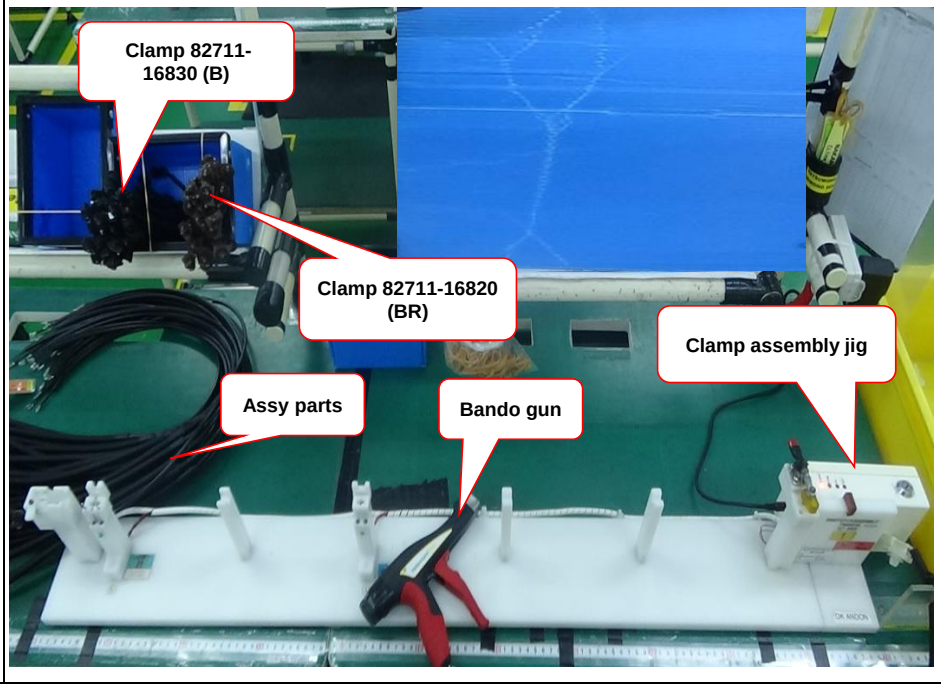
	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 468B / 7M0476-7020A	Customer: TRJ	Car Model: TOYOTA HIACE	Document No.:	WI-ENG-PDE-967		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	1 of 5

PARTS:	1. Assy parts; Clamp 82711-16830 (B); Clamp 82711-16820 (BR); Black tape	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 prescribed 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. BANDO GUN	***Document reference/s:*** *1. Refer to **WI-ENG-PDE-252** for Taping assembly process* 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/22/24	0	Initial issue. Separate clamp assy from Taping assembly process.	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:	October 22, 2024		

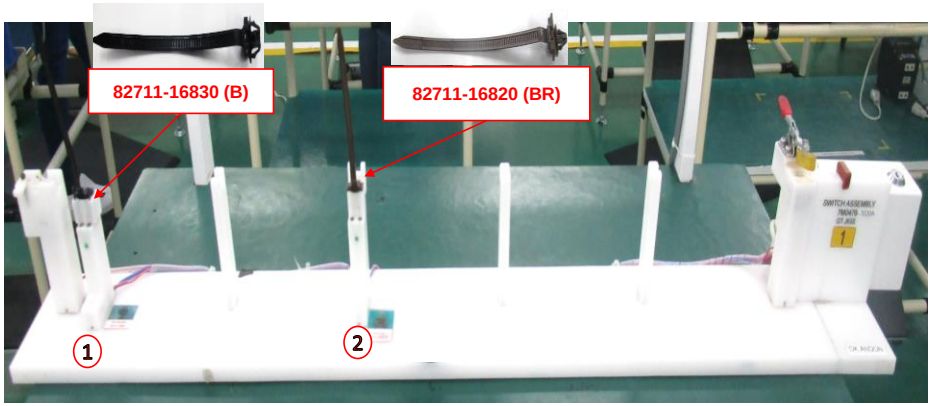
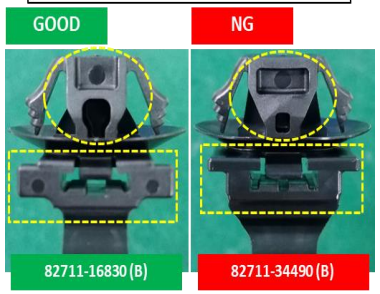
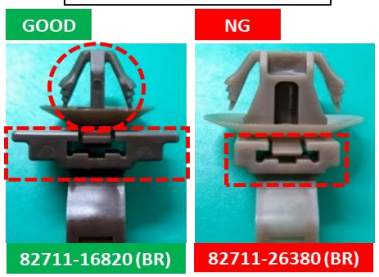
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	October 22, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	468B / 7M0476-7020A	Customer: TRJ / Car Model: TOYOTA HIACE	Document No.:	WI-ENG-PDE-967
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0
				Page No.:	2 of 5

