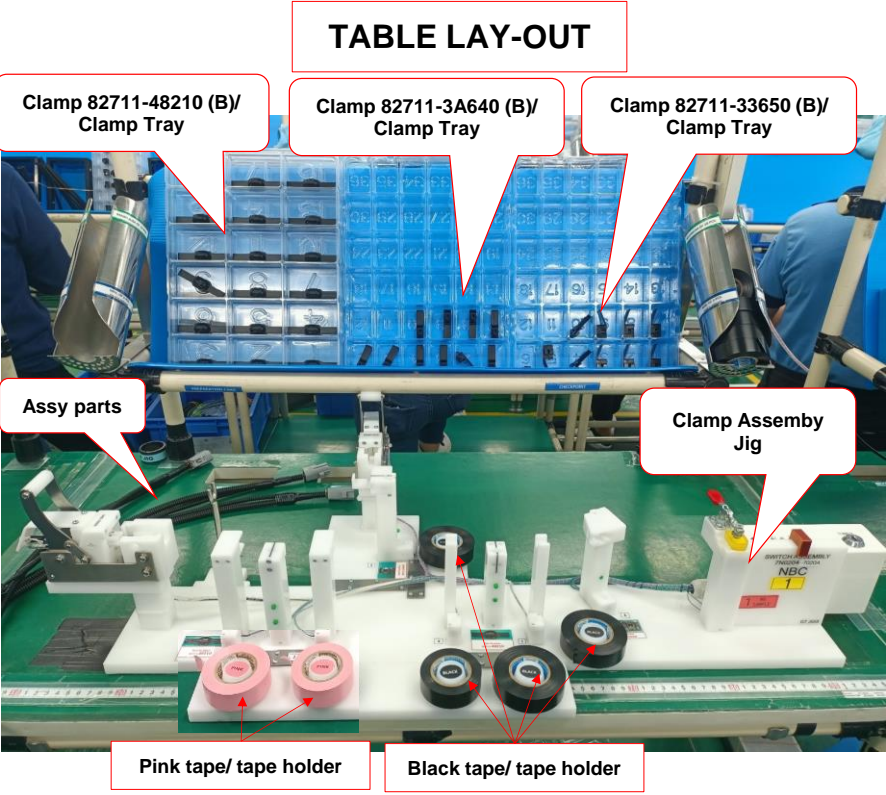



	WORK INSTRUCTION				Effectivity Date:	November 18, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-876		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 7

PARTS:	1. All parts: Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-33650 (B); Black tape [4pcs]; Pink tape [2pcs]			JIG:	1. Clamp assembly jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	CLAMP ASSY	<div><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>Pink tape/ tape holder</div><div>Black tape/ tape holder</div></div></div>  <div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>			<div>Document references: 1. Refer to WI-ENG-PDE-875 for Taping assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>			

Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/18/24	1	Change Pre-launch to Masspro.						 D. Castillo	 C. Villanueva	 A. Arañes	n/a
04/16/24	0	Initial issue									
Eff. Date	Rev. No	Details of Change									
							Revised	Reviewed	Approved	Noted	

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7N0204-7020C

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TRJ

Car Model:

TOYOTA-4 RUNNER

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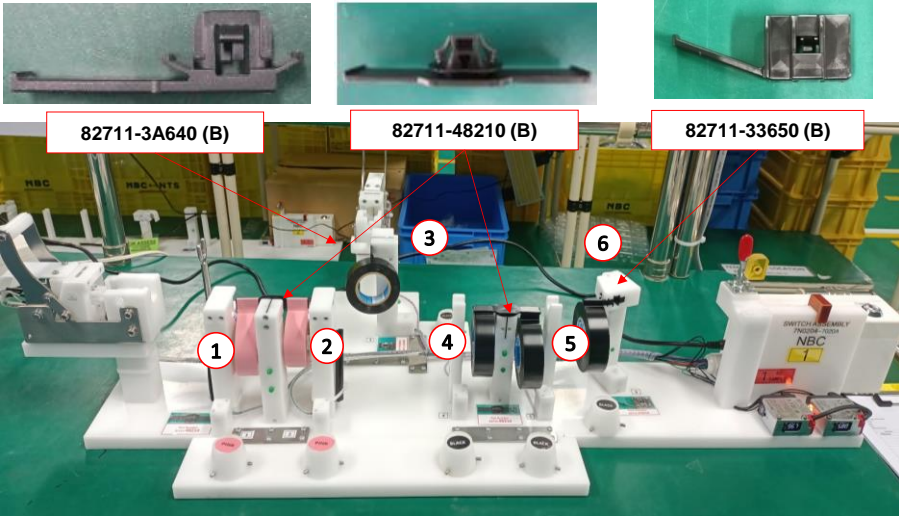
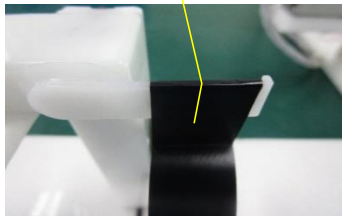
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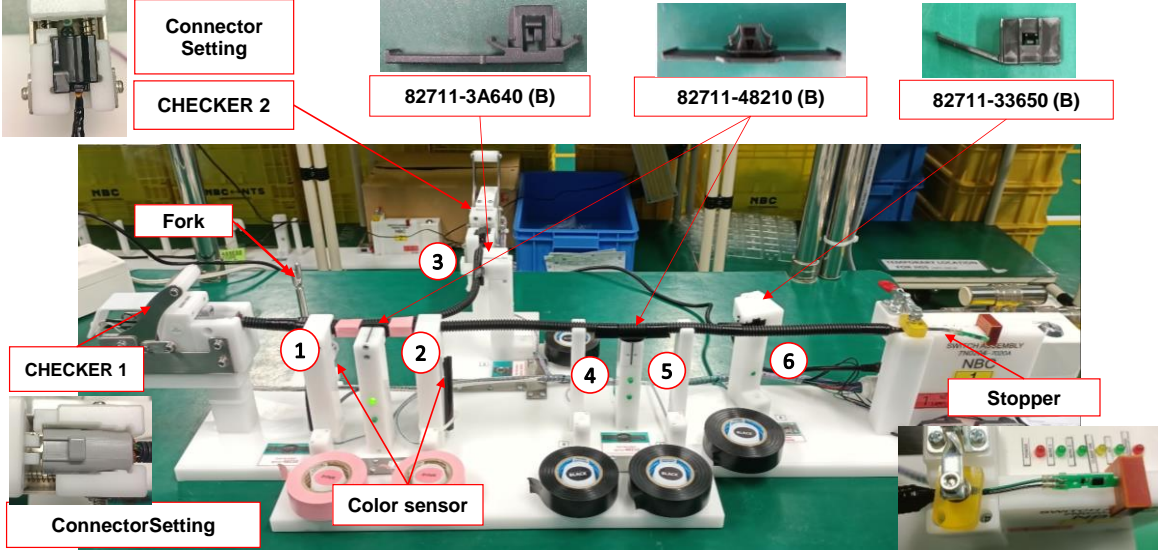
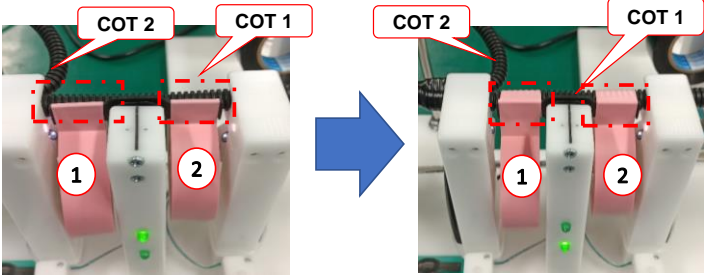

PARTS:		1. Black tape [4pcs] 2. Clamp 82711-33650 (B) 3. Clamp 82711-3A640 (B) 4. Clamp 82711-48210 (B) [2pcs] 5. Pink tape [2pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp Setting	<div></div> <div>1. Get 2pcs of clamp 82711-48210 (B) using right hand and set to clamp location 1,2,4 and 5 using both hands.</div> <div>2. Get 1pc of clamp 82711-3A640 (B) using right hand and set to clamp location 3 using both hands.</div> <div>3. Get 1pc of clamp 82711-33650 (B) using right hand and set to clamp location 6 using both hands.</div> <div>4. Initially attach Pink tape to clamp location 1 and 2 using both hands.</div> <div>5. Initially attach Black tape to clamp location 3, 4, 5 and 6 using both hands.</div>		n/a	<div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div><div>One wind for under tape</div></div>

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	Model code/Part number: 930B / 7N0204-7020C		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-876		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 7

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><p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6188-0066 (GR) to Checker 1 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 hotmelted within stopper then press by toggle clamp.</p><p>2. Check if all LED light for POWER ON, Wire 1, 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.</p><p>3. Hold the tape in clamp location 1, make 2 windings of tape using both hands. Color sensor will ON, if color sensor detected the Pink tape. Press the switch button. Continue if the sequence light of location 2 was ON. Repeat the process to location 2. Press the switch button. Sequence light will OFF. NOTE: DO NOT CUT THE TAPE</p></div></div> <div></div>		<div><p>Important reminders/Note/s:</p><ul style="list-style-type: none">1. Make sure no gap between terminal and stopper jig.2. Make 2-3 windings for clamp taping<ul style="list-style-type: none">1. No wrong use of parts2. No wrong use of tape3. No damaged clamp4. No wrong clamp position</div>

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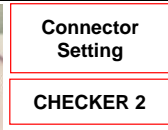



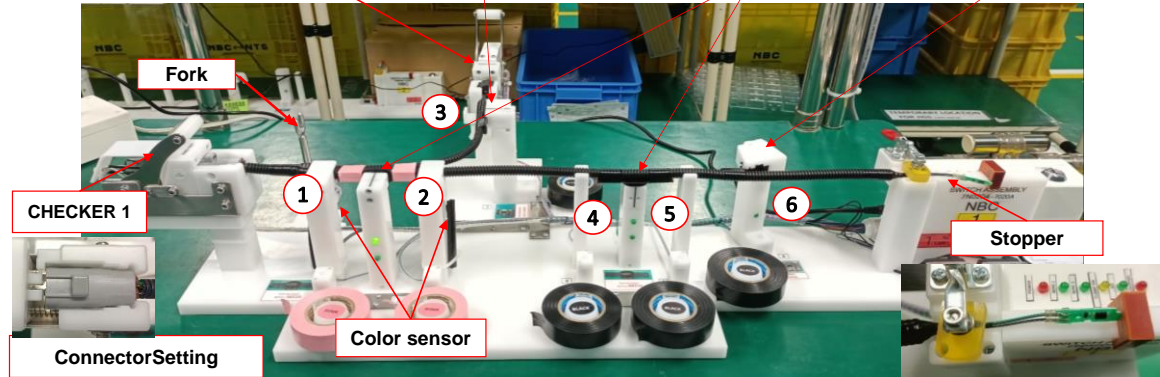
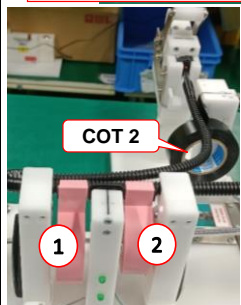
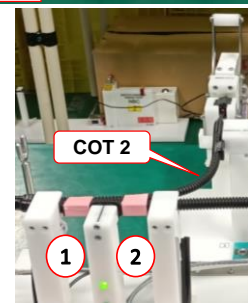

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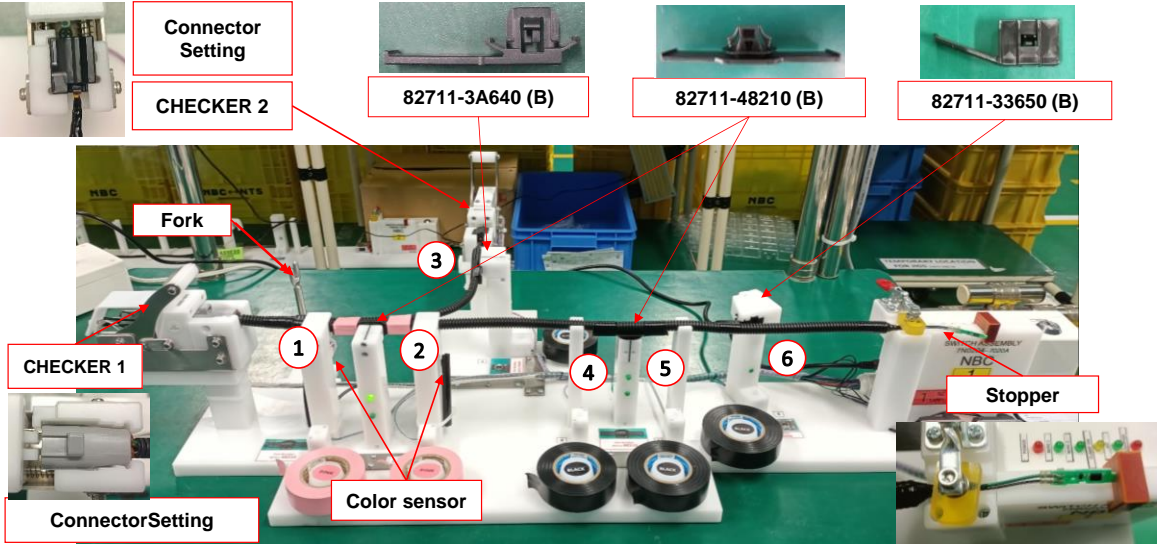
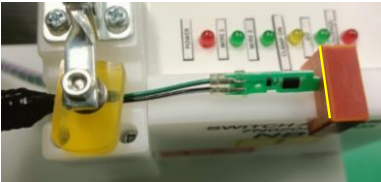
PARTS:		1. Assy parts 2. Black tape [4pcs]		3. Pink tape [2pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)	<div><div><div>Connector Setting</div></div><div><div>CHECKER 2</div></div><div><div>82711-3A640 (B)</div></div><div><div>82711-48210 (B)</div></div><div><div>82711-33650 (B)</div></div><div></div><div><div>COT 2</div></div><div><div>COT 2</div></div></div> <div><div>4. After taping of clamp location 1 and 2. Get the COT 2 and set the connector in Checker 2 then pull the checker fixture for Continuity testing.</div><div>5. Check if all LED light for Wire 1 and Wire 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Continue the process if the sequence light on location 1 was ON.</div><div>7. Hold the tape in clamp location 2, make 2 windings of tape using both hands then cut the tape. Color sensor will ON, if color sensor detected the Pink tape. Press the switch button. Continue if the sequence light of location 3 was ON.</div><div>8. Hold the tape in clamp location 3, make 2 windings of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location 4 was ON.</div></div> <div><div></div><div>Important reminders/Note/s: 1. Make sure no gap between terminal and stopper jig. 2. Make 2-3 windings for clamp taping</div></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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PARTS:	1. Assy parts 2. Black tape [4pcs] 3. Pink tape [2pcs]			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp Assembly (Continuation)	<div></div> <div>9. Hold the tape in clamp location 4, make 2 windings of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location 5 was ON.</div> <div>10. Hold the tape in clamp location 4, make 2 windings of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location 5 was ON.</div> <div>11. Hold the tape in clamp location 5, make 2 windings of tape using both hands then cut the tape. Press the switch button. Continue if the sequence light of location 6 was ON.</div> <div>12. Hold the tape in clamp location 6, make 2 windings of tape using both hands then cut the tape. Press the switch button. GO buzzer will be heard.</div> <div>13. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div> <div>14. Remove the harness, start from toggle clamp up to clamp, then checker 1 to checker 2.</div>			 Important reminders/Note/s: 1. Make sure no gap between terminal and stopper jig. 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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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

