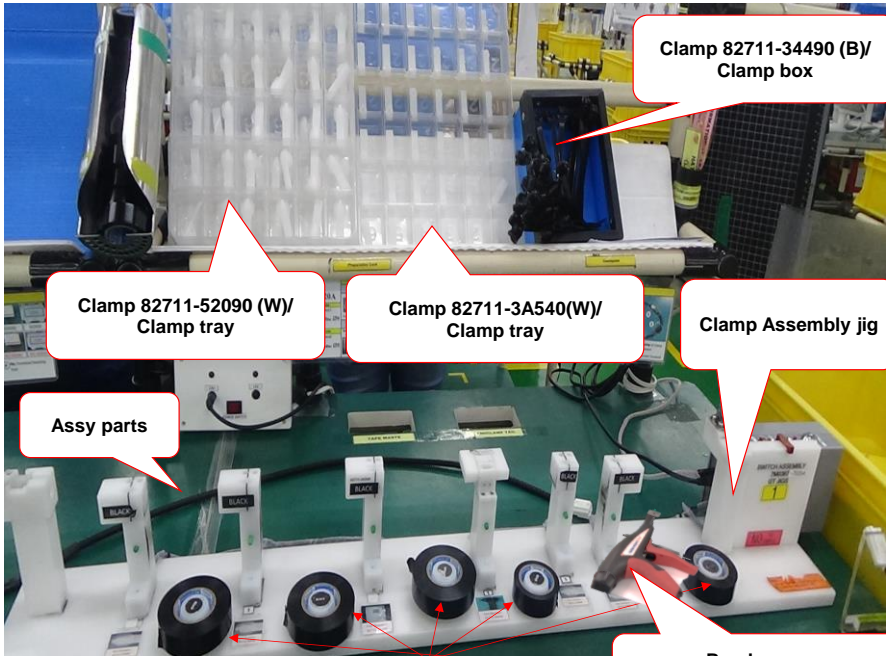

	WORK INSTRUCTION			Effectivity Date:	July 02, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 011B / 7M0367-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-755		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 6

PARTS:		1. Clamp 82711-52090 (W) [4pcs.]; Clamp 82711-34490 (B); Clamp 82711-3A540 (W); Black tape [5pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	<div> <div>Table Lay-out</div>  <div>Clamp 82711-34490 (B)/ Clamp box</div> <div>Clamp 82711-52090 (W)/ Clamp tray</div> <div>Clamp 82711-3A540(W)/ Clamp tray</div> <div>Clamp Assembly jig</div> <div>Assy parts</div> <div>Black tape/ Tape holder</div> <div>Bando gun (FLAT NOSEPIECE)</div> </div>		<div> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> <div> Bando Gun  </div>	<div> Document reference/s: 1. Refer to WI-ENG-PDE-174A-B for Taping assembly process </div> <div> 1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp </div> <div> <div>CLAMP ILLUSTRATION</div> <div> <div>GOOD</div> <div>NG</div> </div> <div> <div>82711-52090 (W)</div> <div>82711-12A80 (W)</div> </div> </div> <div> <div>BAND CLAMP ILLUSTRATION</div> <div> <div>GOOD</div> <div>NG</div> </div> <div> <div>82711-34490 (B)</div> <div>82711-16830 (B)</div> </div> </div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/02/24	1	Improved Measurement and Visual inspection/Quality checkpoints.				D. Castillo	C. Villanueva	A. Arañes	n/a
11/15/23	0	Initial issue. Separate Clamp setting and Clamp assembly from Taping assembly process (WI-ENG-PDE-174)				D. Castillo	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	November 15, 2023		

