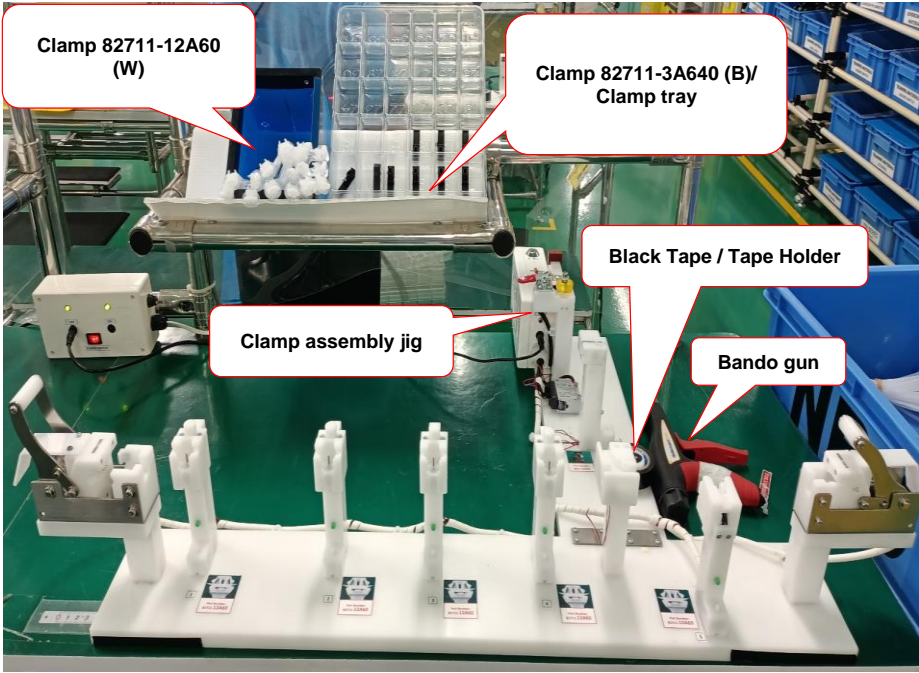






	WORK INSTRUCTION				Effectivity Date: June 24, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 920B / 7R0118-7023		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.: WI-ENG-PDE-896	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 0 Page No.: 1 of 5	

PARTS: 1. Assy parts: Clamp 82711-12A60 (W); Clamp 82711-3A640 (B); Black tape		JIG: 1. Clamp assembly jig
---	--	----------------------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	Table Lay-out 	<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>  BANDO GUN </div>	Document reference/s: 1. Refer to WI-ENG-PDE-654A-C for Taping assembly process 1. No missing parts/tools 2. No excess parts/tools <div> CLAMP ILLUSTRATION  </div> <div> BAND CLAMP ILLUSTRATION  </div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
						 D. Castillo	 C. Villanueva	 A. Arañes	N/A	
06/24/24	0	Initial issue.	D. Castillo	C. Villanueva	A. Arañes					N/A
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved					Noted

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WI-ENG-PDE-896

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:		1. Clamp 82711-12A60 (W) [5pcs.] 2. Clamp 82711-3A640 (B)		3. Black tape	JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting	<div></div> <div><p>1. Get 2pcs. of clamp 82711-12A60 (W) then set to clamp location 1 and 2 then lock using both hands.</p><div></div></div> <div><p>2. Get 2pcs. of clamp 82711-12A60 (W) then set to clamp location 3 and 4 then lock using both hands.</p></div> <div><p>3. Get 1pc. of clamp 82711-12A60 (W) then set to clamp location 5 then lock using both hands.</p></div> <div><p>4. Get 1pc. of clamp 82711-12A80 (W) then set to clamp location 6 using both hands.</p></div> <div><p>5. Initially attach Black tape on clamp location 6 using both hands.</p></div>				<div>STANDARD TAPING FOR CLAMP</div> <div><p>One wind for under clamp</p></div> <div>Important reminders/Note/s:</div> <div><p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p></div> <div><p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p></div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD 82711-12A80 (W)</div><div>NG 82711-52090 (W)</div></div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD 82711-12A60 (W)</div><div>NG 82711-52070 (B)</div></div></div>

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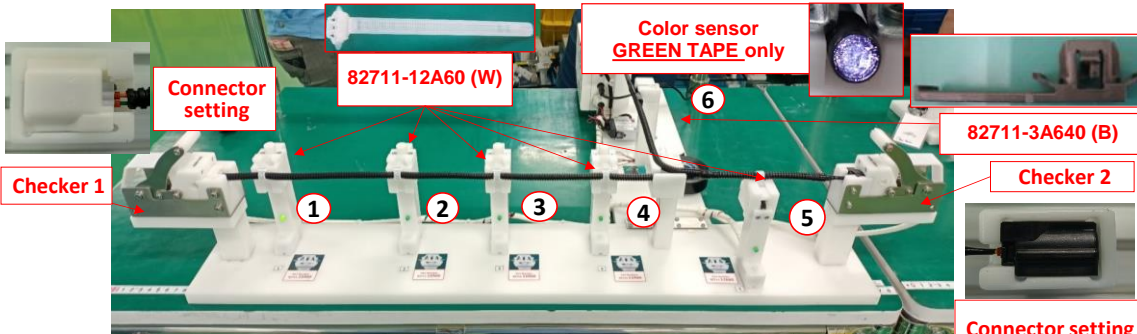
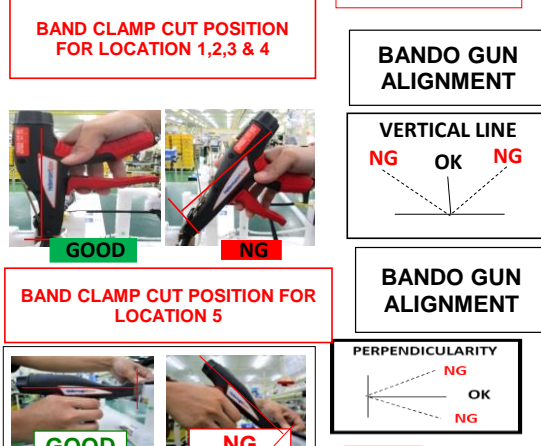

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><p>1. Get the assy parts and set to jig using both hands. <i>(See above picture for correct setting)</i>. First, set the connector 6189-1142 (W) to Checker 1 then pull the checker fixture for continuity checking. Set the connector 6189-1161 (B) to Checker 2 then push the checker fixture for continuity checking. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Green tape. Last, set the end of PCB within the stopper jig then press the toggle clamp. Continue if the clamp location 1 was ON.</p><p>2. Initially tighten the band clamp on clamp location 1, 2, 3, 4 and 5 using both hands.</p><p>3. Get the Bando gun using right hand then cut the clamp on location 1, 2, 3, 4 and 5 using both hands.</p><p>4. Hold the tape on clamp location 6. Make 3 windings of tape then cut the tape using both hands.</p><p>5. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p><p>6. Remove the connector in checker 1 then unlock the clamp receiver base lock 1 by 1 from location 1 to 5. Next, remove connector to checker 2 and continue location 6 then toggle clamp using both hands.</p></div>		<div><p>BAND CLAMP CUT POSITION FOR LOCATION 1,2,3 & 4</p><p>BAND CLAMP CUT POSITION FOR LOCATION 5</p><p>VERTICAL LINE NG OK NG</p><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY NG OK NG</p><p>Fixed setting of band clamp cutter: 1~2</p></div>	<div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and PCB</p><p>2. Make 2-3 windings for clamp taping..</p><p>BAND CLAMP ILLUSTRATION</p><p>GOOD NG</p><p>82711-12A60 (W) 82711-52070 (B)</p><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>EXTENDED NOSEPIECE (3mm) EXTENDED NOSEPIECE (4mm)</p></div>

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DCC Stamp

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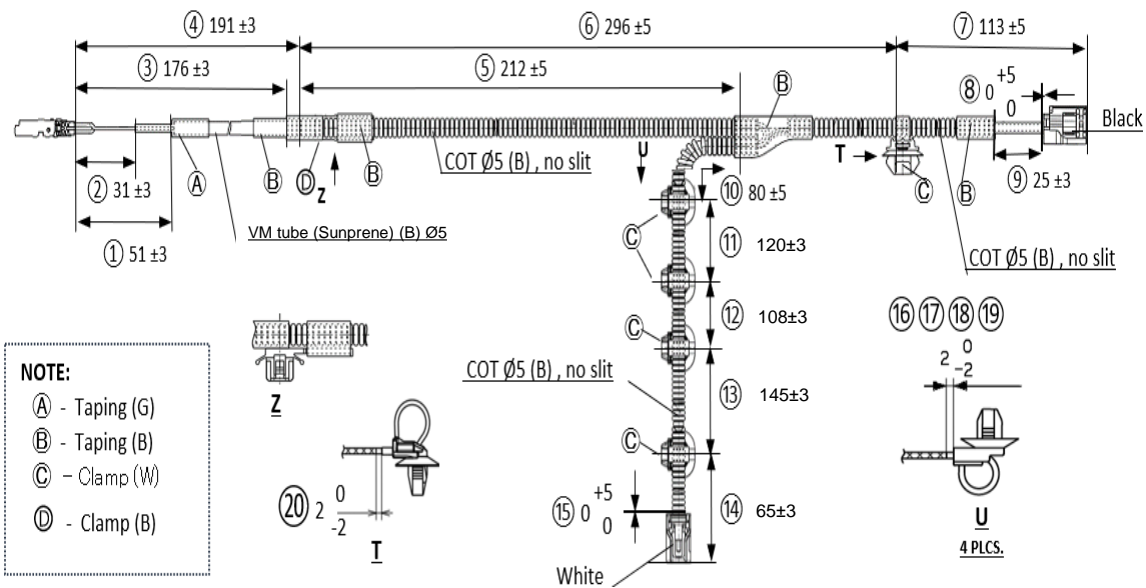
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Revision No.:

0

Page No.:

4 of 5

PARTS:		1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement	<div></div>		

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

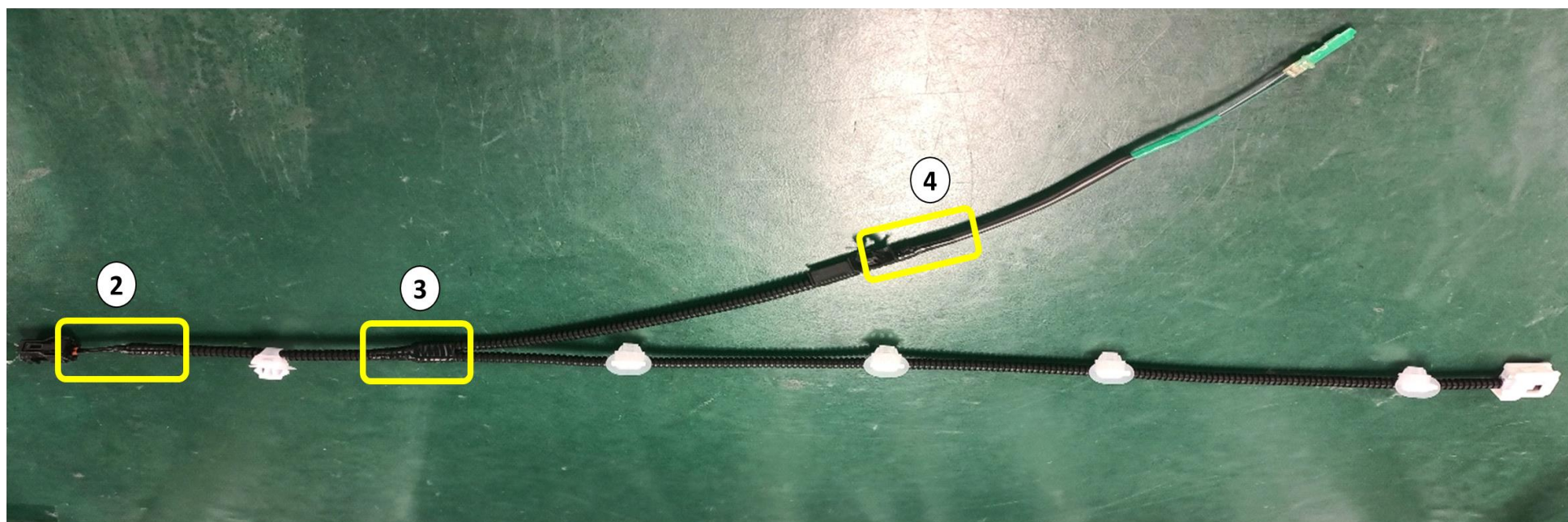
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7R0118-7023****1** No Wrong facing of clamp**2 3 4** No Missing Tape (Black tape)

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