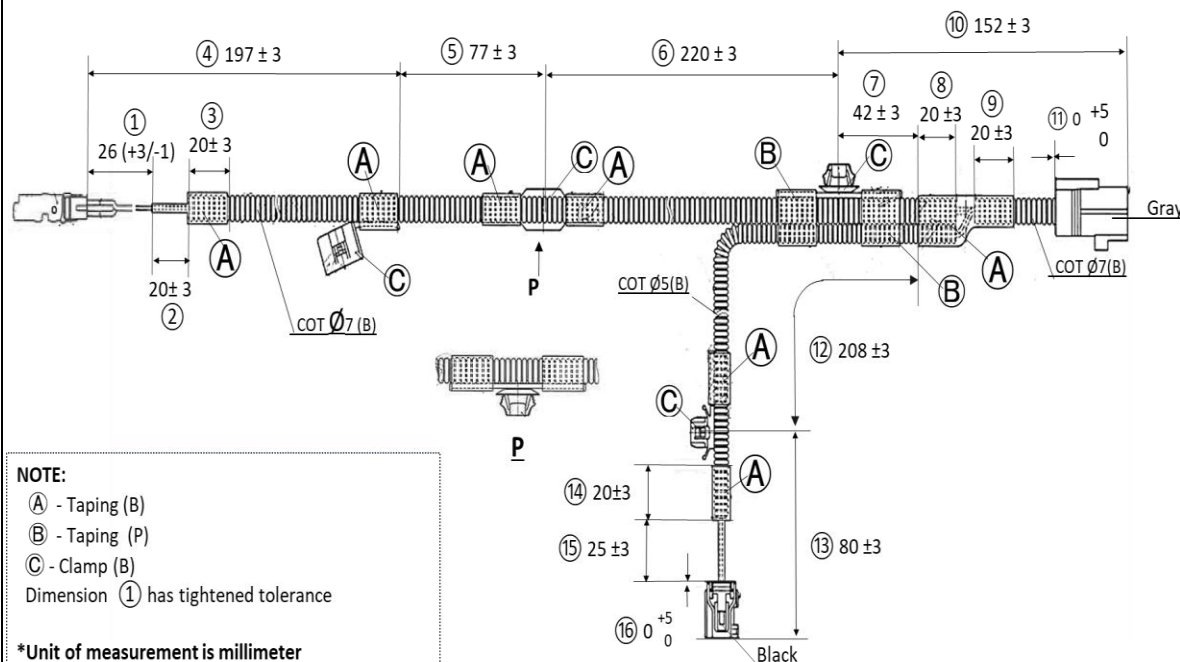
TOOLS/PPE

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

Note: Measurement should be on END TAPE



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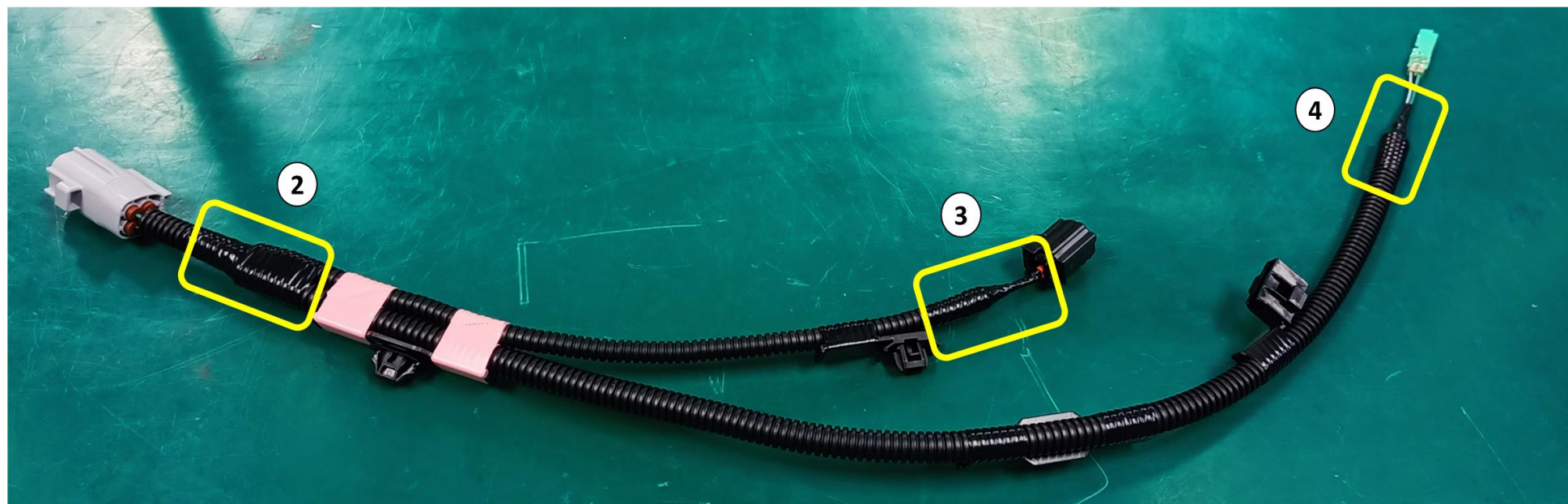
Page No.:

7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINT/ VISUAL INSPECTION**CLAMP ASSY****7N0204-7020C****1** No Wrong facing of clamp**2 3 4** No Missing Tape (Black tape)

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