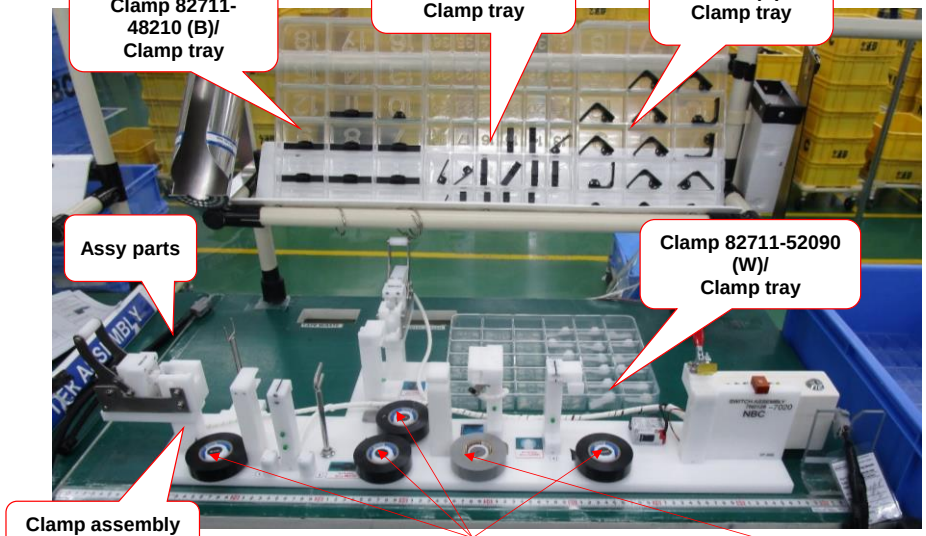
	WORK INSTRUCTION			Effectivity Date:	October 22, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 178D / 7N0128-7021C	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1117	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 7

PARTS:	1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [4pcs.]; Gray tape	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 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 ***Document reference/s:*** *1. Refer to **WI-ENG-PDE-419A-B** for Taping assembly process* CLAMP ILLUSTRATION GOOD 82711-48210 (B) NG 82711-3F290 (B) CLAMP ILLUSTRATION GOOD 82711-52090 (W) NG 82711-12A80 (W)

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/22/24	1	Change purpose from pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
10/17/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024		

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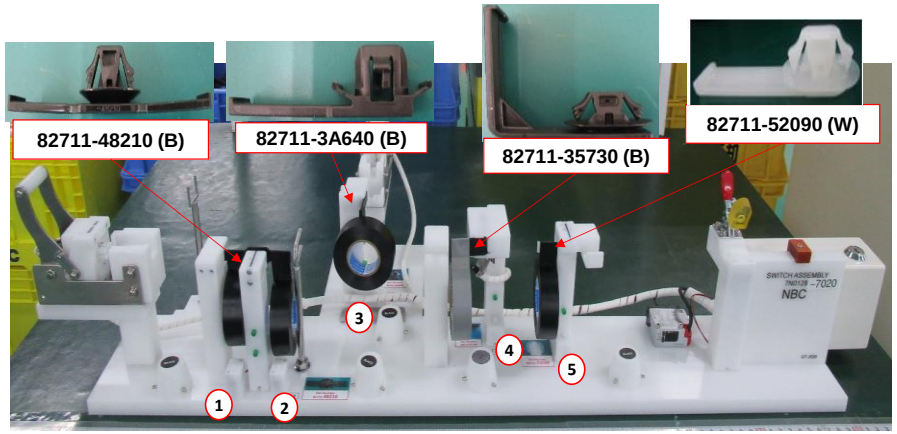
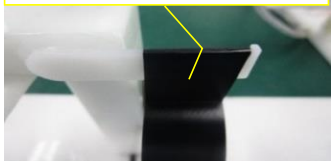
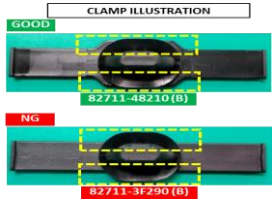
NBC	WORK INSTRUCTION			Effectivity Date:	October 22, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	178D / 7N0128-7021C	Customer: TRJ / Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1117
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 2 of 7

PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-3A640 (B) 3. Clamp 82711-35730 (B 4. Clamp 82711-52090 (W) 5. Black tape [4pcs.] 6. Gray tape	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	 1. Get 1 pc. of clamp **82711-48210 (B)** using right hand then insert to clamp location **1 and 2** using both hands. 2. Get 1 pc. of clamp **82711-3A640 (B)** using right hand then insert to clamp location **3** using both hands. 3. Get 1 pc. of clamp **82711-35730 (B)** using right hand then insert to clamp location **4** using both hands. 4. Get 1 pc of clamp **82711-52090 (W)** using right hand then insert to clamp location **5** using both hands. 5. Get the **Gray tape** then initially attach to clamp location **4** using both hands. 6. Get the **Black tape** then initially attach to clamp location **1, 2, 3, and 5** using both hands.	n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No wrong use of clamp **STANDARD TAPING FOR CLAMP** One wind for under tape   ***Important reminders/Note/s:*** ***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.***

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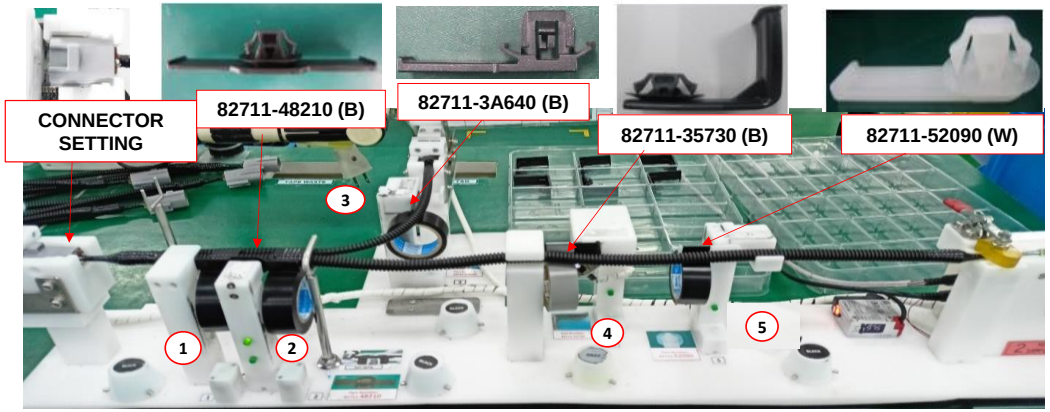
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 178D / 7N0128-7021C	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1117		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.:	3 of 7

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

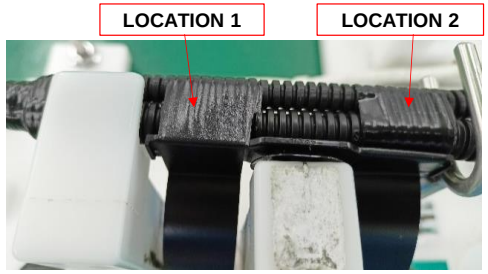
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp assembly			1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position



1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-1161 (B)** to **Checker 2** then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB 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,Wire 1 & Wire 2** was **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 the process if sequence light on clamp location **2** was **ON.**



Important reminders/Note/s:

1. Make sure no gap between stopper jig and PCB
2. Make 2-3 windings for clamp taping

Document references:

1. Refer to GL-ENG-PDE-006 for Two sides clamp taping for 2 corrugated tubes.

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	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	178D / 7N0128-7021C	Customer: TRJ / Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1117
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 4 of 7

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp assembly (Continuation)	 4. Hold the tape on clamp location **2**,make **3 windings** of tape then cut using both hands. Press the **SW** button after taping. Continue the process if sequence light 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 the process if sequence light on clamp location **4** was **ON.**		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. Make sure no gap between stopper jig and PCB*** ***2. Color sensor GRAY TAPE only*** ***3. Make 2-3 windings for clamp taping***

