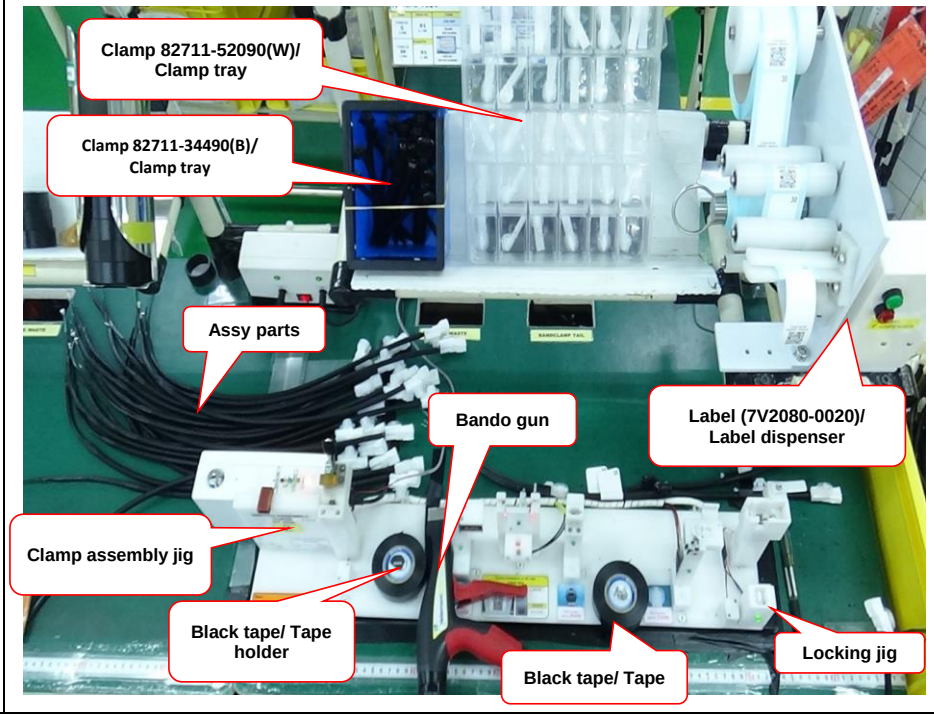
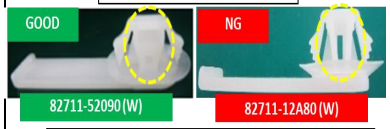
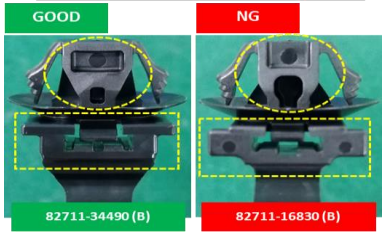
	WORK INSTRUCTION			Effectivity Date:	May 20, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 010B / 7L0030-7024	Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-800	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 1 of 8

PARTS:	1.Assy parts; Label 7V1070-0020 (73230-06750); Clamp 82711-34490 (B); 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	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. **Bando Gun** 	***Document reference/s:*** *1. Refer to **WI-ENG-PDE-390** for Taping assembly process.* 1. No missing parts/tools 2. No excess parts/tools CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION 

Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/20/24	0	Initial issue.	D.Castillo	C.Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 20, 2024		

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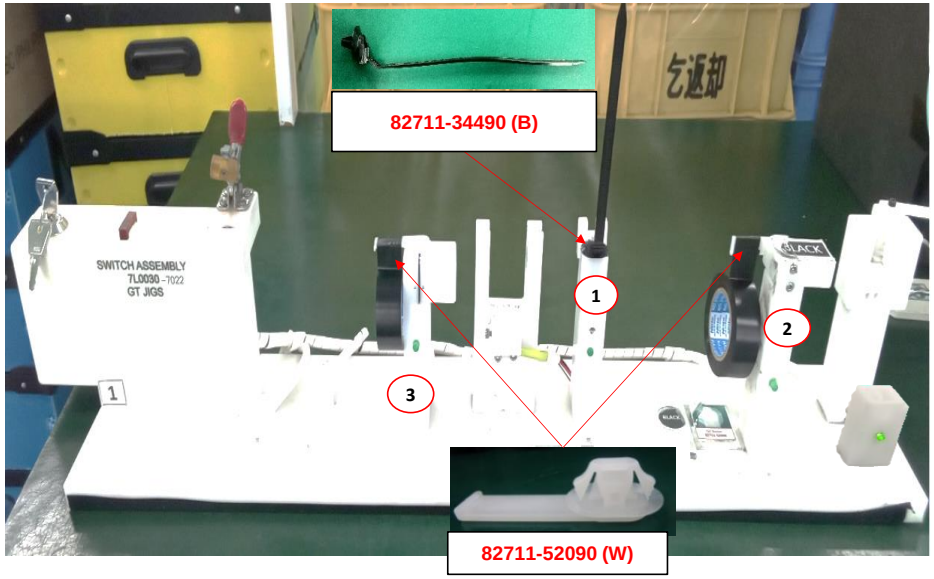
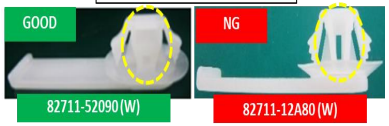
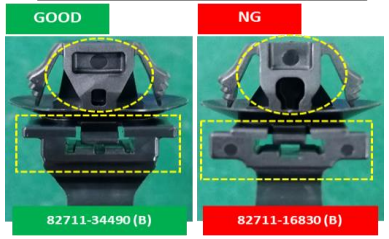
DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	May 20, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 010B / 7L0030-7024	Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-800		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	2 of 8

