



	<b>WORK INSTRUCTION</b> <b>CLAMP ASSEMBLY PROCESS</b>			Effectivity Date:	October 09, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	920B / 7R0115-7021A	Customer:	TRMX	Car Model:	TOYOTA-TACOMA	
	Purpose:			<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-1087	
				Revision No.:	0	Page No.:	1 of 6

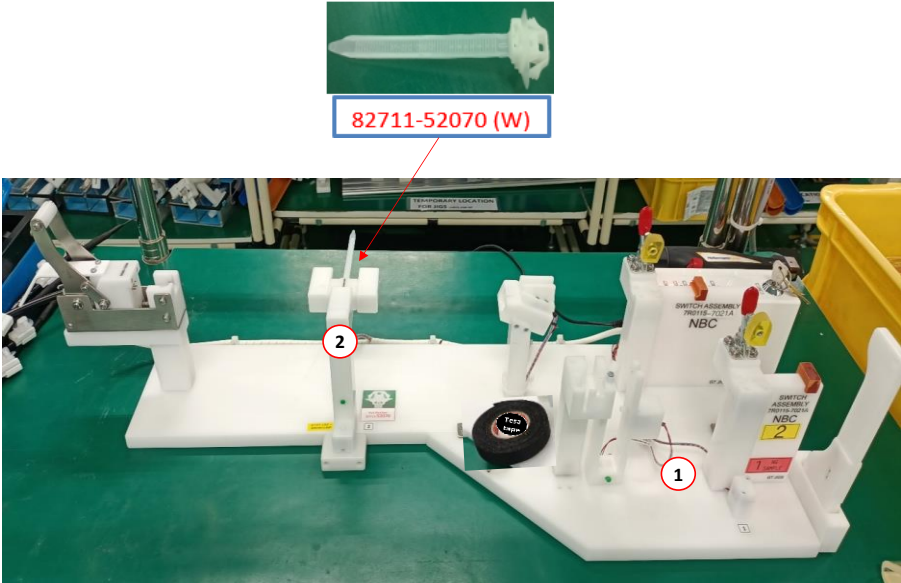
PARTS:	1. Assy parts; Clamp 82711-52070 (W); Tesa tape (51036)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div>Table Lay-out</div>		<div>Safety Instruction</div> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)	<div>Document reference/s:</div> 1. Refer to <b>WI-ENG-PDE-655A-C</b> for Taping assembly process
				<div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.	1. No missing parts/tools 2. No excess parts/tools
				<div>Alert level!</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/09/24	0	Initial issue. Separate clamp assembly from Taping assembly process.		D.Castillo	C.Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	October 09, 2024

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<b>PARTS:</b>		1. Clamp 82711-52070 (W)		JIG:	1. Clamp assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	CLAMP ASSY	<div><div>1. Get <b>1pc.</b> of clamp <b>82711-52070 (W)</b> using right hand then set to clamp <b>location 2</b> using both hands.</div></div>		n/a	1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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PARTS:	1. Assy parts 2. Tesa tape (51036)			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	CLAMP ASSY	<div><div>Connector Setting</div><div>Connector receiver base</div><div>Tesa tape</div><div>1</div><div>Handy Tesa cutter</div></div> <div>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-6653 (W) to Connector receiver base. Second, set the terminal end together within the stopper then press by Toggle clamp. Last, set the twist tube in spot taping guide and lock. Check if the sequence light of location 1 was ON.</div> <div>2. Get the Tesa tape using right hand and attach in the twist tube. Wind the tape (1 wind only) and cut using both hands. Press the SW button after cut. Continue the process on clamp location 2.</div> <div>3. Remove the harness into jig.</div> <div>4. After removal, fix the end tape of tesa then press 2x.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals</div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun 5. No peel-off tape 6. No flip-out tape 7. No loose tape 8. No missing tape</div>		
		<div><div>L</div><div>Handy Tesa cutter</div><div>R</div><div>L</div><div>Tesa tape</div><div>L</div><div>L</div><div>Press</div></div>					

