

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Model code/Part number:

920B / 7R0116-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-921

Purpose:

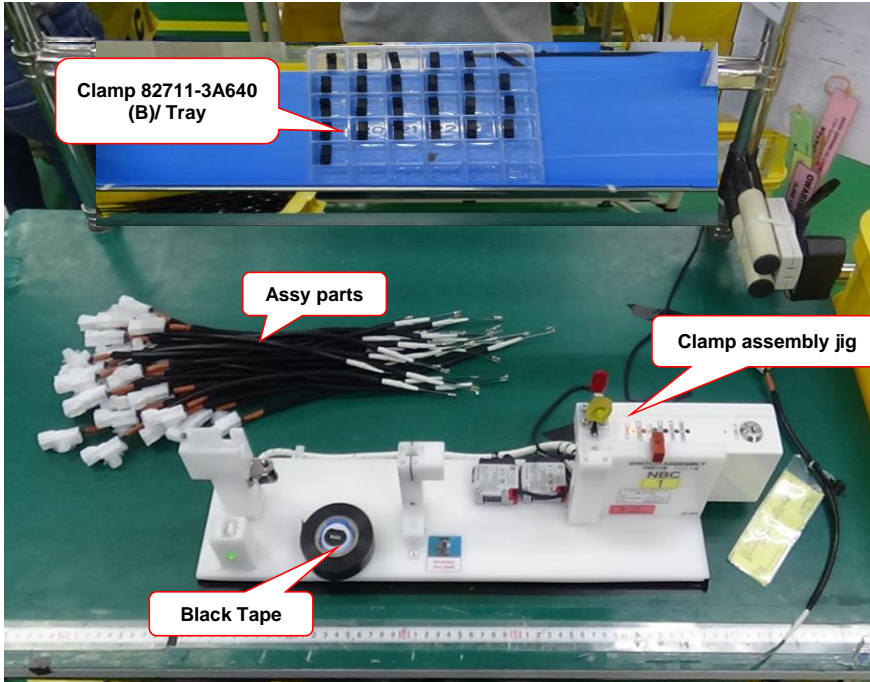
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


1 of 6

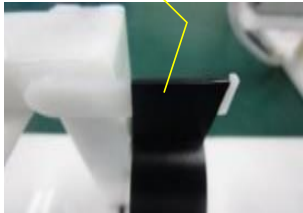
PARTS:	1. Assy parts: Clamp 82711-3A640 (B) ; Black tape				JIG:	1. Clamp assembly jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	Clamp Assy	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (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>Document reference/s: 1. Refer to WI-ENG-PDE-650A-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	
06/24/24	0	Initial issue. Separate Clamp setting, Connector lock an Clamp assembly from P2 (WI-ENG-PDE-650B).				D. Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Est. Date:	June 24, 2024			

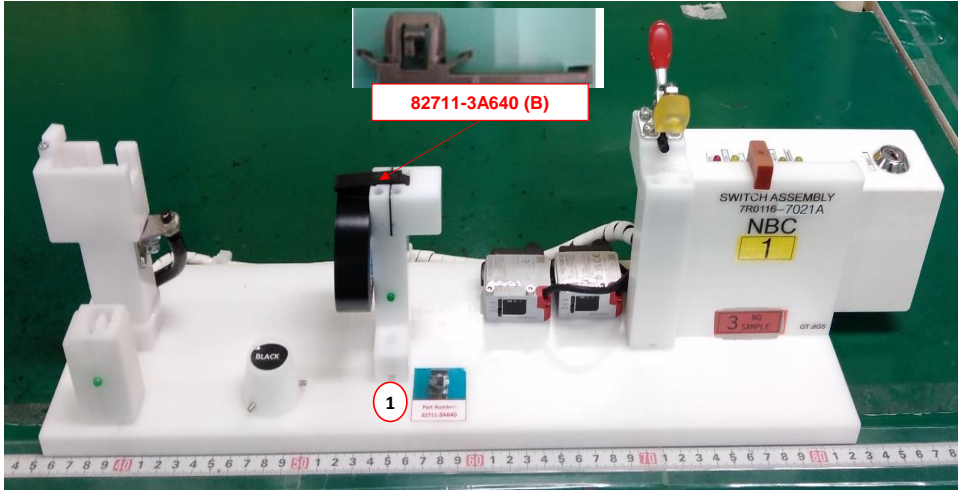
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	June 24, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 920B / 7R0116-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-921		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 6

