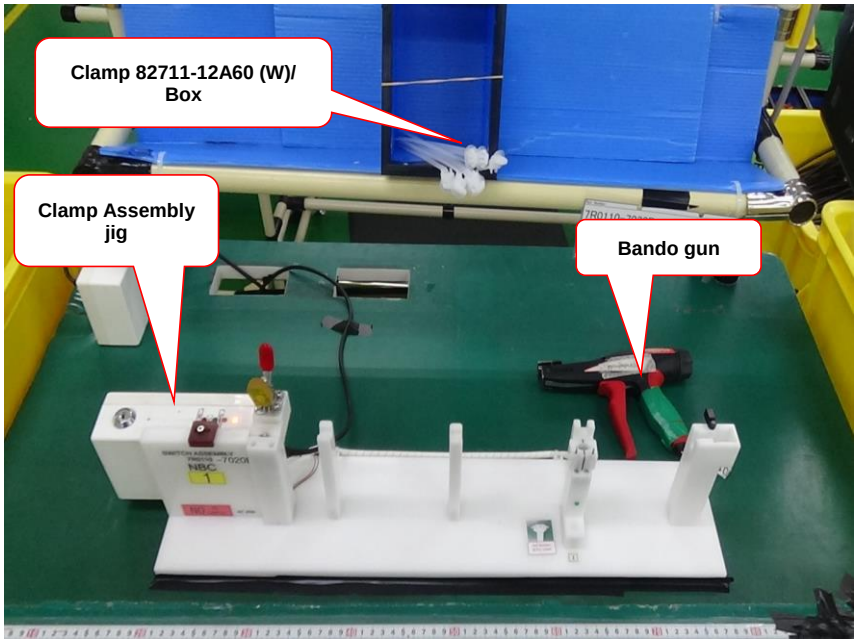
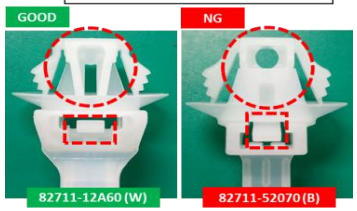
NBC	WORK INSTRUCTION			Effectivity Date:	June 11, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	660B / 7R0110-7020B	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.: WI-ENG-PDE-780
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.: 0	Page No.: 1 of 5

PARTS:	1. All parts: Assy part; Clamp 82711-12A60 (W)	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 work place 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** **Extended nosepiece**	***Document references:*** ***1. Refer to WI-ENG-PDE-321 Taping Assembly Process*** 1. No missing parts/tools 2. No excess parts/tools BAND CLAMP ILLUSTRATION  BANDO GUN ILLUSTRATION

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
06/11/24	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:	June 11, 2024		

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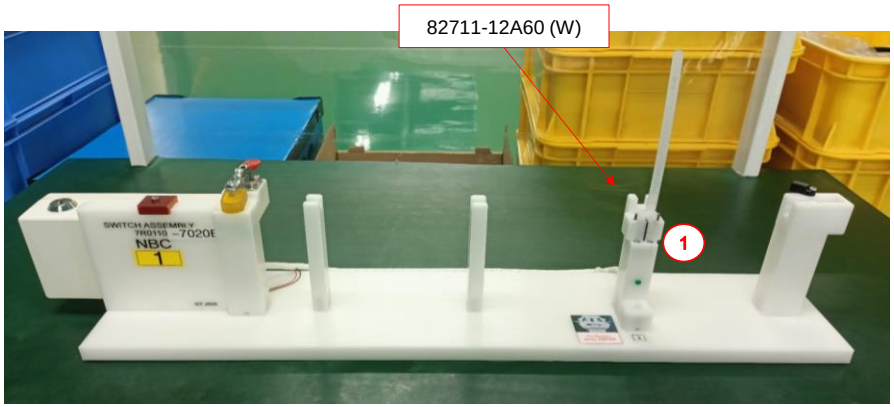
DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	660B / 7R0110-7020B	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-780	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 2 of 5

PARTS:	1. Clamp 82711-12A60 (W)			JIG:	1. Clamp Assembly Jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	Clamp Assy	Clamp Setting	  1. Get 1pc of clamp 82711-12A60 (W) then insert to clamp **location 1** using both hands.	n/a	 1. No wrong use of clamp 2. No missing clamp 3. No damaged clamp

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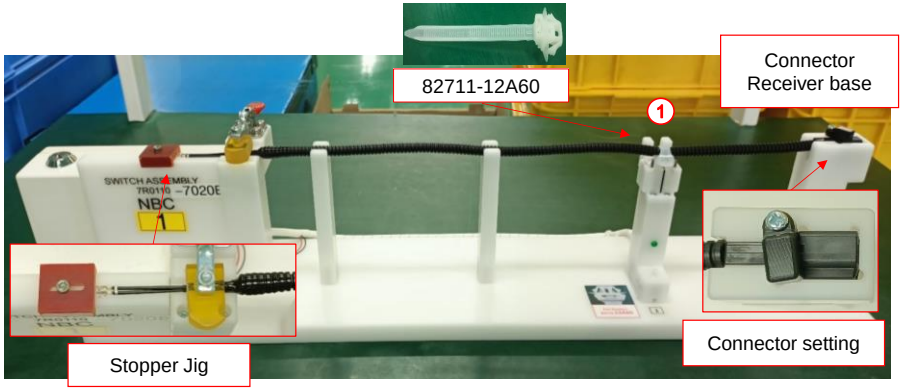
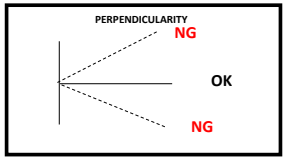
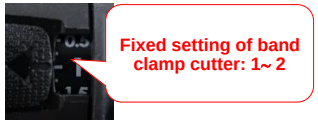
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 3 of 5

PARTS:	1. Assy parts	JIG:	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly	 1. Get the assy parts and set into jig. ***(see above picture for correct setting)*** First, set the connector **6098-3803(B)** to **receiver base** then lock both. 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 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light in location 1 is ON. 3. Initially tighten the band clamp using both hands. 4. Get the bando gun using right hand then cut the band clamp. 5. Conduct POINT CHECKING before removal from jig. **BANDO GUN ALIGNMENT**  	n/a	***Important reminders/Note/s:*** ***1. Make sure no gap between stopper jig and terminal.*** ***2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube.*** ***For: ø5 - 1~2, ø7 - 3~4*** 1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts

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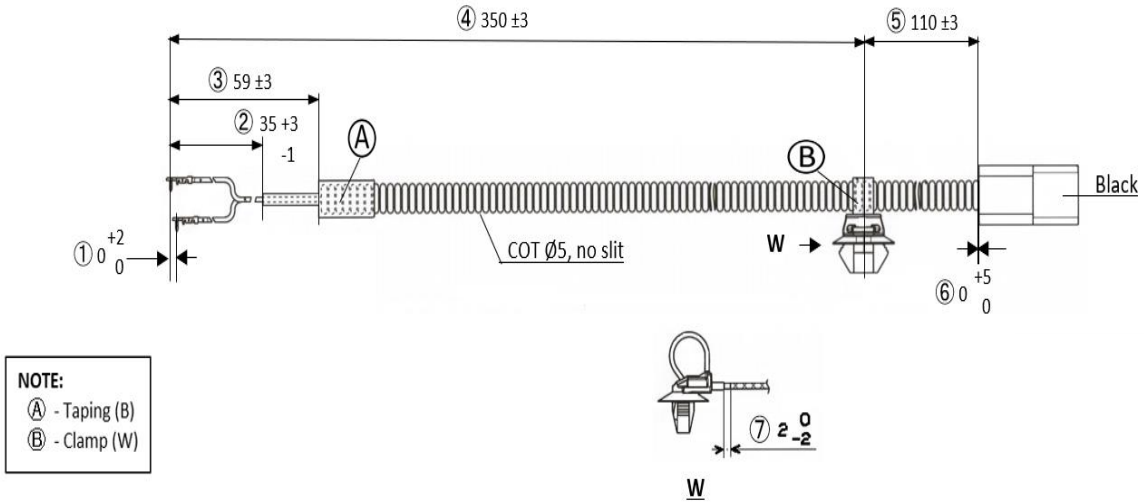
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 4 of 5

PARTS:	n/a	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	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.

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PARTS:	nla	JIG:	n/a

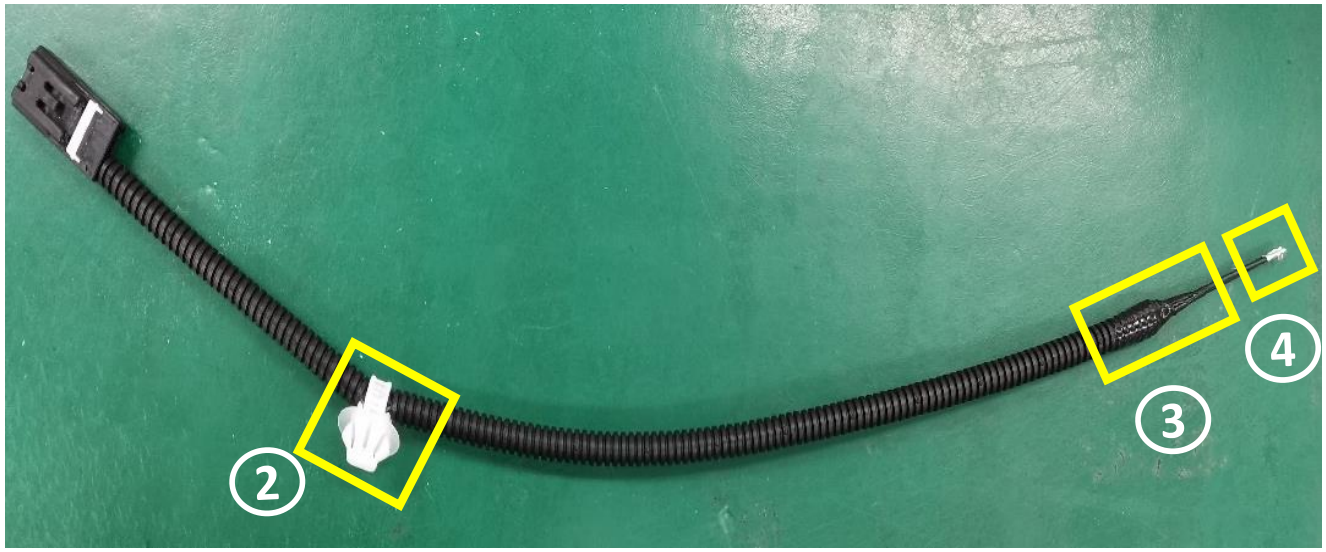
VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7R0110-7020B

GOOD

NO GOOD



GOOD

NO GOOD

① No Unlock/ Halflocked Connector

② No Missing/Damaged Bandclamp

③ No Missing Tape

④ No Deformed Terminal

⑤ No Wrong Insert

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