



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-979

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-3A640 (B); Black Tape; QR Code 7V3180-0020

JIG:

1. Clamp assembly jig
2. Label Dispencer

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

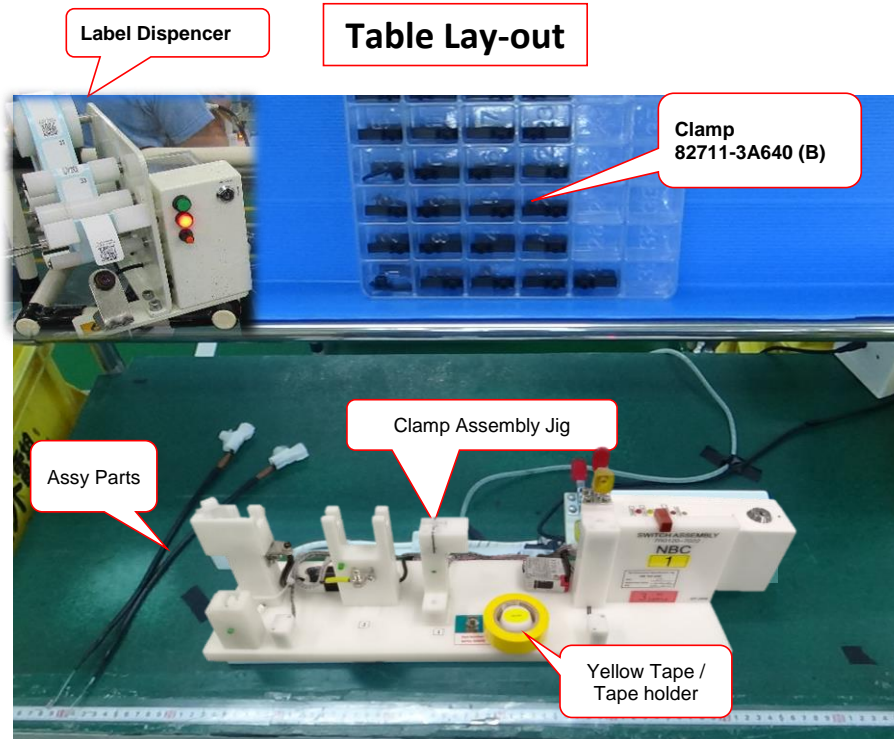
TOOLS/PPE

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 references:

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

08/09/24 1 Change Pre-Launch to Mass Production.

