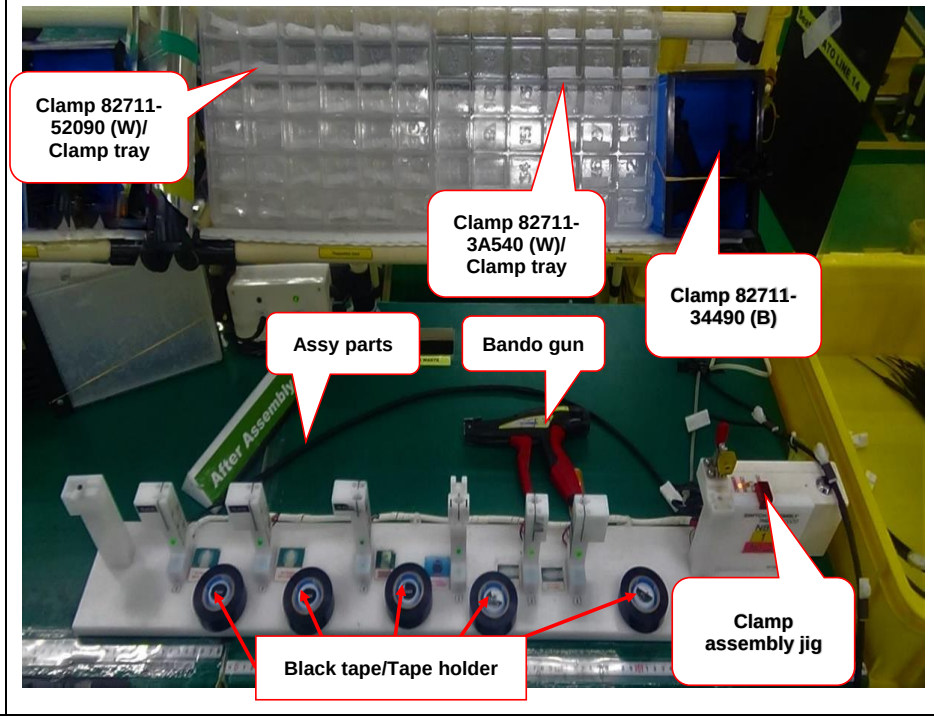
	WORK INSTRUCTION			Effectivity Date:	September 25, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 895B / 7N0093-7020	Customer: TRQSS	Car Model: TOYOTA-COROLLA CROSS	Document No.:	WI-ENG-PDE-980		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	1 of 6

PARTS:	1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Clamp 82711-34490 (B); Black tape (5pcs)	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 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 reference/s:*** *1. Refer to **WI-ENG-PDE-521** for Taping assembly process* 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							D. Castillo	C.Villanueva	A. Arañes	n/a
09/25/24	0	Initial issue. Seperate clamp assy process from Taping assembly process.	D.Castillo	C.Villanueva	A. Arañes	N/A				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 25, 2024		

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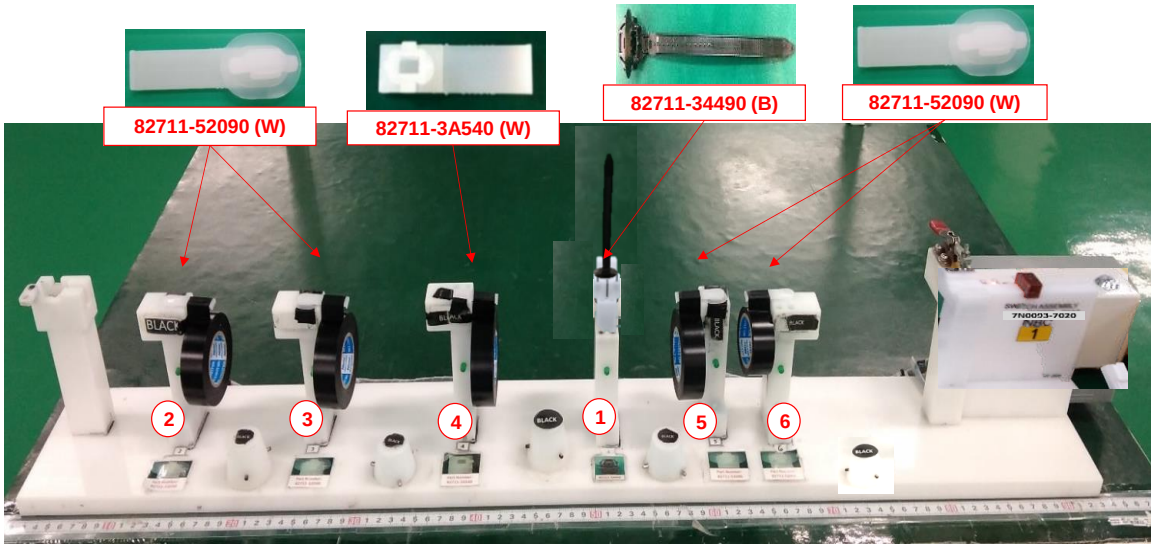
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	2 of 6

