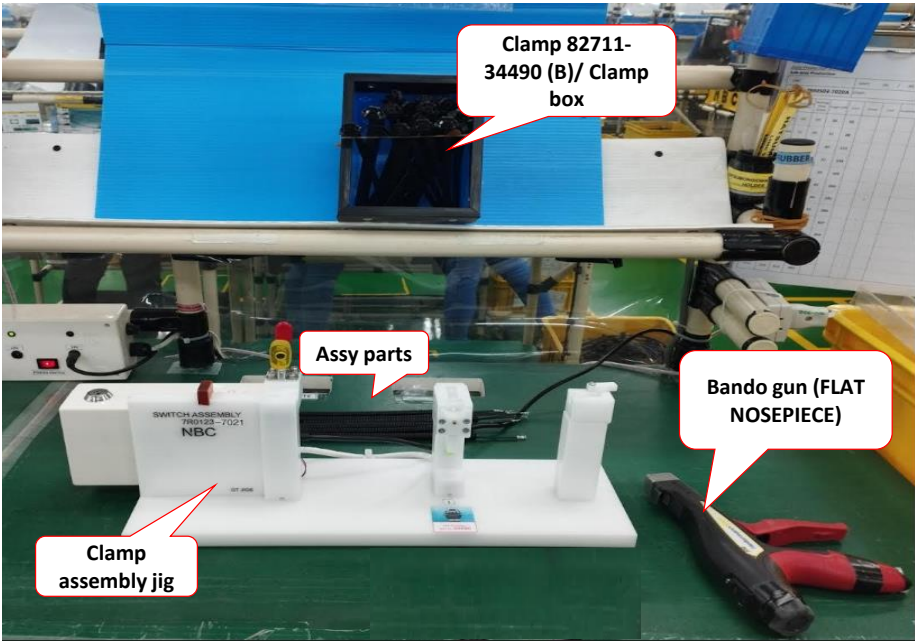





	<b>WORK INSTRUCTION</b>				Effectivity Date: <b>November 03, 2023</b>	
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>200D/220D / 7R0123-7022</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-SEQUOIA</b>	Document No.: <b>WI-ENG-PDE-743</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: <b>0</b> Page No.: <b>1</b> of <b>7</b>	

<b>PARTS:</b> 1. Assy parts; Clamp 82711-34490 (B)		<b>JIG:</b> 1. Clamp Assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	Clamp Assy Table Lay-out	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 	<div> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div> <div> <b>BANDO GUN</b>   </div>
<b>QUALITY POINTERS</b>		<b>Document references:</b> 1. Refer to WI-ENG-PDE-576 Taping assembly process	
		1. No missing parts/tools. 2. No excess parts/tools.	

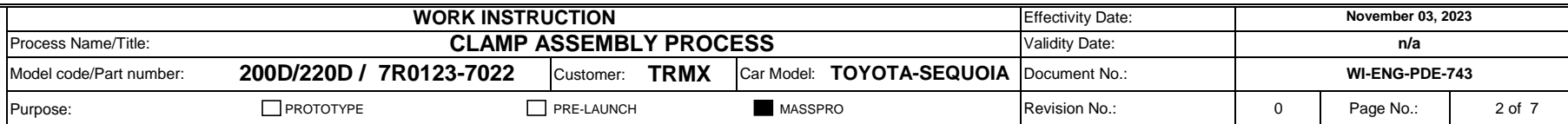
  

Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/03/23	0	Initial issue. Transfer of Clamp setting and Clamp assembly process from Taping assembly process (WI-ENG-PDE-576) to Clamp assembly process.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 3, 2023			

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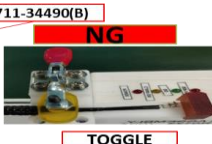

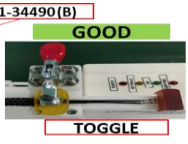
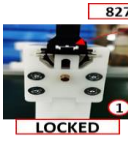


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<b>PARTS:</b>		1. Assy parts ; Clamp 82711-34490 (B)		JIG:	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Clamp Assy	<div></div> <div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector <b>6098-6663 (B)</b> in <b>Receiver base 1</b> then lock using right hand. Continue to set the harness then last, set the <b>B-B wires</b> together within the stopper then press by <b>Toggle clamp</b>. Continue if the sequence light of location ① was <b>ON</b>. the <b>CLAMP ON</b>.</p><p>2. Check if LED light for <b>POWER, CLAMP</b>, and <b>SEQUENCE LIGHT</b> is <b>ON</b>. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the Leader and <b>WAIT</b> for instruction.</p><div></div><p><b>NOTE:</b> On clamp location 2, if clamp <b>82711-34490 (B)</b> is <b>locked</b> and the <b>toggle clamp</b> is <b>set</b>, the proces will <b>proceed</b>. If <b>clamp 82711-34490 (B)</b> is <b>unlock</b> and the <b>toggle clamp</b> is <b>set</b>, the process will <b>not proceed</b> and <b>NG buzz</b> will be heard.</p></div>		n/a	<div><p><b>BAND CLAMP ILLUSTRATION</b></p><div></div><p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p></div>

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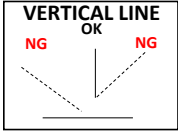



