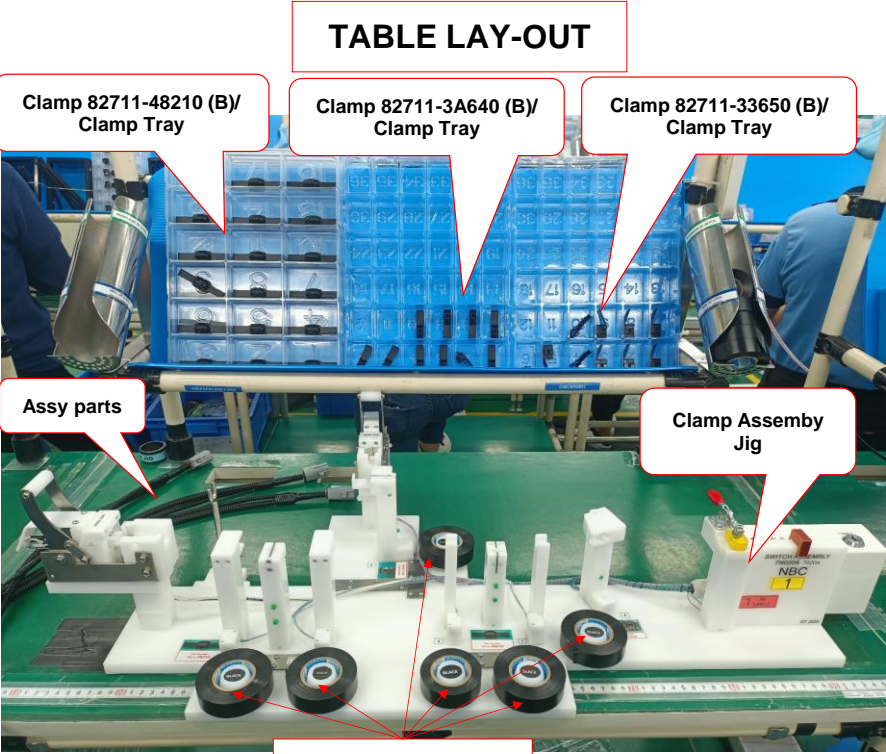
	WORK INSTRUCTION					Effectivity Date:		February 6, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS					Validity Date:		n/a		
	Model code/Part number: 930B / 7N0204-7020A		Customer: TRJ		Car Model: TOYOTA-4 RUNNER		Document No.:		WI-ENG-PDE-825	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		0		Page No.: 1 of 9

PARTS:		1. All parts: Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-33650 (B); Black tape				JIG:		1. Clamp assembly jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		CLAMP ASSY		<div>TABLE LAY-OUT</div> <div><div>Clamp 82711-48210 (B)/ Clamp Tray</div><div>Clamp 82711-3A640 (B)/ Clamp Tray</div><div>Clamp 82711-33650 (B)/ Clamp Tray</div><div>Assy parts</div><div>Clamp Assembly Jig</div><div>Black tape/ tpe holder</div></div>  <div><div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div> <td colspan="2"><b>Document references:</b> 1. Refer to WI-ENG-PDE-792 for Taping assembly process  1. No missing parts/tools 2. No excess parts/tools</td>				<b>Document references:</b> 1. Refer to WI-ENG-PDE-792 for Taping assembly process  1. No missing parts/tools 2. No excess parts/tools			

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
02/06/24 0 Initial issue								D.Castillo		C. Villanueva		A. Arañes		n/a	
Eff. Date Rev. No Details of Change								Revised		Reviewed		Approved		Noted	
								Est. Date:		February 6, 2024					

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**February 6, 2024**

Validity Date:

**n/a**

Model code/Part number:

**930B****/****7N0204-7020A**

Customer:

**TRJ**

Car Model:

**TOYOTA-4 RUNNER**

Document No.:

**WI-ENG-PDE-825**

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<b>PARTS:</b>	1. Black tape [6pcs] 2. Clamp 82711-33650 (B)	3. Clamp 82711-3A640 (B) 4. Clamp 82711-48210 (B) [2pcs]	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP P ASSY	Clamp Setting  <div data-bbox="553 405 1458 1326"><div data-bbox="562 943 1469 1321"><p>1. Get 2pcs of clamp <b>82711-48210 (B)</b> using right hand and set to clamp location <b>1,2,4 and 5</b> using both hands.</p><p>2. Get 1pc of clamp <b>82711-3A640 (B)</b> using right hand and set to clamp location <b>3</b> using both hands.</p><p>3. Get 1pc of clamp <b>82711-33650 (B)</b> using right hand and set to clamp location <b>6</b> using both hands.</p><p>4. Initially attach <b>Black tape</b> to clamp location <b>1, 2, 3, 4, 5 and 6</b> using both hands.</p></div></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <p><b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <div data-bbox="1744 839 2119 1102"><p>One side tape under clamp</p></div>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 6, 2024

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n/a

Model code/Part number:

930B

/ 7N0204-7020A

Customer:

TRJ

Car Model: TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-825

Purpose:

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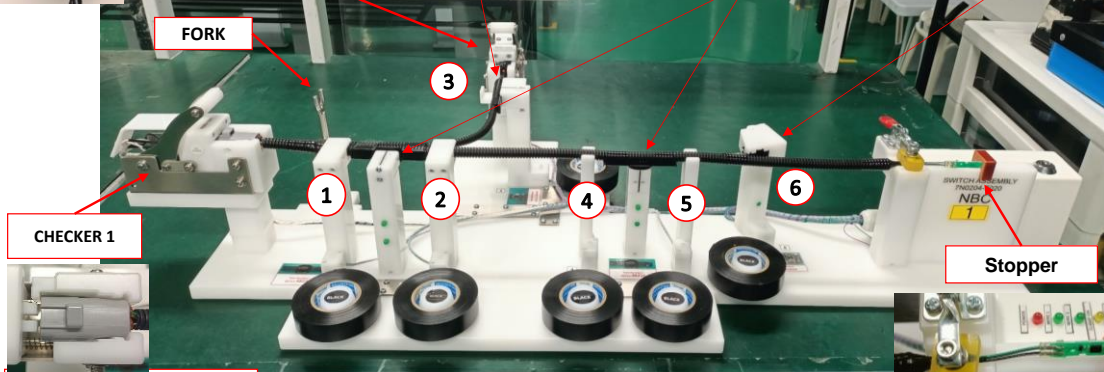
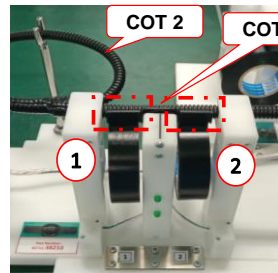

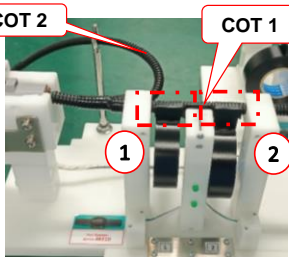

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PARTS:		1. Assy parts 2. Black tape [6pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly			
		<div><div><div></div><div><div>Connector Setting</div><div>CHECKER 2</div></div><div></div><div><div>82711-3A640 (B)</div></div><div></div><div><div>82711-48210 (B)</div></div><div></div><div><div>82711-33650 (B)</div></div><div></div></div><div><div>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6188-0066 (GR) to <b>Checker 1</b> then pull the checker fixture. Second, set the connector 6189-1161 (B) to hook then continue to set the harness in jig. Last, set the <b>hotmelted</b> within stopper then press by toggle clamp.</div><div>2. Check if all <b>LED light</b> for <b>POWER ON</b>, and <b>CLAMP ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process.</div></div><div><div><div></div><div></div><div></div></div><div>3. Hold the tape in clamp location <b>1</b>, make <b>2 windings</b> of tape using both hands. Press the switch button. Continue if the sequence light of location <b>2</b> was <b>ON</b>. Repeat the process to location 2. Press the switch button. Sequence light will <b>OFF</b>. <b>NOTE: DO NOT CUT THE TAPE</b></div></div></div>		<div></div> <div><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between terminal and stopper jig</b></div> <div><div>1. No wrong use of parts</div><div>2. No wrong use of tape</div><div>3. No damaged clamp</div><div>4. No wrong clamp position</div></div>	

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 6, 2024

Validity Date:

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Model code/Part number:

930B

/

7N0204-7020A

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

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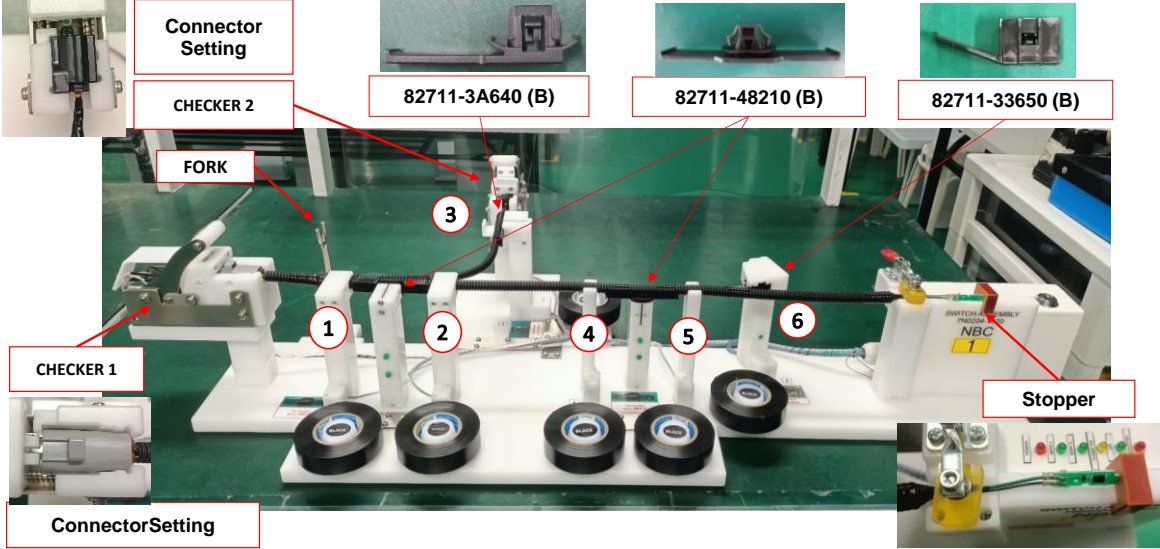
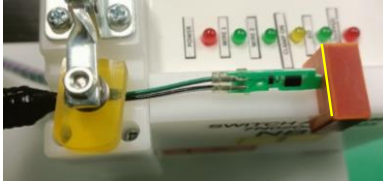
PARTS:		1. Assy parts 2. Black tape [6pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)			
		<div><div><div>Connector Setting</div><div>CHECKER 2</div><div>82711-3A640 (B)</div><div>82711-48210 (B)</div><div>82711-33650 (B)</div><div>FORK</div><div>CHECKER 1</div><div>ConnectorSetting</div><div>COT 2</div><div>COT 2</div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div><div>6</div><div>Stopper</div></div><div><p>4. After taping of clamp location <b>1</b> and <b>2</b>. Get the COT 2 and set the connector in <b>Checker 2</b> then pull the checker fixture for Continuity testing.</p><p>5. Check if all <b>LED light</b> for <b>Wire 1 and Wire 2</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process. Continue the process if the sequence light on location <b>1</b> was <b>ON</b>.</p><p>6. Hold the tape in clamp location <b>1</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location <b>2</b> was <b>ON</b>.</p><p>7. Hold the tape in clamp location <b>2</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location <b>3</b> was <b>ON</b>.</p><p>8. Hold the tape in clamp location <b>3</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location <b>4</b> was <b>ON</b>.</p></div></div>			<div><p><b>Important reminders/Note/s:</b></p><p>1. Make sure no gap between terminal and stopper jig</p><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div>

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>930B / 7N0204-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-825</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	5 of 9




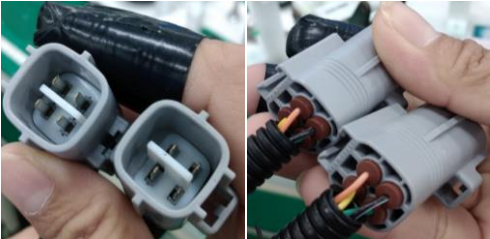


<b>PARTS:</b>	1. Assy parts 2. Black tape [6pcs]		JIG:	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	CLAMP ASSY  Clamp Assembly (Continuation)	<div></div> <div>9. Hold the tape in clamp location <b>4</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location <b>5</b> was <b>ON</b>.</div> <div>10. Hold the tape in clamp location <b>4</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location <b>5</b> was <b>ON</b>.</div> <div>11. Hold the tape in clamp location <b>5</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location <b>6</b> was <b>ON</b>.</div> <div>12. Hold the tape in clamp location <b>6</b>, make <b>2 windings</b> of tape using both hands then cut the tape. Press the switch button. <b>GO</b> buzzer will be heard.</div> <div>13. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</div>	 <b>Important reminders/Note/s:</b> <b>1. Make sure no gap between terminal and stopper jig</b>  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position	

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	Model code/Part number: <b>930B / 7N0204-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-825</b>		
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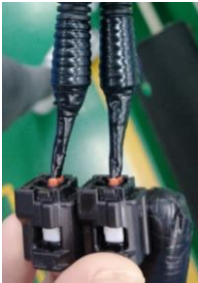





<b>PARTS:</b>	1. Assy parts 2. Master sample			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1  Visual/By Two's Inspection	<div><p>ACTUAL PRODUCT</p></div> <div><p>Master sample</p></div> <div><p>Assembled parts</p></div> <div></div> <div></div> <div>1. Conduct <b>alignment of harness (Master sample vs. Assembled parts)</b> using both hands.</div> <div>2. Check the <b>connector lock condition, insertion and terminal.</b></div> <div>3. Check the <b>presence of clamp attachment, taping condition and Spot taping condition.</b></div>		<div><b>MASTER SAMPLE</b></div>  <p>1. No skip checking during inspection.</p>	

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>930B / 7N0204-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-825</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	7 of 9

<b>PARTS:</b>	1. Assy parts 2. Engineering sample			JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1  Visual/By Two's Inspection (Continuation)	<div><div>ACTUAL PRODUCT</div></div> <div></div> <div></div> <div>4. Check the <b>presence of clamp attachment, taping condition</b> and <b>Taping condition</b>.</div> <div><div>5. Check the <b>taping condition</b> and <b>appearance of PCB</b>.</div></div>				<div><div>ENGINEERING SAMPLE</div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>


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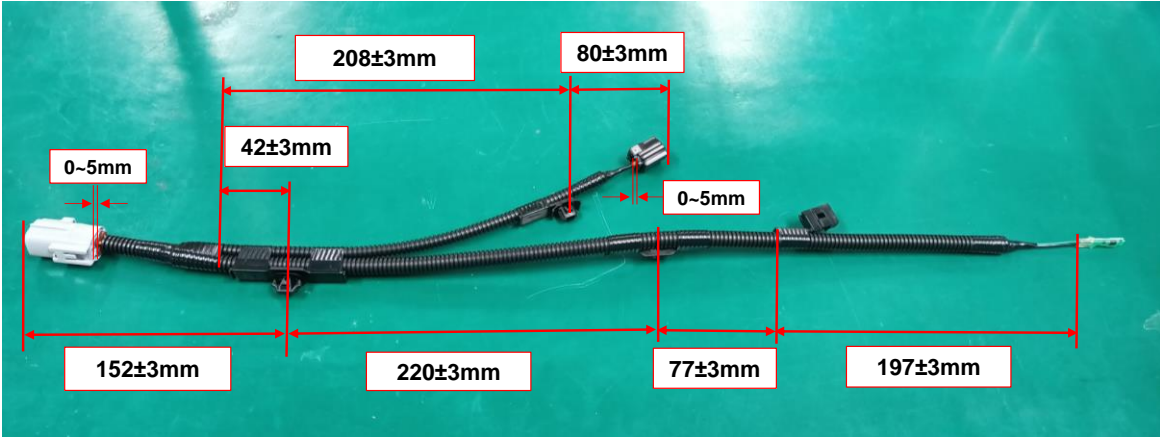

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>		
	Model code/Part number: <b>930B / 7N0204-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-825</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>0</b>	Page No.:	<b>8 of 9</b>

<b>PARTS:</b>		1. Assy parts		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
5	P1	Measurement	<div>MEASURING TAPE</div>    <div>Note: Measurement should be on <b>END TAPE</b></div>	<div><b>Important reminders and note/s:</b></div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div><b>Document reference/s:</b></div> <div>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>		

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**WORK INSTRUCTION**

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**WI-ENG-PDE-825**

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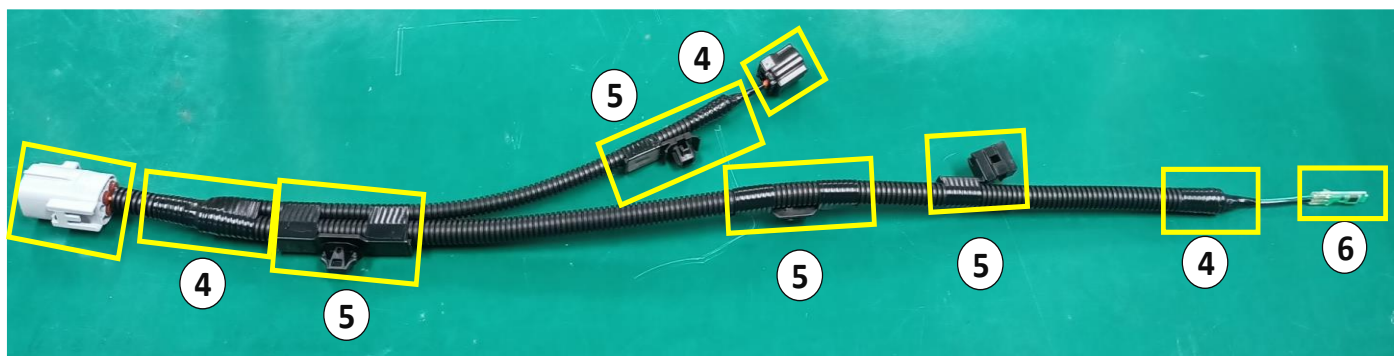
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**PARTS:**

1. Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7N0204-7020A****NO GOOD****GOOD****① No Unlock/ Halflocked Connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Missing tape****⑤ No Missing clamp (4pcs)****⑥ No Deformed Hotmelted****GOOD****GOOD****NO GOOD****NO GOOD**

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