A.Hernandez

C. Villanueva

A. Arañes

n/a

08/08/24 0 Initial issue

A.Hernandez

C. Villanueva

A. Arañes

n/a

Eff. Date Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

August 08, 2024

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2 of 8**PARTS:**

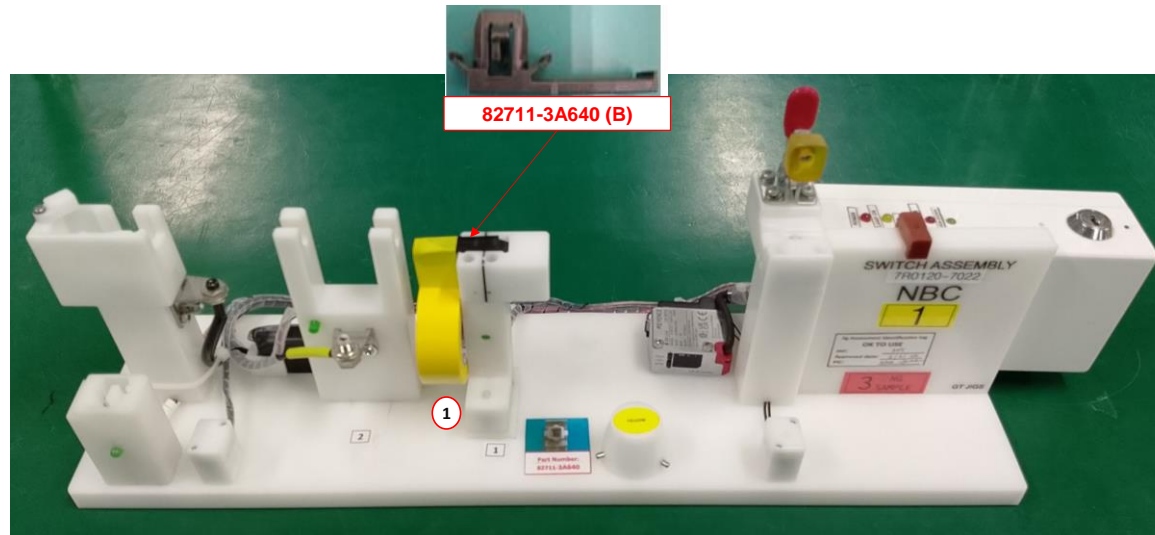
1. Clamp 82711-3A640 (B)
2. Black Tape

JIG:

1. Clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2**Clamp
Assy

Clamp Setting



1. Get 1pc. of clamp **82711-3A640 (B)** using both hands then set to clamp location **1** using both hands.

2. Initially attach **Yellow tape** on clamp location **1** using both hands.

Important reminders/Note/s:

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

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

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☐ PROTOTYPE

☐ PRE-LAUNCH

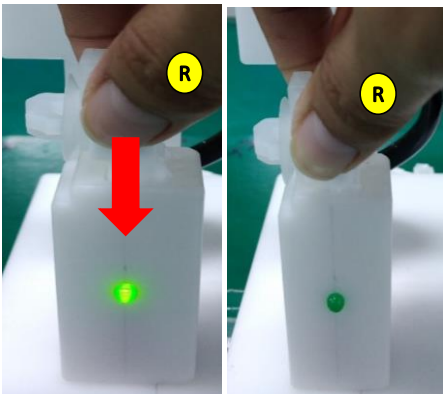
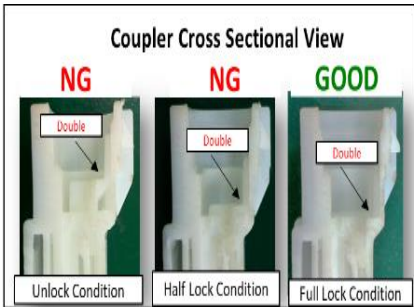
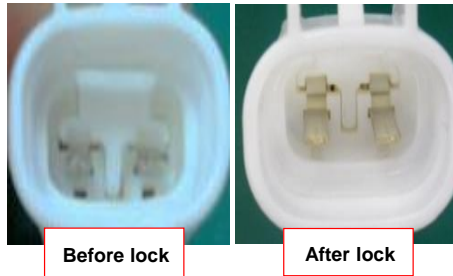

☒ MASSPRO

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PARTS:		1. Clamp 82711-3A640 (B) 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp setting	<div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</p></div> <div></div> <div></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>

