



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

800B / 7N0068-7020A

Customer:

TRJ

Car Model:

LEXUS NX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-794

Revision No.:

0

Page No.:

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PARTS:

1. Clamp 82711-52090 (W) [2pcs];Clamp 82711-48070 (GR);Clamp 82711-48210 (B); Black tape [2pcs]; Yellow tape [3pcs]

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

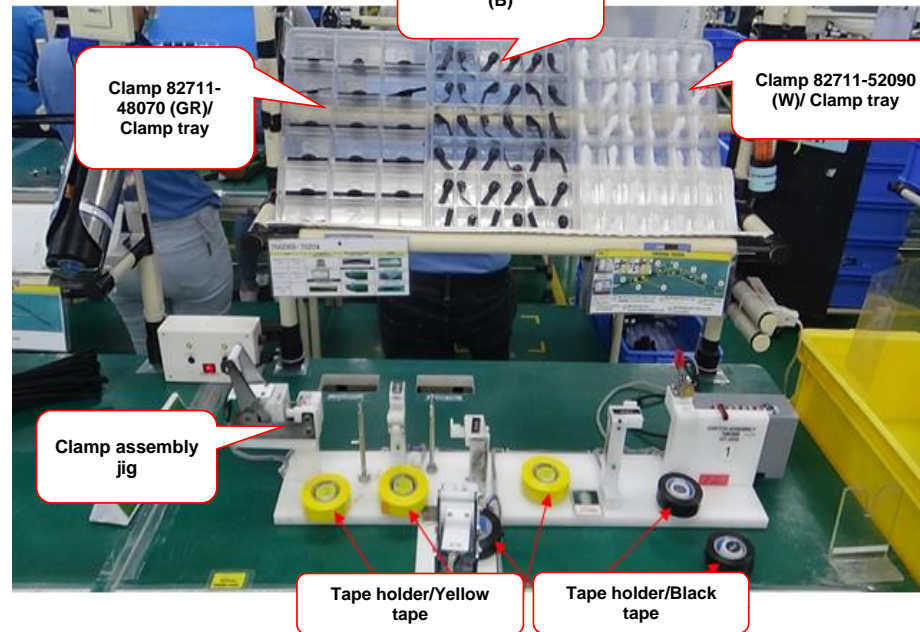
QUALITY POINTERS

1

CLAMP
ASSY

Table Lay-out

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

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

Revision History

								Prepared by	Reviewed by	Approved by	Noted by
06/06/24	0	Initial issue.						D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 6, 2024			

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PARTS:		1. Clamp 82711-52090 (W) [2pcs] 2. Clamp 82711-48070 (GR)		3. Clamp 82711-48210 (B) 4. Black tape [2pcs]		5. Yellow tape [3pcs]		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 1pc of clamp 82711-48210 (B) using right hand and set to clamp location 1 and 2 using both hands.</div> <div>2. Get 2pcs of clamp 82711-52090 (W) using right hand and set to clamp location 4 and 5 using both hands.</div> <div>3. Get 1pc of clamp 82711-48070 (GR) using right hand and set to clamp location 3 using both hands.</div> <div>4. Get Yellow tape using right hand and put pre-tape on clamp location 1, 2 and 3 using both hands.</div> <div>5. Get Black tape using right hand and put pre-tape on clamp location 4 and 5 using both hands.</div>				n/a		<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. Taping should be one side under (taping side of clamp before taping with COT).</div> <div>Important reminders/Note/s: <i>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</i></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	<div><div><div>CONNECTOR SETTING</div><div>CHECKER 1</div><div>HOOK</div><div>COT GUIDE LOWER BUTTON</div><div>CHECKER 2</div><div>CONNECTOR SETTING</div></div><div><div>82711-48210</div><div>82711-48070</div><div>82711-52090</div></div><div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div></div><div><div>1. Get the assy parts and set into jig. (See above picture to fro correct setting of harness). First, set the connector 6098-3085 (GR) to Checker 1. Next, set the B-B wires together within the stopper jig then press by toggle clamp. Last, initially put the COT with connector 6098-2220 (W) in HOOK.</div><div><div>2. Get Yellow tape using right hand. Wrap the COT2 & SIDE B of the clamp 2 windings of tape using both hands.</div></div></div></div> <div><div><div>HOOK</div><div>COT 1</div><div>COT 2</div><div>Side A</div><div>Side B</div></div></div>		<div><div>STOPPER JIG</div></div> <div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between terminal and stopper jig</div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape.</div></div>

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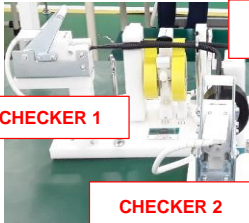

