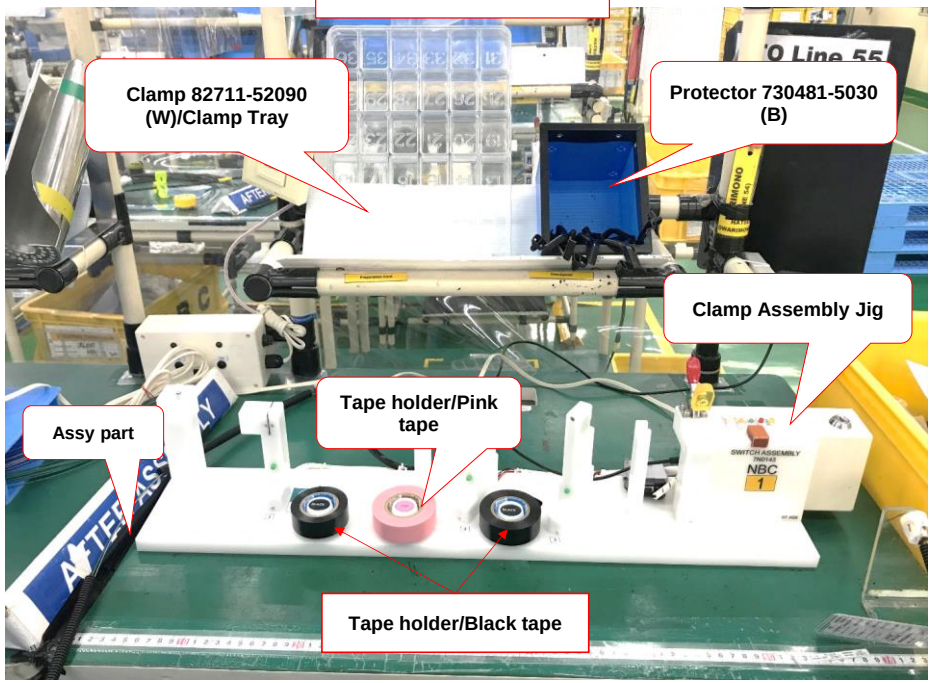
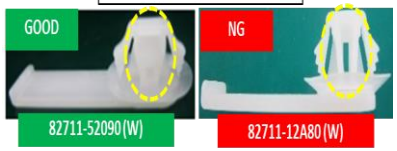
NBC	WORK INSTRUCTION			Effectivity Date:	October 22, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 990B / 7N0143-7020D	Customer: TRJ	Car Model: TOYOTA PRIUS	Document No.:	WI-ENG-PDE-1142
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 1 of 7

PARTS:	1. Assy parts; Clamp 82711-52090 (W); Protector 730481-5030 (B); Black tape [2 pcs.]; Pink 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 prescribed 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. CLAMP ILLUSTRATION 

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
10/22/24	1	Change pre-launch to mass pro	A.Hernandez	C.Villanueva	A. Arañes	n/a
10/17/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
A.Hernandez	C.Villanueva	A. Arañes	N/A
Est. Date:	October 17, 2024		

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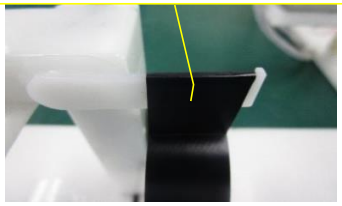
	Model code/Part number: 990B / 7N0143-7020D	Customer: TRJ	Car Model: TOYOTA PRIUS	Document No.:	WI-ENG-PDE-1142	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 7

PARTS:	1. Clamp 82711-52090 (W) 2.Protector 730481-5030 (B)	3. Black tape [2pcs.] 4. Pink tape	JIG:	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting	 1. Get the clamp **82711-52090 (W)** using right hand and put to location **1** using both hands. 2. Get the **Protector 730481-5030 (B)** using right hand and put to location **2 and 3** using both hands. 3. Initially attach black tape to location **1** using both hands.		**STANDARD TAPING FOR CLAMP** **One wind for under tape**  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wvrong clamp position ***Important reminders/note/s:*** *1. Please check the clamp first before start of assembly to avoid wrong use of clamp.*

