



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

200D / 7R0124-7020

Customer:

TRMX

Car Model:

TOYOTA-SEQUIOA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 10, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-706

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts

2. Clamp 82711-60640 (B)

3. Black tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

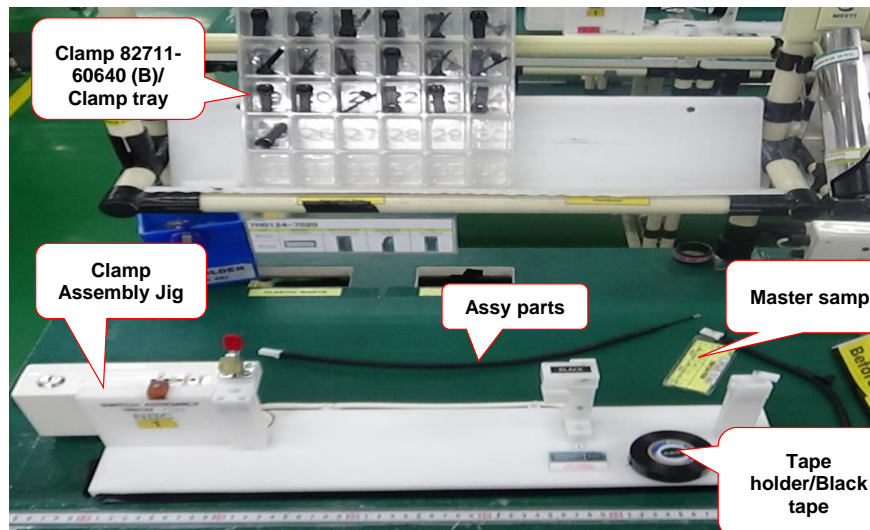
QUALITY POINTERS

1

n/a

Table lay-out

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.

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

Important reminders/Notes:

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

CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/10/24	1	Improve measurement and visual inspection.	A.Hernandez	C. Villanueva	A. Arañes	n/a				
07/29/23	0	Initial Issue. Updated template; Inclusion of CAR MODEL "TOYOTA- SEQUIOA" Excuded process from WI-ENG-PDE-499; Change process Name/Title from "TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS". Change Document control no. from WI-ENG-PDE-499 to WI-ENG-PDE-706 due to separation of process.	M Ariola	J. Loterte	C. Villanueva	A. Arañes	A.Hernandez	C. Villanueva	A. Arañes	n/a

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DCC Stamp

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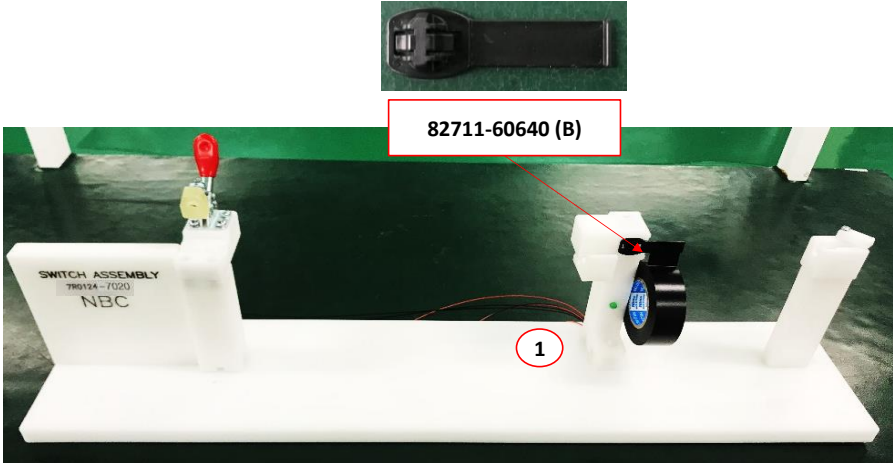
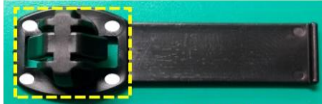
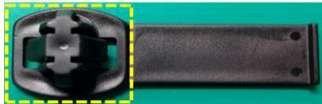
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Clamp 82711-60640 (B) 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Clamp setting	<div></div> <div>1. Get 1 pc of Clamp 82711-60640 (B) then attach to clamp location ①.</div>		n/a	<div>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp</div> <div>Important reminders/Notes: 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>82711-60640 (B)</div><div>NG</div><div></div><div>82711-21020 (B)</div></div></div>

