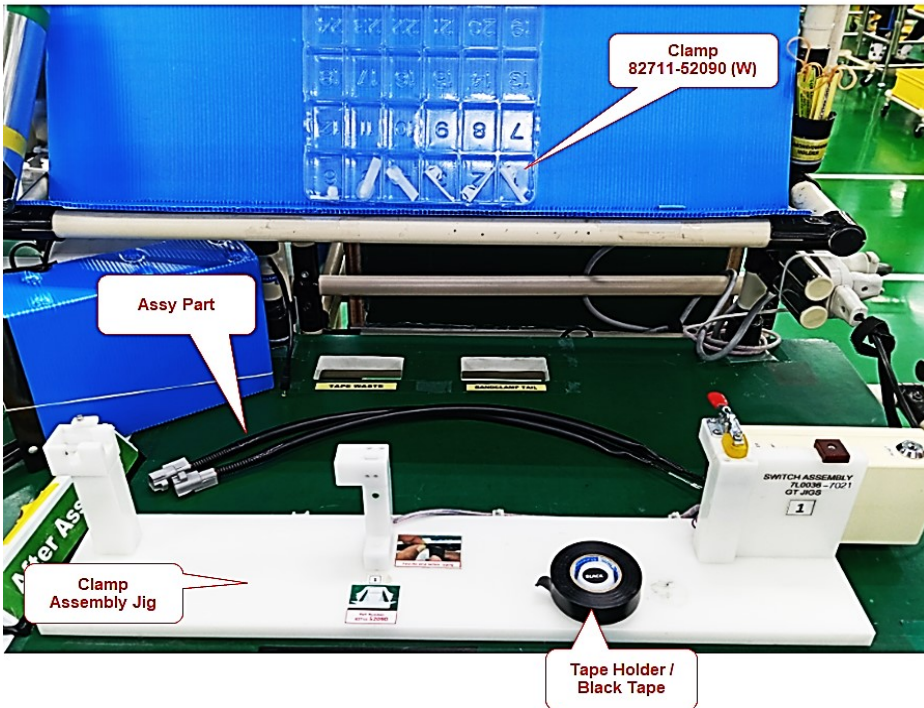







WORK INSTRUCTION
CLAMP ASSEMBLY PROCESS

| | | | |
|-------------------|----------------|-----------|--------|
| Effectivity Date: | May 9, 2024 | | |
| Validity Date: | n/a | | |
| Document No.: | WI-ENG-PDE-891 | | |
| Revision No.: | 0 | Page No.: | 1 of 5 |

| | | | |
|-------------------------|------------------------------------|-------------------------------------|---|
| Process Name/Title: | CLAMP ASSEMBLY PROCESS | | |
| Model code/Part number: | 291B / 7L0036-7021 | Customer: | TRQSS |
| Car Model: | TOYOTA-SEQUOIA | | |
| Purpose: | <input type="checkbox"/> PROTOTYPE | <input type="checkbox"/> PRE-LAUNCH | <input checked="" type="checkbox"/> MASSPRO |

| | | | | | |
|--------|--------------|--|--|---|--|
| PARTS: | | 1. Clamp 82711-52090 (W) 2. Black tape [19mm] | | JIG: | 1. Clamp Assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 1 | Clamp | <p>TABLE LAY OUT</p>  | | <p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> | <p>1. No wrong use of parts 2. No wrong use of clamp 3. No wrong use of tape</p> <p>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> |

| Revision History | | | | | | | Prepared by | Reviewed by | Approved by | Noted by | |
|------------------|---------|-------------------|--|--|--------------|---------------|---|--|--|------------|--------------|
| | | | | | | |  A. Hernandez |  C. Villanueva |  A. Arañes | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| 05/09/24 | 0 | Initial issue. | | | A. Hernandez | C. Villanueva | A. Arañes | n/a | | n/a | |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted | Est. Date: | May 09, 2024 |

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**WORK INSTRUCTION****Process Name/Title: CLAMP ASSEMBLY PROCESS**

Effectivity Date:

May 9, 2024

Validity Date:

n/a

Model code/Part number:

291B / 7L0036-7021

Customer:

TRQSS

Car Model:

TOYOTA-SEQUOIA

Document No.:

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Purpose:





☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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|--------|--------------|--|--|---|-----------------------|---|
| PARTS: | | 1. Clamp 82711-52090 (W) 2. Black tape [19mm] | | JIG: | 1. Clamp Assembly jig | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | |
| 2 | Clamp | Clamp setting | | <div></div> <div>1. Get 1pc. of clamp 82711-52090 (W) using right hand and insert to location 1 using both hands.</div> <div>2. Initially attach Black tape on location 1 using both hands.</div> <div>Note: Please check the clamp before start of assembly to avoid wrong use of parts.</div> | | <div>1. No wrong use of parts 2. No wrong use of clamp 3. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div> <div><div>STANDARD TAPING FOR CLAMP</div><div>One side tape under clamp</div><div></div></div> |