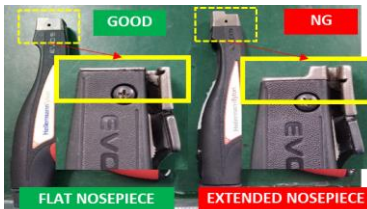
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PARTS:	1. Assy parts ; Clamp 82711-34490 (B)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy  Clamp assembly ( Continuation )	<div><div>No gap between stopper and terminals</div><div></div><div>3. Initially tighten the band clamp <b>82711-34490</b> on clamp location <b>1</b> using right hand.</div><div>4. Get the bando gun using right hand then cut the band clamp on Location <b>①</b> using both hands. Press the <b>SW button</b> after cut. <b>GO</b> sound will be heard.</div><div><div>UNLOCKED PIN</div><div></div><div>NOTE: Pin must be hit during cutting of bando gun.</div></div><div><div></div><div>GOOD</div><div>NG</div><div></div><div>VERTICAL LINE OK NG NG</div><div></div><div>Fixed setting of band clamp cutter: 1 ~ 2</div></div><div>5. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div></div> <div><div></div><div>BANDO GUN</div><div></div><div>FLAT NOSEPIECE</div></div> <div><div></div><div>BAND CLAMP ILLUSTRATION</div><div>GOOD</div><div>NG</div><div>FLAT NOSEPIECE</div><div>EXTENDED NOSEPIECE</div><div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp 5. No wrong use of bando gun.</div></div>		

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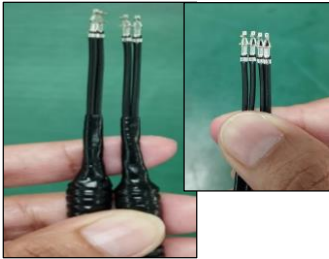



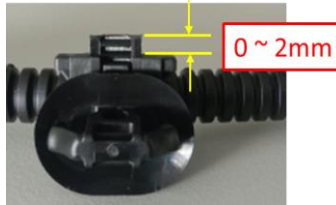
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<b>PARTS:</b>		1. Assembled parts 2. Master sample	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	Clamp Assy	<p>Visual/By two's inspection</p>  <p><b>ACTUAL PRODUCT</b></p>  <p><b>Master sample</b></p>  <p><b>Assembled parts</b></p>  <p>1. Conduct <b>alignment of harness (Master sample vs. Assembled parts)</b> using both hands.</p>  <p>2. Check the <b>connector lock condition</b> and <b>insertion</b>.</p> <p>3. Check the <b>presence of clamp attachment</b>.</p>  <p>4. Check the <b>taping condition</b> and <b>terminal appearance</b>. Must be <b>no deformed terminal</b>.</p>		<p><b>MASTER SAMPLE</b></p>  <p><b>Important reminders/Note/s:</b></p> <p>1. Using a steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p>  <p>0 ~ 2mm</p>

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**PARTS:**

Assy parts

JIG:

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

Clamp  
Assy

Measurement

**MEASURING TAPE**

1. No wrong dimension.

**Important reminders/Note/s:**

1. For Hatsumono and Owarimono.
2. Please use calibrated/verified measuring tape when getting the measurement.

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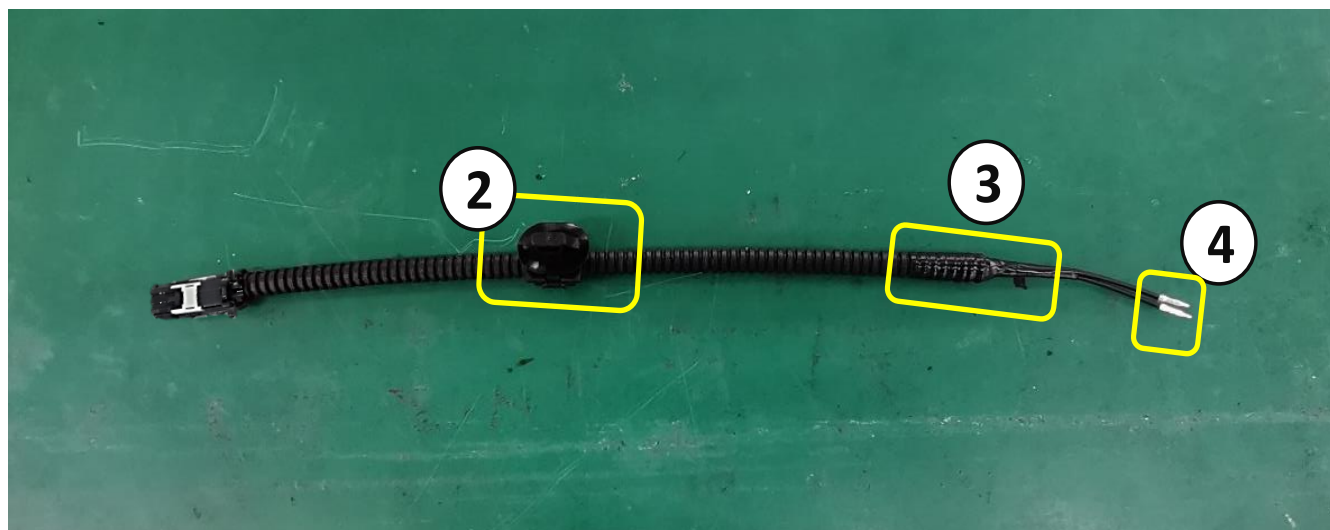
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**PARTS:**

Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7R0123-7022****GOOD****NO GOOD****GOOD****NO GOOD**

- ① No **Unlock/ Halflock Connector**
- ② No **Missing band clamp**
- ③ No **Missing Tape**
- ④ No **Deformed Terminal**
- ⑤ No **Terminal Backing Out**

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