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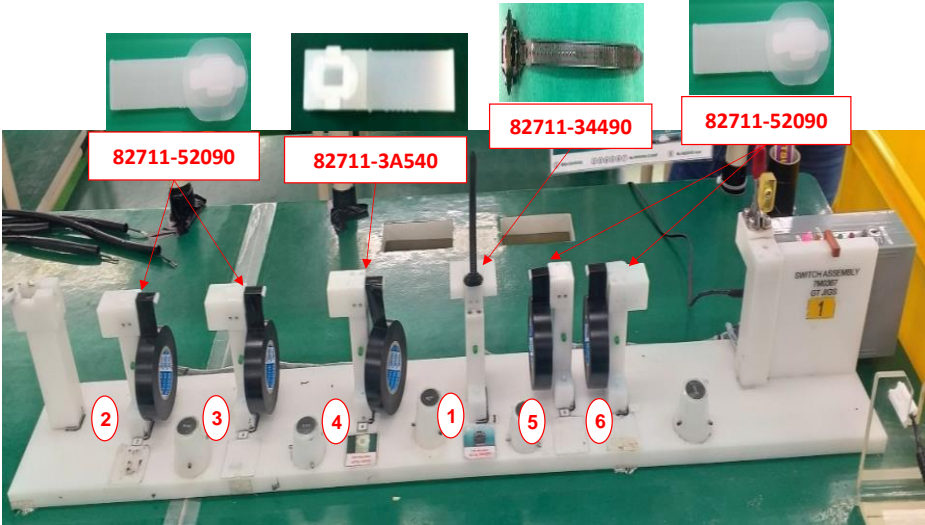
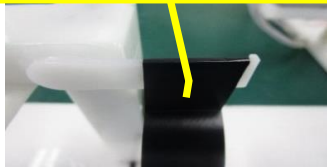
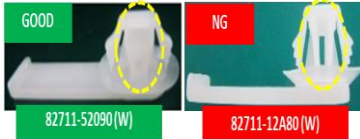
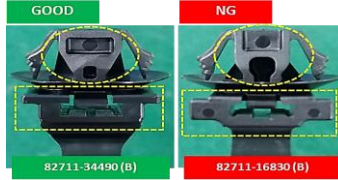
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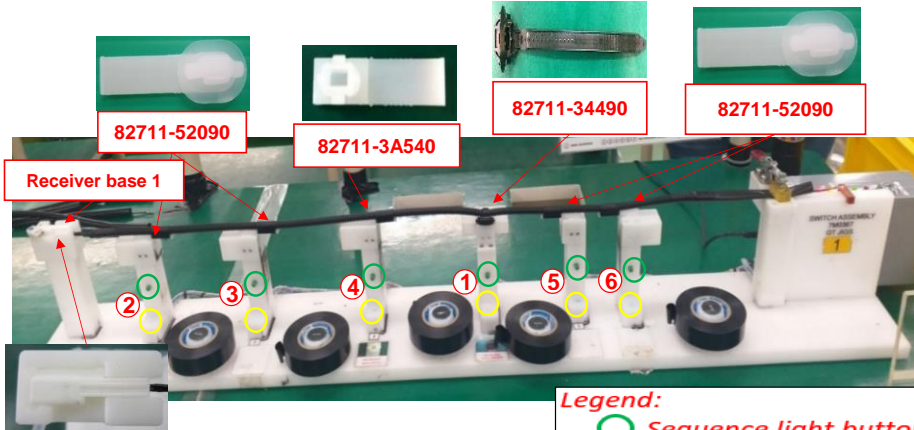


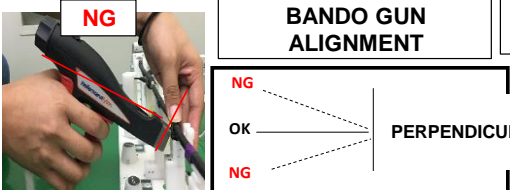



PARTS:	1. 82711-52090 (W) [4pcs] 2. Black tape [5pcs]	3. 82711-3A540 (W) 4. 82711-34490 (B)	JIG:	Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Clamp setting	 <div>1. Get 2 pcs. of clamp 82711-52090 (W) then set to jig location 2 and 3 using both hands.</div> <div>2. Get 2 pcs. of clamp 82711-52090 (W) then set to jig location 5 and 6 using both hands.</div> <div>3. Get the clamp 82711-3A540 then set to jig location 4 using both hands.</div> <div>4. Get the clamp 82711-34490 then set to jig location 1 using both hands.</div> <div>5. Initially attach tape on clamp location 2, 3, 4, 5, and 6 using both hands.</div>	n/a	Important reminders/Note/s: <i>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</i> STANDARD TAPING FOR CLAMP One wind for under tape  CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION  1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp

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DCC Stamp

		WORK INSTRUCTION				Effectivity Date:		July 02, 2024		
		CLAMP ASSEMBLY PROCESS				Validity Date:		n/a		
		Process Name/Title:		Model code/Part number: 011B / 7M0367-7020A		Customer: TRJ	Car Model: TOYOTA-CAMRY		Document No.: WI-ENG-PDE-755	
		Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1
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PARTS:		1. Assy parts 2. Black tape				JIG:		1. Clamp Assembly Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
3	Clamp Assy	<div><div></div><div><div>CONNECTOR SETTING</div><div>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.</div><div>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.</div><div>3. Initially tighten the band clamp on location 1 using both hands.</div><div>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.</div></div><div><div></div><div>Bando Gun</div></div><div><div></div><div>Legend: Sequence light button Switch button</div></div><div><div></div><div>BANDO GUN ALIGNMENT</div></div><div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</div></div></div> <div><div></div><div>Important reminders/note/s: 1. Make sure no gap between stopper jig and terminals. 2. Make 2-3 windings for clamp taping</div><div><div></div><div>Bando Gun</div></div><div><div></div><div>BANDO GUN ILLUSTRATION</div></div><div>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</div></div>							

