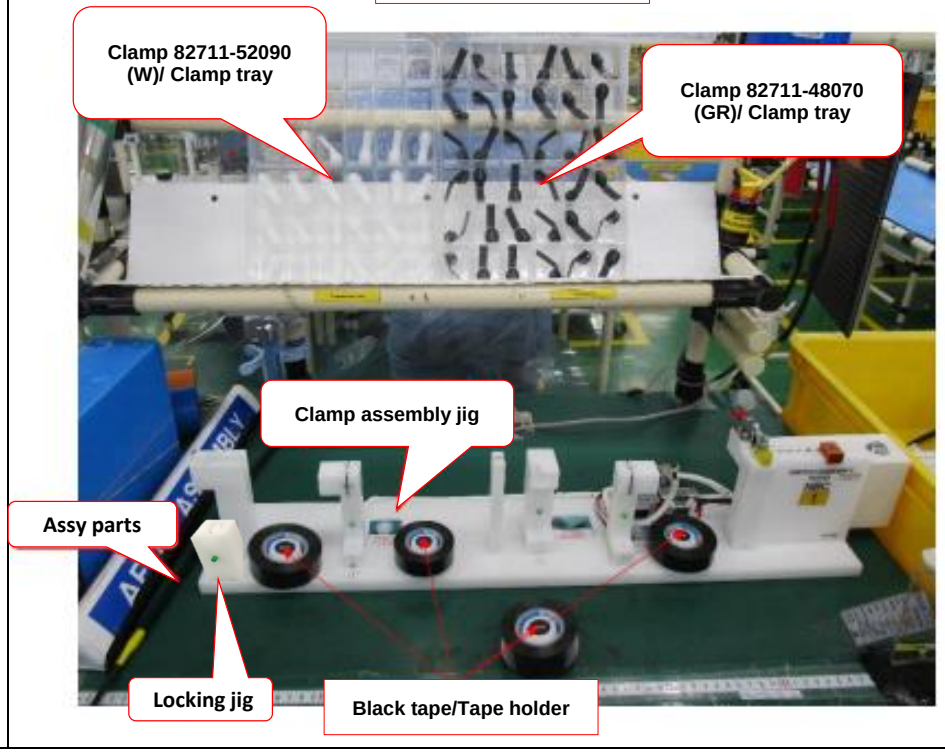
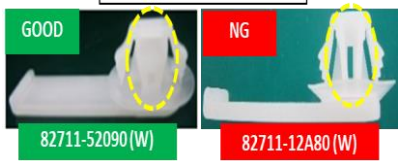
NBC	WORK INSTRUCTION			Effectivity Date:	June 11, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	102D / 7L0121-7024	Customer: TRQSS / Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-797
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0 — Page No.: 1 of 6

PARTS:	1. All parts: Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [3pcs.]	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 required 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.	***Document references:*** ***1. Refer to WI-ENG-PDE-424A-B Taping Assembly Process*** 1. No missing parts/tools 2. No excess parts/tools CLAMP ILLUSTRATION 

Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/11/24	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:	June 11, 2024		

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DCC Stamp

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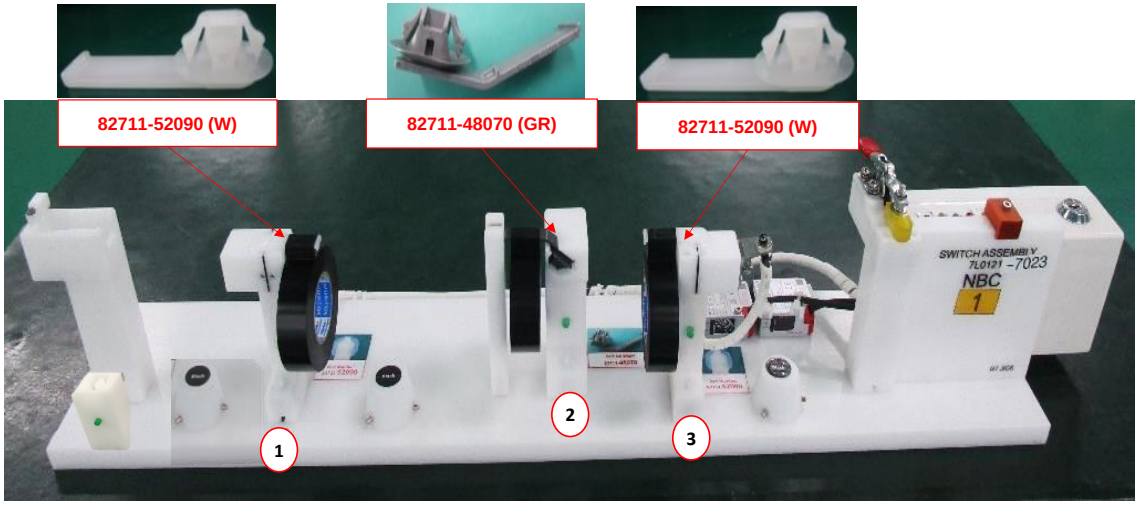
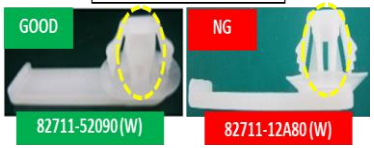
	Model code/Part number: 102D / 7L0121-7024	Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-797	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 2 of 6

PARTS:	1. Clamp 82711-52090 (W) [2pcs.] 2. Clamp 82711-48070 (GR)	3. Black tape [3pcs.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	 1. Get 2pcs. of clamp **82711-52090 (W)** using both hands then set to clamp location **1 and 3** using both hands. 2. Get 1pc. of clamp **82711-48070 (GR)** using right hand then set to clamp location **2** using both hands. 3. Initially attach **Black tape** on clamp location **1, 2, and 3** using both hands.		**STANDARD TAPING FOR CLAMP** One wind for under tape 1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape ***Important reminders/Note/s:*** *1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.* **CLAMP ILLUSTRATION** 

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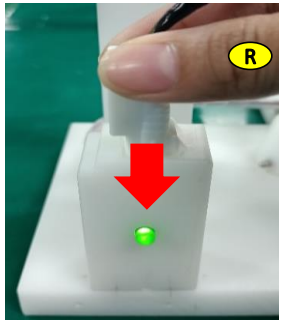
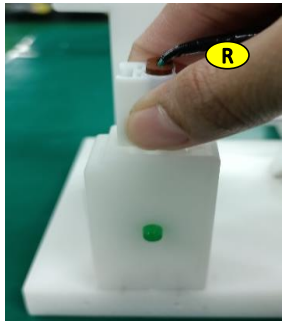
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	3 of 6

PARTS:	1. Assy parts			JIG:	1. Locking Jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	CLAMP ASSY	Connector 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. Before lock After lock	**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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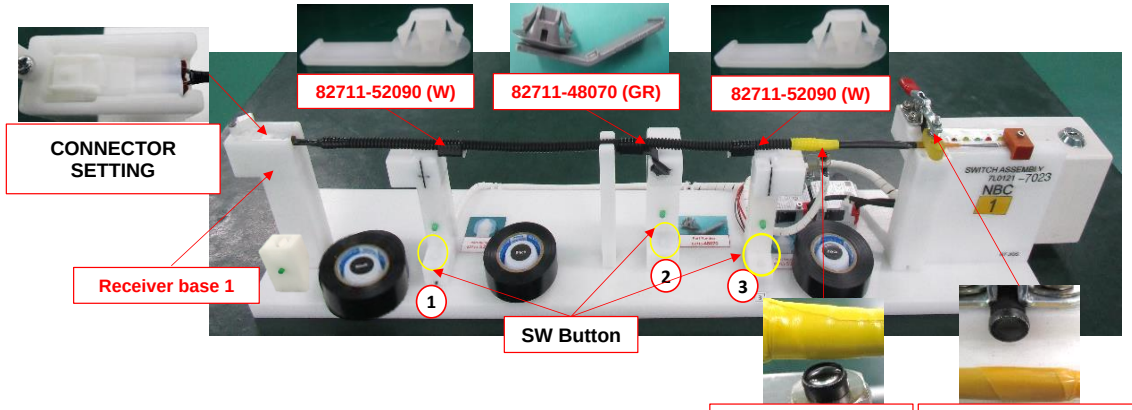
PARTS:	1. Assy parts 2. Black tape	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Clamp assembly			



1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0407 (W)** to **Receiver base 1** then lock. Continue to set the harness in jig, **Color sensor** light will beep/buzz if detects **Yellow tape**. **Color sensor** light will beep/buzz if sensor detects **Orange tape**. Last, set the **G-B/W wires** together within stopper jig then press by toggle clamp. Continue if sequence light in location **1** was **ON.**

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2, Sensor ON** 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 in clamp location **2** was **ON.**

4. Hold the tape on clamp location **2.** Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **3** was **ON.**

5. Hold the tape on clamp location **3.** Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard.

6. After taping, **CONDUCT POINT CHECKING** before removing the harness in jig.

Important reminders/Note/s:

1. Make sure no gap between stopper and terminals.
2. Make 2-3 windings for clamp taping

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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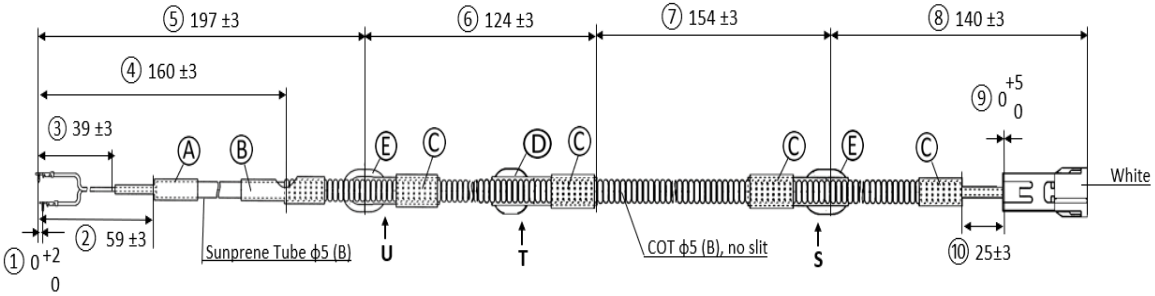
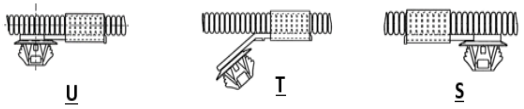
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 5 of 6

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

MEASURING TAPE



NOTE:
- Ⓐ - Taping (OR)
- Ⓑ - Taping (Y)
- Ⓒ - Taping (B)
- Ⓓ - Clamp (GR)
- Ⓔ - Clamp (W)



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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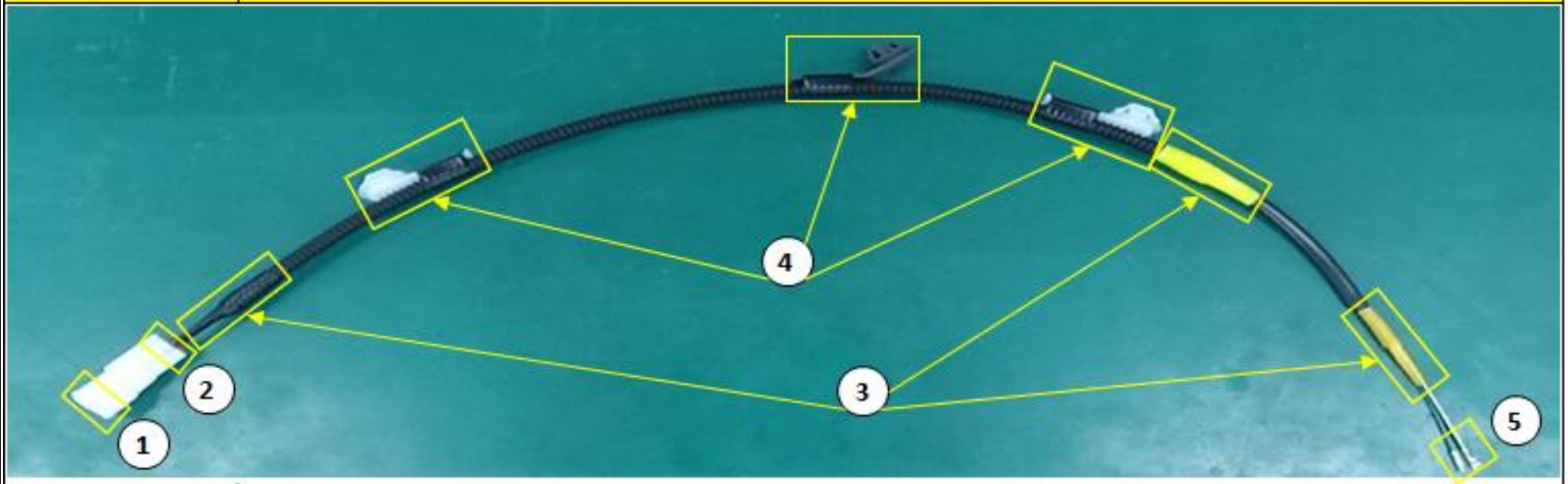
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY	7L0121-7024



1. No Unlock/Halflock Connector
2. No Wrong Insert/ Terminal Backing Out
3. No Missing Tape
   (COT to wire near connector)
   (COT to Sunprene tube near terminal (Y))
   (Sunprene tube to wire near terminal (OR))
4. No Missing Clamp
   (82711-52090) (W)
   (82711-48070) (GR)
5. No Deformed Terminal

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