



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 14, 2025

Validity Date:

n/a

Model code/Part number:

177D / 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-1047

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:

1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [4pcs.]; Gray tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

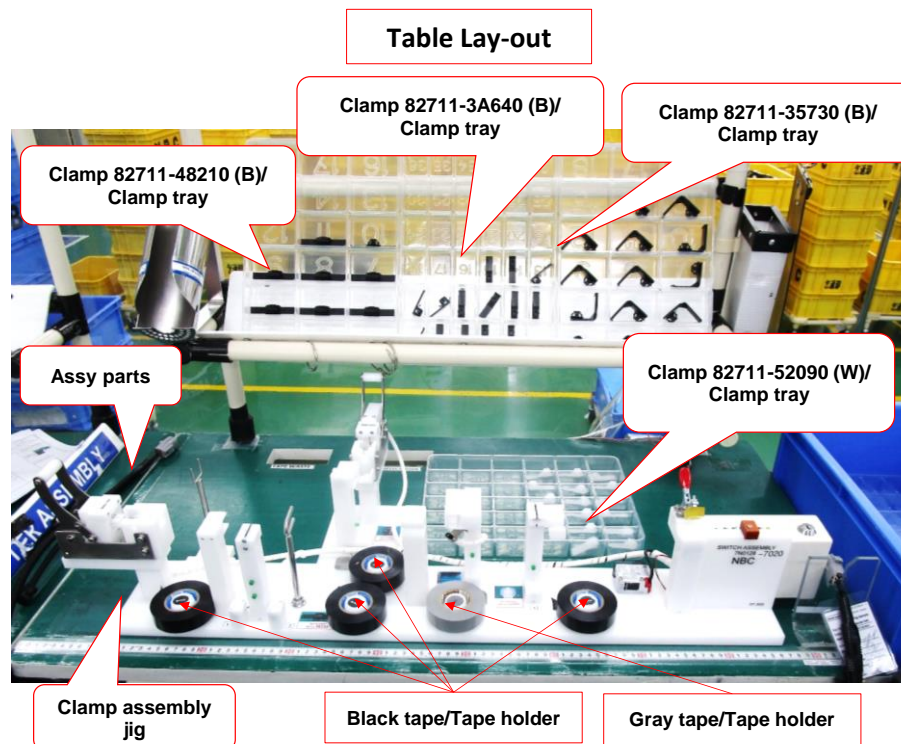
TOOLS/PPE

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.

Document reference/s:

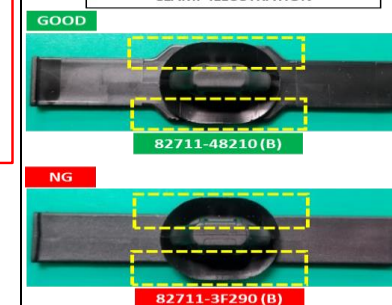
1. Refer to **WI-ENG-PDE-351A-B** for Taping assembly process

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




CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



Revision History

							Prepared by	Checked by	Reviewed by	Approved by
05/14/25	2	Update work procedure of clamp assembly process page 3 no.2;page 5 no. 8	A.Buban	n/a	C.Villanueva	A. Arañes		n/a		
09/25/24	1	Change from pre-launch to Masspro.	M. Ariola	n/a	C.Villanueva	A. Arañes				
09/11/24	0	Initial issue. Seperate clamp assy process from Taping assembly process.	M. Ariola	n/a	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Reviewed	Approved	Est. Date:	September 11, 2024		

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PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-3A640 (B) 3. Clamp 82711-35730 (B)		4. Clamp 82711-52090 (W) 5. Black tape [4pcs.] 6. Gray tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	<div><div></div><div><div>1. Get 1 pc. of clamp 82711-48210 (B) using right hand then insert to clamp location 1 and 2 using both hands.</div><div>2. Get 1 pc. of clamp 82711-3A640 (B) using right hand then insert to clamp location 3 using both hands.</div><div>3. Get 1 pc. of clamp 82711-35730 (B) using right hand then insert to clamp location 4 using both hands.</div><div>4. Get 1 pc of clamp 82711-52090 (W) using right hand then insert to clamp location 5 using both hands.</div><div>5. Get the Gray tape then initially attach to clamp location 4 using both hands.</div><div>6. Get the Black tape then initially attach to clamp location 1, 2, 3, and 5 using both hands.</div></div></div>				<div><div>STANDARD TAPING FOR CLAMP</div><div></div><div><div>1. No wrong use of parts</div><div>2. No wrong use of tape</div><div>3. No damaged clamp</div><div>4. No wrong clamp position</div></div><div><div>Important reminders/Note/s:</div><div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div></div><div><div>CLAMP ILLUSTRATION</div><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><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-48210 (B)</div></div><div><div>NG</div><div></div><div>82711-3F290 (B)</div></div></div></div></div></div>

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp assembly	<div><p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, put the assy parts with black connector 6189-1161 (B) into HOOK. 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. Get Black tape using right hand. Wrap the COT2 & SIDE B of the clamp using both hands. Make 2 windings. Press the SW button after taping.</p><div><p>HOOK</p><p>COT 1</p><p>COT 2</p><p>Side B</p><p>Side A</p><p>Side B</p><p>Side A</p></div></div>	<div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals.</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No wrong use of clamp</p><p>2. No damaged clamp</p><p>3. No missing clamp</p><p>4. No wrong use of tape</p><p>5. No missing tape</p></div>

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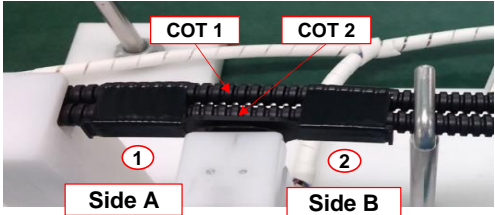
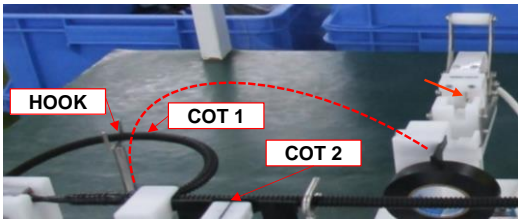
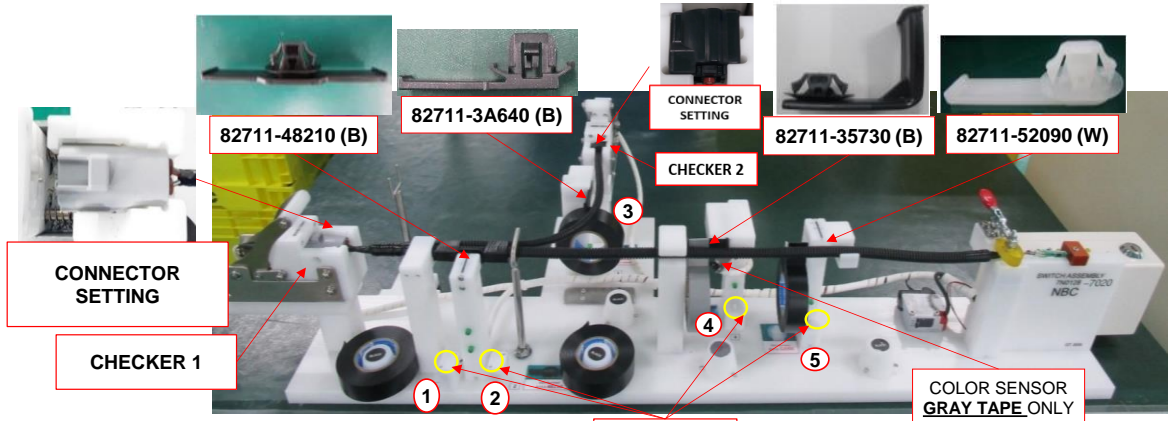

☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Clamp assembly (Continuation)	<div></div> <div><p>3. Remove the assy parts with Black connector 6189-1161 (B) from HOOK then set to CHECKER 2, pull down the handle to lock using both hands.</p><p>4. Check LED light for POWER, CLAMP, WIRE1&WIRE2, SEQUENCE LIGHT on location 1 was ON. If encountered abnormality, STOP the process, CALL the leader and WAIT for instruction.</p><p>5. Combine the COT 1 and COT 2 on Side A/ Location 1 using both hands then make 3 windings of tape then cut the tape using both hands. Press the SW button using both hands.</p></div>		<div></div> <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Make sure no gap between stopper and terminals.2. Make 2-3 windings for clamp taping <ol style="list-style-type: none">1. No wrong use of clamp2. No damaged clamp3. No missing clamp4. No wrong use of tape5. No missing tape

