



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA- CAMRY

Validity Date:

-

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-683

Revision No.:

1

Page No.:

1 of 6

PARTS: 1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-52090 (W); Black tape [4pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

Clamp Assy

Table lay-out

BATCHING

TABLE LAY-OUT

Clamp 82711-48210 (B)/
Clamp Tray

Clamp 82711-52090/ Clamp tray

Assy parts

Clamp Assembly

Tape holder/ Black tape

Tape holder/ Black tape

Safety Instruction

Be sure to wear required 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

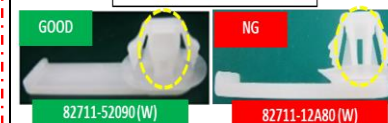
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools.

Important reminders/Note/s:

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

CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/11/24	1	Additional sequence for spot taping to prevent missing spot tape (pg.3 procedure 2 and 3); Improve Measurement and Visual Inspection and Quality checkpoint.	M. Ariola	C. Villanueva	A. Arañes	n/a				
06/21/23	0	Initial issue. Change Process name/Title from "TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS"; Changed Document no. from "WI-ENG-PDE-175C" to "WI-ENG-PDE-683" due to separation of process.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	C. Villanueva	A. Arañes	-

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****CLAMP ASSEMBLY PROCESS**

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

-

Document No.:

WI-ENG-PDE-683

Purpose:

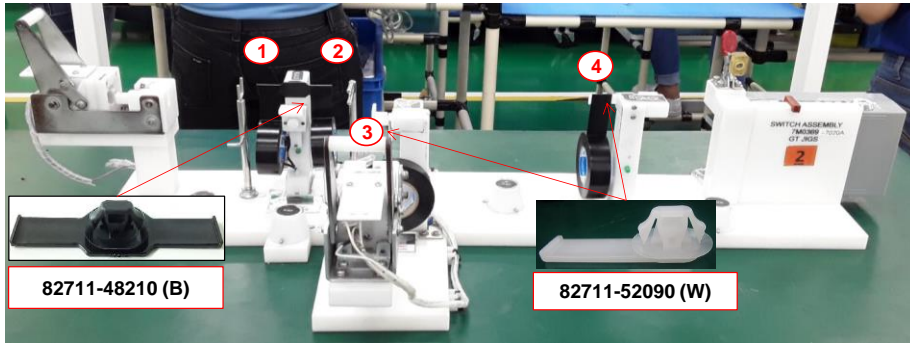
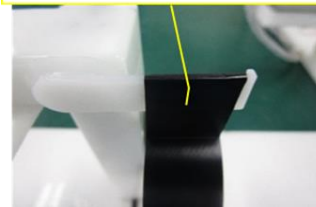
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Assy parts 2. Clamp 82711-48210 (B)		3. Black tape [4pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting	<div><div>82711-48210 (B)</div><div>82711-52090 (W)</div></div> <div>1. Get 1pc of Clamp 82711-48210 (B) using right hand and set to location 1 using both hands.</div> <div>2. Get 2pcs Clamp 82711-52090 (W) using right hand and set to location 3 and 4 using both hands.</div> <div>3. Get Black tape using right hand and conduct pre-taping from location 1, 2, 3 and 4.</div>			n/a	<div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</div> <div>Important reminders/Note/s: 1. Please check the clamp before start of assembly to avoid wrong use of clamp</div> <div>STANDARD TAPING FOR CLAMP</div> <div>1</div> <div>One wind for under tape</div> <div></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

CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 11, 2024

Validity Date:

-

Document No.:

WI-ENG-PDE-683

Revision No.:

1

Page No.:

3 of 6

PARTS:

1. Assy parts

2. Clamp 82711-48210 (B)

3. Clamp 82711-52090 (W) [2pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

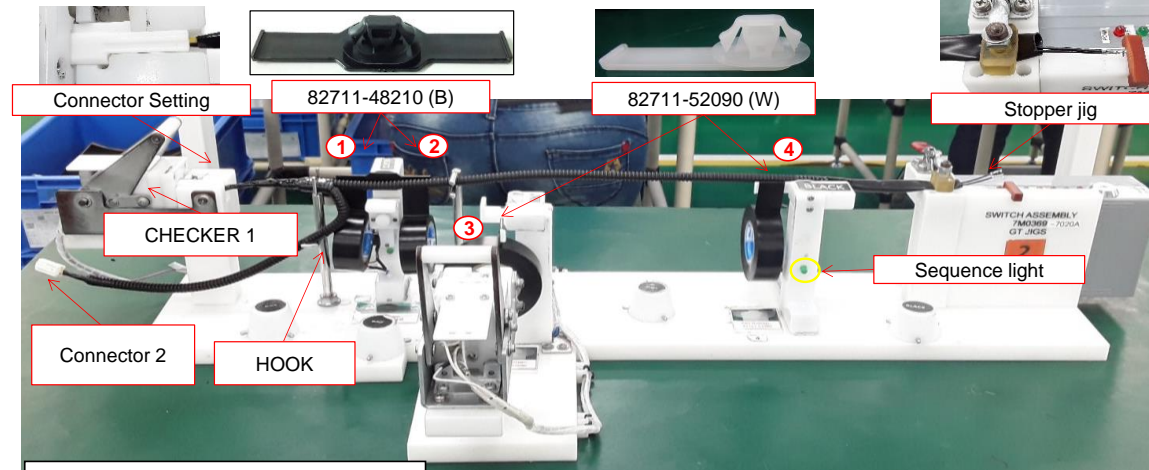
TOOLS/PPE

QUALITY POINTERS

3

Clamp
Assy

Clamp assembly

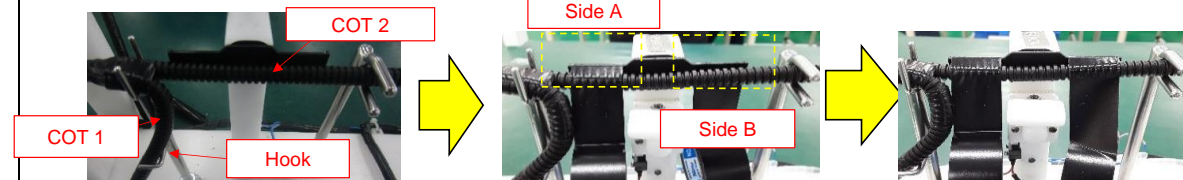


1. Get the assy parts using right hand and set to jig using both hands. First, put the first Connector to checker 1, second, put the Sunprene tube to toggle clamp and last, initially put the COT (with connector 2) in HOOK.

Note: Refer to above illustration for correct setting

2. Wrap the **COT2 & Side A** of the clamp (**2 windings**) using both hands. Press the **SW Button** after taping (Do not cut the tape).

3. Wrap the **COT2 & Side B** of the clamp (**2 windings**) using both hands. Press the **SW Button** after taping (Do not cut the tape).



Important reminders/Note/s:

1. Make sure no gap between terminal and stopper jig.
2. Make 2-3 windings of 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



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

-

Document No.:

WI-ENG-PDE-683

Purpose:

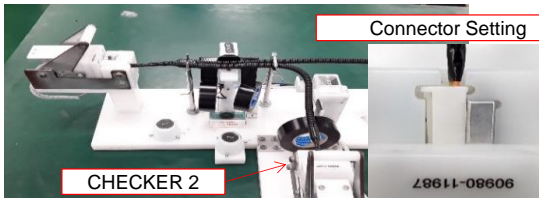
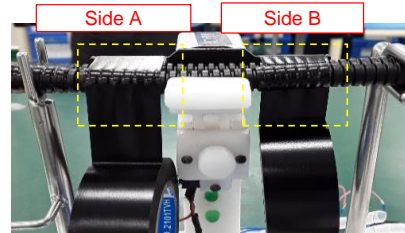
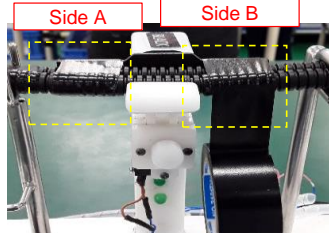
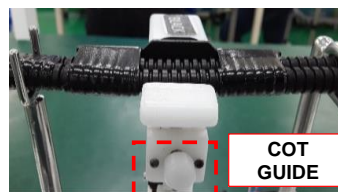
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div><p>Connector Setting</p><p>CHECKER 2</p></div><div>4. Put the Connector 2 to checker 2 using both hands. the lock <i>Refer to above illustration for correct setting.</i></div></div> <div><div><p>Side A Side B</p></div><div>6. Combine the COT1 and COT2 from clamp side A (3 windings). Press the SW button after taping. Continue if the sequence light of location 2 was ON.</div></div> <div><div><p>Side A Side B</p></div><div>7. Combine the COT1 and COT2 from clamp side B (3 windings). Press the SW button after taping. Continue if the sequence light of location 3 was ON.</div></div> <div><div><p>COT GUIDE</p></div><div>8. Hold the tape in clamp location 3, make 3 windings of tape using both hands then cut the tape . Press the SW button after taping. Continue if the sequence light of location 4 was ON.</div><div>9. Hold the tape in clamp location 3, make 3 windings of tape using both hands then cut the tape . Press the SW button after taping. GO buzzer will be heard.</div><div>10. Press the COT guide using right hand. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div></div>		<div><p>Note: Push the COT guide upward using right thumb.</p></div> <div>5. Check the LED light for POWER, CLAMP, WIRE1 and WIRE2 and sequence light is ON. If encountered abnormality, STOP the process, CALL the attention of Leaders and WAIT for instructions.</div>	<div>1. No wrong use of tape 2. No lacking and excess tape windings 3. No missing tape</div> <div>1 Important reminders/Note/s: 1. Make sure no gap between terminal and stopper jig. 2. Make 2-3 windings of tape.</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