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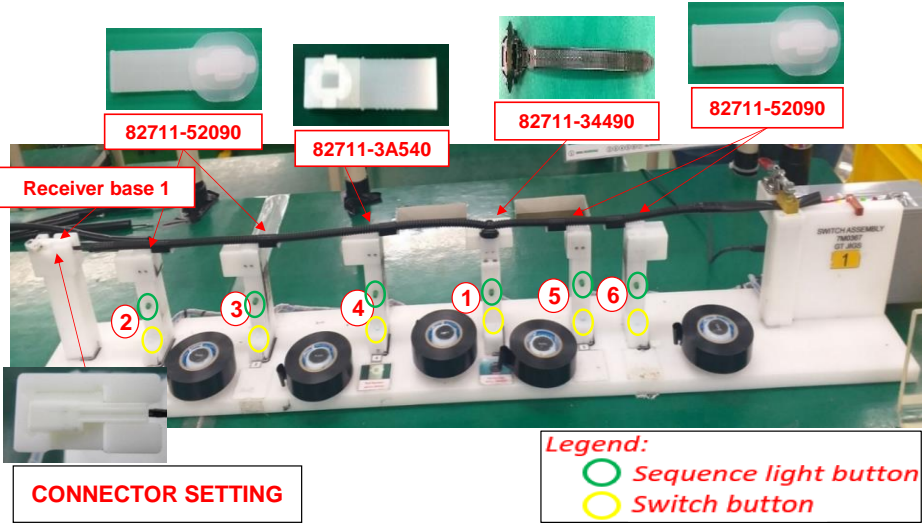


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	Process Name/Title:		Model code/Part number: 011B / 7M0367-7020A		Customer: TRJ	Car Model: TOYOTA-CAMRY		Document No.: WI-ENG-PDE-755
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	4 of 6	

PARTS:	1. Assy parts 2. Black tape			JIG:	Clamp assembly jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	Clamp Assy	<div></div> <div><div><div>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.</div><div>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.</div><div>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.</div></div><div><div>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.</div><div>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.</div><div>10. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div></div></div> <td>N/A</td> <td colspan="3"><div><p>Important reminders/note/s:</p><p>1. Make sure no gap between stopper jig and terminals.</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p></div></td>			N/A	<div><p>Important reminders/note/s:</p><p>1. Make sure no gap between stopper jig and terminals.</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p></div>		

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PARTS:

1. Assy parts

JIG:

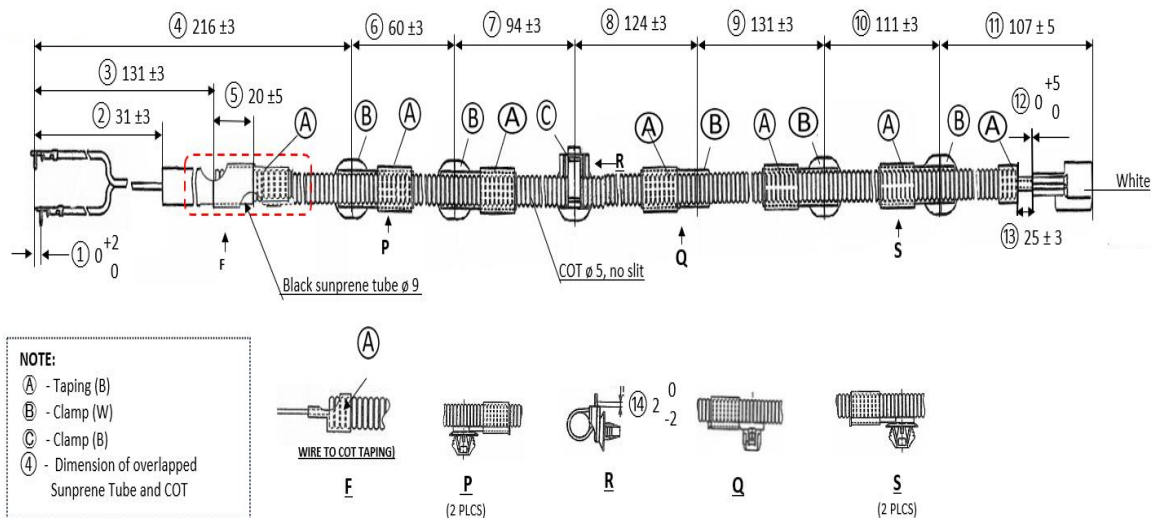
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NO.**PROCESS NAME****1****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

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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011B / 7M0367-7020ACustomer: **TRJ**Car Model: **TOYOTA-CAMRY**

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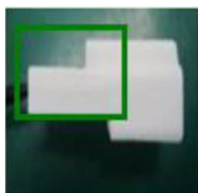
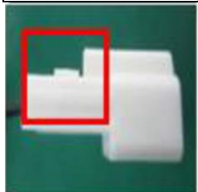
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7M0367-7020A****GOOD****NO GOOD****3****4****1** No Wrong Facing of Clamp**2** No Unlock/Halflock connector**3** **4** No Missing Tape (Black Tape)

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