



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model code/Part number:

240B / 7M0516-7021B

Customer:

TRJ

Car Model:

LEXUS-ES

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS:

1. Assy part: Clamp 82711-52090 (W); Clamp 82711-48210 (B); Clamp 82711-3A540 (W); White tape; Black tape [7pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

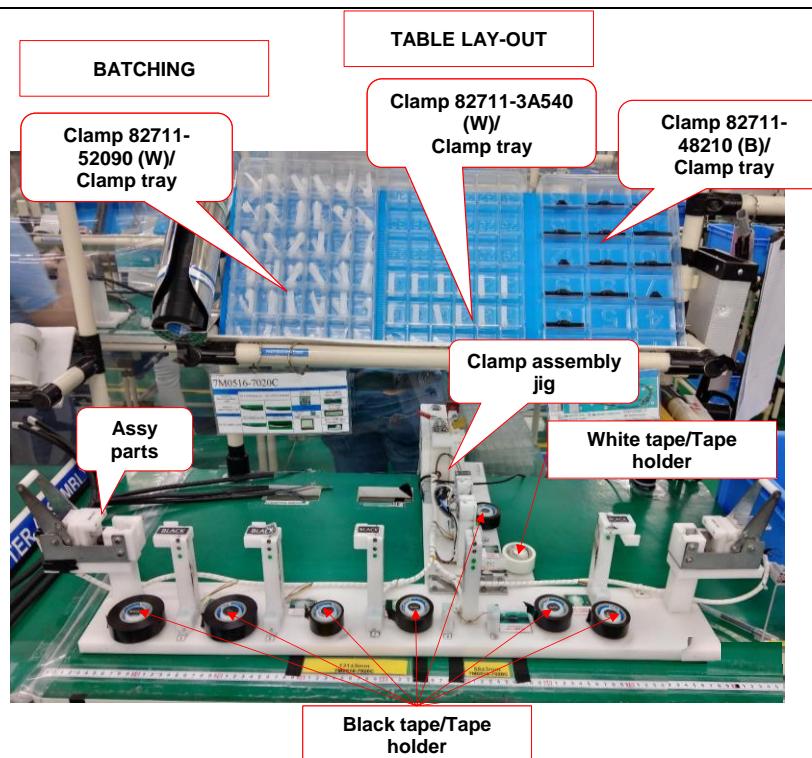
TOOLS/PPE

QUALITY POINTERS

1

Clamp
Assy

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

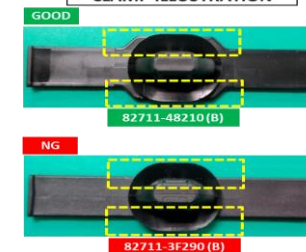
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/22/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
10/17/24	0	Initial Issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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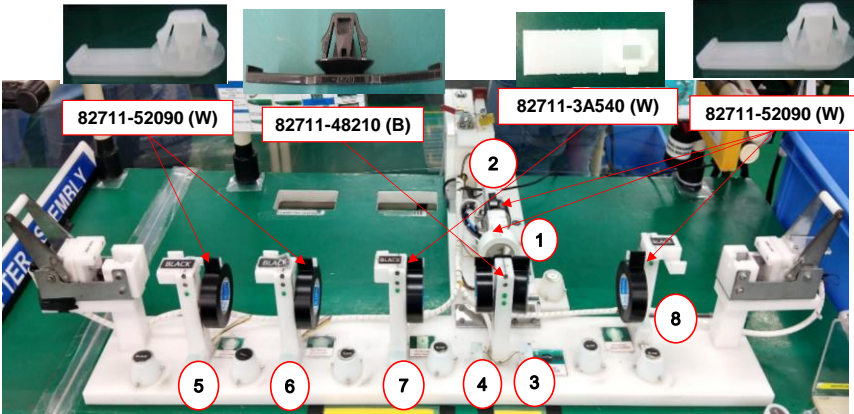
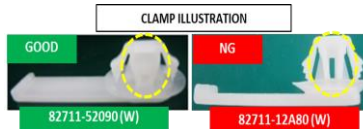
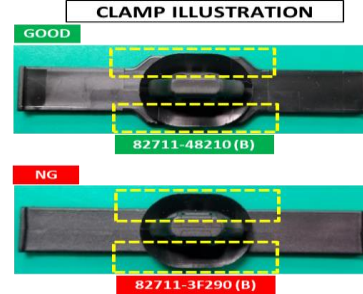
MASSPRO

Revision No.:

1

Page No.:

