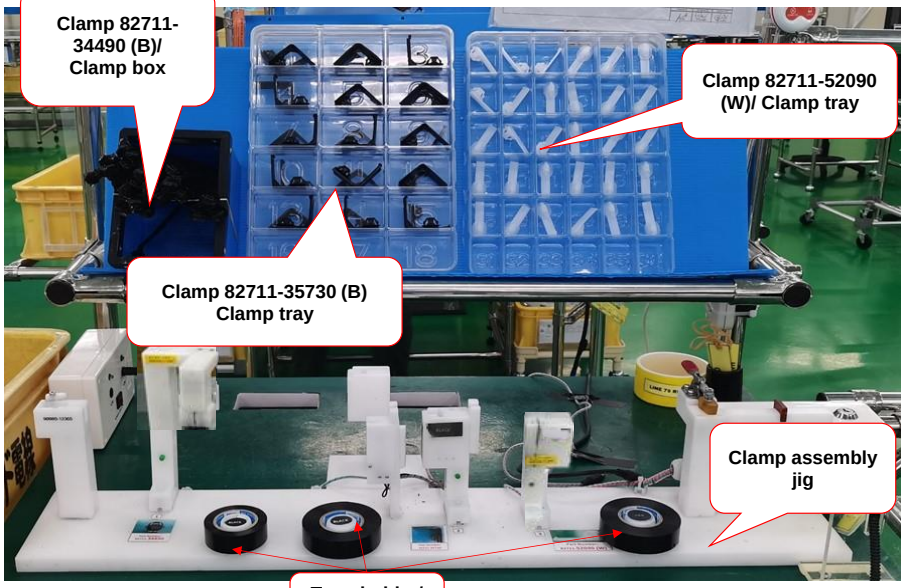
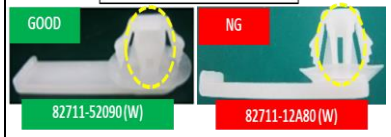
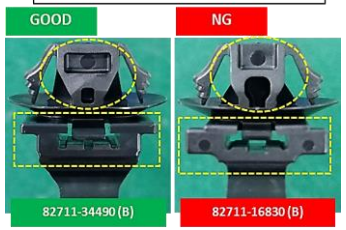
	WORK INSTRUCTION			Effectivity Date:	June 24, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 895B / 7N0091-7020A	Customer: TRJ	Car Model: TOYOTA COROLLA CROSS	Document No.:	WI-ENG-PDE-673	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 1 of 7

PARTS:	1. Assy parts; Clamp 82711-34490 (B); Clamp 82711-52090 (W); Clamp 82711-35730 (B); Black tape [3pcs]	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		2 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.	***Documents reference/s:*** *1. Refer to **WI-PRO-CNC-664** for Offline assembly process.* 1. No missing parts/tools 2. No excess parts/tools CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION 

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/24/24	2	Improved assemby jig. Update table lay-out, Measurement and Visual inspection/Quality checkpoints. Inclusion of Car model "TOYOTA-COROLLA CROSS" .	D.Castillo	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
05/29/23	1	Improve Work procedure/Illustration on process no. 1-3; Additional notes for spot taping; Inclusion of spot taping switch guide as countermeasure to customer claim for wrong facing of clamp.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
05/03/23	0	Initial Issue. Change Process name/Title from TAPING ASSEMBLY PROCESS to CLAMP ASSEMBLY PROCESS; change Document no. from WI-ENG-PDE-664B to WI-ENG-PDE-673 due to separation of process.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
							Est. Date:	May 03, 2023		