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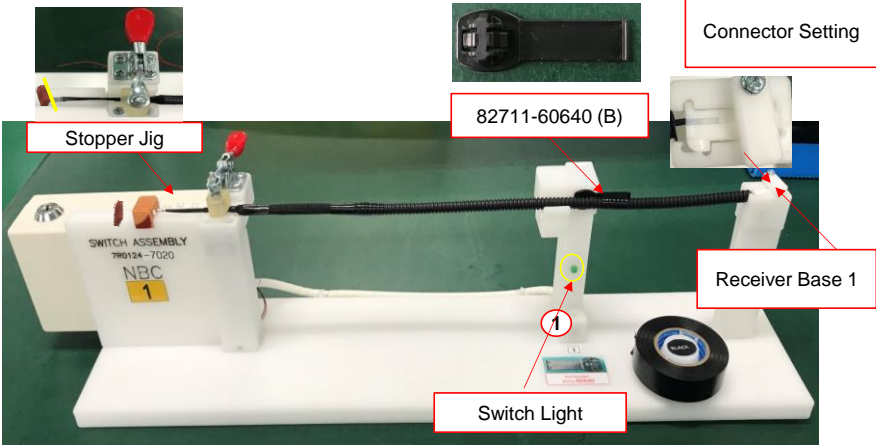
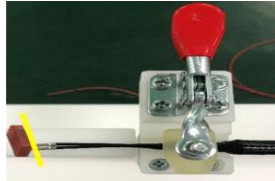
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PARTS:	1. Assy parts 2. Black tape		3. Clamp 82711-60640 (B)	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp assembly	<div></div> <div>1. Get the assy parts and set into jig. (<i>See above picture for correct setting</i>). First, set the connector 6098-6662 (W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was on.</div> <div>2. Check if all LED light for POWER ON, and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>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. GO sound will be heard.</div> <div>4. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>	n/a	<div>1. No wrong setting of clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing tape 5. No damage clamp 6. No missing clamp</div> <div>Important reminders/Note/s: <i>1. Make sure no gap between terminal and stopper jig.</i></div> <div></div>

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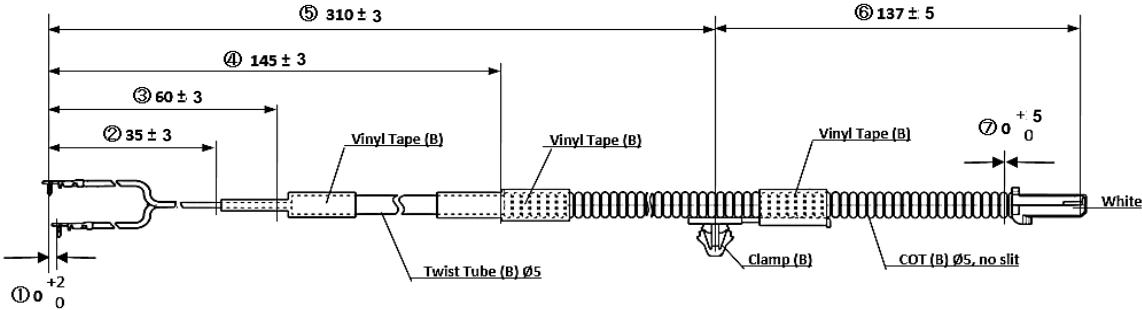
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assembled parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
4	n/a	Measurement		<div><div>MEASURING TAPE</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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n/a

JIG:

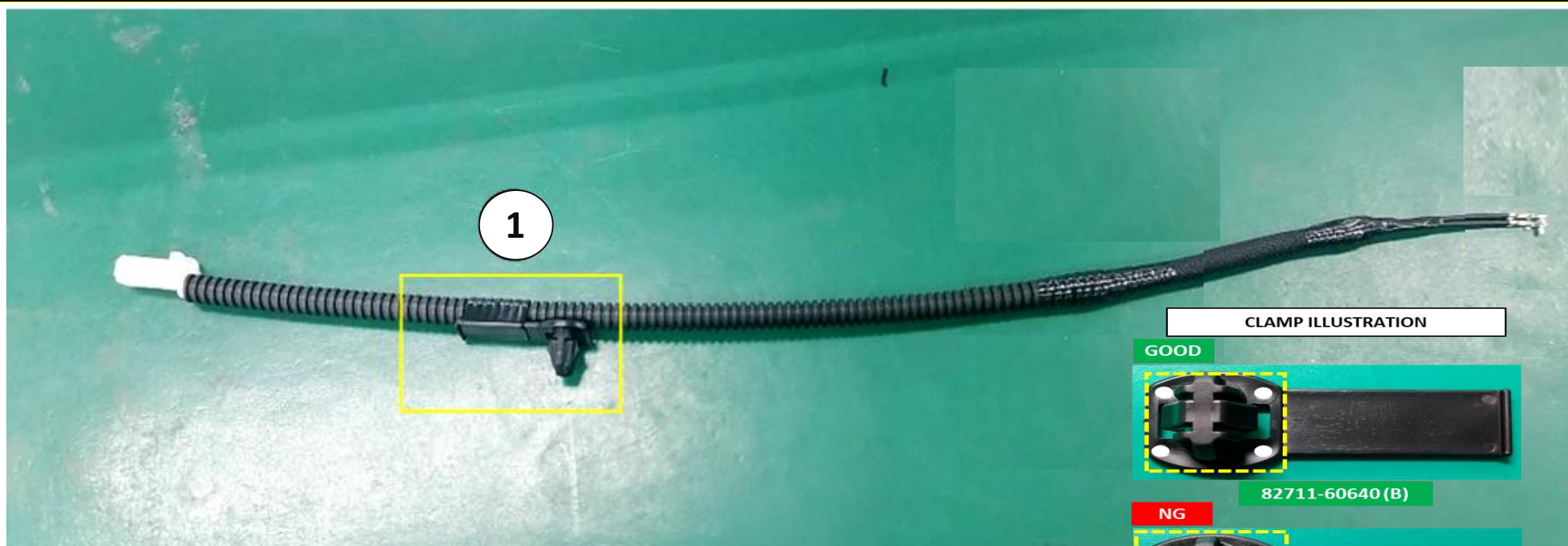
n/a



VISUAL INSPECTION

CLAMP ASSEMBLY

7R0124-7020



CLAMP ILLUSTRATION

GOOD



82711-60640 (B)

NG



82711-21020 (B)

1

Check the **Clamp Appearance**

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