2 of 7

PARTS:		1. Clamp 82711-52090 (W) (5pcs.) 2. Clamp 82711-48210 (B) 3. Clamp 82711-3A540 (W) 4. White tape 5. Black tape [7pcs.]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div></div> <div>1. Get 2pcs. of clamp 82711-52090 (W) using both hands then set to location 5 & 6 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-52090 (W) using both hands then set to location 1 & 2 using both hands.</div> <div>3. Get 1pc. of clamp 82711-52090 (W) using both hands then set to location 8 using both hands.</div> <div>4. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to location 7 using both hands.</div> <div>5. Get 1pc. of clamp 82711-48210 (B) using right hand then set to location 3 and 4 using both hands.</div> <div>6. Get the White tape then initially attach to clamp location 1 using both hands.</div> <div>7. Get the Black tape then initially attach to clamp location 2, 3, 4, 5, 6, 7 and 8 using both hands.</div>		n/a	<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div> </div>

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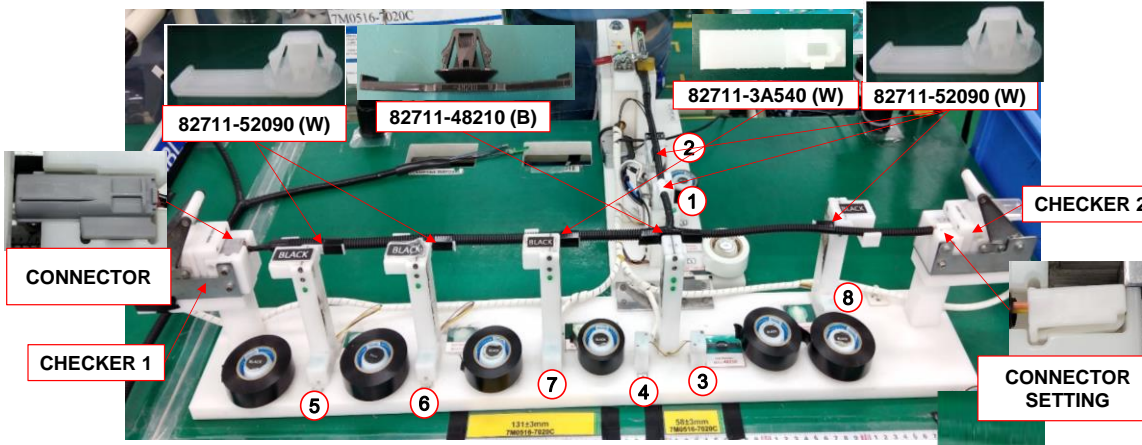
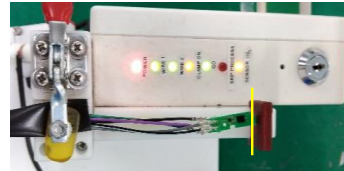

MASSPRO

Revision No.:

1

Page No.:

3 of 7

PARTS:		1. Assy parts 2. Black tape 3. White tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp Assembly (Continuation)	<div><p>82711-52090 (W)</p><p>82711-48210 (B)</p><p>82711-3A540 (W)</p><p>82711-52090 (W)</p><p>CHECKER 1</p><p>CHECKER 2</p><p>CONNECTOR</p><p>CONNECTOR SETTING</p></div> <div><p>1. Hold the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 6188-0779 (GR) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the connector 6098-2220 (W) to Checker 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><div><p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Color sensor light will beep/buzz if sensor detects White tape. Press the SW button after taping. Continue the process if sequence light on clamp location 2 was ON.</p><p>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 3 was ON.</p></div></div>		<div><p>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB</p><p>1. No flip-out tape 2. No peel-off tape 3. No wrong use of tape 4. No damaged clamp 5. No missing tape 6. No wrong clamp position</p><div><p>STANDARD TAPING FOR CLAMP</p><p>One wide for under tape</p></div></div>	

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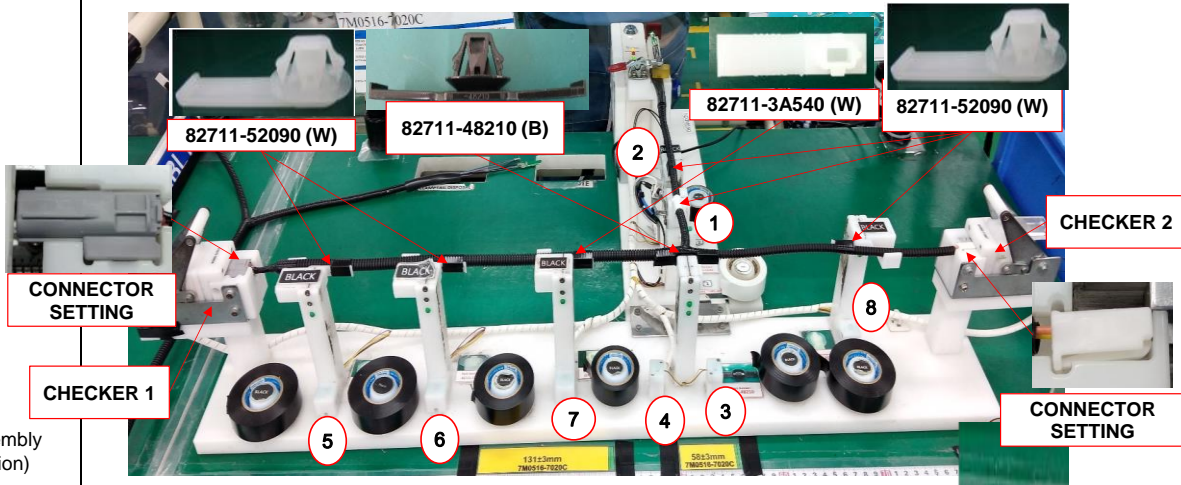

WI-ENG-PDE-1092

Revision No.:

1

Page No.:

4 of 7

PARTS:		1. Assy parts 2. Black 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>5. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 4 was ON.</div> <div>6. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 5 was ON.</div> <div>7. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 6 was ON.</div> <div>8. Hold the tape on clamp location 6, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 7 was ON.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper jig and PCB</div> <div>1. No flip-out tape 2. No peel-off tape 3. No wrong use of tape 4. No damaged clamp 5. No missing tape 6. No wrong clamp position</div>

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MASSPRO

Revision No.:

1

Page No.:

5 of 7

PARTS:

1. Assy parts
2. Black tape

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Clamp Assy

Clamp Assembly (Continuation)

9. Hold the tape on clamp location **7**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **8** was **ON**.

10. Hold the tape on clamp location **8**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard.

11. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



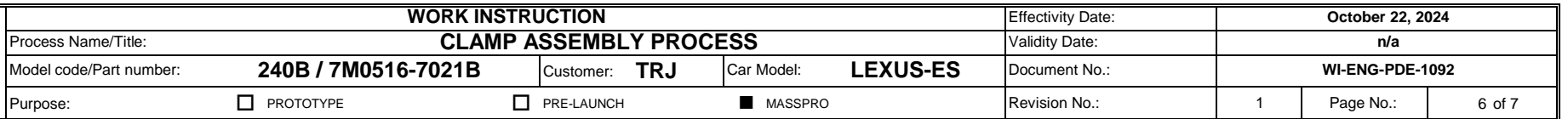
Important reminders/Note/s:
1. Make sure no gap between stopper jig and PCB

1. No flip-out tape
2. No peel-off tape
3. No wrong use of tape
4. No damaged clamp
5. No missing tape
6. No wrong clamp position

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Page No.:

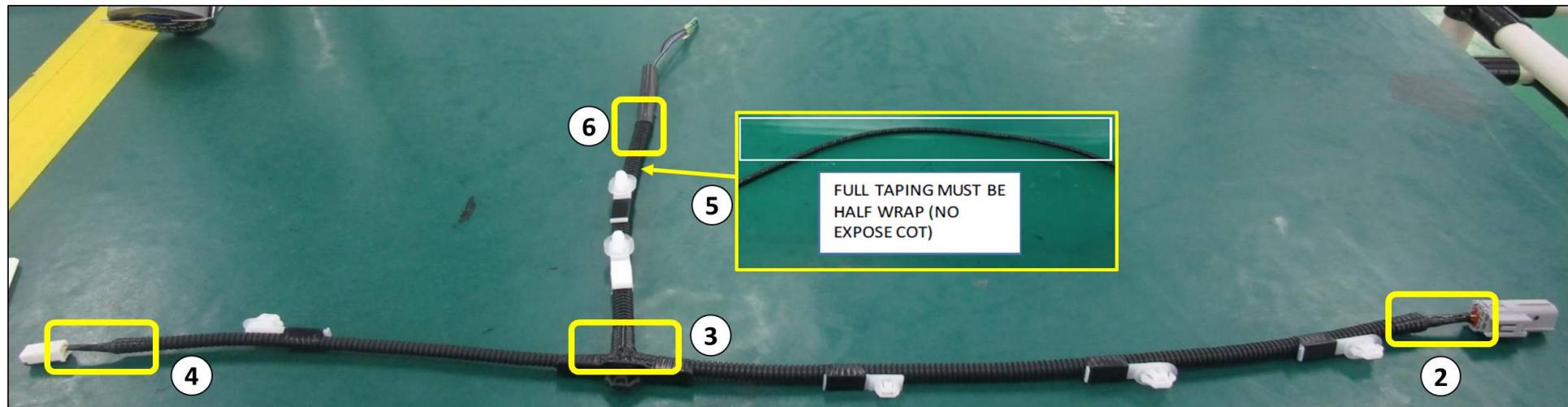
7 of 7

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0516-7021B****① No Wrong facing of clamp****② ③ ④ ⑤ ⑥ No Missing Tape (Black tape)**

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