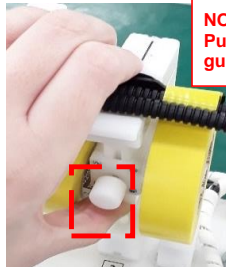
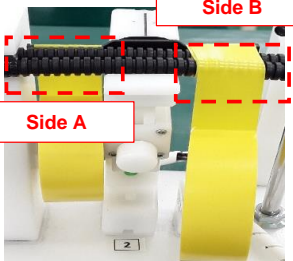
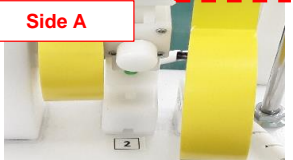
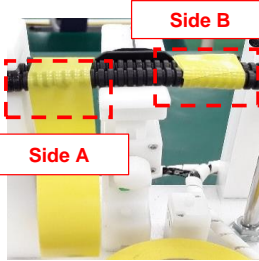

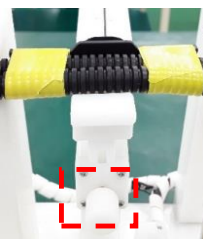
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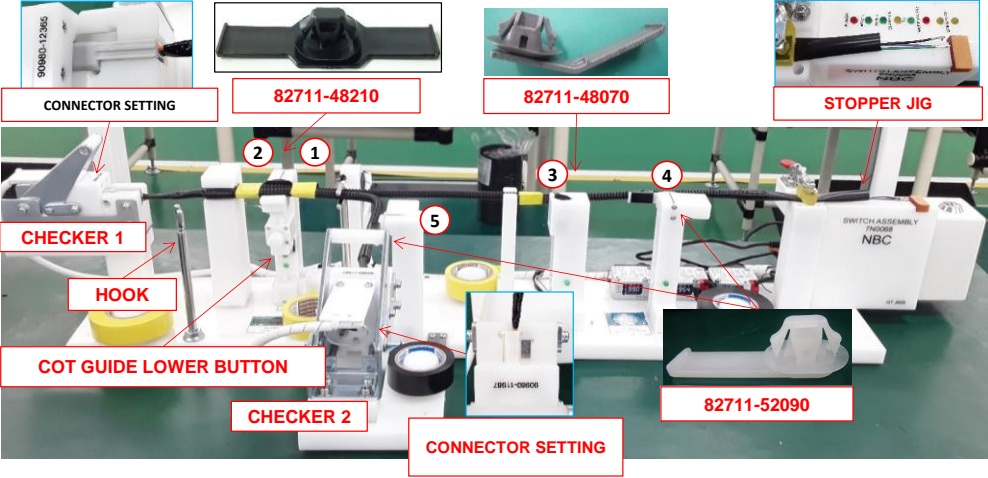

PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	<div><div><div><p>CHECKER 1</p></div><div><p>CHECKER 2</p></div></div><div>CONNECTOR SETTING</div><div><p>NOTE: Push the lower button for COT guide using left hand.</p></div><div>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.</div><div>3. Hold the COT2 and put the White connector to checker 2 using both hands.</div><div><div><p>Side B</p></div><div><p>Side A</p></div><div><p>Side B</p></div><div><p>Side A</p></div><div><p>COT GUIDE</p></div><div>5. Combine the COT1 and COT2 on SIDE B of the clamp using both hands. Make 3 winds and cut the tape. Beep sound will be heard if the color sensor detects the Yellow tape. Press the SW button after taping.</div><div>6. Combine the COT1 and COT2 on SIDE A of the clamp using both hands. Make 3 winds and cut the tape. Beep sound will be heard if the color sensor detects the Yellow tape. Press the SW button after taping.</div></div></div>			<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape.</div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	5 of 7

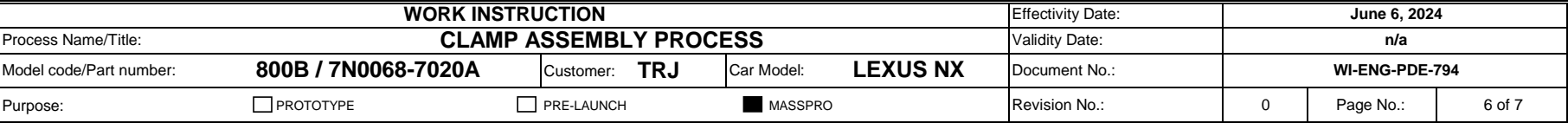
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	CLAMP ASSY	<div>Clamp Assembly (continuation)</div> <div><div><div>7. Hold the Yellow tape on clamp location 3 then start taping process using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Beep sound will be heard if the color sensor detects the yellow tape. Continue if the sequence light in location 4 was ON.</div><div>8. Hold the Black tape on clamp location 4 then start taping process using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light on location 5 was ON.</div><div>9. Conduct POINT CHECKING, press the button of COT guide the slowly remove the harness from jig</div></div><div><div>COT GUIDE</div></div></div> <div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape.</div></div>			


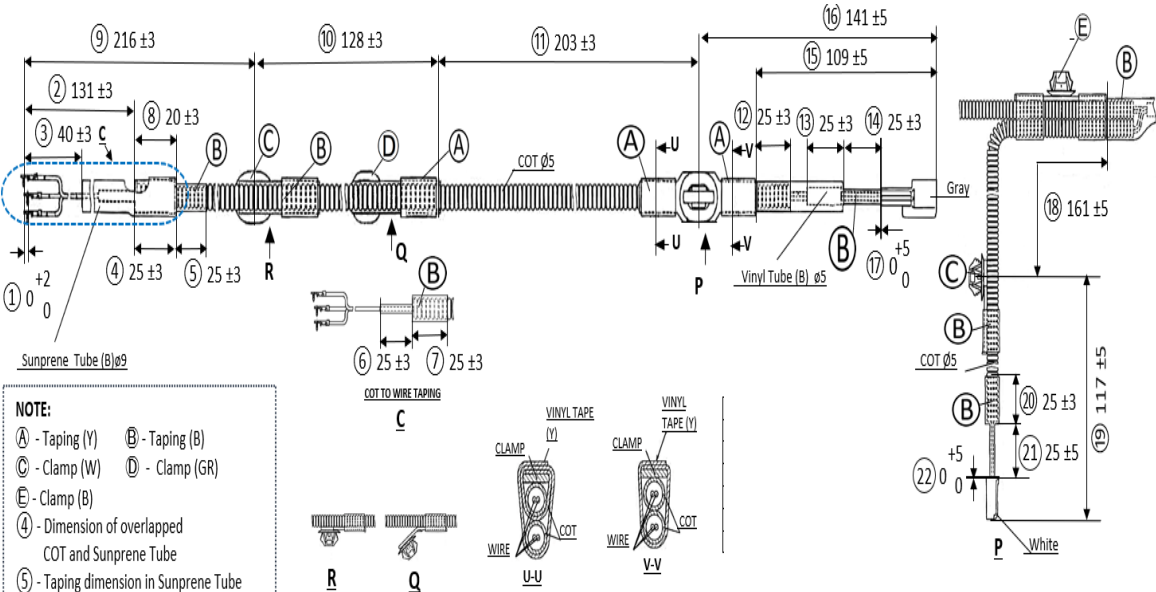
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PARTS:	n/a	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
5	CLAMP ASSY	<p>MEASURING TAPE</p>   <p>NOTE:</p> <ul style="list-style-type: none"> A - Taping (Y) B - Taping (B) C - Clamp (W) D - Clamp (GR) E - Clamp (B) 4 - Dimension of overlapped COT and Sunprene Tube 5 - Taping dimension in Sunprene Tube <p>COT TO WIRE TAPING</p> <p>U-U V-V</p>	<p>TOOLS/PPE</p> <p>MEASURING TAPE</p> <p>Important reminders and note/s:</p> <ol style="list-style-type: none"> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none"> 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1.No wrong dimension</p>

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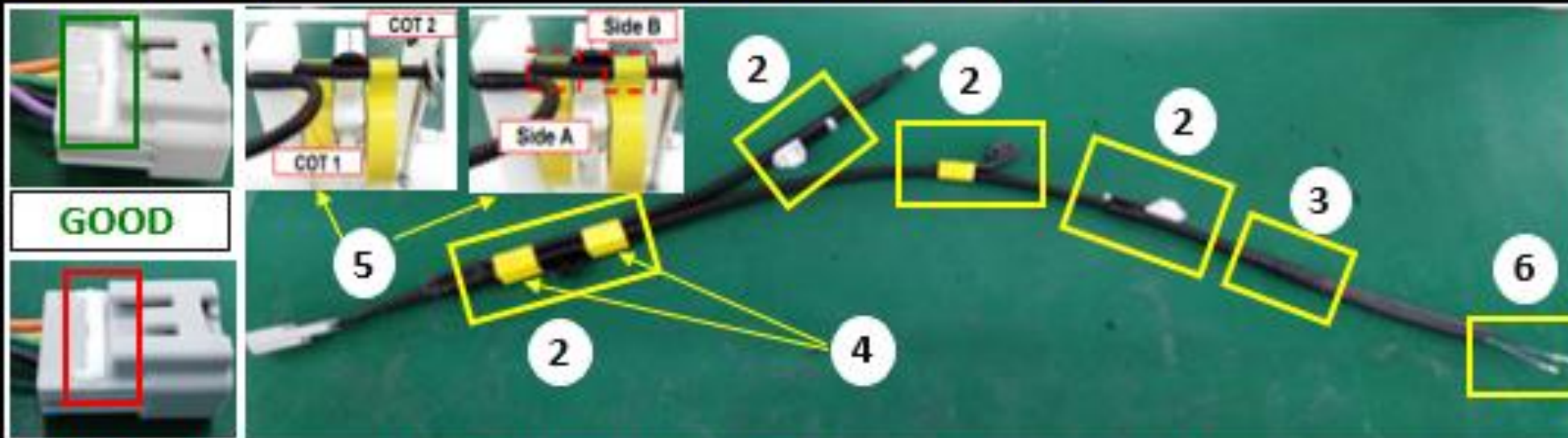
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0068-7020A****NO GOOD**

① No Unlock/
Halflocked Connector
(on 2 connector)

② No Missing Clamp (4pcs.) and
BENDING of 2 sides of wing clamp

③ No Missing Tape
(conduct bending on sunprene tube)

④ No Wrong Used of Tape
(yellow tape)

⑤ No Missing Spot Tape on
COT 2 and SIDE B

⑥ No Deformed
Terminal

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