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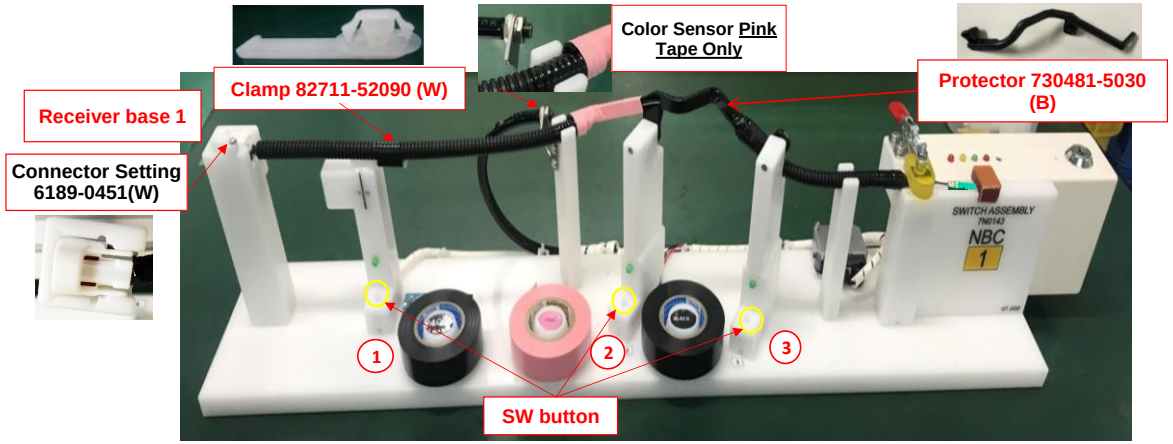
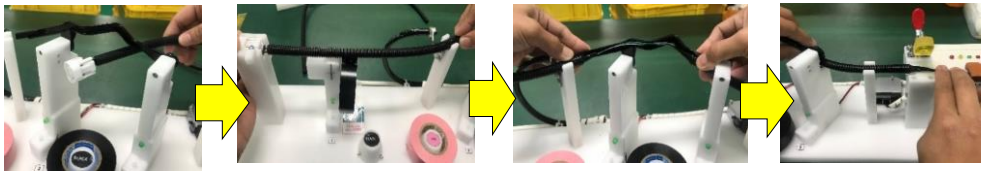
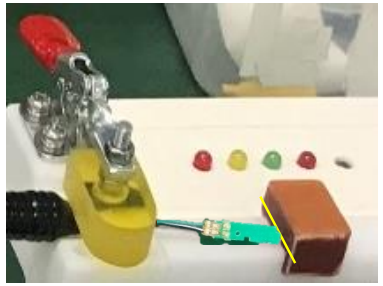
	Model code/Part number: 990B / 7N0143-7020D	Customer: TRJ	Car Model: TOYOTA PRIUS	Document No.:	WI-ENG-PDE-1142	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 3 of 7

PARTS:	1. Assy parts 2. Black tape [2pcs.]	3. Pink tape	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 and set into jig. ***(See below picture for the proper sequence of setting the harness).*** First, insert the assy parts between the protector and set the connector **6189-0451 (W)** to **Receiver Base 1** then lock. Second, fix the assy part to protector **730481-5030 (B)** then continue to set the harness in jig. Set the COT near PCB in the COT guide and put the PCB into stopper jig then pull down the toggle clamp.  2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** 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 the PCB and stopper jig.* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No loose wire in protector

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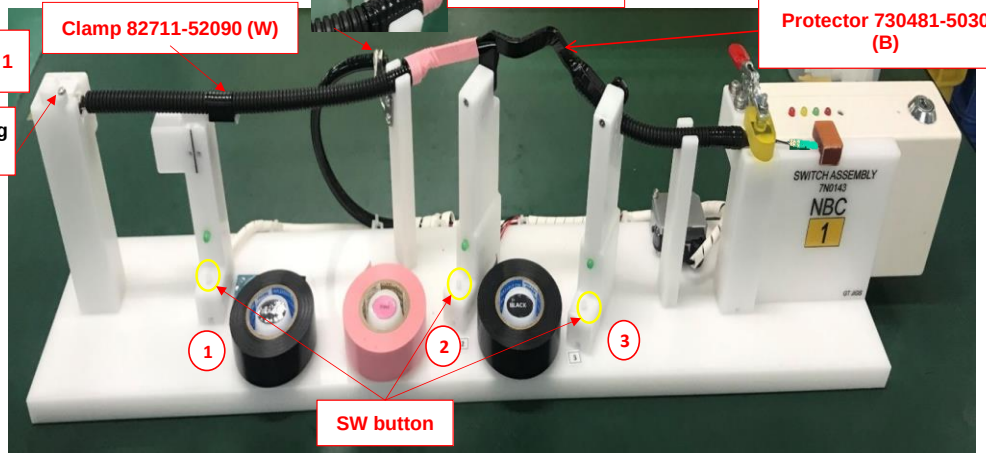
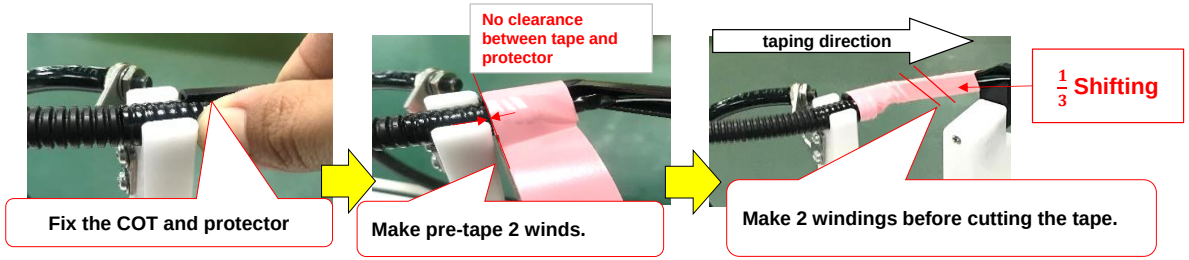
	Model code/Part number: 990B / 7N0143-7020D	Customer: TRJ	Car Model: TOYOTA PRIUS	Document No.:	WI-ENG-PDE-1142
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 4 of 7

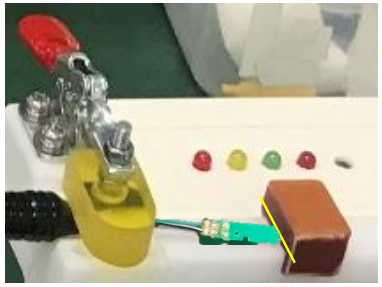
PARTS:	1. Assy parts 2. Black tape [2pcs.]	3. Pink tape	JIG:	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly (Continuation)			1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No loose wire in protector



4. Get the pink tape on location 2, start taping the COT to protector. Make half wrap taping untill it covers the first side of the protector. *(See bellow illustration and procedure)*. Clamp assembly jig will beep/buzz if the color sensor detect **PINK TAPE.** Press the **SW button** after taping. Continue the process if sequence light on clamp location **3** was ON.





Important reminders/note/s:

1. Make sure no gap between the PCB and stopper jig.

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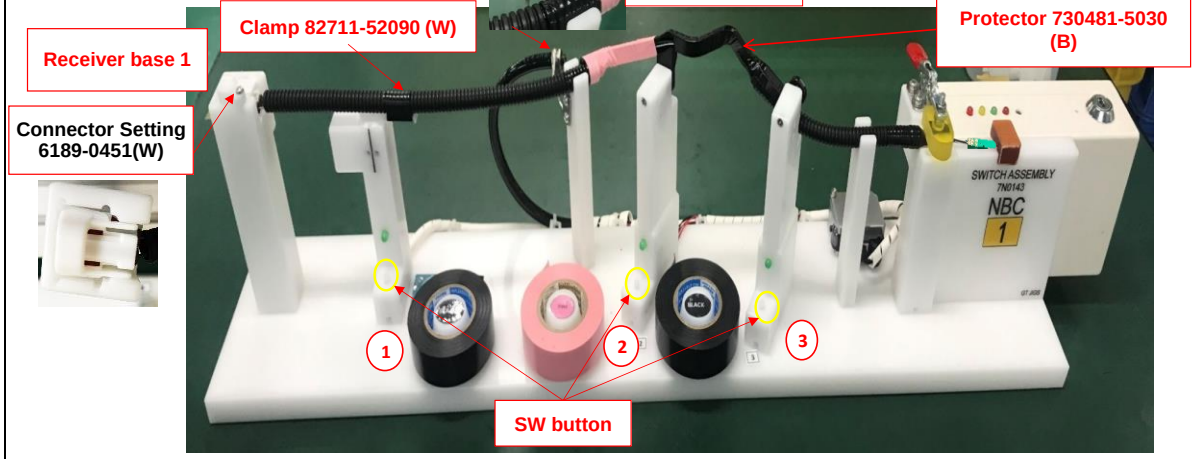
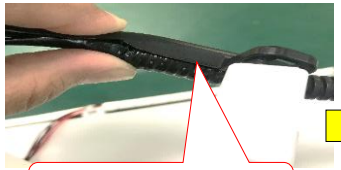
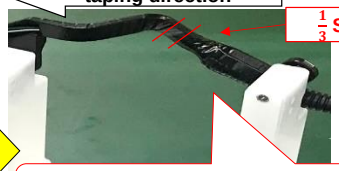
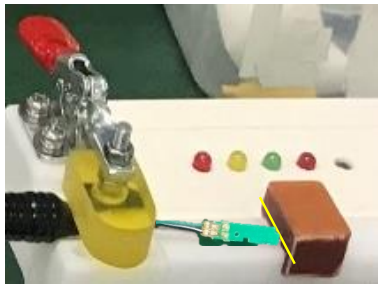
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 7

PARTS:	1. Assy parts 2. Black tape [2pcs.]	3. Pink tape	JIG:	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly (Continuation)	  5. Get the black tape on location 3, start taping the COT to protector. Make half wrap taping untill it covers the second side of the protector. *(See bellow illustration and procedure).* Press the SW button after taping GO sound will be heard. 6. Conduct Point Checking using right hand and slowly remove the harness from jig.  Fix the COT and protector No clearance between tape and protector Make pre-tape 2 winds.  taping direction $\frac{1}{3}$ Shifting Make 2 windings before cutting the tape.		1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No loose wire in protector  ***Important reminders/note/s:*** *1. Make sure no gap between the PCB and stopper jig.*

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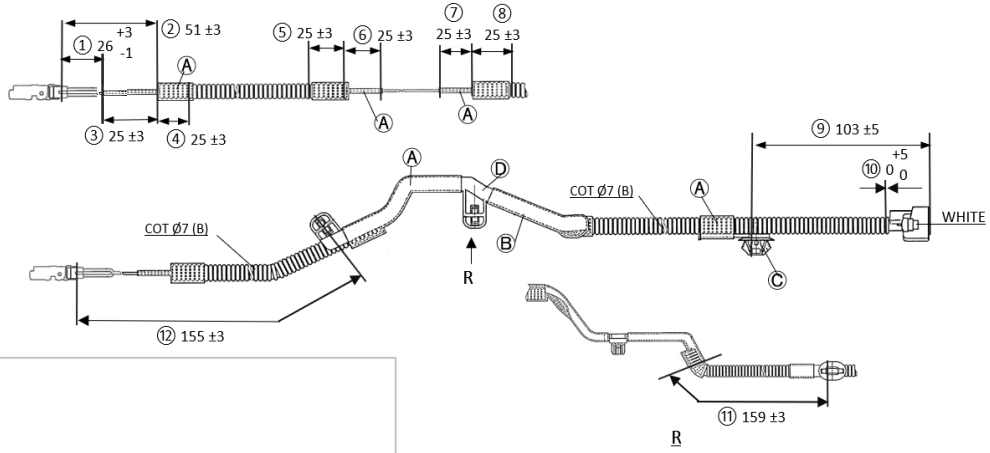
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.:	6 of 7

PARTS:	1. Assy parts	JIG:	N/A

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement	 **NOTE:** Ⓐ - Taping (B) Ⓑ - Taping (P) Ⓒ - Clamp (W) Ⓓ - Protector (B) *for item number ①, Dimension tolerance is different from the master drawing due to Internal change only.*	**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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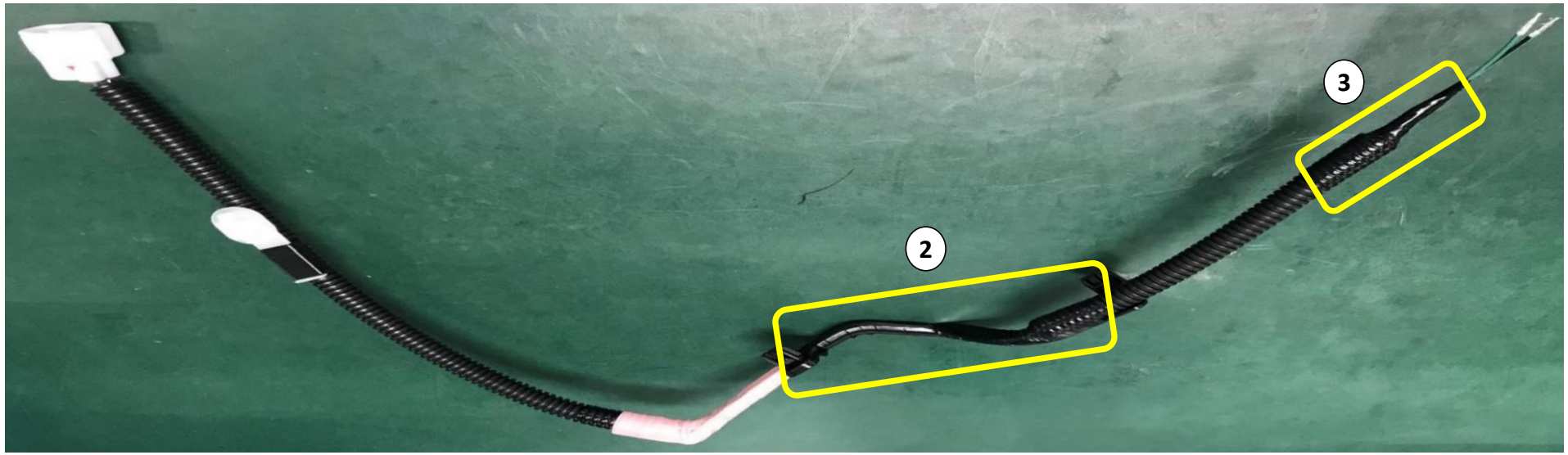
PARTS:	1. Assy parts	JIG:	N/A

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY	**7N0143-7020D**



(1) **No Wrong facing of clamp**

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

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