



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCES

Model code/Part number:

500B / 7L0084-7023A

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 1, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1074

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-3A540 (W); Black tape [5pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

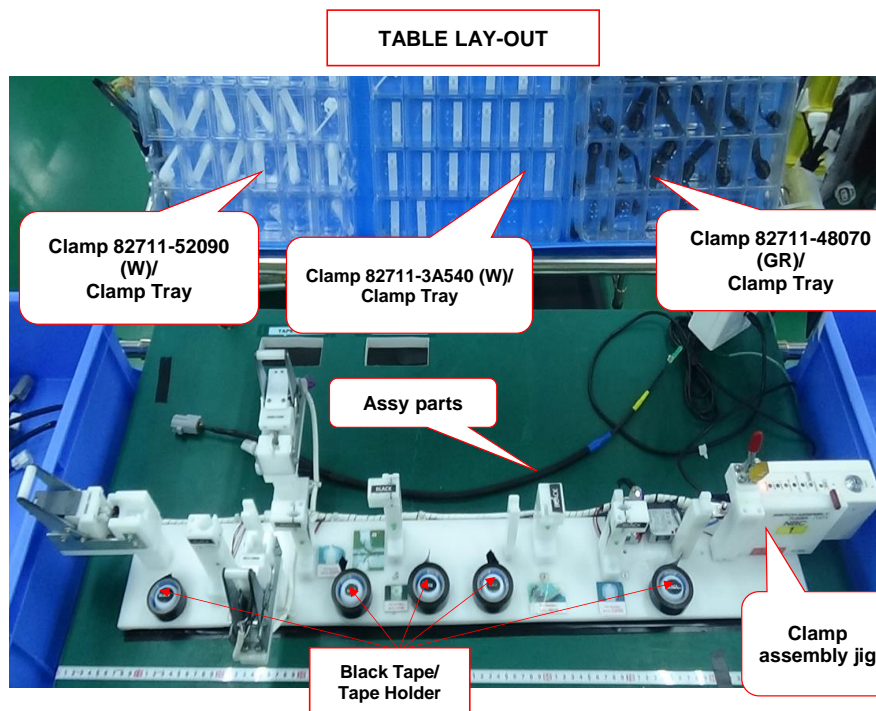
TOOLS/PPE

QUALITY POINTERS

1

Clamp
Assy

Table Lay-out

**Safety Instruction**

Be sure to wear 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.

Document reference/s:

1. Refer to **WI-ENG-PDE-426A-C** for Taping assembly process

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

								Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change purpose from pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a					n/a
09/26/24	0	Initial issue. Separate Clamp assy from Taping assembly process.	M. Ariola	C. Villanueva	A. Arañes	n/a					n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 26, 2024			

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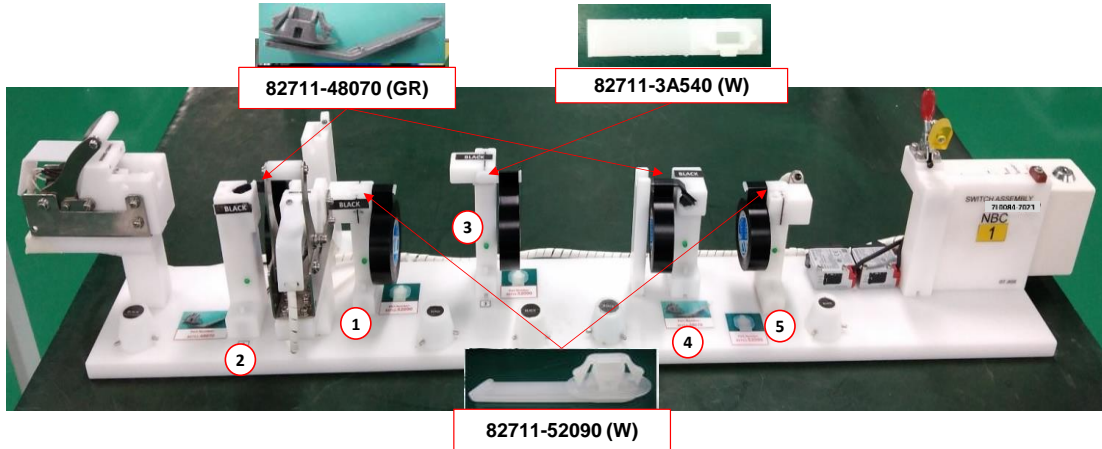
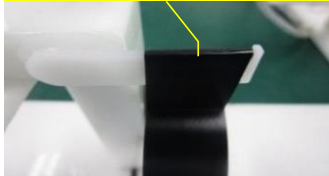


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PARTS:		1. Assy parts 2. Clamp 82711-52090 (W) [2pcs.] 3. Clamp 82711-48070 (GR) [2pcs.]		4. Clamp 82711-3A540 (W) 5. Black tape [5pcs.]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting	<div></div> <div>1. Get 2pcs. of clamp 82711-52090 (W) using right hand then set to clamp location 1 and 5 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-48070 (GR) using right hand then set to clamp location 2 and 4 using both hands.</div> <div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to location 3 using both hands.</div> <div>4. Initially attach Black tape to clamp location 1, 2, 3, 4 and 5 using both hands.</div>				<div>STANDARD TAPING FOR CLAMP</div> <div><p>One wind for under tape</p></div> <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>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div>

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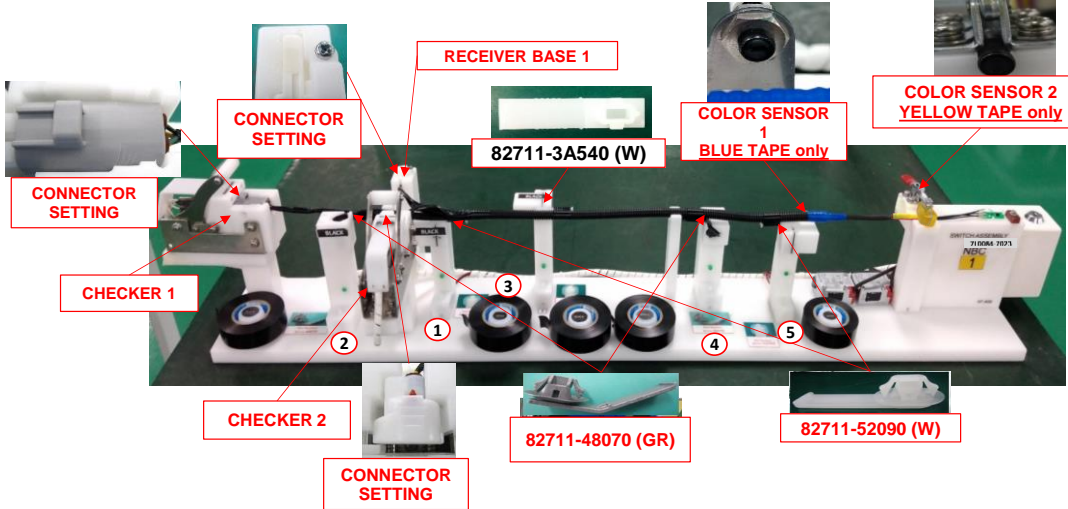

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PARTS:	1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp Assembly	 <p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Third, set the connector 6098-3810 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor 1 will beep/buzz if sensor detects Blue tape. Color sensor 2 will beep/buzz if sensor detects Yellow tape. Last, set the hotmelted wires and terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p>	 <p>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB 2. Make 2-3 windings for clamp taping</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>	

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PARTS:		1. Black tape 2. Assy parts		JIG:	1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	Clamp Assy Clamp Assembly (Continuation)	<div><p>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in 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 in clamp location 3 was ON.</p><p><i>Note: Follow the correct arrangement of vinyl tubes before taping.</i></p></div>			<div></div>	<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and PCB</p> <p>2. Make 2-3 windings for clamp taping</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	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 in 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 in 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. Go sound will be heard.</div> <div>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB 2. Make 2-3 windings for clamp taping</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Clamp Assy	Measurement	<div><p>NOTE:</p><ul style="list-style-type: none">(A) - Taping (Y)(B) - Taping (B)(C) - Clamp (GR)(D) - Clamp(W)(E) - Taping (L)<p>MEASURING TAPE</p></div>		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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PARTS:

1. Assy parts

JIG:

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VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0084-7023A****1 No Wrong facing of clamp****2 3 4 5 No Missing Tape (Black tape)**

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