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

-

Document No.:

WI-ENG-PDE-683

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

5 of 6

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

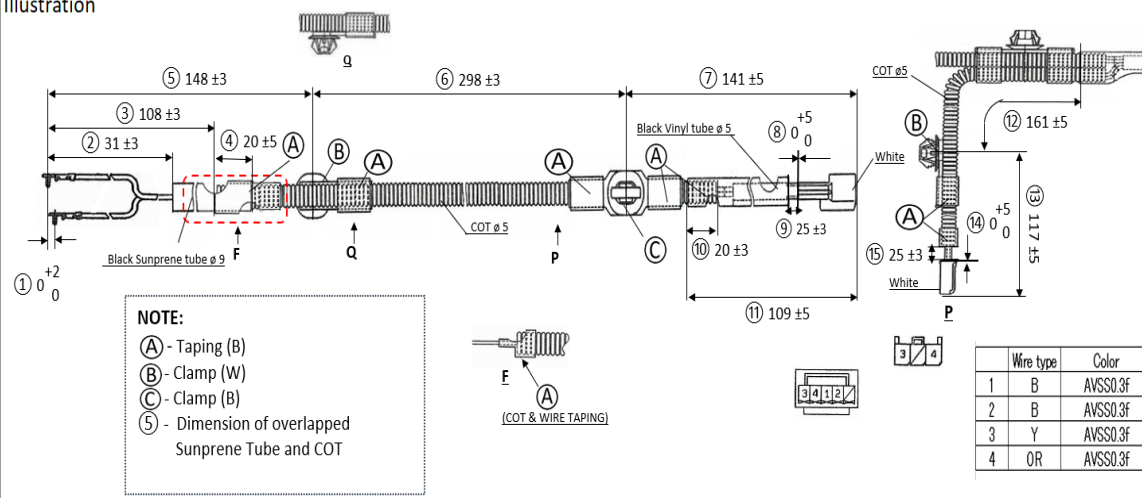
QUALITY POINTERS

4

Clamp
Assy

Measurement

Illustration



1. No wrong dimension

Important reminders/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

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 11, 2024

Validity Date:

-

Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-683

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

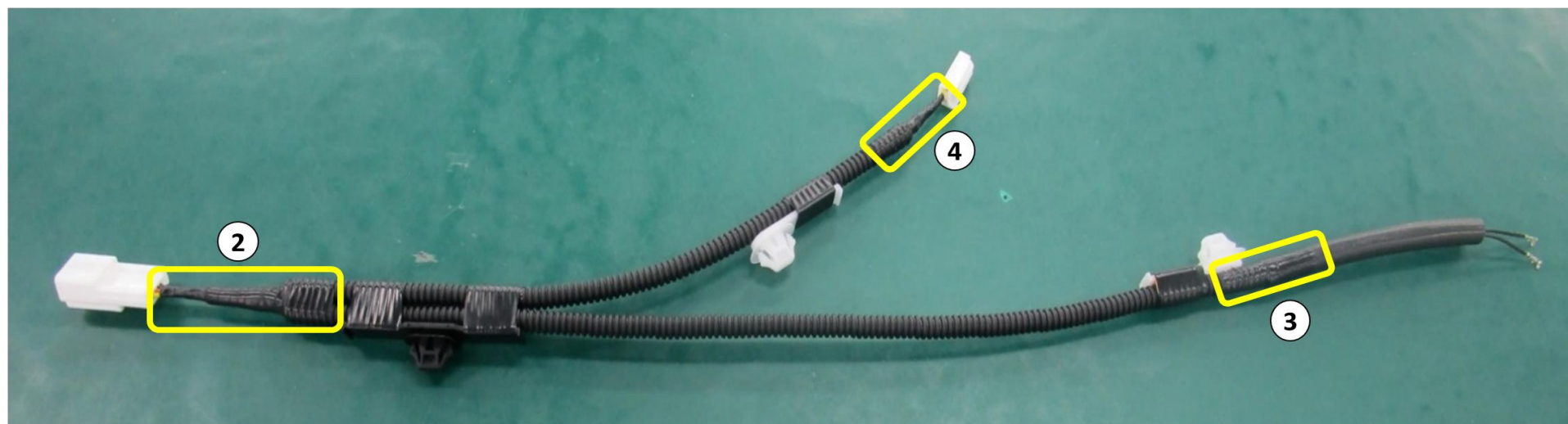
6 of 6

PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION / QUALITY CHECKPOINTS****CLAMP ASSY****7M0369-7020A****① No Wrong facing of clamp****② ③ ④ No Missing Tape (Black 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