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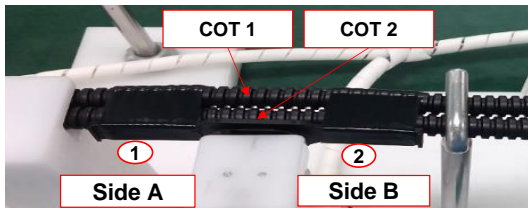
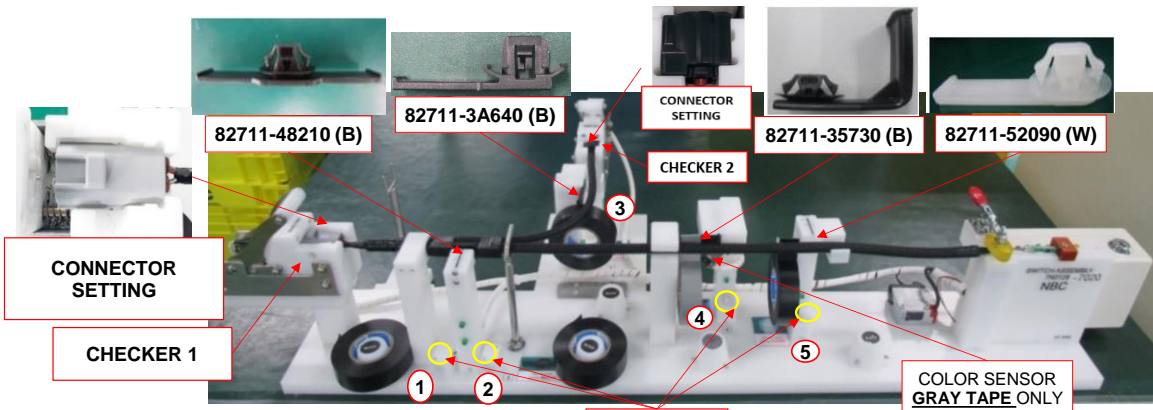
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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Clamp assembly (Continuation)	<div><p>6. Combine the COT 1 and COT 2 on Side B/ Location 2 using both hands then make 3 windings of tape then cut the tape using both hands. Press the SW button using both hands.</p><p>7. 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.</p></div> <div><p>8. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands press the SW button. <i>Note: Color sensor will proceed (beep) after pressing of SW button.</i></p><p>9. 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.</p><p>10. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div>		<p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals. 2. Make 2-3 windings for clamp taping</p> <p>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</p>

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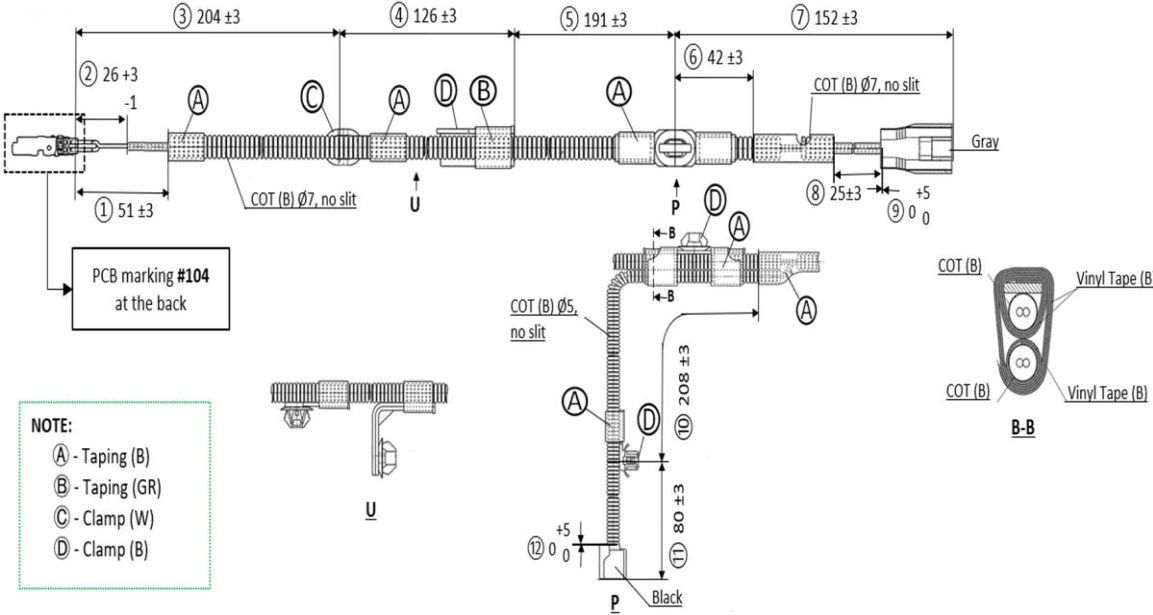
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Clamp Assy Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (B) B - Taping (GR) C - Clamp (W) D - Clamp (B)</div>		<p>Important 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:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0127-7020B****1** No Wrong facing of clamp**2 3** No Missing Tape (Black tape)

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