PARTS:	1. Clamp 82711-52090 (W) [4pcs.] 2. Clamp 82711-3A540 (W)	3. Clamp 82711-34490 (B) 4. Black tape (5pcs)	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting			



1. Get 2pcs. of clamp **82711-52090 (W)** then set to jig location **2 and 3** using both hands.

2. Get 2pcs. of clamp **82711-52090 (W)** then set to jig location **5 and 6** using both hands.

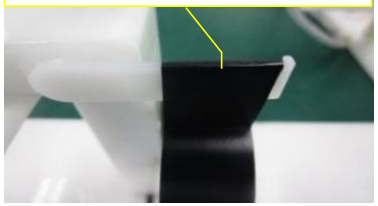
3. Get the clamp **82711-3A540** then set to jig location **4** using both hands.

4. Get the **clamp 82711-34490** then set to jig location **1** using both hands.

5. Initially attach tape on clamp location **2, 3, 4, 5, and 6** using both hands.

STANDARD TAPING FOR CLAMP

One wind for under tape



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

Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

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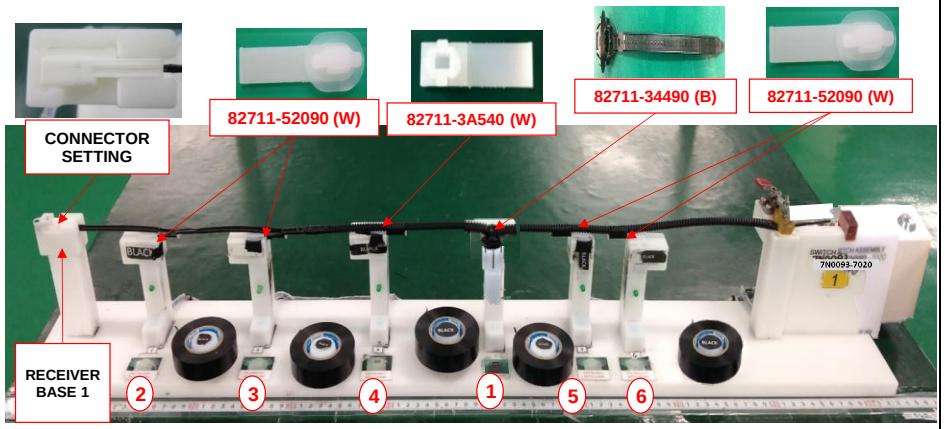
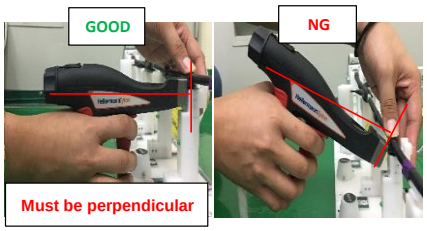
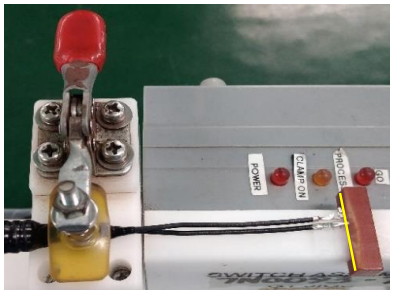
	Model code/Part number:	895B / 7N0093-7020	Customer: TRQSS / Car Model: TOYOTA-COROLLA CROSS	Document No.:	WI-ENG-PDE-980
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0 / Page No.: 3 of 6