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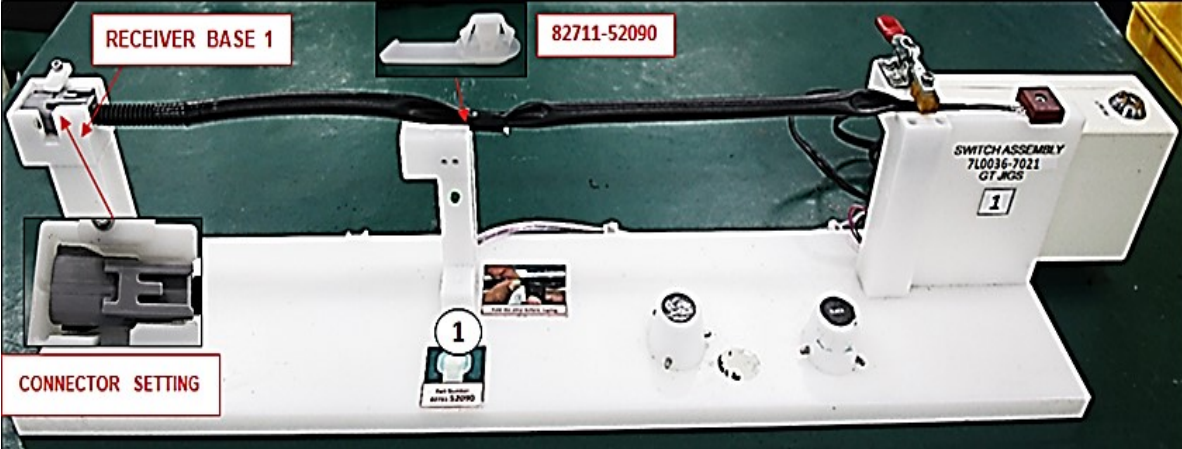
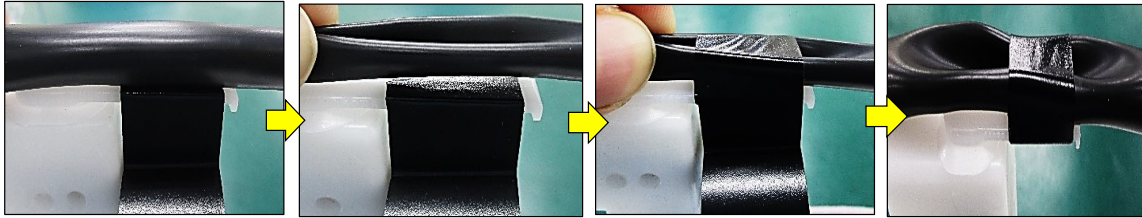
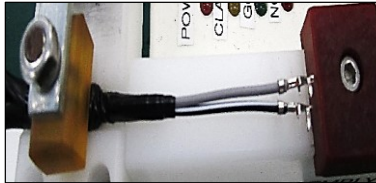
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|--------|-----------------------------|--|--|---|---|
| PARTS: | | 1. Assy parts 2. Clamp 82711-52090 (W) 3. Black tape (19mm) | | JIG: | 1. Clamp Assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | Clamp Clamp assembly | <div></div> <div><p>1. Get the assy parts and set into jig. (See above picture for the correct setting). First, set the connector 6188-0294 (GR) to Receiver base 1 and then lock. Continue to set the harness in jig. Last, set the B/W-G wires together within the stopper then press by toggle clamp. Continue the process if sequence light in location 1 was ON.</p><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 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.</p></div> <div></div> <div><p>3. On clamp location 1, fold the vinyl tube. (See above picture as guide). Make 3 windings before cutting of tape. Press the SW button after taping. Go sound will be heard.</p><p>4. Conduct POINT CHECKING before removing the harness from jig.</p></div> | | <div></div> <div>Note: Make sure theres no clearance between terminal and stopper jig.</div> | <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong insertion of connector 5. Make sure no gap between terminal and stopper jig</div> |