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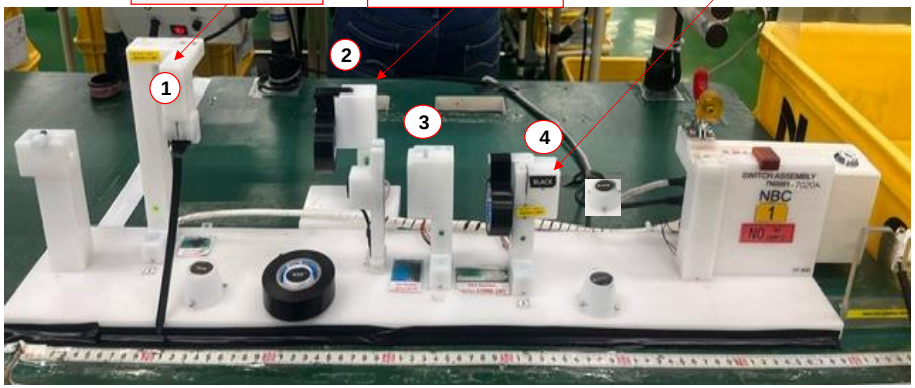
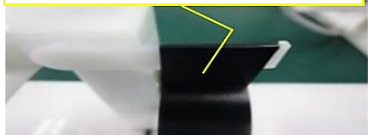
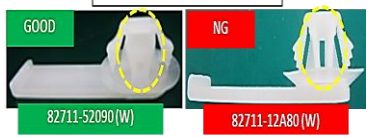
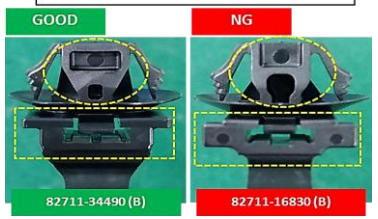
	WORK INSTRUCTION			Effectivity Date:	June 24, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 895B / 7N0091-7020A	Customer: TRJ	Car Model: TOYOTA COROLLA CROSS	Document No.:	WI-ENG-PDE-673		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.:	2 of 7

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

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	Clamp Setting	 82711-34490 (B) 82711-35730 (B) 82711-52090 (W)  1. Get 1 pc. of band clamp **82711-34490 (B)** then set to clamp location **1** using both hands. 3. Get 1 pc. of clamp **82711-52090 (W)** then set to clamp location **4** using both hands. 2. Get 1 pc. of clamp **82711-35730 (B)** then set to clamp location **2** using both hands. 4. Initially attach **Black tape** on clamp location **2 and 4** using both hands.	n/a	1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp ***Important reminders/Note/s:*** *1. Please check the Clamp first before start of assembly to avoid wrong use of* STANDARD TAPING FOR CLAMP One wind for under tape  CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION 

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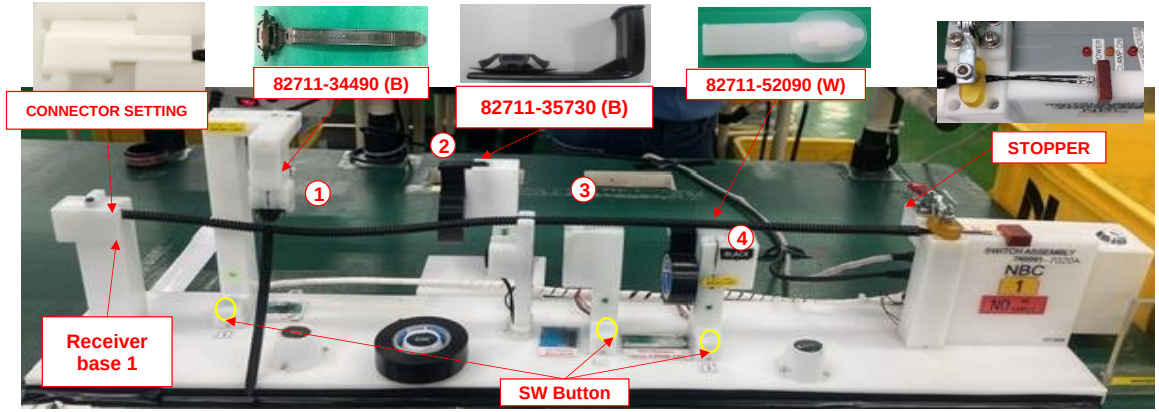
NBC	WORK INSTRUCTION			Effectivity Date:	June 24, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 895B / 7N0091-7020A	Customer: TRJ	Car Model: TOYOTA COROLLA CROSS	Document No.:	WI-ENG-PDE-673
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.: 3 of 7