PARTS:	1. Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W) [2pcs]	3. Black tape [2pcs]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	 1. Get **1 pc** of band clamp **82711-34490 (B)** using right hand and set to clamp location ① using both hands. 2. Get **2 pcs** of clamp **82711-52090 (W)** using both hands and set to clamp location **3** and **2** using both hands. 3. Get the Black tape using right hand and conduct pre-taping on clamp location **3** and **2** using both hands.	n/a	**One wide for under clamp** 1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION 

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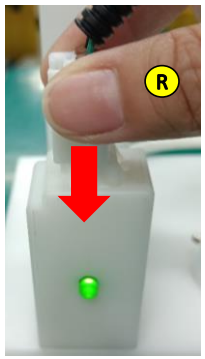
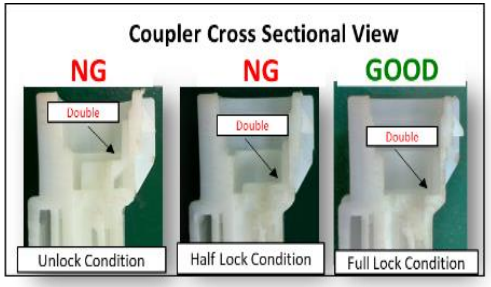
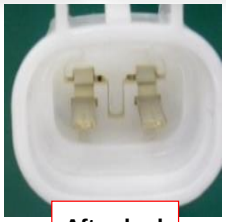
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	3 of 8

PARTS:	1. Assy parts			JIG:	1. Locking Jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	Clamp Assy	Connector Lock	  Before lock  After lock 1. Put the connector into locking jig using right hand then press **2x** to lock using both hands. Check the lock if properly locked.	LOCKING JIG	***Important reminders/Note/s:*** *1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.* 1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process

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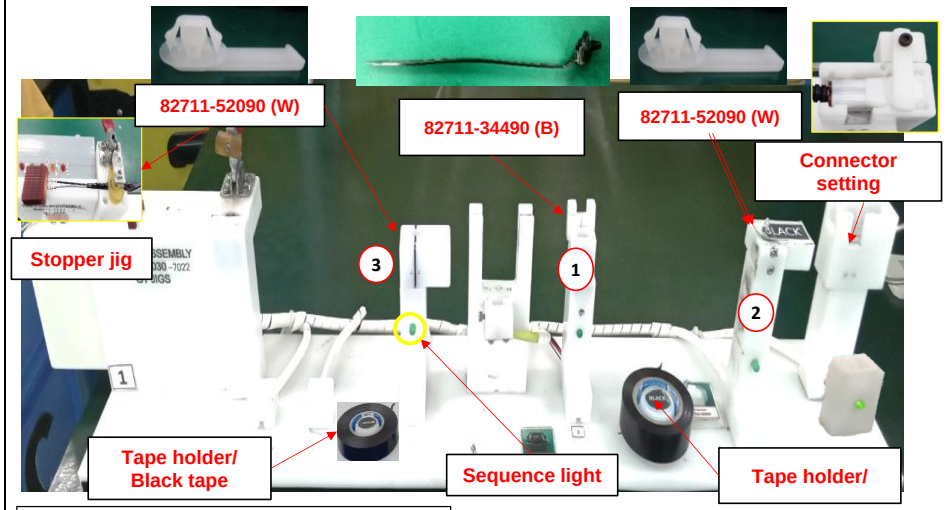
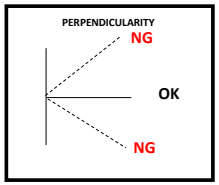
	WORK INSTRUCTION			Effectivity Date:	May 20, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 010B / 7L0030-7024	Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-800		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	4 of 8

PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	Clamp Assy	Clamp Assembly	 1. Put the assy parts into jig using both hands. First put the connector to receiver base using left hand and lock using right hand. Second, put the terminal into stopper jig usig left hand and pull down the toggle clamp using right hand. *Refer to above illustration for the correct setting.* 2. Check if the LED light for **POWER, CLAMP and SEQUENCE LIGHT** is **ON.** If encountered abnormality, **STOP** the process, **CALL** the attention of the Leader and **WAIT** for instruction. 3. Initially tighten the band clamp **82711-34490** on clamp location **1** using right hand. 4. Get the bando gun using right hand then cut the band clamp on Location **①.** Press the **SW button** every cut using both hand. 	**BANDO GUN** 	***Important reminders/note/s:*** *1.Make sure no clearance between terminal and stopper jig.* 1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No wrong use of tape 6. No peel off tape 7. No missing tape Fixed setting of band clamp cutter: 1 ~ 2 **BANDO GUN ALIGNMENT** 

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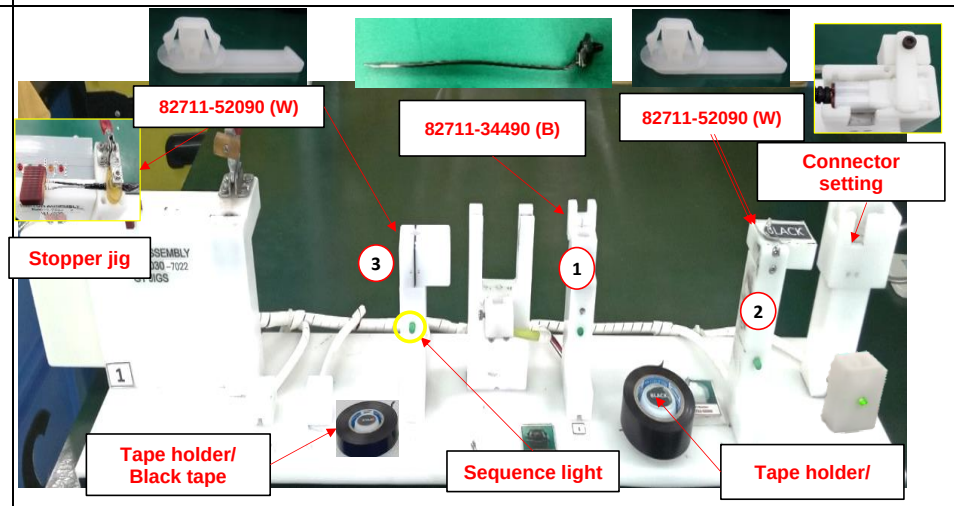
PARTS:	1. Assy parts; Clamp 82711-52090; Clamp 82711-34490; Black tape	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Clamp assembly (Continuation)	 5. Hold the tape on clamp location **2** using both hands. Make **3 windings** then cut the tape using both hand. Press the **SW button** every taping.Continue if sequence light on clamp location **3** was **ON.** 6. Hold the tape clamp on location **3** using both hands. Make **3 windings** then cut the tape. Press the **SW button** every taping. Proceed to attachment of Label.	n/a	***Important reminders/note/s:*** *1.Make sure no clearance between terminal and stopper jig.* 1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No wrong use of tape 6. No peel off tape 7. No missing tape

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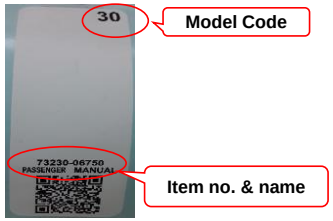
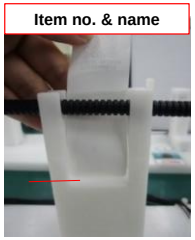
	Model code/Part number: 010B / 7L0030-7024	Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-800		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	6 of 8

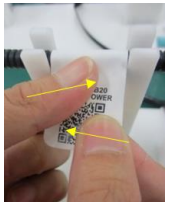
PARTS:	1.Assy parts; Label (7V1070-0020)			JIG:	1. Clamp assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
5	Clamp Assy	Clamp assembly Label Attachment			





1. Get the label.
Check the model code, item no. & name

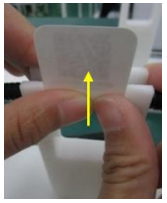
2. Align the end part of label in the jig.

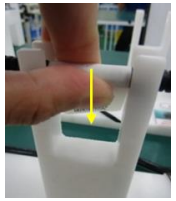


3. Fold the center part of the label.

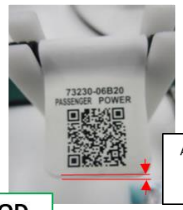
4. Align both end part of label .