PARTS:	1. Clamp 82711-16830 (B) 2. Clamp 82711-16820 (BR)	JIG:	1.Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp S etting	 1. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **1** using both hands. 2. Get 1pc. of clamp **82711-16820 (BR)** using right hand and set to clamp location **2** using both hands.	n/a	1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts ***Important reminders/note/s:*** *1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.* BAND CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION 

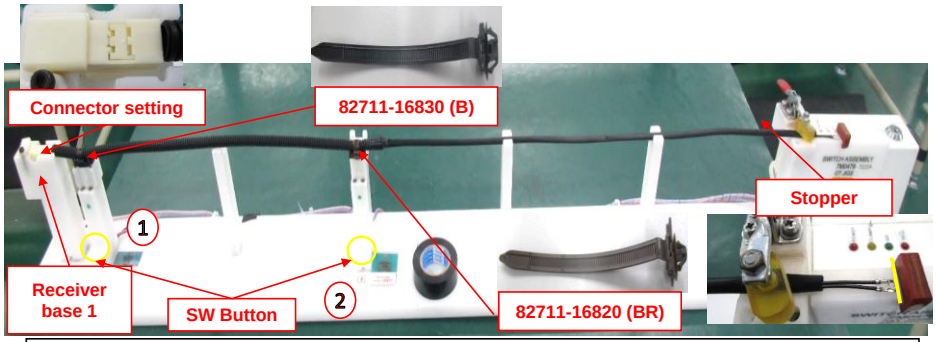
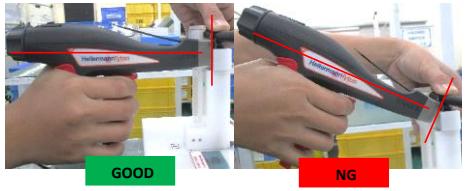
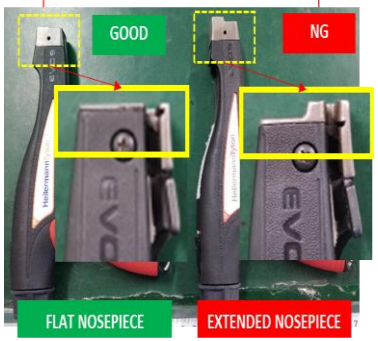
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 468B / 7M0476-7020A	Customer: TRJ	Car Model: TOYOTA HIACE	Document No.:	WI-ENG-PDE-967		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	3 of 5

PARTS:	1. Assy parts 2. Clamp 82711-16830 (B)	JIG:	1.Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly	 1. Get the assy parts then set to jig. ***(See above picture for correct setting).*** First, set the connector **7282-1020 (W)** to **Receiver base 1** then lock. Continue to set the harness in jig. Last, set the **B-B terminal** together within the stopper jig then press by toggle clamp. Continue if the sequence light in location **1** was O**N.** 2. Check the LED light for **POWER, WIRE1&WIRE2** and **CLAMP ON** was **ON.** If encountered abnormality, **STOP** the process, **CALL** the attention of leader and **WAIT** for further instruction. 3. Initially tighten the band clamp on clamp location **1 and 2** using both hands.  4. Get the Bando Gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was **ON.** 5. Cut the band clamp on location **2** using both hands. Press the **SW button** after cutting of band clamp. **Go** sound will be heard. **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.** **For: ø5 - 1~2, ø7 - 3~4** 6. Conduct **POINT CHECKING** before removing the harness from jig.	**BANDO GUN** 	 ***Important reminders/Note/s:*** *1. Make sure no gap between stopper and terminals.* 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts BANDO GUN ILLUSTRATION 

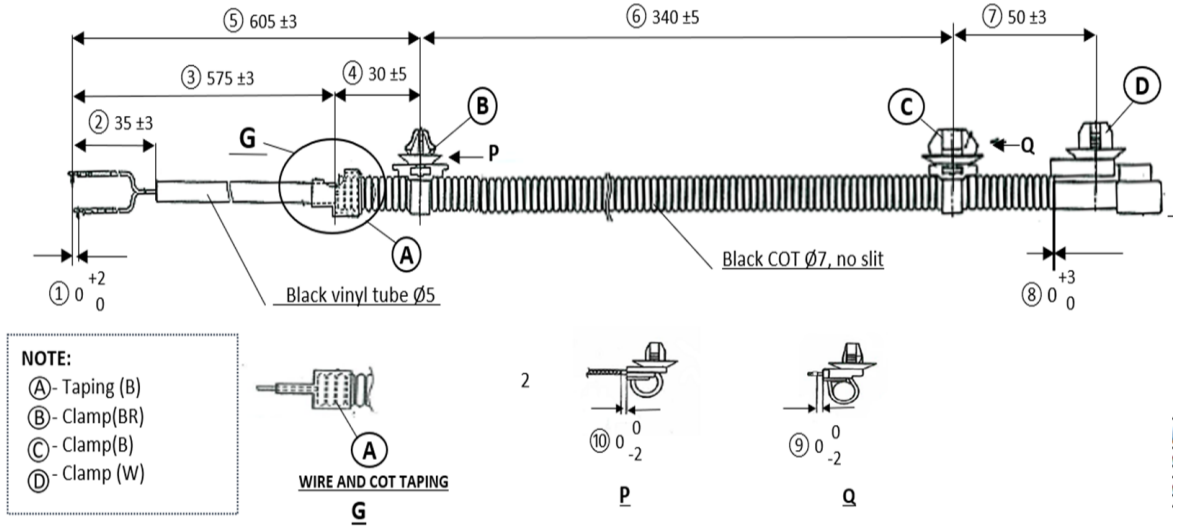
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	October 22, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	468B / 7M0476-7020A	Customer: TRJ / Car Model: TOYOTA HIACE	Document No.:	WI-ENG-PDE-967
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		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		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

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

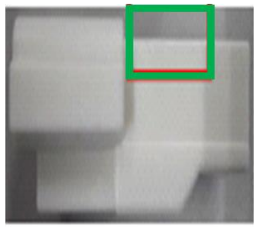
NBC (Philippines)
MASTER COPY

DCC Stamp

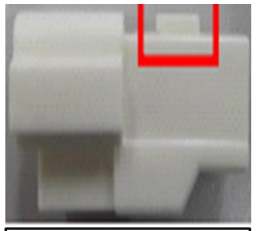
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

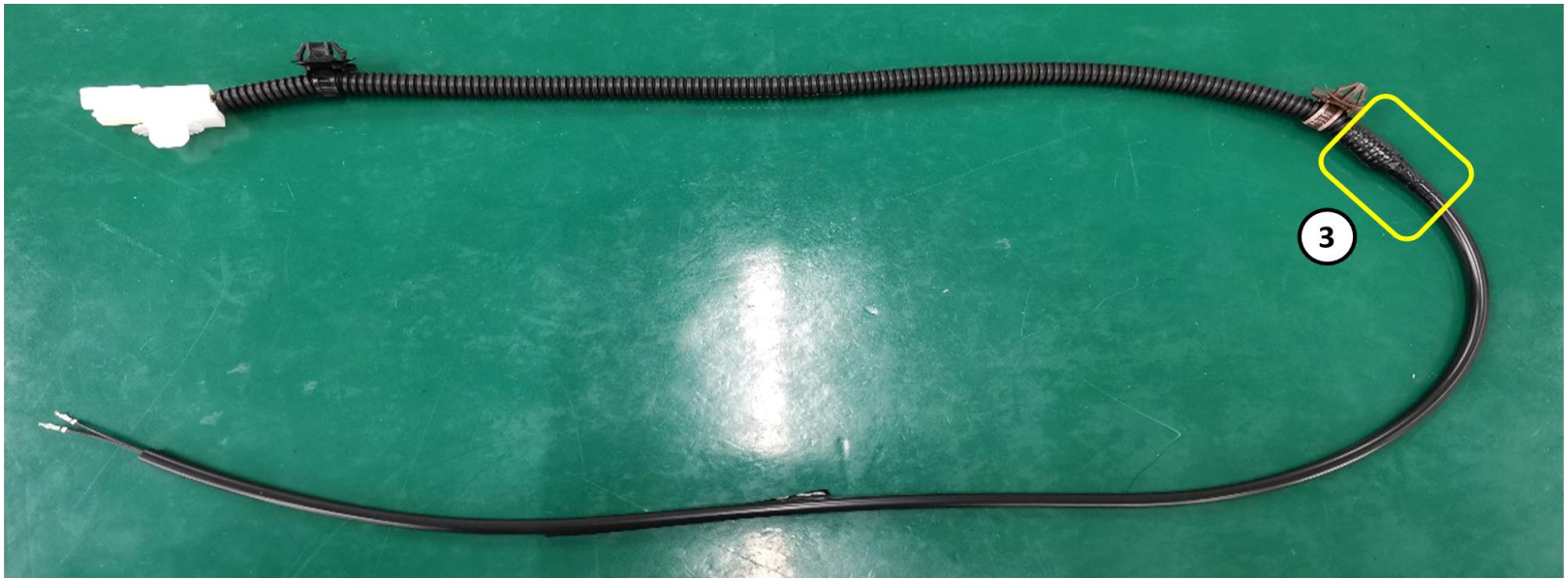
CLAMP ASSY	7M0476-7020A



GOOD



NO GOOD



1. No Wrong Facing of Clamp
2. No Unlocked / Halflocked Connector
3. No Missing Tape (Black Tape)

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp