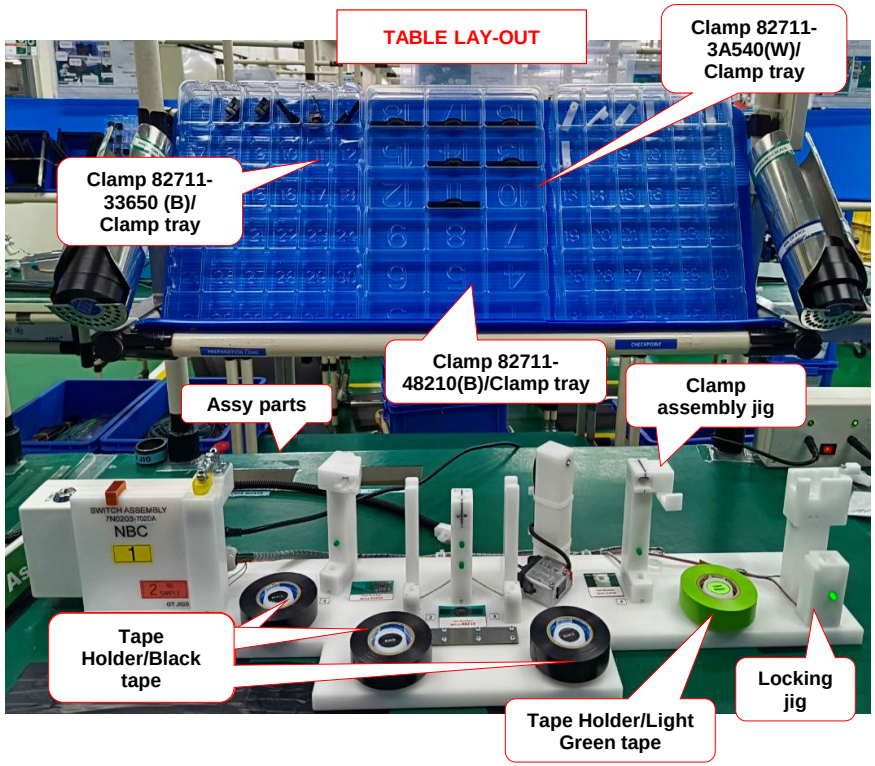
	WORK INSTRUCTION			Effectivity Date:	November 4, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	930B / 7N0203-7020B	Customer: TRJ / Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-1140		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	1 of 6

PARTS:	1. Assy parts; Clamp 82711-33650 (B); Clamp 82711-3A540(W); Clamp 82711-48210(B); Black tape [3pcs]; Light Green	JIG:	1. Clamp assembly jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	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 reference/s:*** *1. Refer to **WI-ENG-PDE-1139** 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
11/04/24	1	Change form purpose form pre-launch to Masspro	M. Ariola	C.Villanueva	A. Arañes	n/a
10/29/24	0	Initial issue	M. Ariola	C.Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Ariola	C. Villanueva	A. Arañes	n/a
Est. Date:	October 29, 2024		

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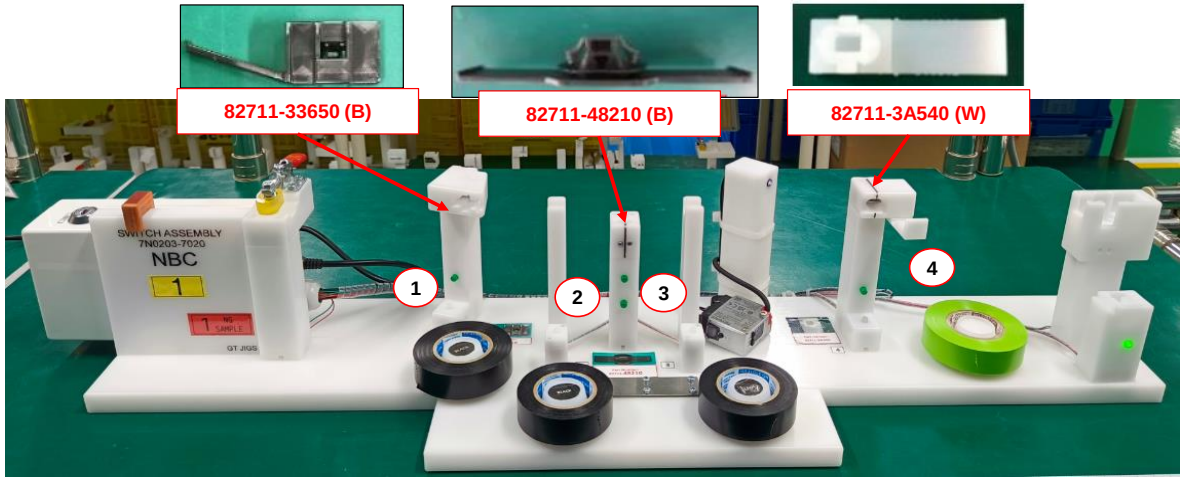
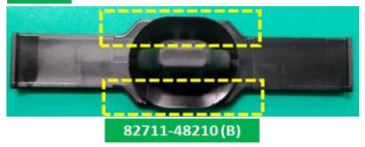
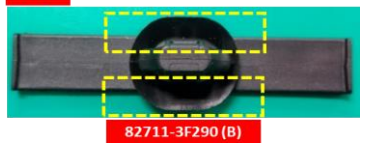
DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	November 4, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0203-7020B	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-1140	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 6

PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B) 3. Clamp 82711-3A540 (W) 4. Black tape [3pcs] 5. Light green tape	JIG:	1. Clamp assembly jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	 1. Get **1pc** of clamp **82711-33650 (B)** using right hand then set to Clamp location no.**1** using both hands. 2. Get **1pc** of clamp **82711-48210 (B)** using right hand then set to Clamp location no. **2 and 3** using both hands. 3. Get **1pc** of clamp **82711- 3A540 (W)** using right hand then set to Clamp location no.**4** using both hands. 4. Initially attach **GREEN TAPE** to **location 4** using both hands. 5. Initially attach **BLACK TAPE to location 1, 2, and 3** using both hands.		***Important reminders/Notes*** ***1. Please check the clamp first before start of clamp 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 CLAMP ILLUSTRATION GOOD  NG 

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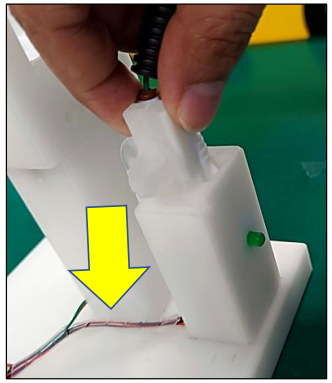
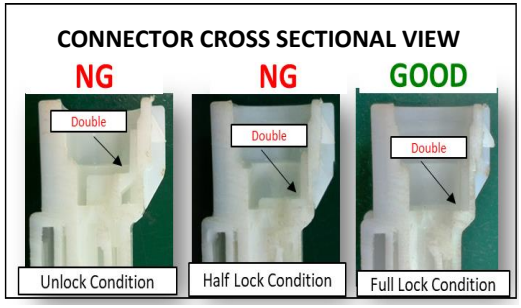
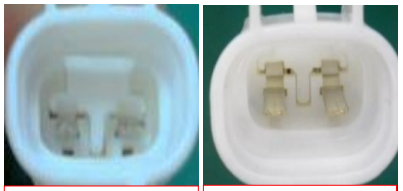
	WORK INSTRUCTION			Effectivity Date:	November 4, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	930B / 7N0203-7020B	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-1140	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 3 of 6

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Connector lock	 1. Put the connector into locking jig using right hand then press to lock **2x.** Check the connector lock if properly locked.   Before lock After lock		1. Use the provided locking per model 2. No unlock/half-locked connector

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	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 930B / 7N0203-7020B	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-1140		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	4 of 6

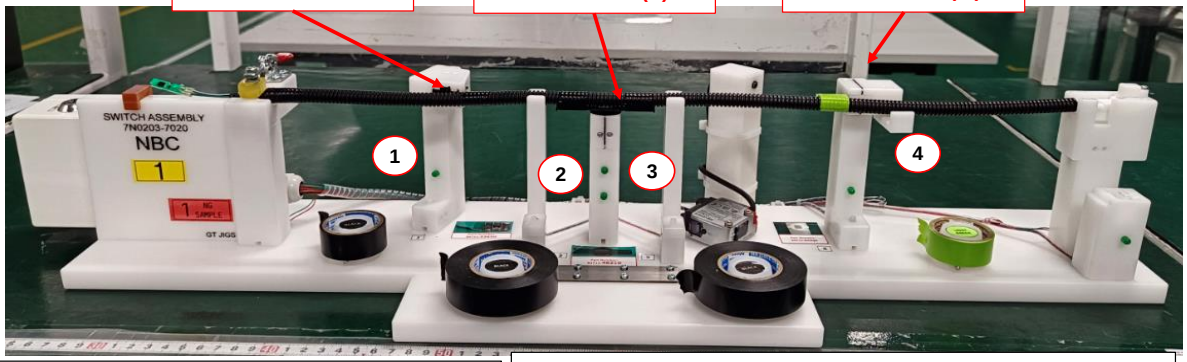
PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B) 3. Clamp 82711-3A540 (W) 4. Black tape [3pcs] 5. Light green tape	JIG:	1. Clamp assembly jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Clamp setting			

82711-33650 (B)

82711-48210 (B)

82711-3A540 (W)



1. Get the assy part and set to jig.***(See above picture for the correct setting)***. First, set the connector **6189-0407 (W)** to **Receiver base 1** and lock. Continue to set the harness in jig. Last, set **B/W-G wires with PCB** end together within stopper then press by toggle clamp.

2. Check if **LED light** for **POWER ON** and **CLAMP ON** was **ON**. Check also the clamp location 1 sequence light is **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader, **WAIT** for further instruction then continue the process.

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 if sequence on clamp **location 2** was **ON**.

4. Hold the tape on clamp **location 2**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue if sequence on clamp **location 3** was **ON**.

5. Hold the tape on clamp **location 3**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue if sequence on clamp **location 4** was **ON**.

6. 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**. Go** sound will be heard.

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

8. After point checking, remove the harness. Start from toggle clamp up to clamp, unlock and remove to connector receiver base.

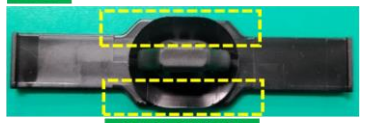
Important reminders/Notes

1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.
2. Make 2-3 windings for clamp taping.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

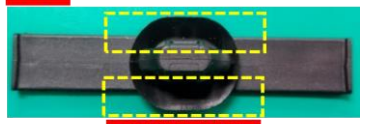
CLAMP ILLUSTRATION

GOOD



82711-48210 (B)

NG



82711-3F290 (B)

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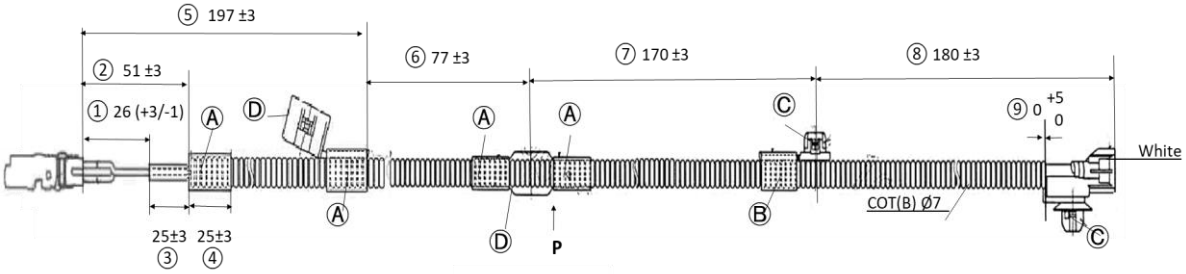
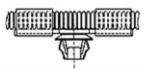
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 5 of 6

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	Measurement	 **NOTE:** Ⓐ - Taping (B) Ⓑ – Taping(LG) Ⓒ - Clamp (W) Ⓓ - Clamp (B) *Unit of measurement is in millimeter  P	**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

QUALITY CHECKPOINTS

CLAMP ASSY	7N0203-7020B

1 **No Wrong Facing of Clamp**

2 **No Missing Tape (Black Tape)**

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