5. After alignment , Press the label with both fingers. Make sure it was attach properly.





6. Press the label upside down using finger.



Acceptable overlap
0~1mm

GOOD

7. Press the SW button after label attachment. Conduct **POINT CHECKING** and remove the harness from jig.

Label Dispenser

Model	Item no.	Item name
7L0030	73230-06750	Passenger Manual
7L0031	73230-06740	Driver Manual
7L0032	73230-06B20	Passenger Power
7L0033	73230-06760	Driver Power

1. No bubbles
2.No damage
3.No peel off
4.No wrong use of label
5. No missing parts
6. No loose attachment

NG

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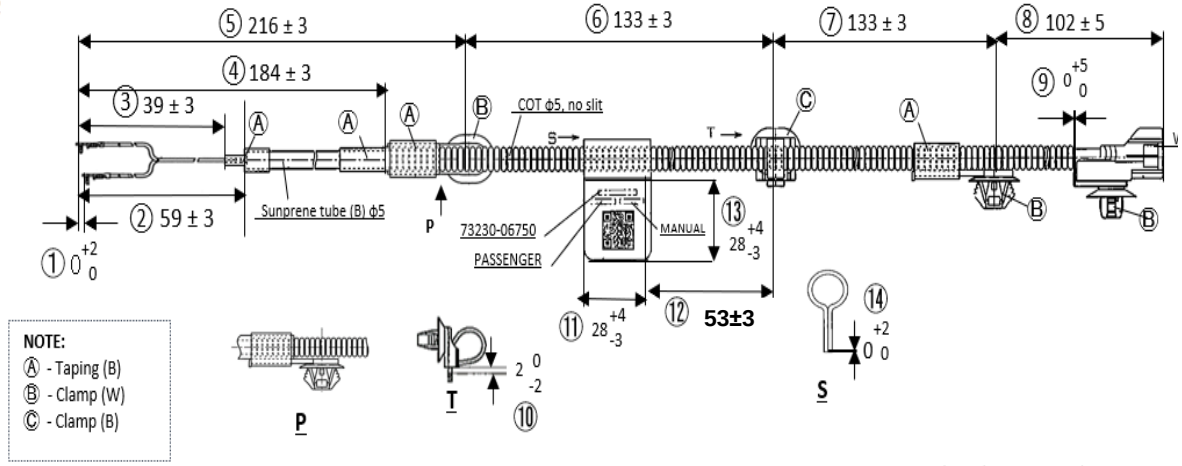
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	7 of 8

PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
6	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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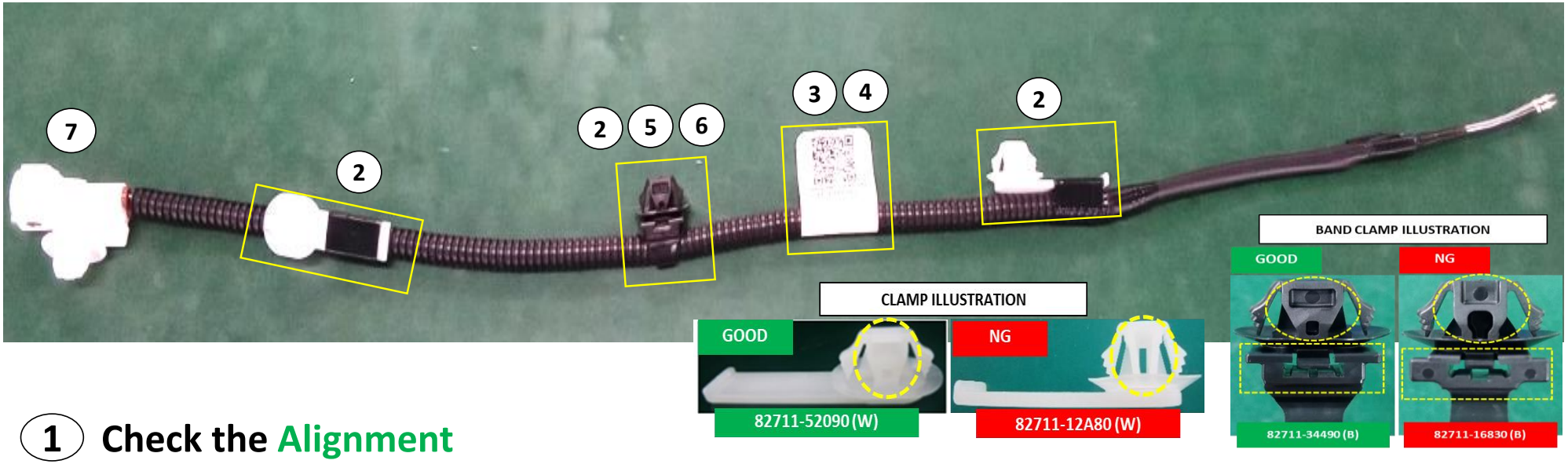
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION

CLAMP ASSY	7L0030-7024



1. Check the Alignment
2. Check the Clamp appearance
3. No Wrong orientation of Barcode
4. No Wrong use of Barcode
5. No Loose band clamp
6. No NG cut
7. No Deformed Terminal

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