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly			1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape 5. No loose/tight clamp attachment

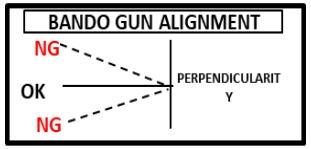


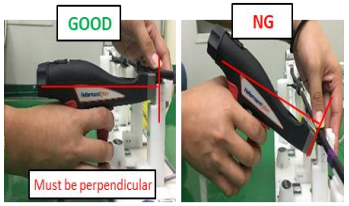
1.Get the assy parts and set into jig. *(See above picture for correct setting).* First, set the connector **6098-3802 (W)** to **Receiver base 1**. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of **location** ① was on.

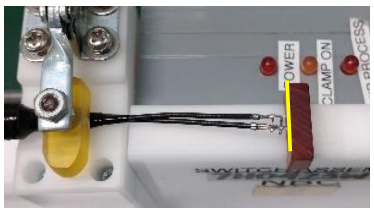
2. Check if all **LED light** for **POWER ON, WIRE1, WIRE 2 and CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.

3. Initially tighten the band clamp on **location 1** using both hands.

4. Get the bando gun using right hand then cut the band clamp on location **1.** Continue the process if sequence light button on location **2** was on.

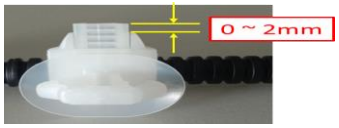


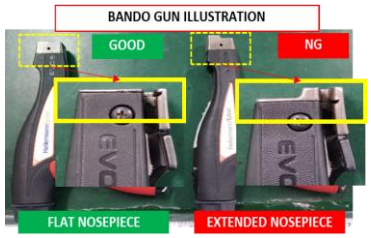




Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.
2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).





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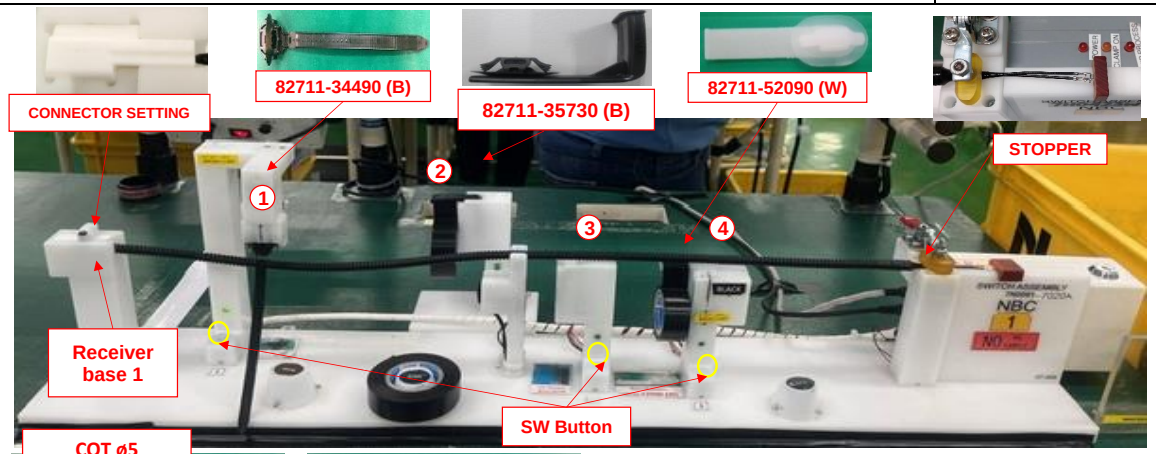
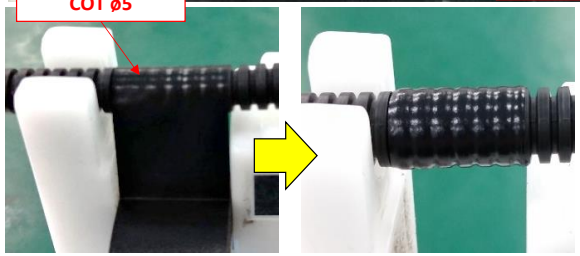
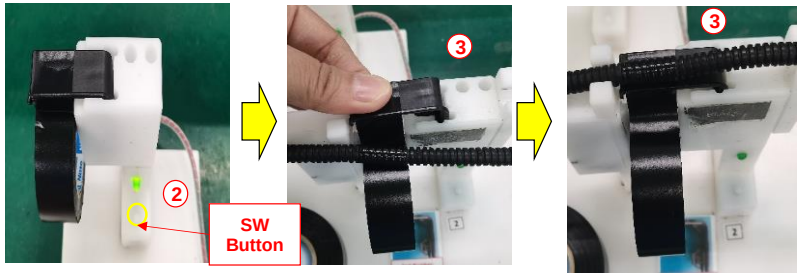
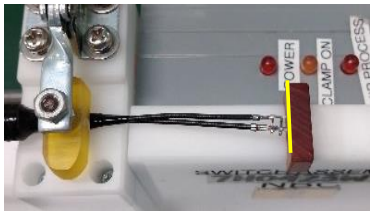
	WORK INSTRUCTION			Effectivity Date:	June 24, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 895B / 7N0091-7020A	Customer: TRJ	Car Model: TOYOTA COROLLA CROSS	Document No.:	WI-ENG-PDE-673	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 4 of 7

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly (Continuity)	  5. Conduct spot taping on COT in clamp location **3**. Make **2 winds** only then cut the tape .Press the SW button after taping . ***Note: No exessive windings of tape***  6. Press the **SW button** and get the clamp **(82711-35730 (B))** in location **2** then put in location **3.**		1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape  ***Important reminders/Note/s:*** ***1.Make sure no gap between stopper jig and terminals.*** ***2. Make 2-3 windings for clamp taping.***

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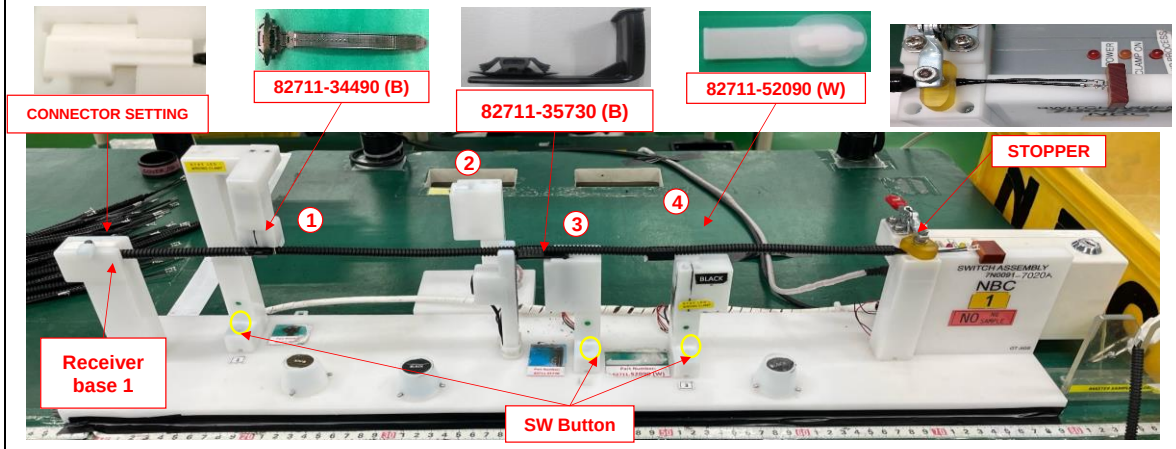
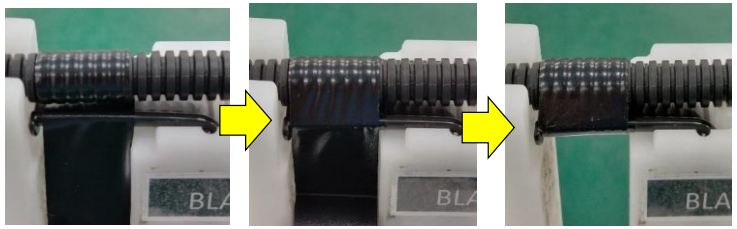
	Model code/Part number: 895B / 7N0091-7020A	Customer: TRJ	Car Model: TOYOTA COROLLA CROSS	Document No.:	WI-ENG-PDE-673	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 5 of 7

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly (Continuity)			1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process

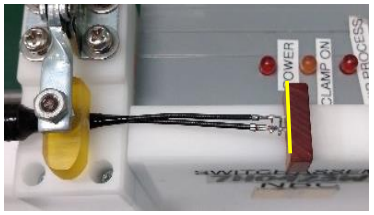




7. Tape the clamp on location **3** using both hands. Make **3 winds** then cut the tape. Press the SW button after taping. Continue the process if sequence light in location **4** was **on**.
Note: Controller will alarm if detect excessive windings of tape.

8. Tape the clamp on location **4** using both hands. Make **3 winds** then cut the tape. Press the **SW button** after taping. **Go** sound will be heard .

9. Conduct **POINT CHECKING** before removing the harness from jig.



Important reminders/Note/s:

1. Make sure no gap between stopper jig and terminals.

2. Make 2-3 windings for clamp taping

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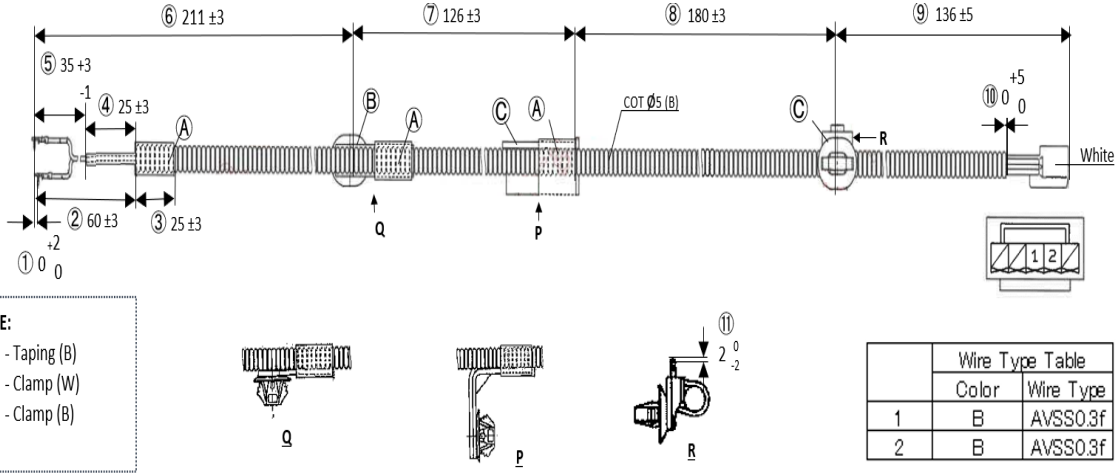
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 6 of 7

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		2 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



	Wire Type Table	
	Color	Wire Type
1	B	AVSS0.3f
2	B	AVSS0.3f

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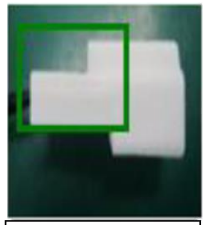
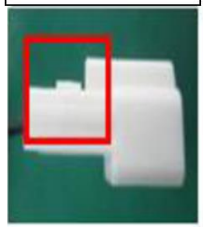
PARTS:	1. Assy parts	JIG:	n/a

2 VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY	7N0091-7020A



GOOD



NO GOOD

1 No Wrong Facing of Clamp 2 No Unlock/Halflock connector 3 No Missing Tape (Black Tape)

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