



WORK INSTRUCTION
CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 26, 2024

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

NB8 / 7N0207-7020

Customer: TRJ

Car Model: SUBARU-LEGACY

Document No.:

WI-ENG-PDE-947

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. Assy part
2. Band Clamp RT18RSF (W)

3. Band Clamp 82711-16820 (BR)

JIG:

1. Clamp Assembly Jig
2. Bando Gun (Not Modified)

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

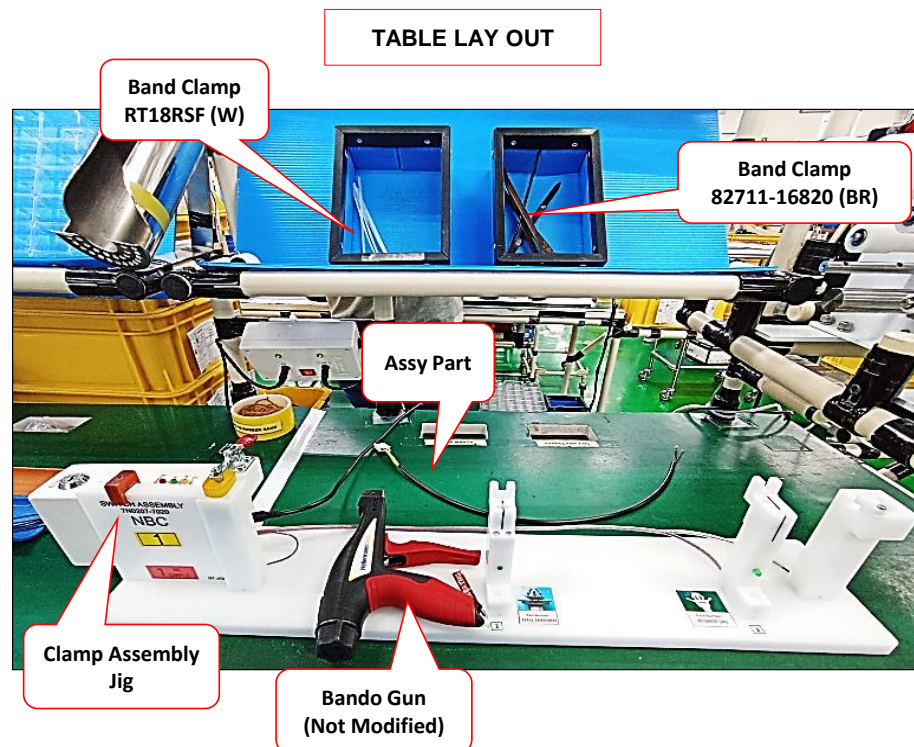
TOOLS/PPE

QUALITY POINTERS

1

P1

Table lay-out



Safety Instruction

Be sure to wear required 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

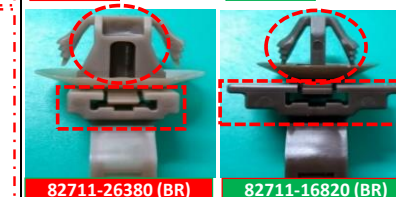
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

BAND CLAMP ILLUSTRATION

NG

GOOD



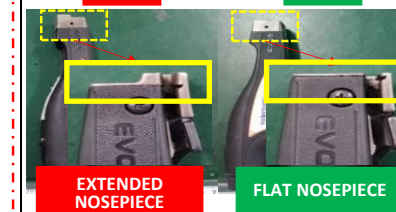
82711-26380 (BR)

82711-16820 (BR)

BANDO GUN ILLUSTRATION

NG

GOOD



EXTENDED NOSEPIECE

FLAT NOSEPIECE

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/26/24	1	Correction of number sequence in process.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a
07/10/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a

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DCC Stamp



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Page No.:

2 of 5

PARTS:

1. Band Clamp RT18RSF (W)
2. Band Clamp 82711-16820 (BR)

JIG:

Temporary Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2 ¹

n/a

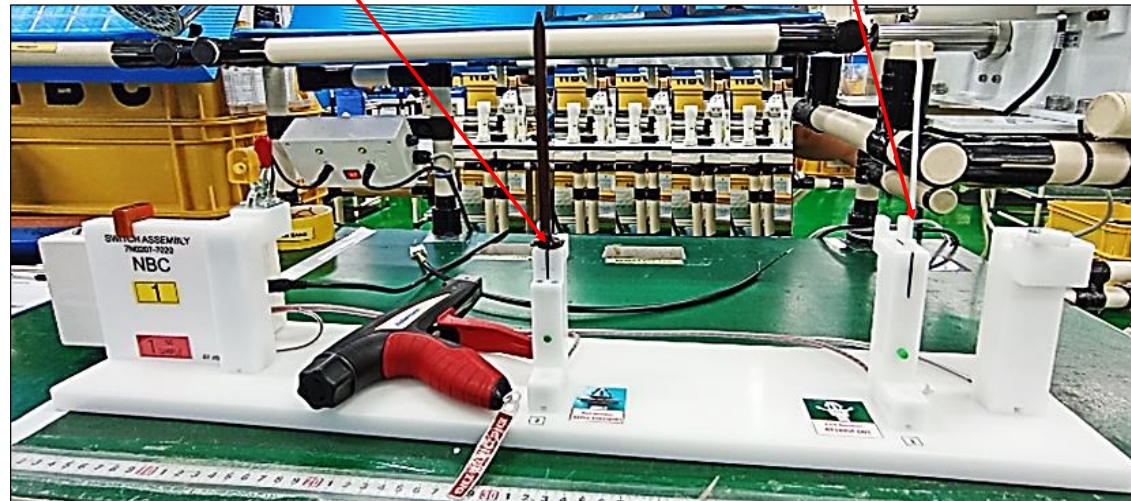
Clamp Setting



82711-16820 (BR)



RT18RSF (W)



1. Get 1 pc of clamp RT18RSF (W) using right hand and set in to clamp location 1 using both hands.

2. Get 1 pc of clamp 82711-16820 (BR) using right hand and set in to clamp location 2 using both hands.

1. No damaged clamp
2. No wrong use of clamp
3. No missing clamp

Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

BANDO GUN



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Page No.:

3 of 5

PARTS:	1. Assy Parts	JIG:	Temporary Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
3 	n/a Clamp Setting	<div data-bbox="698 391 1115 481"></div> <div data-bbox="1229 391 1632 481"></div> <div data-bbox="544 529 1677 858"></div> <div data-bbox="544 865 1169 997"><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 4F5260-0000 (W) in Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp.</p></div> <div data-bbox="544 1008 1169 1082"><p>2. Initially tighten the band clamp on location 1 and location 2 using both hands.</p></div> <div data-bbox="1180 865 1713 997"><p>3. Get the bando gun using right hand then cut the band clamp on location 1 and location 2 using both hands.</p></div> <div data-bbox="1180 1008 1713 1082"><p>4. Conduct POINT CHECKING before removing the harness from jig.</p></div> <div data-bbox="544 1120 707 1305"><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div> <div data-bbox="714 1098 1209 1319"></div> <div data-bbox="1243 1114 1440 1137" data-label="Section-Header">BANDO GUN ALIGNMENT</div> <div data-bbox="1243 1145 1429 1294"></div> <div data-bbox="1440 1157 1603 1294"></div> <div data-bbox="1599 1184 1718 1264"><p>Fixed setting of band clamp cutter: 1</p></div>	<div data-bbox="1731 391 2123 497"><p>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp</p></div> <div data-bbox="1731 603 2123 826"></div> <div data-bbox="1778 858 2074 884" data-label="Section-Header">Important reminders/Note/s:</div> <div data-bbox="1731 906 2123 1050"><p>1. Make sure no gap between stopper and terminals.</p><p>2. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p></div> <div data-bbox="1832 1098 2007 1126" data-label="Section-Header">BANDO GUN</div> <div data-bbox="1769 1145 2067 1319"></div>

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Page No.:

4 of 5

PARTS: 1. Assy Parts

JIG:

1. Measuring tape

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

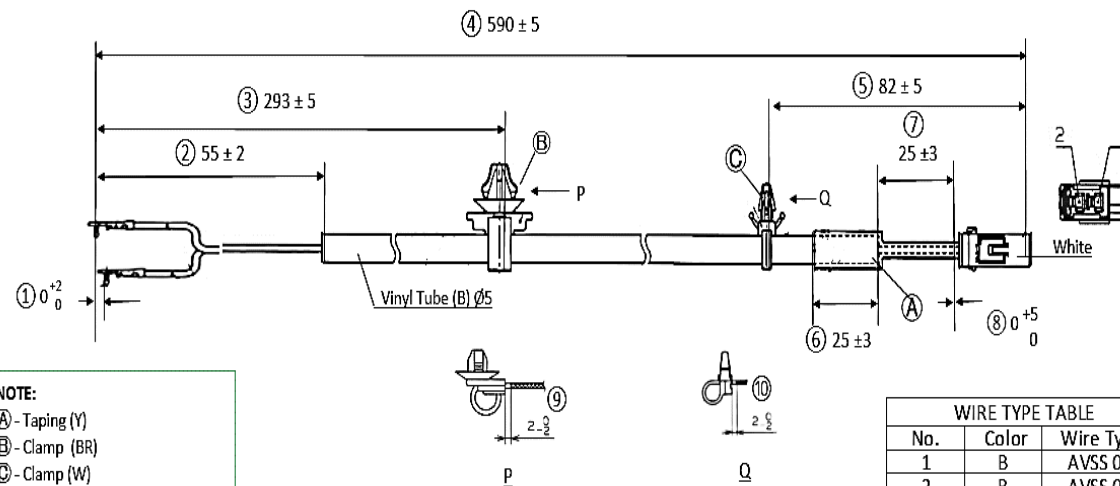
TOOLS/PPE

QUALITY POINTERS

4

n/a

Measurement



NOTE:

- A - Taping (Y)
- B - Clamp (BR)
- C - Clamp (W)

1. No wrong dimension

Important reminders and note/s:

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

MEASURING TAPE



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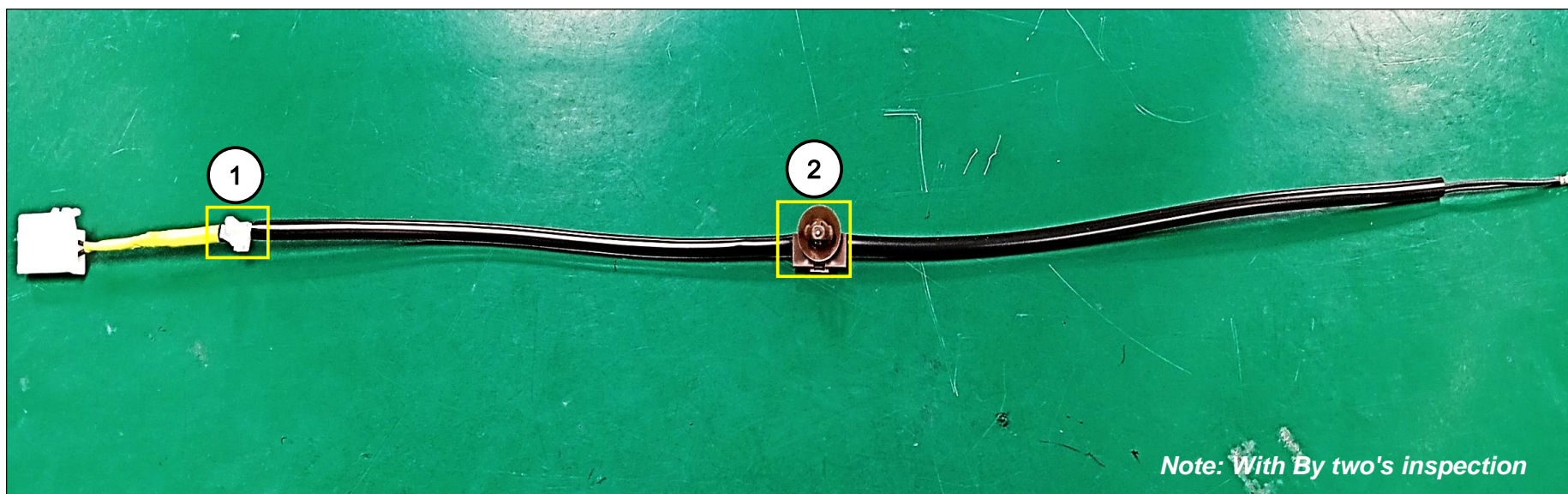
5 of 5

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP ASSY****7N0207-7020****① No Wrong Dimension****③ No Missing and Misalign Band Clamp****② Check the Clamp Appearance**

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