PARTS:	1. Clamp 82711-3A640 (B) 2. Black tape			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting			<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div>  <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</div>



1. Get 1pc. of clamp 82711-3A640 (B) using both hands then set to clamp location 1 using both hands.

2. Initially attach Black tape on clamp location 1 using both hands.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0116-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-921

Purpose:

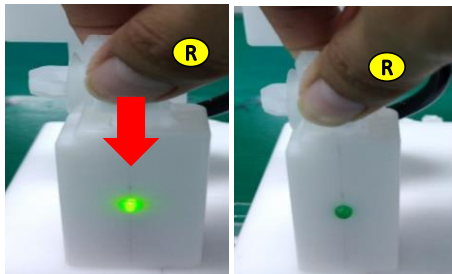
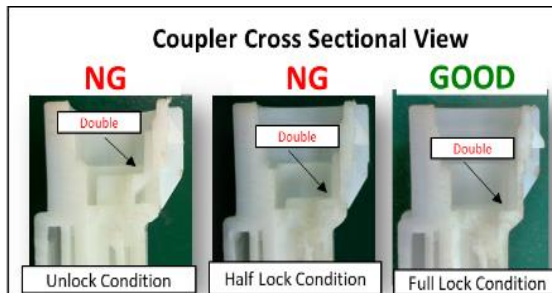
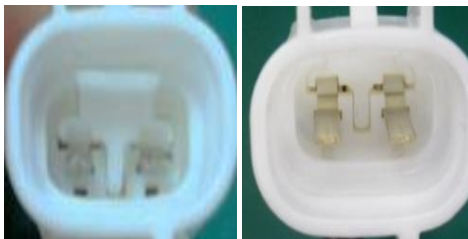
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


3 of 6

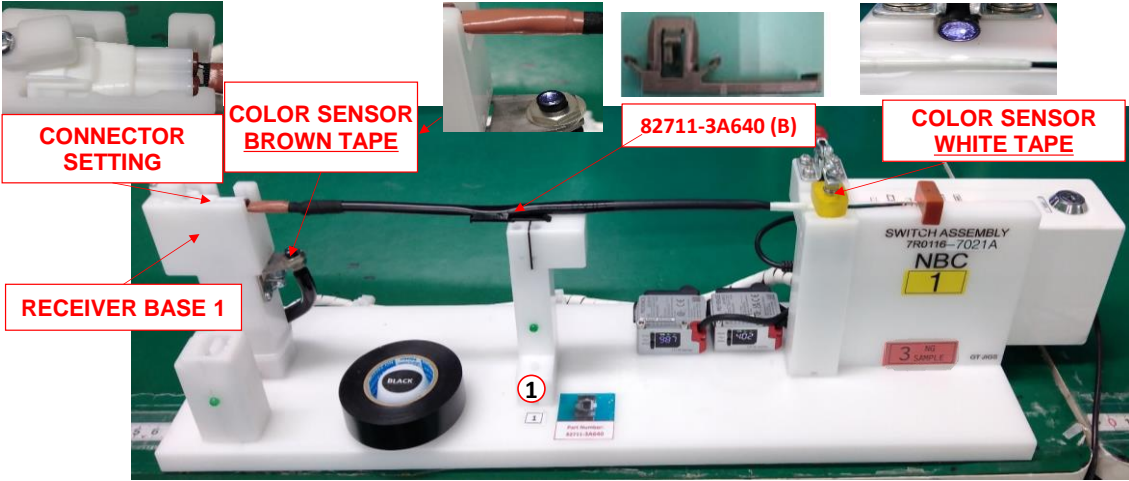

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</div><div><div>LOCKING JIG</div><div><div>Before lock After lock</div></div></div></div>			Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use the provided locking jig per model 2. No unlock/half-locked connector

