing Out**

④ ⑤ No **Missing Band clamp**

⑥ No **Missing Tape (G)**

⑦ No **Deformed Terminal**

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