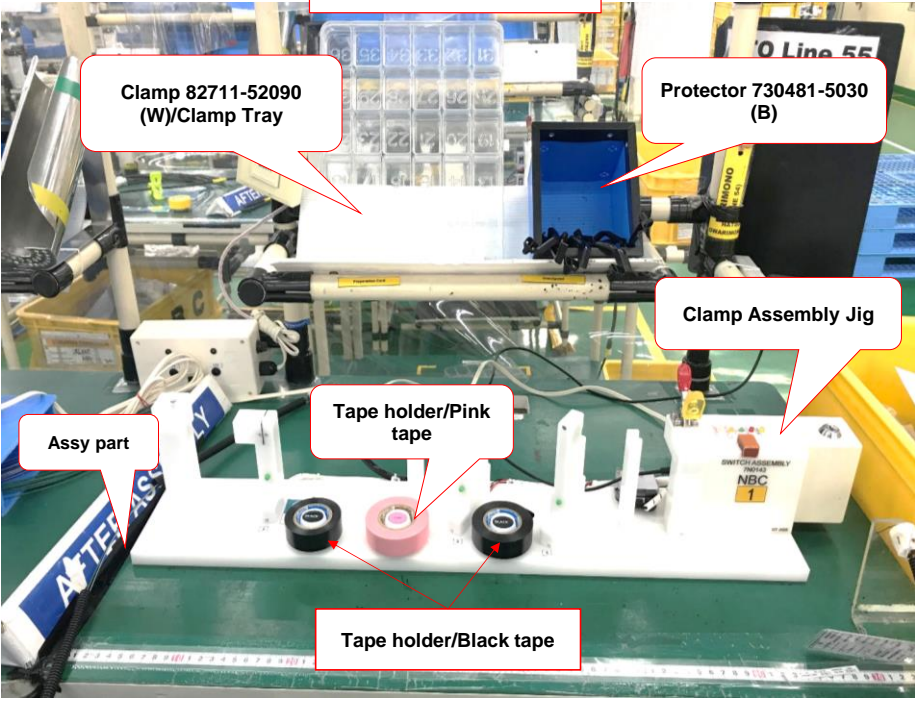
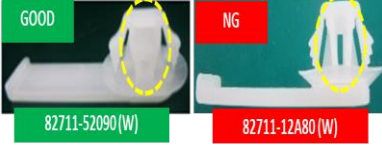
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>July 10, 2024</b>		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>990B / 7N0143-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA PRIUS</b>	Document No.:	<b>WI-ENG-PDE-903</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 7

<b>PARTS:</b> 1. Assy parts; Clamp 82711-52090 (W); Protector 730481-5030 (B); Black tape [2 pcs.]; Pink tape		JIG:	1. Clamp Assembly Jig
---	--	------	-----------------------


NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	Table Lay-out	<div> <p><b>TABLE LAY-OUT</b></p>  </div> <div> <p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. No missing parts/ tools. 2. No excess parts/tools.</p> <div> <p>CLAMP ILLUSTRATION</p>  </div>

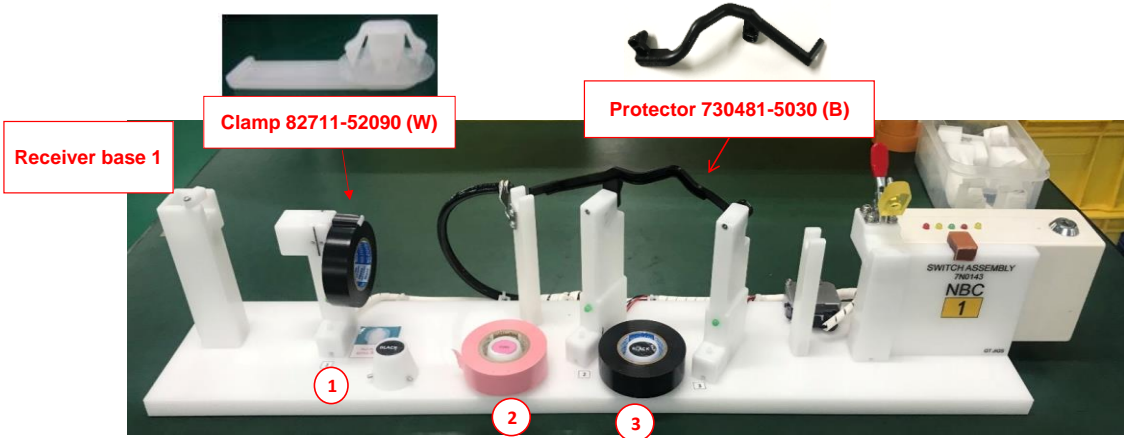
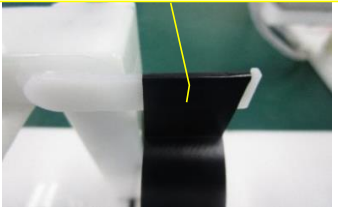
  

Revision History								Prepared by	Reviewed by	Approved by	Noted by
07/10/24	0	Initial issue.				D.Castillo	C.Villanueva	A. Arañes	N/A		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 10, 2024

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	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>990B / 7N0143-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA PRIUS</b>	Document No.:	<b>WI-ENG-PDE-903</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 7


<b>PARTS:</b>	1. Clamp 82711-52090 (W) 2.Protector 730481-5030 (B)		3. Black tape [2pcs.] 4. Pink tape		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>
2	Clamp Assy	<div><div>Receiver base 1</div><div>Clamp 82711-52090 (W)</div><div>Protector 730481-5030 (B)</div></div> <div>1. Get the clamp <b>82711-52090 (W)</b> using right hand and put to location <b>1</b> using both hands.</div> <div>2. Get the <b>Protector 730481-5030 (B)</b> using right hand and put to location <b>2 and 3</b> using both hands.</div> <div>3. Initially attach black tape to location <b>1</b> using both hands.</div>				<div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</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> <div><b>Important reminders/note/s:</b> 1. <i>Please check the clamp first before start of assembly to avoid wrong use of clamp.</i></div>

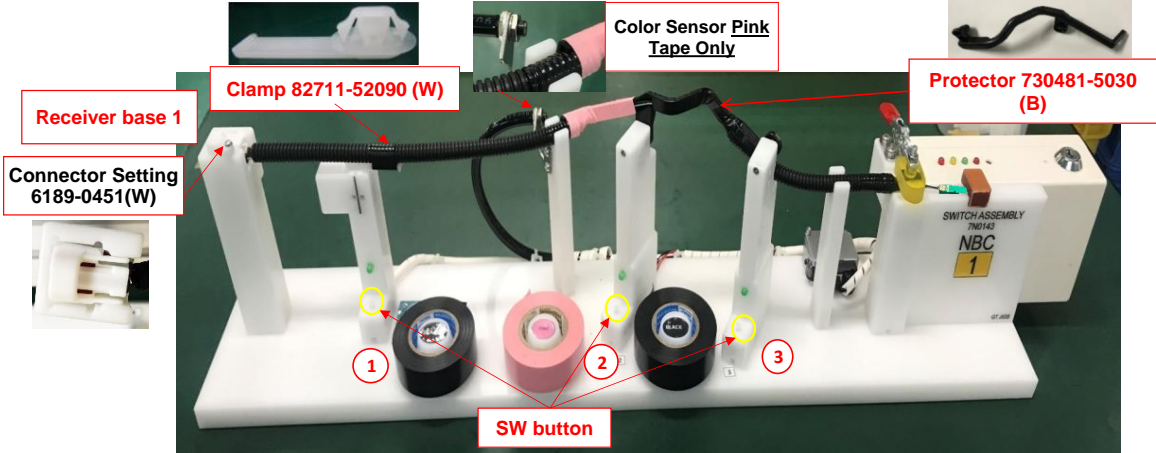
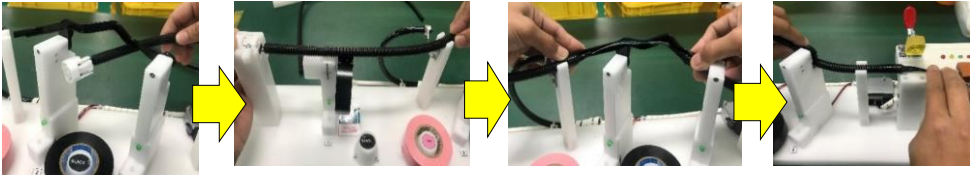
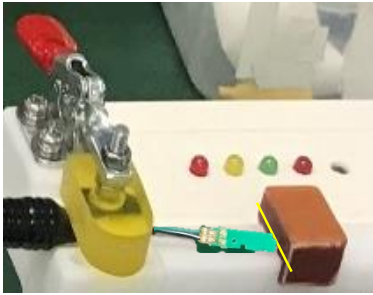
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	<b>CLAMP ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>990B / 7N0143-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA PRIUS</b>	Document No.:	<b>WI-ENG-PDE-903</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 7

<b>PARTS:</b>	1. Assy parts 2. Black tape [2pcs.]  3. Pink tape			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	<div></div> <div>1. Get the assy parts and set into jig. <i>(See below picture for the proper sequence of setting the harness).</i> First, insert the assy parts between the protector and set the connector <b>6189-0451 (W)</b> to <b>Receiver Base 1</b> then lock. Second, fix the assy part to protector <b>730481-5030 (B)</b> then continue to set the harness in jig. Set the COT near PCB in the COT guide and put the PCB into stopper jig then pull down the toggle clamp.</div> <div></div> <div>2. Check if all LED light for <b>Power On, Clamp On, Wire1 &amp; Wire2</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 then continue the process.</div> <div>3. Hold the tape on clamp location <b>1</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light on clamp location <b>2</b> was <b>ON</b>.</div>			<div></div> <div><b>Important reminders/note/s:</b> 1. Make sure no gap between the PCB and stopper jig.</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No loose wire in protector</div>

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## CLAMP ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

990B / 7N0143-7020B

Customer:

TRJ

Car Model:

TOYOTA PRIUS

Document No.:

WI-ENG-PDE-903

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

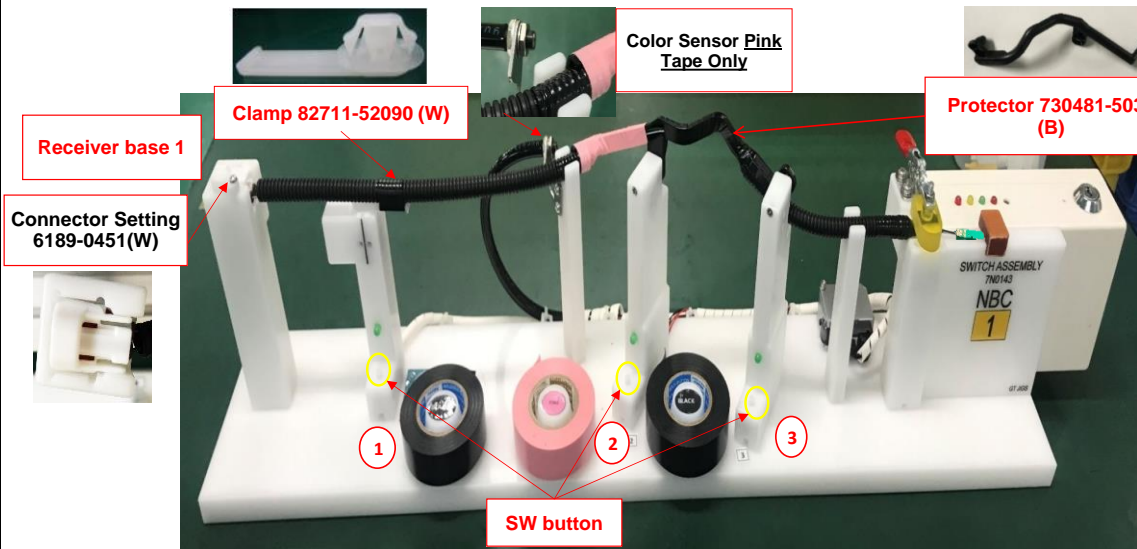
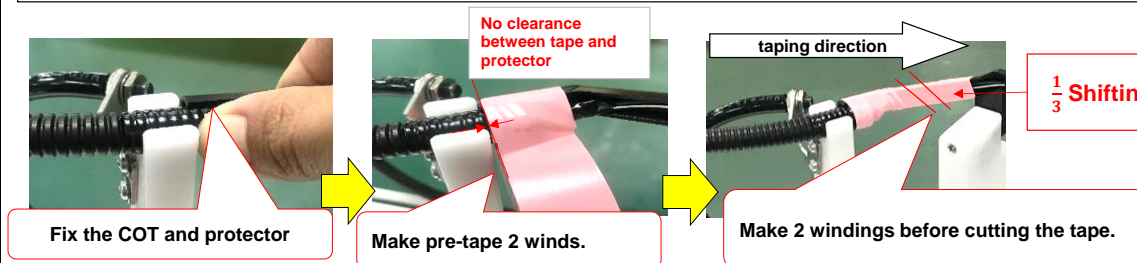
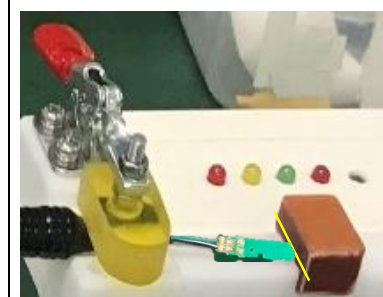
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [2pcs.]		3. Pink tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly (Continuation)	<div></div> <div>4. Get the pink tape on location 2, start taping the COT to protector. Make half wrap taping until it covers the first side of the protector. (See bellow illustration and procedure). Clamp assembly jig will beep/buzz if the color sensor detect PINK TAPE. Press the SW button after taping. Continue the process if sequence light on clamp location 3 was ON.</div> <div></div>			 <p><b>Important reminders/note/s:</b> 1. Make sure no gap between the PCB and stopper jig.</p>	

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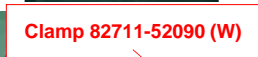



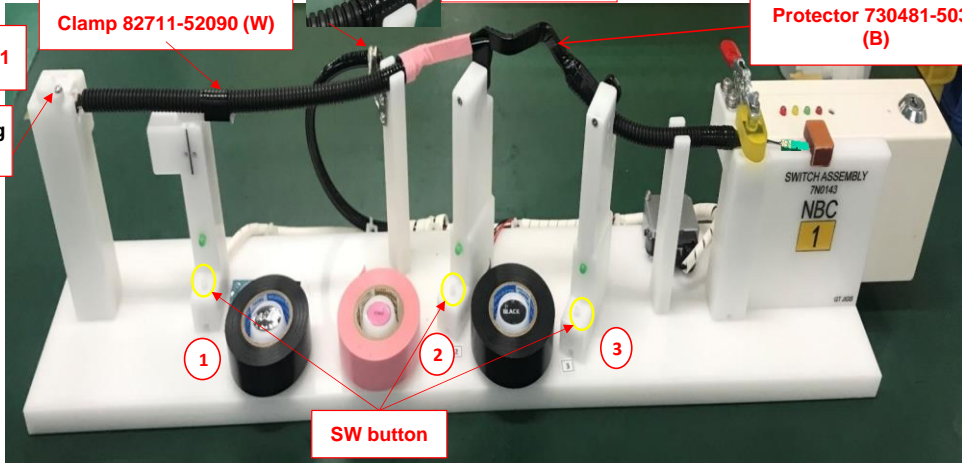
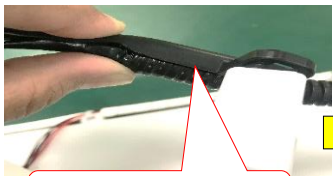

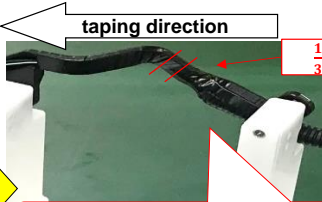


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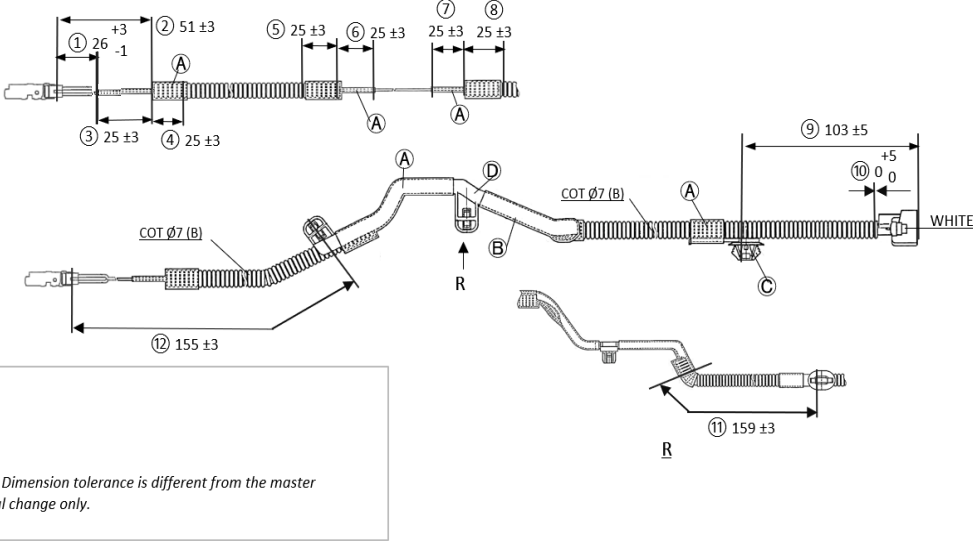

PARTS:		1. Assy parts 2. Black tape [2pcs.]		3. Pink tape	JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly (Continuation)	<div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div><div>5. Get the <b>black tape</b> on location <b>3</b>, start taping the COT to protector. Make half wrap taping until it covers the second side of the protector. <i>(See bellow illustration and procedure)</i>. Press the <b>SW button</b> after taping <b>GO</b> sound will be heard.</div><div>6. Conduct <b>Point Checking</b> using right hand and slowly remove the harness from jig.</div></div> <div><div></div><div></div><div></div></div>		<div></div> <div></div>	<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No loose wire in protector</div> <div><b>Important reminders/note/s:</b> 1. Make sure no gap between the PCB and stopper jig.</div>

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	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>990B / 7N0143-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA PRIUS</b>	Document No.:		<b>WI-ENG-PDE-903</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 6 of 7

<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>	
4	Clamp Assy	<div>Measurement</div> <div></div> <div><p><b>NOTE:</b></p><p>Ⓐ - Taping (B) Ⓑ - Taping (P) Ⓒ - Clamp (W) Ⓓ - Protector (B)</p><p>for item number ①, Dimension tolerance is different from the master drawing due to Internal change only.</p></div>	<div>MEASURING TAPE</div> <div></div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	

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**990B / 7N0143-7020B**Customer: **TRJ**

Car Model:

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Document No.:

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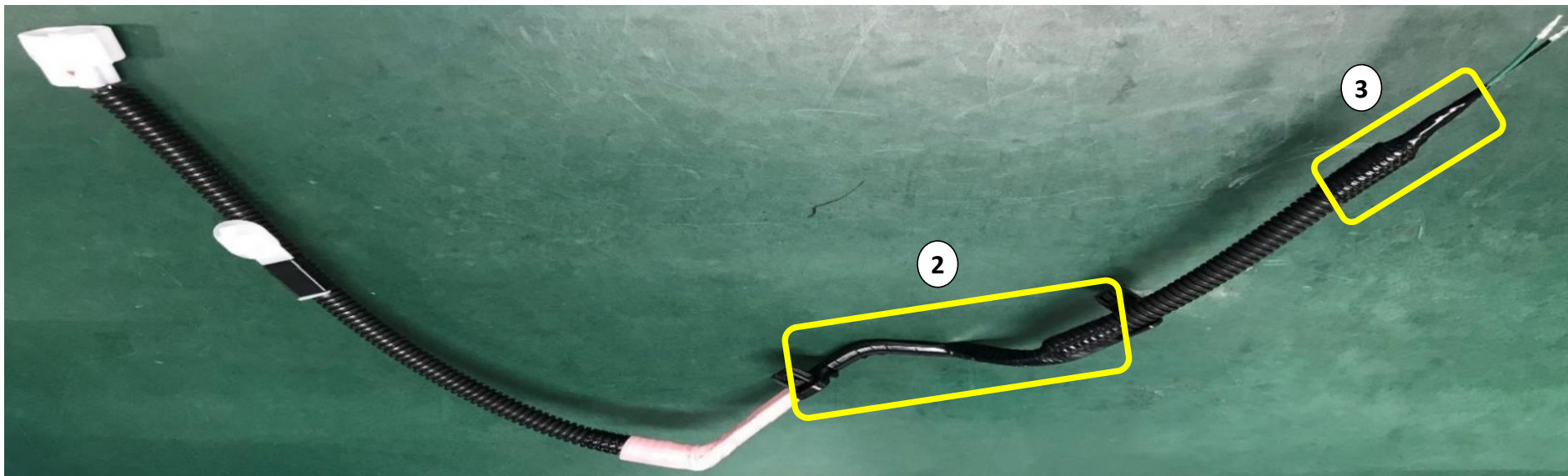
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**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0143-7020B****1** No Wrong facing of clamp**2 3** No Missing Tape (Black tape)

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