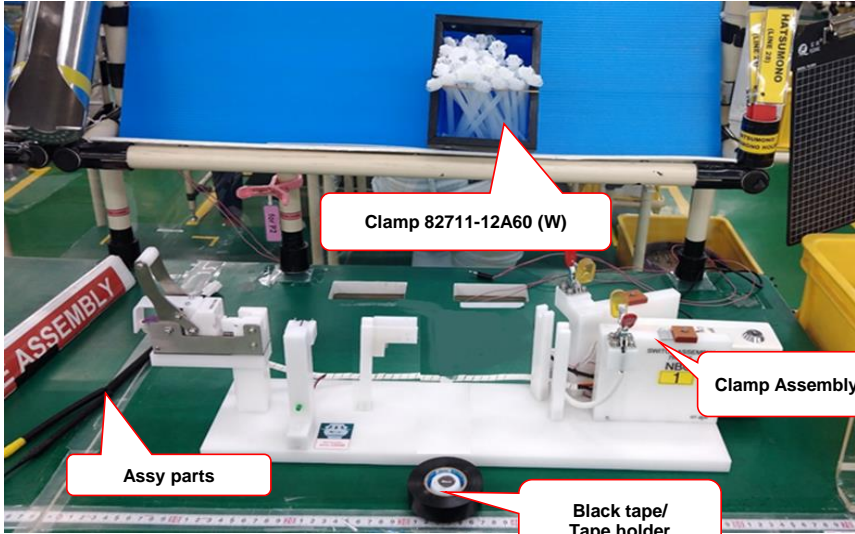

	WORK INSTRUCTION				Effectivity Date:	June 18, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 660B / 7R0111-7021		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-796		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5



PARTS:	1. Assy parts: Clamp 82711-12A60 (W)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	<p style="text-align: center;">Table Lay-out</p> 		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document references: 1. Refer to WI-ENG-PDE-451A-B 7R0111-7021 - TAPING ASSEMBLY PROCESS</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
06/18/24	0	Initial issue.				D.Castillo	C.Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	June 18, 2024

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 6

PARTS:	1. Assy parts 2. Clamp 82711-12A60 (W)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting			<p>Important reminders/Note/s:</p> <p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No damaged clamp 3. No wrong clamp position</p> <div><p>BAND CLAMP ILLUSTRATION</p><div></div></div>

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WI-ENG-PDE-796

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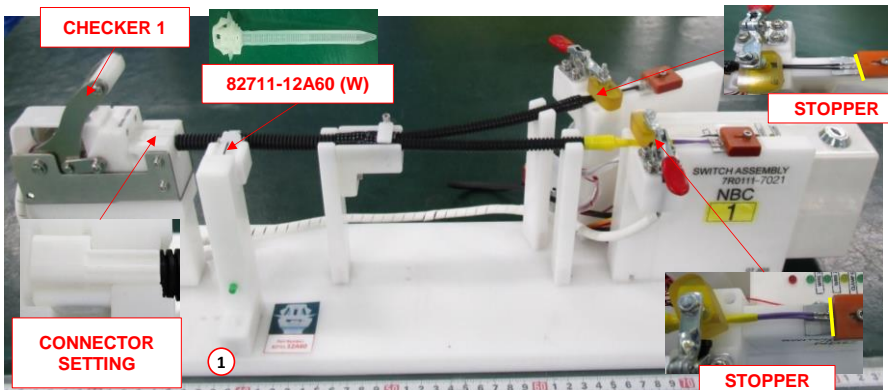


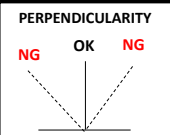
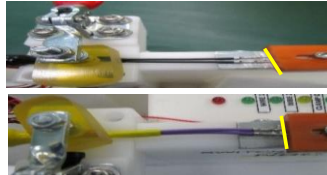

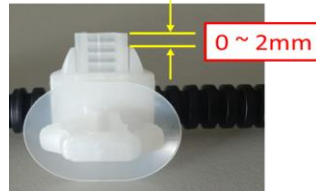
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Revision No.:

4

Page No.:


3 of 6

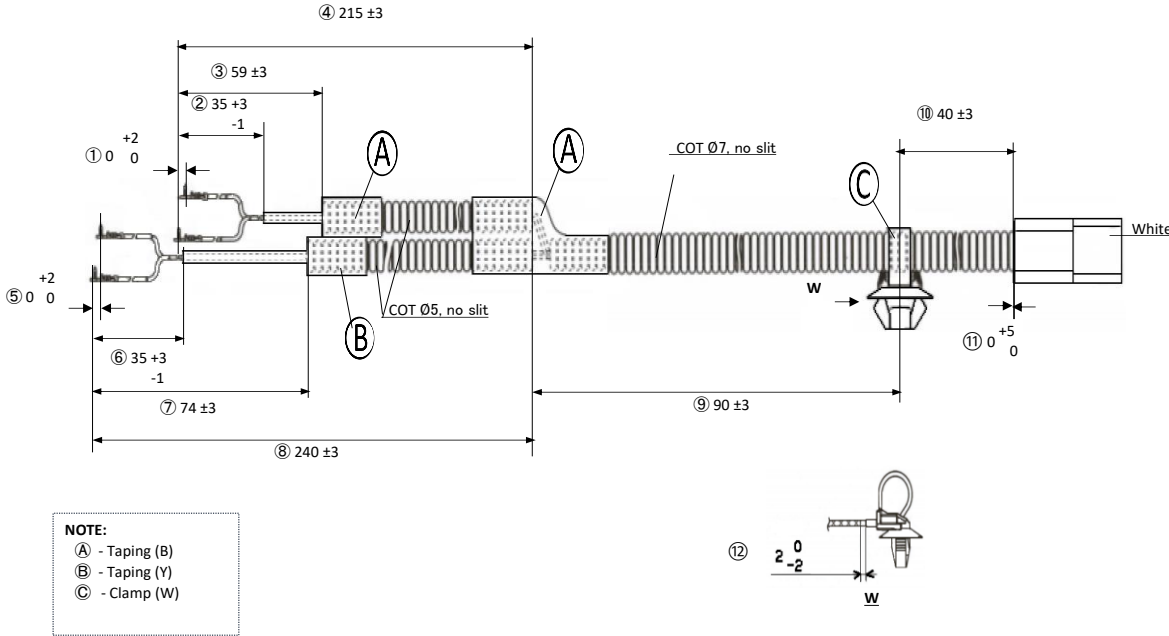

PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp assembly	<div></div> <div>1. Get the assy parts and set into jig. (<i>See above illustration for correct setting</i>). First, set the connector 6098-3802 (W) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Set the V-V wires together within the stopper jig then press by toggle clamp. Color sensor light will beep/buzz if sensor detects Yellow tape. Set the B-B wires together within the stopper jig then press by toggle clamp. Continue if the sequence light in location 1 was ON.</div> <div>2. Initially tighten the band clamp on clamp location 1 using both hand.</div> <div>3. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after cut. Go sound will be heard.</div> <div>4. Conduct POINT CHECKING before removing the harness from jig.</div> <div><div>BANDO GUN</div></div> <div><div>BANDO GUN ALIGNMENT</div><div>PERPENDICULARITY NG OK NG </div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</div></div>			<div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between stopper and terminals</div><div>1. No loose clamp attached</div><div>2. No damage clamp</div><div>3. No missed tape</div><div>4. No missing parts</div><div>5. No gap between terminal and stopper</div></div> <div><div>BANDO GUN ILLUSTRATION</div><div>GOOD NG</div><div>EXTENDED NOSEPIECE FLAT NOSEPIECE</div></div> <div><div>0 ~ 2mm</div></div> <div>Important reminders/Note/s:</div> <div>1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> 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
4	Clamp Assy	Measurement	<div>  <div> MEASURING TAPE  </div> <div> NOTE: (A) - Taping (B) (B) - Taping (Y) (C) - Clamp (W) </div> </div>			<div> Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. </div> <div> Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection </div>	1. No wrong dimension

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Purpose:

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Revision No.:

0

Page No.:

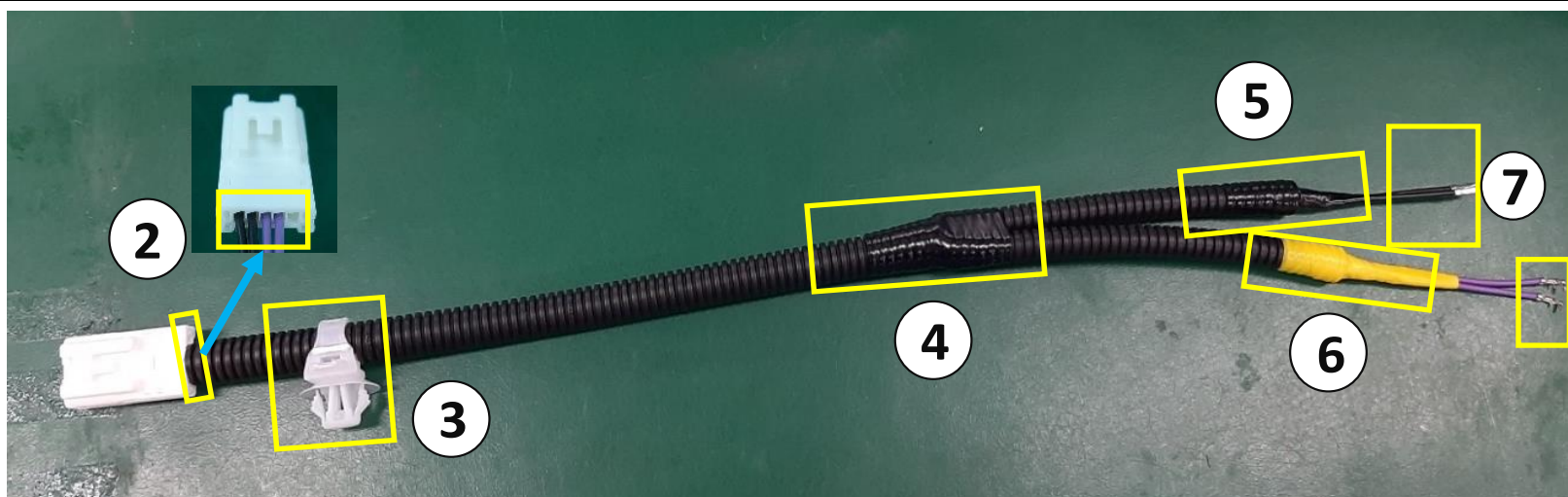
6 of 6

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP
ASSY****7R0111-7021****GOOD****NO GOOD****1 No Unlock
Connector****3 No Missing Band Clamp****7 No Deformed Terminal****2 No Wrong Insert****4 5 6 No Missing Tape****8 Checking of loose/tight band
clamp attachment**

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