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 **6098-3802 (W)** to **Receiver base 1** then lock. Continue to 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** using both hands. 4. Get the bando gun using right hand then cut the band clamp on clamp location **1.** Continue the process if sequence light button on location **2** was on.  **BANDO GUN ALIGNMENT** NG OK NG PERPENDICULARITY **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.** **For: ø5 - 1~2, ø7 - 3~4**	**Bando Gun** 	1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape  ***Important reminders/Note/s:*** *1. Make sure no gap between stopper and terminals.* *2. Make 2-3 windings for clamp taping* **BANDO GUN ILLUSTRATION**

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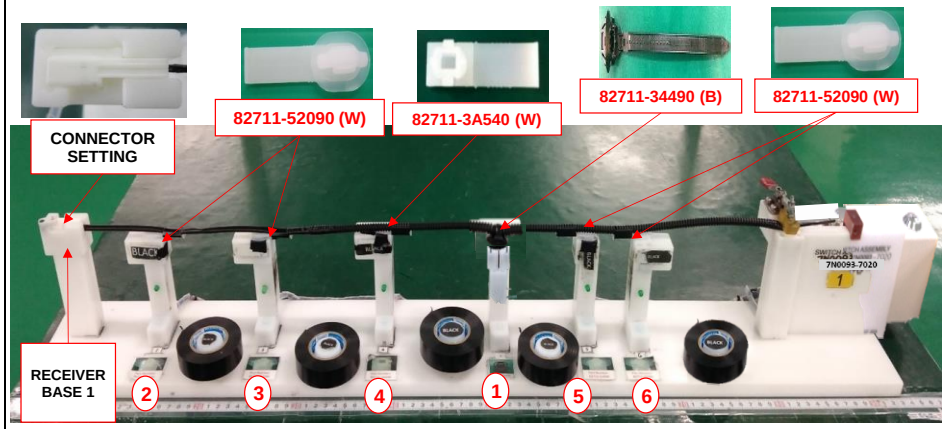
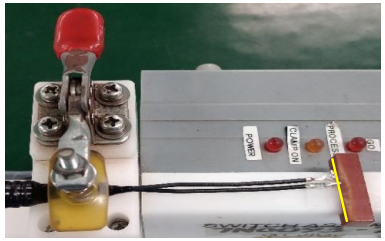
PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp assembly jig (Continuation)	 5. Hold the tape on clamp location **2.** Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue the process if sequence light button on location **3** was on. 6. Hold the tape on clamp location **3.** Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue the process if sequence light button on location **4** was on. 7. Hold the tape on clamp location **4.** Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue the process if sequence light button on location **5** was on. 8. Hold the tape on clamp location **5.** Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue the process if sequence light button on location **6** was on. 9. Hold the tape on clamp location **6.** Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. **Go** sound will be heard. 10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.	n/a	 ***Important reminders/Note/s:*** *1. Make sure no gap between stopper and terminals.* *2. Make 2-3 windings for clamp taping* 1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape

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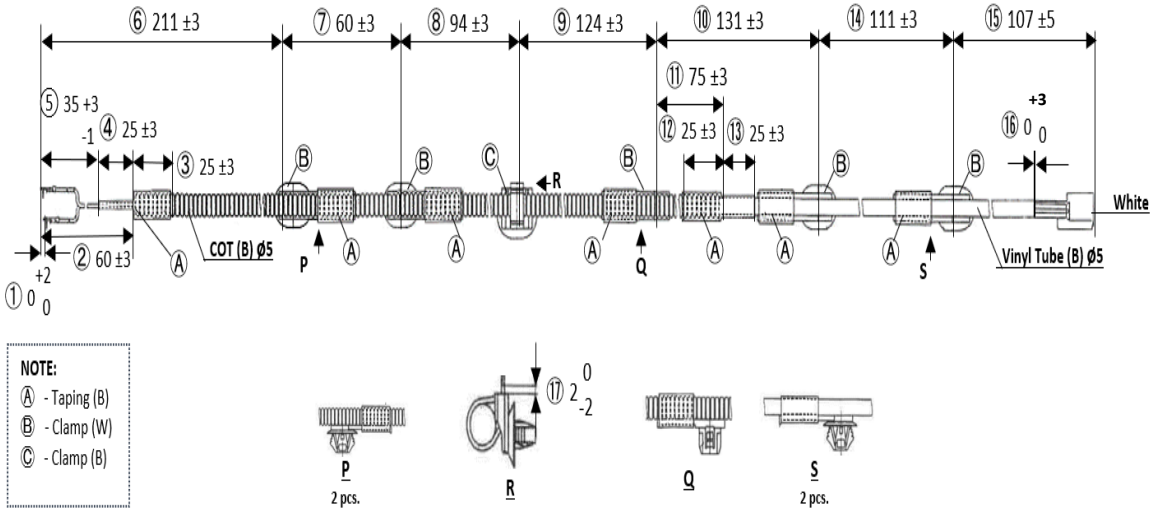
PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	Clamp Assy	Measurement		**MEASURING TAPE** 	***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For 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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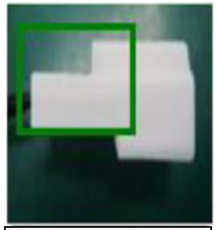
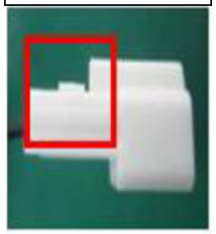
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

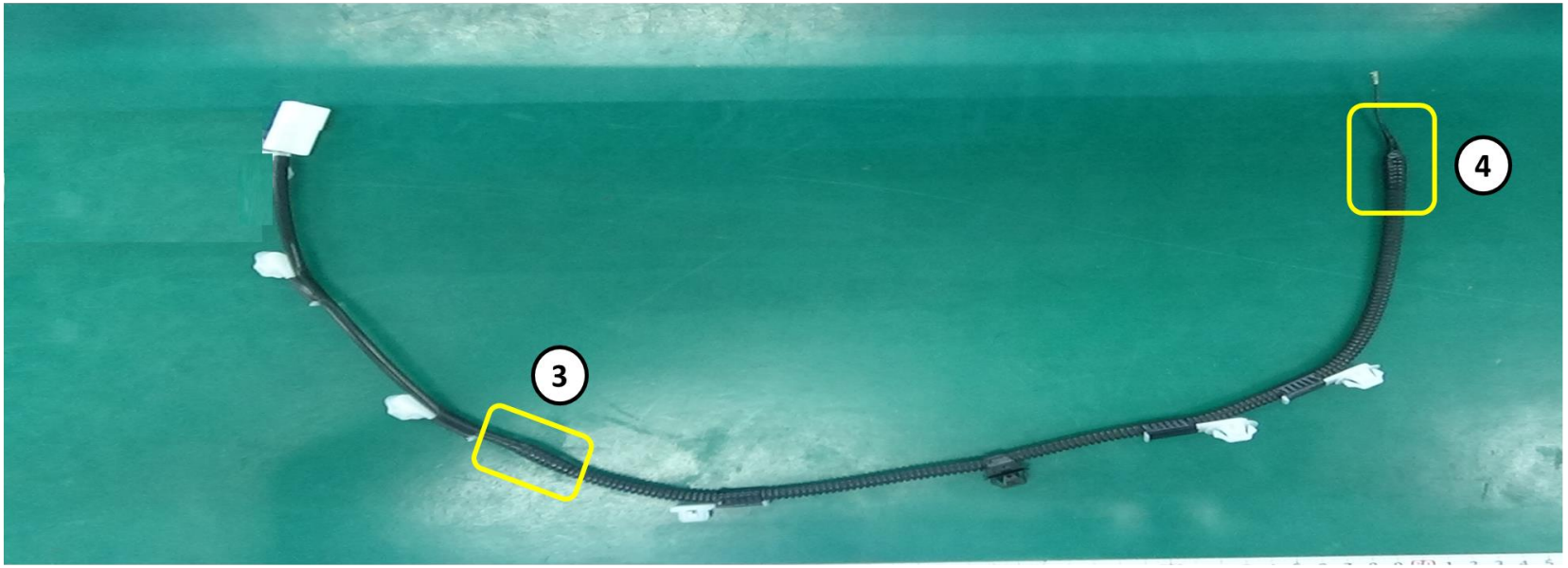
CLAMP ASSY	7N0093-7020



GOOD



NO GOOD



(1) No Wrong Facing of Clamp

(3)(4) No Missing Tape (Black Tape)

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