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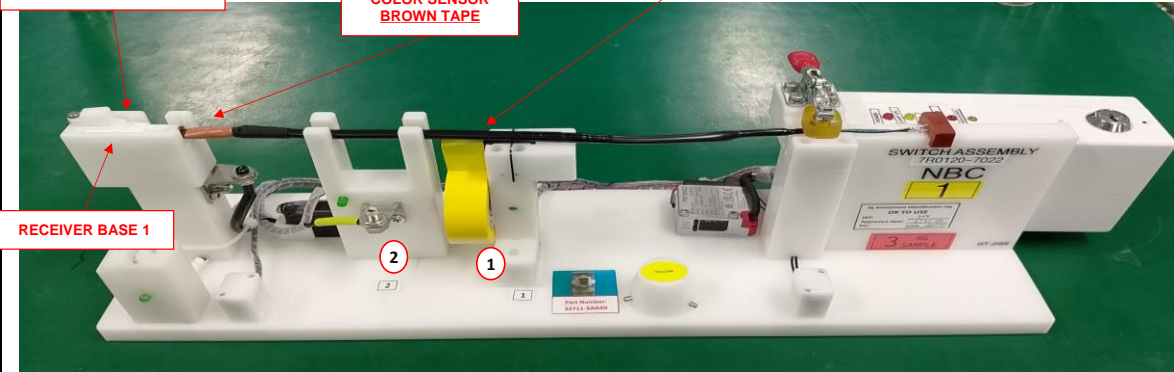
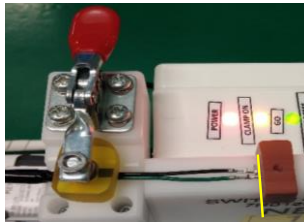
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PARTS:		1. Clamp 82711-3A640 (B) 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	<div><div><p>CONNECTOR SETTING</p></div><div><p>COLOR SENSOR BROWN TAPE</p></div><div><p>82711-3A640 (B)</p></div><div><p>RECEIVER BASE 1</p><p>2</p><p>1</p><p>3</p></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 6098-0407 (B) in Receiver base 1 then lock using right hand. Continue to set the harness then last, set the G-B/W wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was ON. the CLAMP ON.</p></div> <div><p>2. Check if LED light for POWER, CLAMP, and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction.</p></div>		<div></div> <div><p>Important reminders/Note/s: 1. Make sure no gap in stopper and terminals</p></div> <div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div>	

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PARTS:		1. Clamp 82711-3A640 (B) 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Clamp Assembly (Continuation)	<div></div>			

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6 of 8**PARTS:**

1. Assy parts

2. Label 7V3180-0020

JIG:

1. Clamp assembly jig

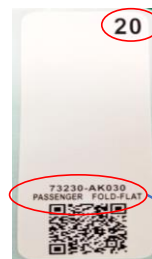
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

Clamp
Assy

Label Attachment

Model Code	Item No.	Item Name
7R0116-7022	73240-AK020	DRIVER PWR/ISO D
7R0117-7025	73240-AK010	DRIVER MANUAL
7R0118-7025	73240-AK020	DRIVER PWR/ISO D
7R0119-7021	73230-AK050	PASSENGER ISO D
7R0120-7022	73230-AK030	PASSENGER FOLD-FLAT



Model code

1. Get the label.
Note: Check the model code, item no. & name

Item no. &



2. Align the end part of label in the jig.



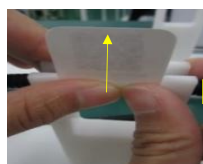
3. Fold the center part of the label



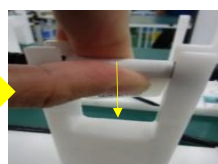
4. Align both end part of label .



5. After alignment , Press the label with both fingers .



6. Press the label upside down using finger.



Acceptable
overlap

GOOD**NG**

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label



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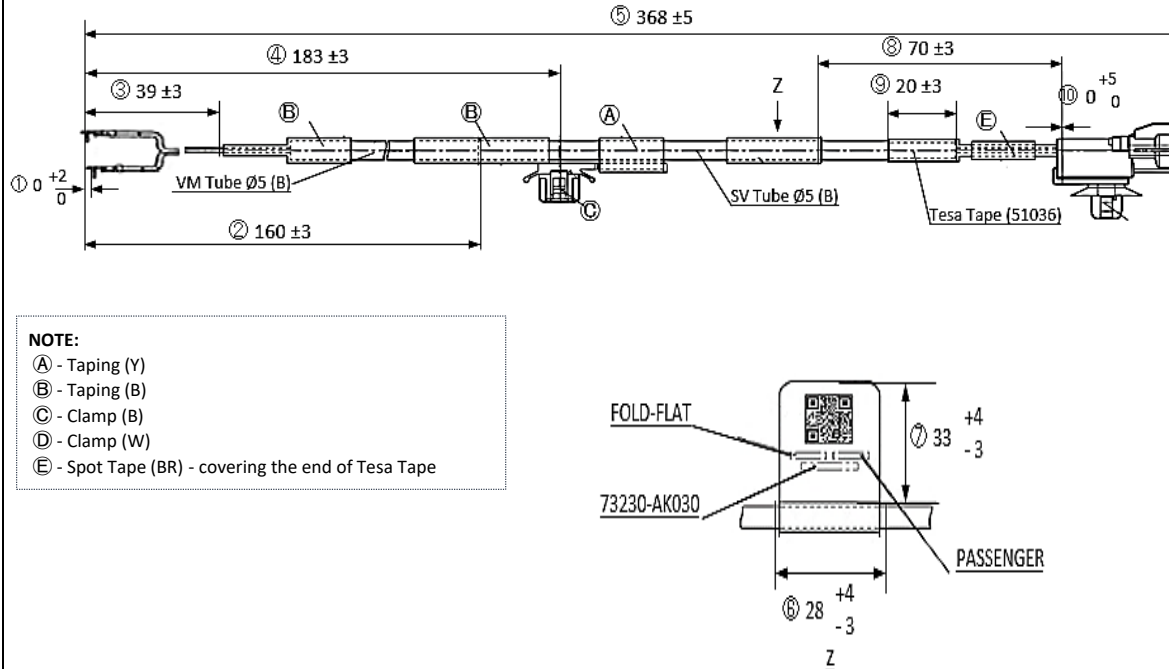
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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Clamp Assy	Measurement	<div></div>		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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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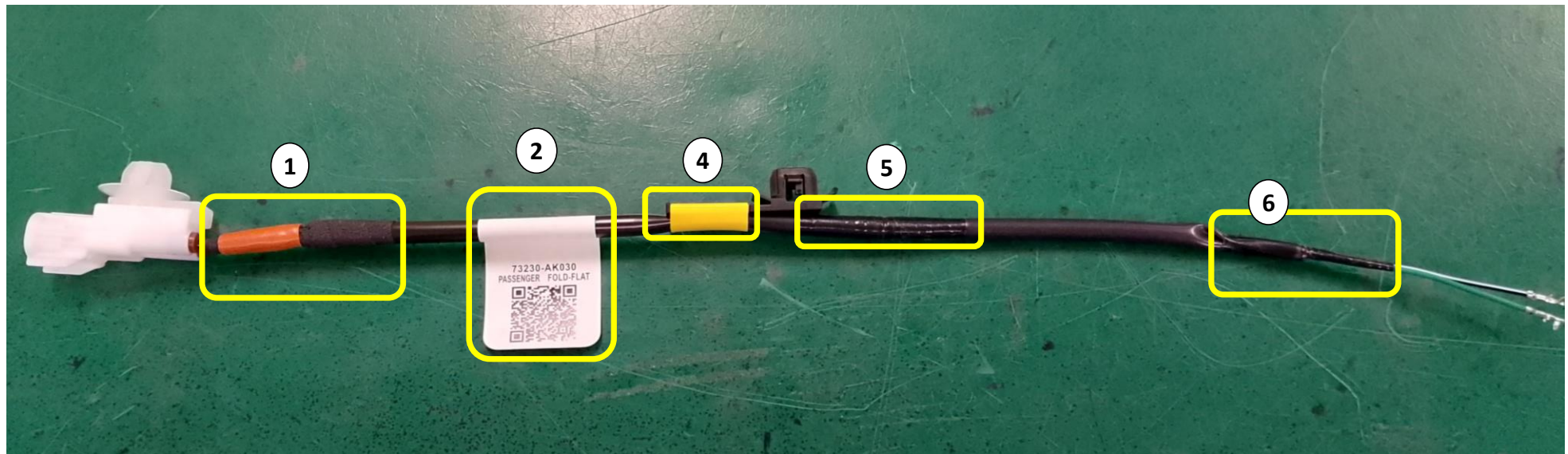
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP ASSY****7R0120-7022****1** No Missing Tape (Black Tesa tape)**3** No Wrong facing of clamp**5** **6** No Missing Tape (Black Nitto tape)**2** No Wrong Facing/Used of QR Code label**4** No Wrong color of tape(Yellow)
(Clamp Taping)

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