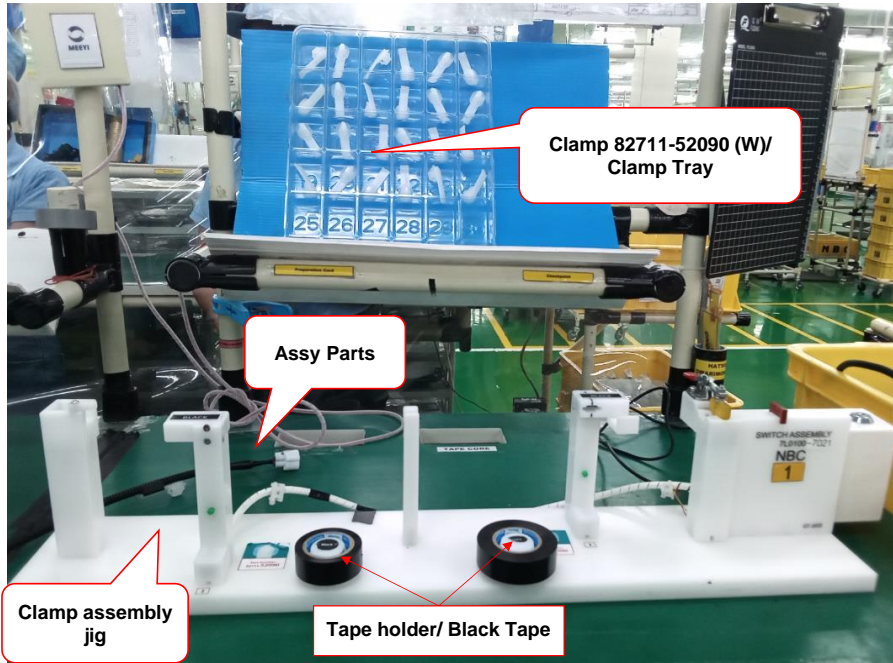





	WORK INSTRUCTION			Effectivity Date:	September 12, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 890B / 7L0100-7021A		Customer: TRQSS	Car Model: TOYOTA-C-SUV	Document No.: WI-ENG-PDE-1041		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 5

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Black tape [2pcs]		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	Clamp assy	<div>Table Lay-out</div>  <div>Clamp 82711-52090 (W)/ Clamp Tray</div> <div>Assy Parts</div> <div>Clamp assembly jig</div> <div>Tape holder/ Black Tape</div>		<div>Safety Instruction Be sure to wear prescribed 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>Document reference/s: 1. Refer to WI-ENG-PDE-405 for Taping assembly process</div> <div>1.No missing parts/tools 2.No excess parts/tools</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/12/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a			
09/10/24	0	Initial issue	A. Hernandez	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024	



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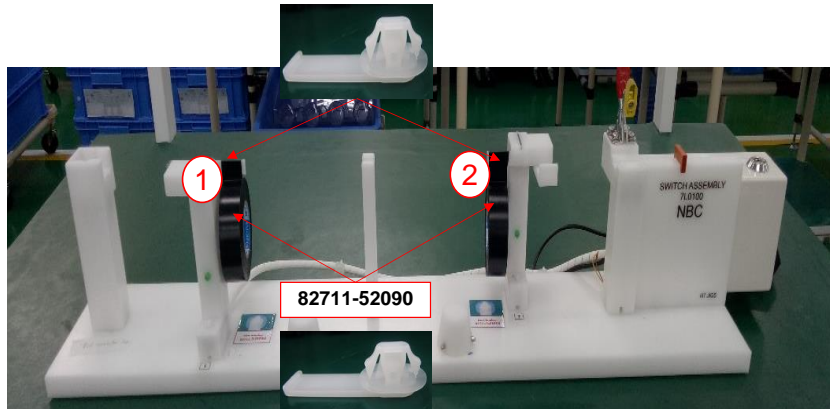
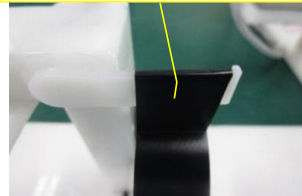
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PARTS:		1. Clamp 82711-52090 (W) [2pcs] 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<div><div>82711-52090 (W)</div><div>82711-52090</div><div>1. Get 2 pcs of clamp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

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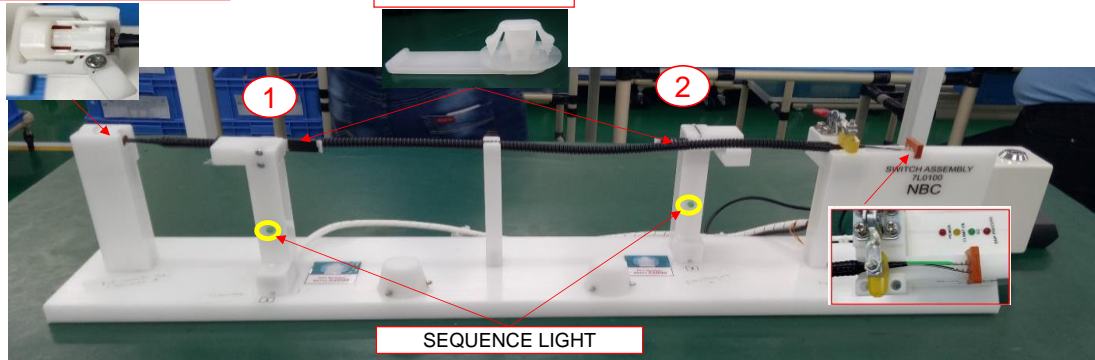