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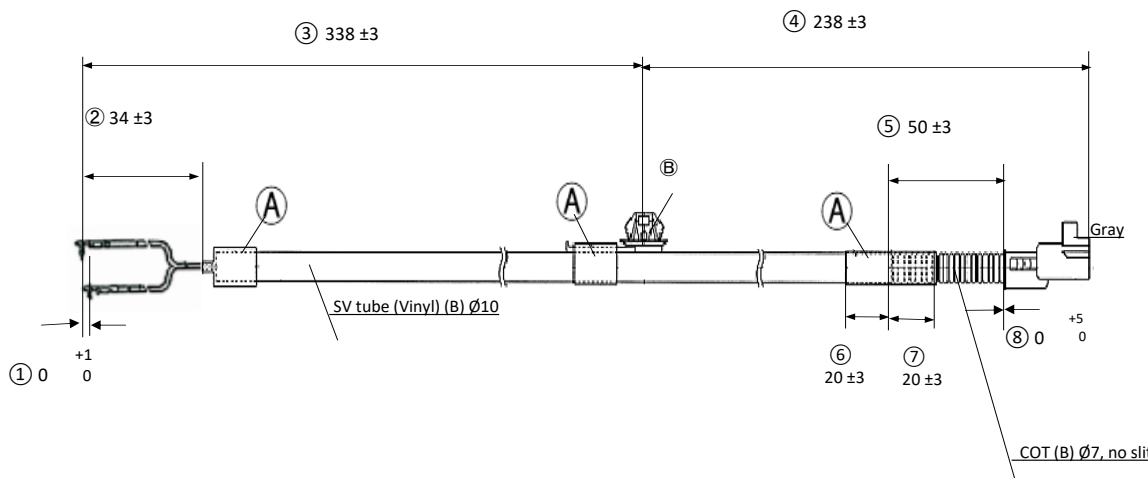


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| | | | | | |
|--------|--------------|------------------------------|--|---|---|
| PARTS: | | 1. Assy part | | JIG: | 1. Measuring Tape |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Clamp | Measurement | <div></div> | <div>  0~1 mm</div> | <div>1. No wrong dimension</div> <div>MEASURING TAPE</div> <div>Wire alignment tolerance</div> <div>0~1 mm</div> <div>Important reminders/note/s: 1.Please use calibrated/verified measuring tape when getting the measurement.</div> |

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PARTS:

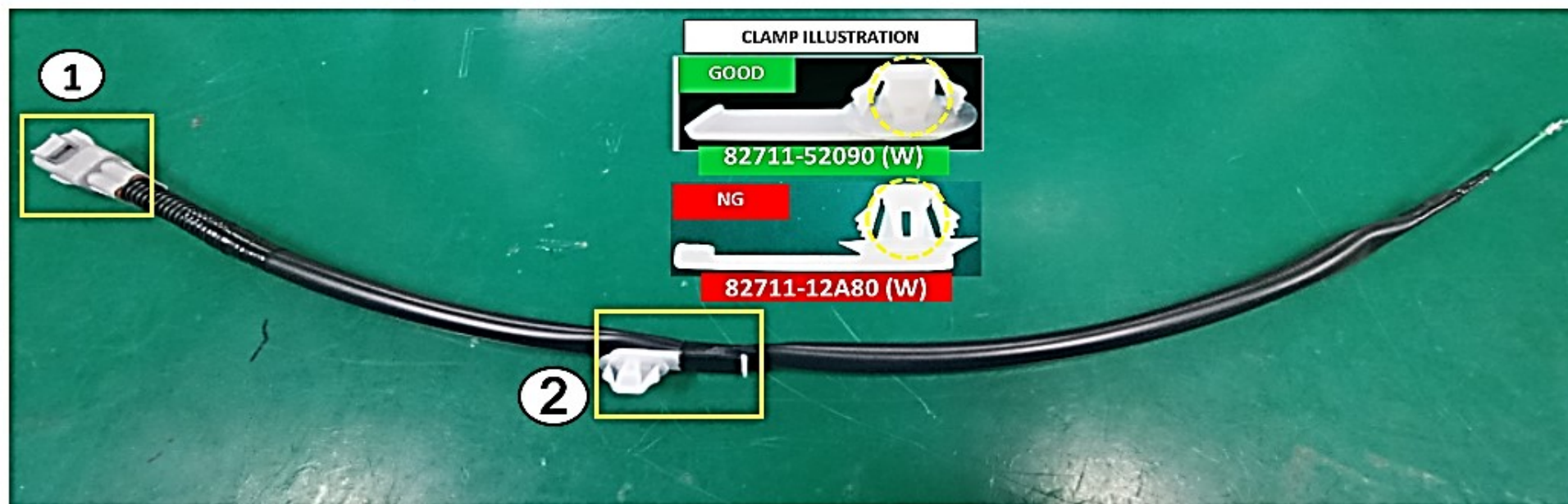
n/a

JIG:

n/a

VISUAL INSPECTION

7L0036-7021



① No Deformed terminal

② Check the Clamp Appearance

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