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	June 24, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 920B / 7R0116-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-921		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 6

PARTS:	1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	Clamp Assy	Clamp assembly			 <p>Important reminders/Note/s: 1. Make sure no gap in stopper and terminals</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>
		<div>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Brown tape. Color sensor light will beep/buzz if sensor detects White tape. Last, set the terminal end together within the stopper then press by Toggle clamp.</div> <div>2. Check if all LED light for Power On, Clamp ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div> <div>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. Go sound will be heard.</div> <div>4. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>			

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Model code/Part number:

920B / 7R0116-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-921

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 6

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Clamp Assy	<div>Measurement</div> <div><div>Measuring tape</div></div> <div><p>NOTE:</p><ul style="list-style-type: none">Ⓐ - Taping (B)Ⓑ - Taping (W)Ⓒ - Clamp (B)Ⓓ - Clamp (W)Ⓔ - Taping (BR) ***Check the presence of spot tape</div> <div><p>Important reminders and note/s:</p><ol style="list-style-type: none">Please use calibrated/verified measuring tape when getting the measurement.For Hatsumono, Nakamono and Owarimono.<p>Document reference/s:</p><ol style="list-style-type: none">Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection<p>1. No wrong dimension</p></div>		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0116-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-921

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

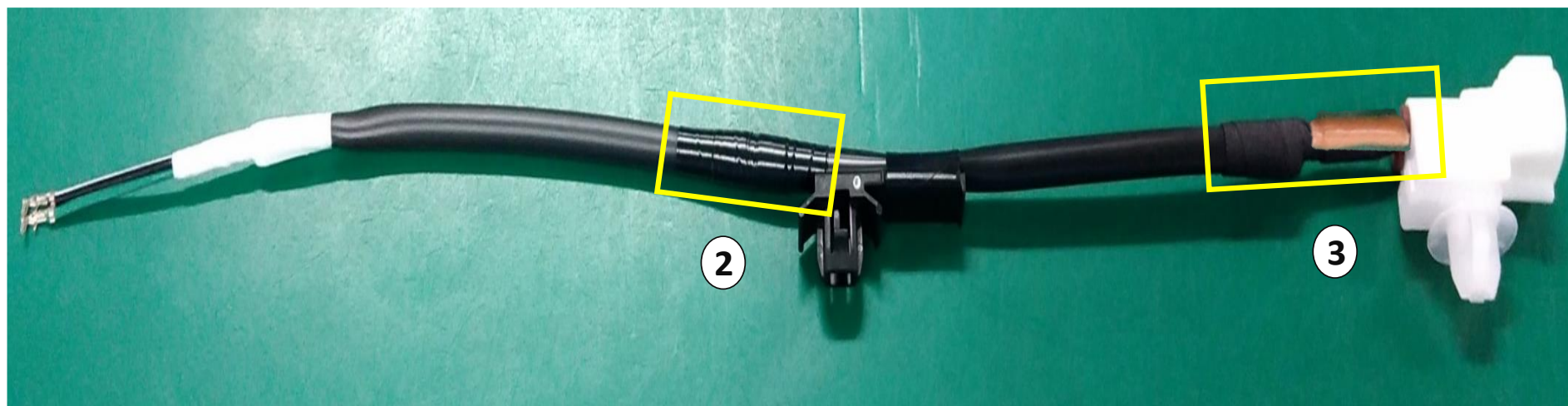
Page No.:

6 of 6**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7R0116-7021A****① No Wrong facing of clamp****② No Missing tape (Black Nitto tape)****③ No Missing tape (Black Tesa tape)**

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp