



## WORK INSTRUCTION

Process Name/Title: **CLAMP ASSEMBLY PROCESS**

Effectivity Date:

April 26, 2024

Model code/Part number: **930B / 7N0205-7020Ca** Customer: **TRJ** Car Model: **TOYOTA-4RUNNER**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-878

Revision No.:

1

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## PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48210(B); Clamp 82711-3A540(W); Clamp 82711-33650 (W); Black tape [5pcs]; Orange tape

JIG:

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

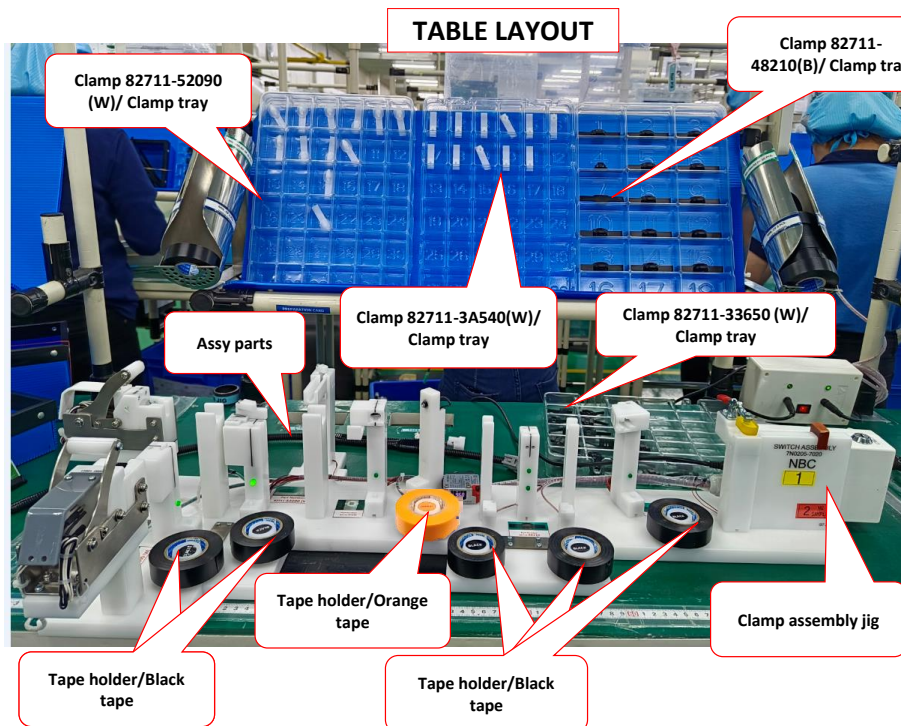
## TOOLS/PPE

## QUALITY POINTERS

1

n/a

Table layout



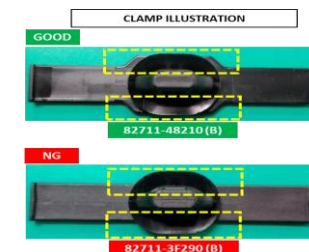
**Safety Instruction**  
Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

**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

**Important reminders/Notes:**  
**1. Please check the clamp first before start of assembly to avoid wrong use of clamp.**



## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/26/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
04/23/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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PROTOTYPE