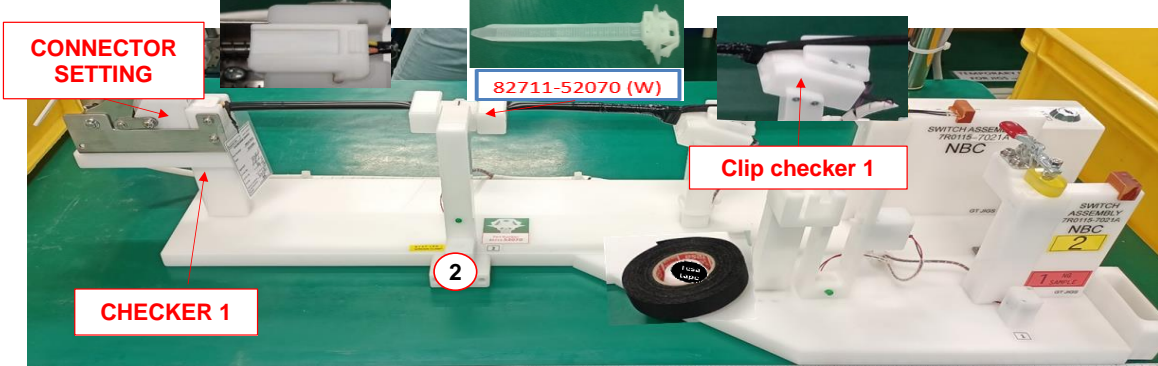
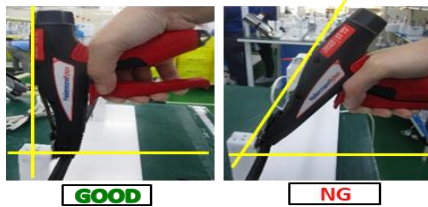

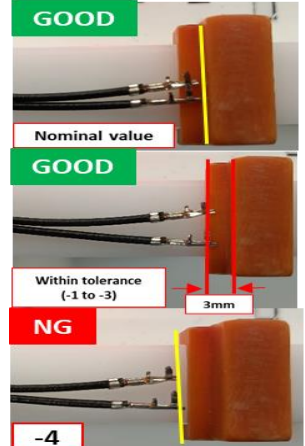
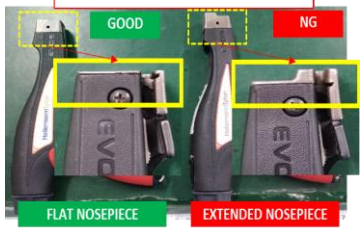
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 6

<b>PARTS:</b>	1. Assy parts 2. Tesa tape (51036)			JIG:	1. Clamp assembly jig 2. Tesa cutter		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
3	CLAMP ASSY	<div>Clamp assembly (Continuation)</div> <div></div> <div>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector <b>7189-0995 (W)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>6098-6653 (W)</b> to <b>Clip Checker 1</b> for continuity checking and se the tube in tube guide. Last, set the terminal end together within the stopper then press by <b>Toggle clamp</b>. Check if the sequence light of <b>location 2</b> was <b>ON</b>.</div> <div>2. Check if all LED light for <b>Power On, Clamp On, Wire1 &amp; Wire2</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 then continue the process.</div> <div>3. Initially tighten the band clamp from <b>location 2</b> using both hands.</div> <div>4. Get the bando gun and cut the band clamp on <b>location 2</b> using both hands. Press the <b>SW button</b> after cut. <b>GO</b> sound will be heard.</div> <div>5. Conduct <b>POINT CHECKING</b> before removing from clamp assembly jig.</div> <div>6. After point checking, remove harness from toggle clamp up to Checker 1, tube guide and clip checker 1.</div> <div></div> <div><b>BANDO GUN ALIGNMENT</b> PERPENDICULARITY OK NG NG</div> <div></div> <div>Fixed setting of bando gun: 2.75~3</div>		<div>1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun</div> <div><b>Important reminders/Note/s:</b> 1. Make sure no gap between stopper and terminals</div> <div><b>Stopper Illustration</b></div> <div></div> <div><b>BANDO GUN ILLUSTRATION</b></div> <div></div>			

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PROTOTYPE



PRE-LAUNCH



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**PARTS:**

1. Assy parts

JIG:

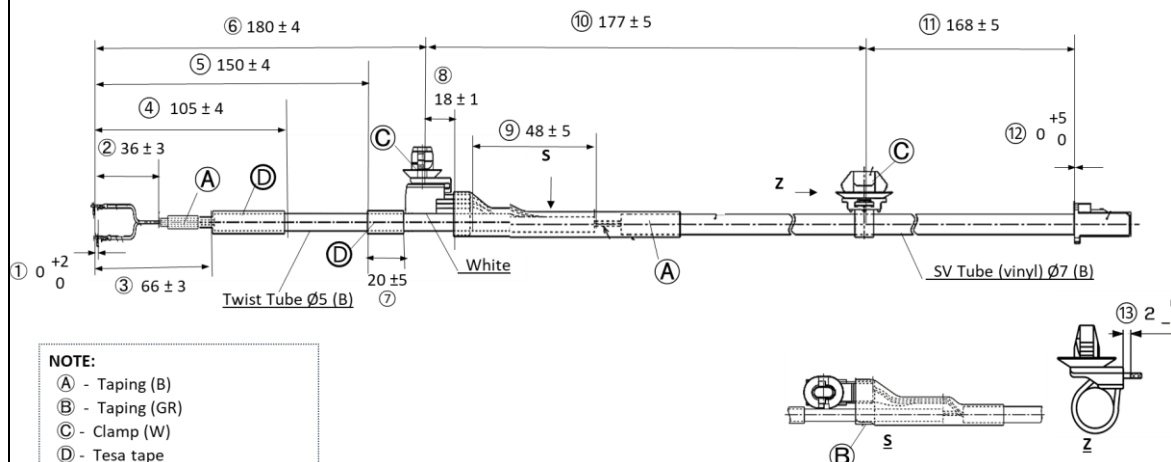
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**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

CLAMP  
ASSY

Measurement

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

**Document reference/s:**

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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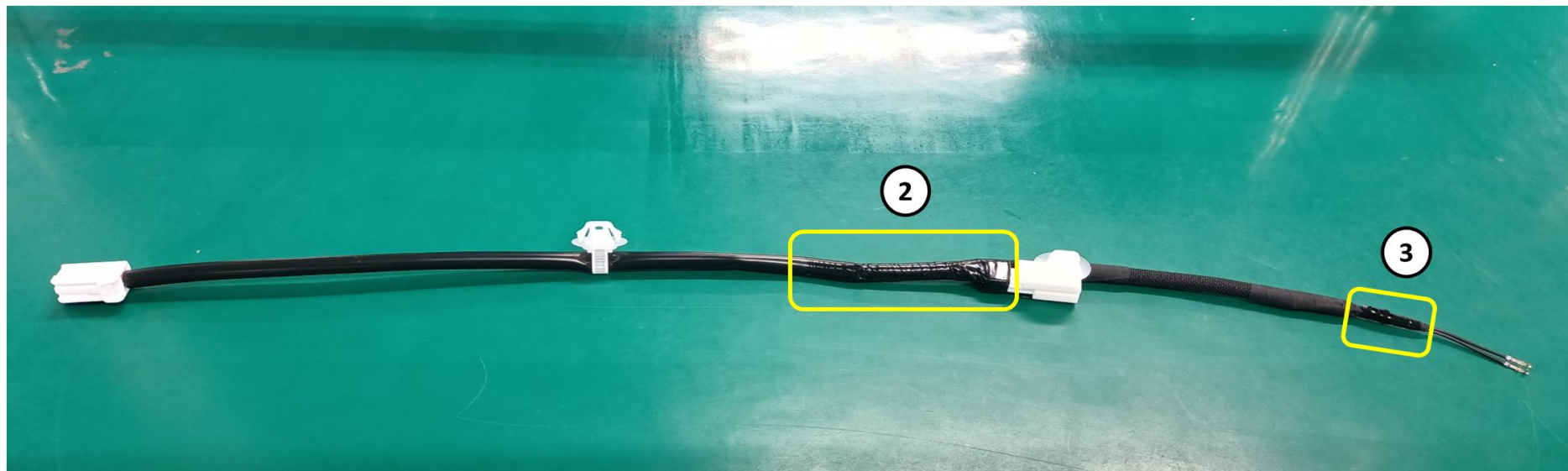
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7R0115-7021A****1****No Wrong Facing of Clamp****2****No Missing Tape (Black Tape )****3****No Missing Spot tape  
( Black Nitto Tape )**

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