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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	<div><div>Connector setting</div><div>82711-52090 (W)</div><div></div><div>SEQUENCE LIGHT</div></div> <div><p>1. Get the assy part and set into jig. (<i>See above picture for correct setting</i>). First, set the connector 6189-0451 (W) to Receiver base 1. Last, set the terminal within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p><p>2. Check if all LED light for POWER ON, CLAMP ON was ON. Check also if sequence light of location 1 is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><div><div><p>3. Hold the clamp on location ① and start taping (3 windings) using both hands. Press the SW button after taping. Continue to location ② if light was on.</p></div><div><p>4. Hold the clamp on location ② and start taping(3 windings) using both hands. Press the SW button after taping. Go sound will be heard.</p></div><div><p>5. Conduct POINT CHECKING before removing of harness from jig.</p></div></div></div> <div><div></div><div>Important reminders/Note/s:</div><div><p>1. Make sure no gap between terminal and stopper jig.</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No wrong use of parts</p><p>2. No wrong use of tape</p><p>3. No damaged clamp</p><p>4. No wrong clamp position</p><p>5. No wrong use of clamp</p></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>			

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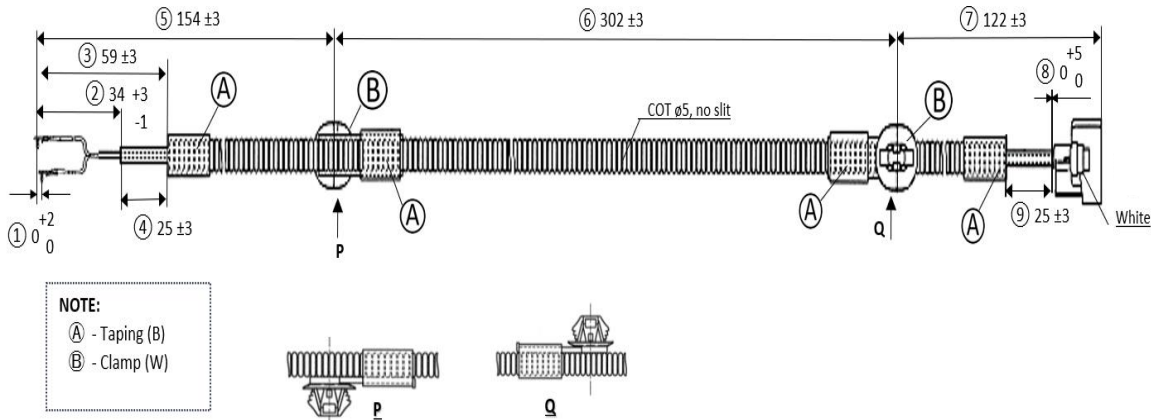

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp assy	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (B) B - Clamp (W)</div>	<div><div>MEASURING TAPE</div></div> <div>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</div>	

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PARTS:

1. Assy parts

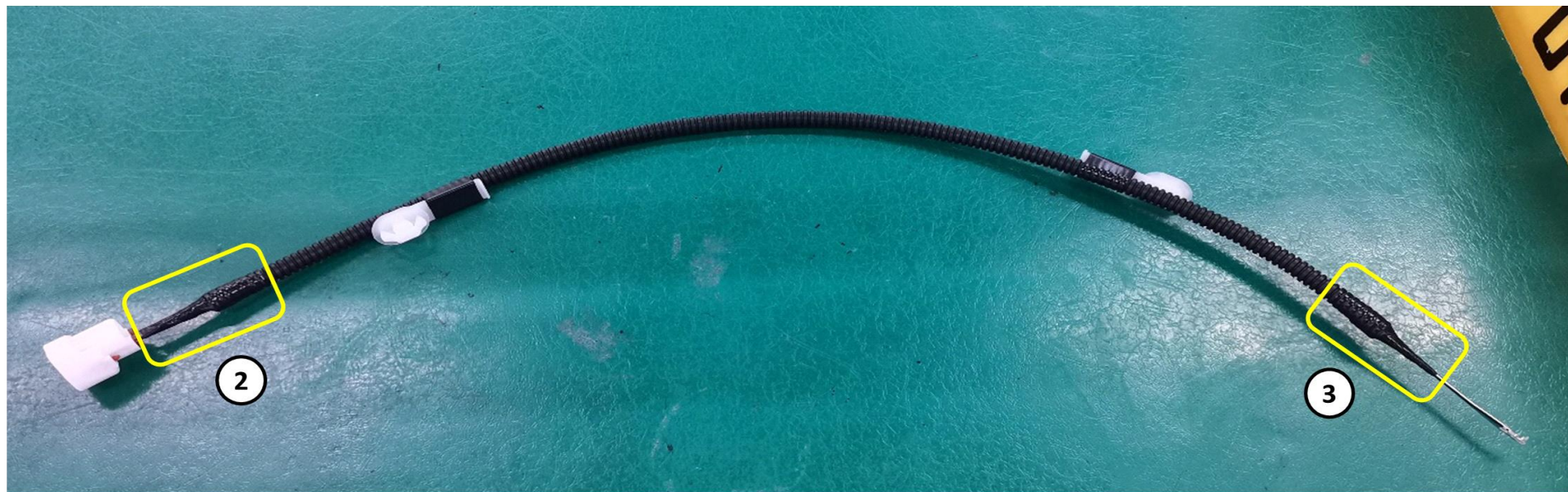
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7L0100-7021A



1 No Wrong Facing of Clamp

2 3 No Missing Tape (Black Tape)

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