PRE-LAUNCH



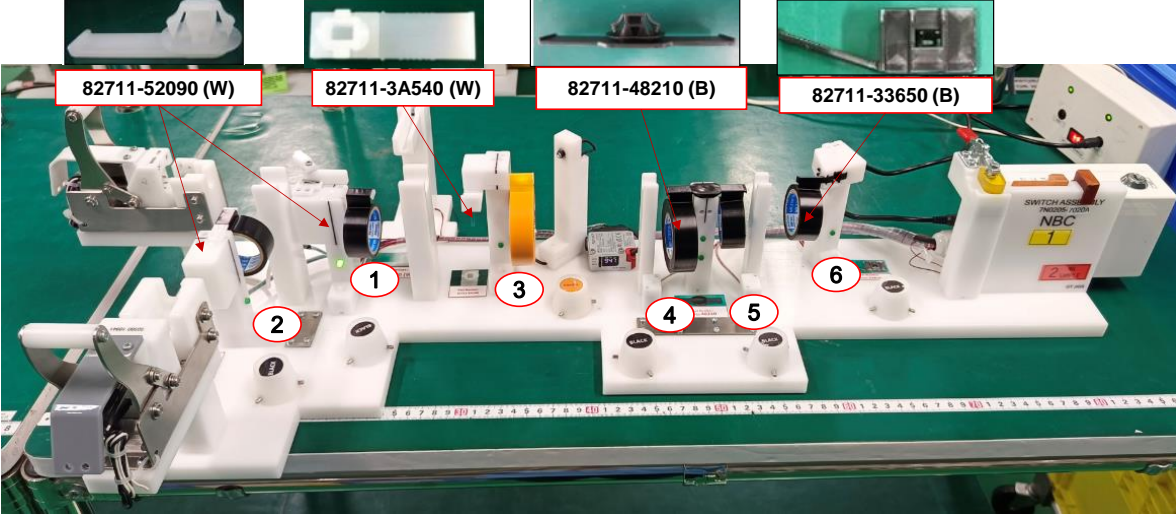
MASSPRO

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PARTS:	1. Clamp 82711-33650 (B) 2. Clamp 82711-48210 (B) 3. Clamp 82711-3A540 (W)	4. Clamp 82711-52090 (W) 5. Orange tape 6. Black tape [5pcs]	JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a  Clamp setting	 <div data-bbox="548 922 1133 1013">1. Get 2pcs of clamp <b>82711-52090 (W)</b> using right hand and set to clamp location <b>1 and 2</b> using both hands.</div> <div data-bbox="548 1034 1133 1125">2. Get 1pc of clamp <b>82711-3A540 (W)</b> using right hand and set to clamp location <b>3</b> using both hands.</div> <div data-bbox="548 1145 1133 1236">3. Get 1pc of clamp <b>82711-48210 (B)</b> using right hand and set to clamp location <b>4 and 5</b> using both hands.</div> <div data-bbox="1144 922 1720 1013">4. Get 1pc of clamp <b>82711-33650 (B)</b> using right hand and set to clamp location <b>6</b> using both hands.</div> <div data-bbox="1144 1034 1720 1125">5. Initially attach <b>Orange tape</b> to clamp location <b>3</b> using both hands.</div> <div data-bbox="1144 1145 1720 1236">6. Initially attach <b>Black tape</b> to clamp location <b>1,2,4,5 and 6</b> using both hands.</div>		<b>Important reminders/Notes:</b> <b>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</b>  1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig

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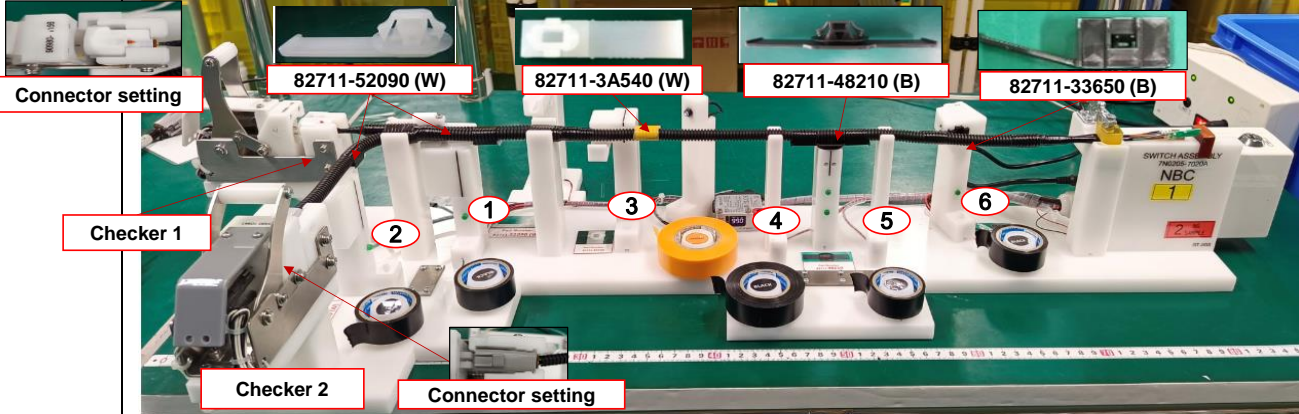
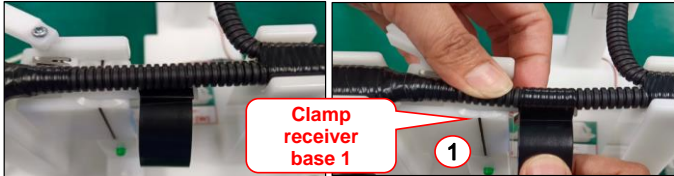