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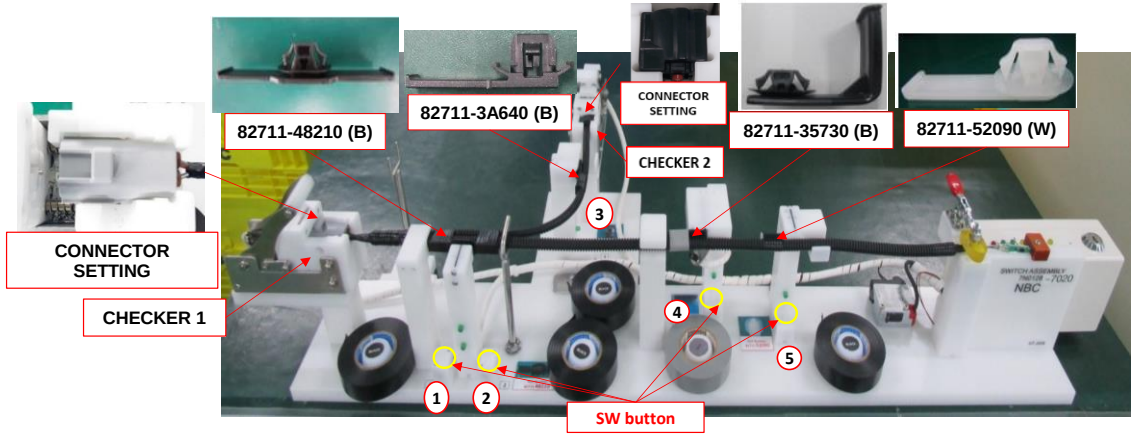
NBC	WORK INSTRUCTION			Effectivity Date:	October 22, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	178D / 7N0128-7021C	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.: WI-ENG-PDE-1117
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1 Page No.: 5 of 7

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp assembly (Continuation)	 6. Hold the tape on clamp location **4,** make **3 windings** of tape then cut the tape using both hands. **Color sensor** light will beep/buzz if sensor detects **Gray tape.** Press the **SW button** after taping. Continue the process if sequence light on clamp location **5** was **ON.** 7. Hold the tape on clamp location **5,** make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard. 8. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.		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. Make sure no gap between stopper jig and PCB*** ***2. Color sensor GRAY TAPE only*** ***3. Make 2-3 windings for clamp taping***

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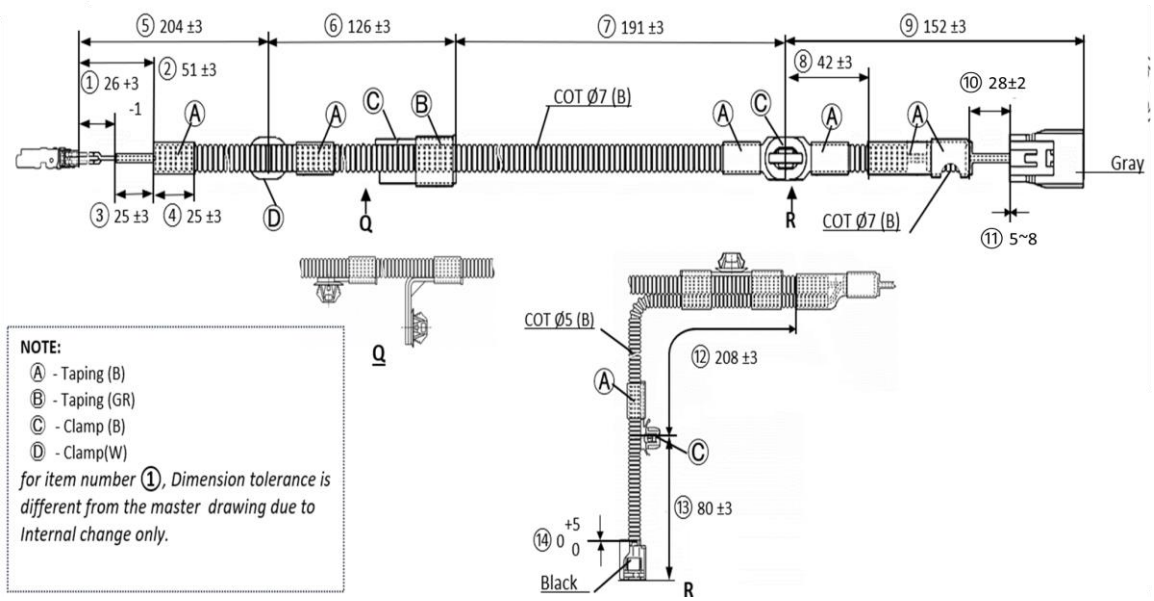
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 6 of 7

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	7N0128-7021C

(1) No Wrong facing of clamp

(2)(3) No Missing Tape (Black tape)

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