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Orange tape 3. Black tape [5pcs]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly			
		<div><div></div><div><p>1.Put the assy parts into jig. <i>(See above picture for the correct setting).</i> First, set the <b>connector 6189-0451 (W)</b> to <b>Checker 1</b>, Second set the <b>Connector 6188-0066 (GR)</b> to <b>Checker 2</b>, Third, set the connector <b>6098-3810 (W)</b>. Last, set the <b>hotmelted wire</b> and <b>B-B wires</b> together within stopper then press by toggle clamp.</p><div><p>Clamp receiver base 1</p></div></div><div><p>1</p></div></div> <div><p>2. Check if all <b>LED</b> light for <b>Wire 1</b> and <b>Wire 2</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process. Continue the process if the sequence light on <b>location 1</b> was <b>ON</b>.</p><p>3. On clamp <b>location 1</b> conduct <b>spot taping</b> using both hands. Make <b>2 windings</b> of tape. Press the <b>SW button</b> after taping. Sequence light will be <b>OFF</b>. <i>(NOTE: DO NOT CUT THE TAPE)</i></p><p>4. Remove the <b>connector 6098-3810 (W)</b> using right hands and set to <b>clamp receiver base 1</b> using both hands then lock. Sequence light will be <b>ON</b>.</p></div>			<p>1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig</p>

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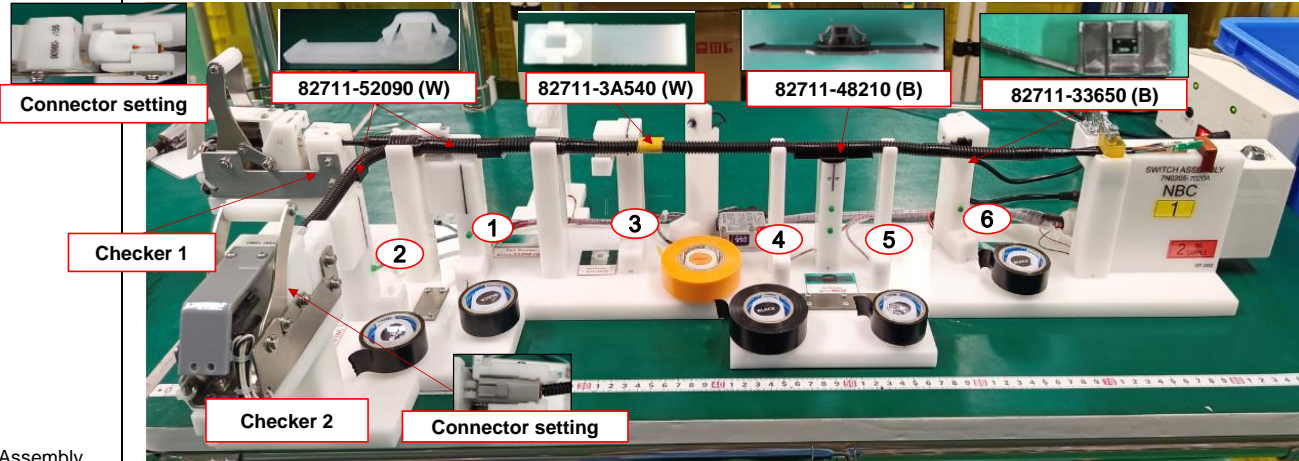
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Orange tape 3. Black tape [5pcs]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a  Clamp Assembly (Continuation)	<div></div> <div>5. Combine the <b>2 COT</b> using both hands, Hold the <b>Black tape</b> using right hand then start taping using both hands on clamp <b>location 1</b>. Make <b>3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue the process if the sequence light on clamp <b>location 2</b> was <b>ON</b>.</div> <div>6. On clamp <b>location 2</b> hold the <b>Black tape</b> using right hand. <b>Make 3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue the process if the sequence light on clamp <b>location 3</b> was <b>ON</b>.</div> <div>7. On clamp <b>location 3</b> hold the <b>Orange tape</b> using right hand. <b>Make 3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue the process if the sequence light on clamp <b>location 4</b> was <b>ON</b>.</div> <div>8. On clamp <b>location 4</b> hold the <b>Black tape</b> using right hand. <b>Make 3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue the process if the sequence light on clamp <b>location 5</b> was <b>ON</b>.</div> <div>9. On clamp <b>location 5</b> hold the <b>Black tape</b> using right hand. <b>Make 3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue the process if the sequence light on clamp <b>location 6</b> was <b>ON</b>.</div> <div>10. On clamp <b>location 6</b> hold the <b>Black tape</b> using right hand. <b>Make 3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. <b>GO</b> buzzer will be heard.</div> <div>11. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</div>			1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig

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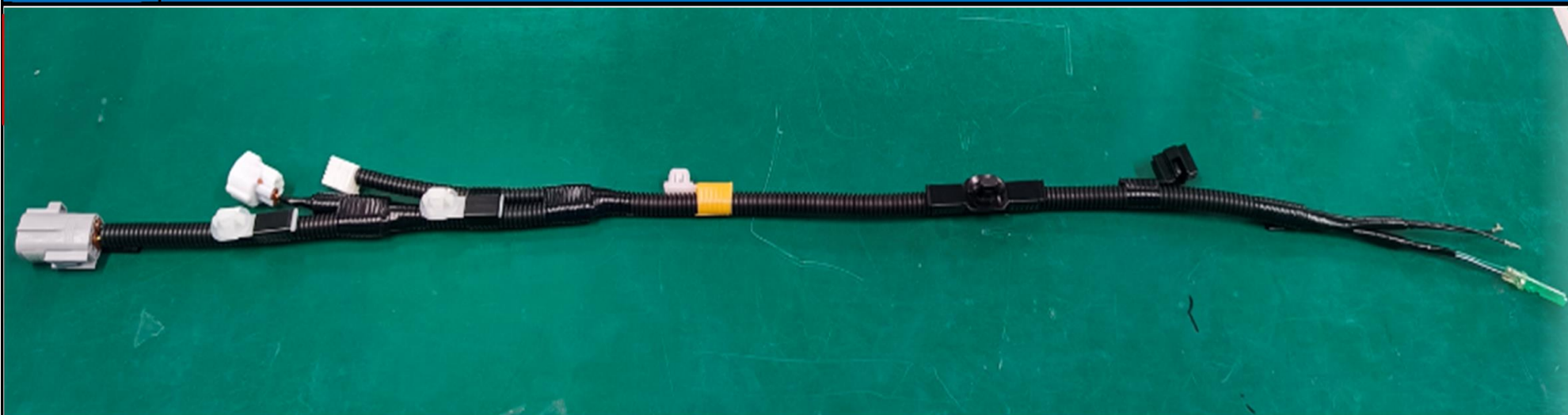
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**PARTS:**

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****CLAMP  
ASSY****7N0205-7020Ca****1 Check the alignment**

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