



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Validity Date:

n/a

Model code/Part number:

178D / 7N0127-7021A

Customer:

TRJ

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-926

Purpose:

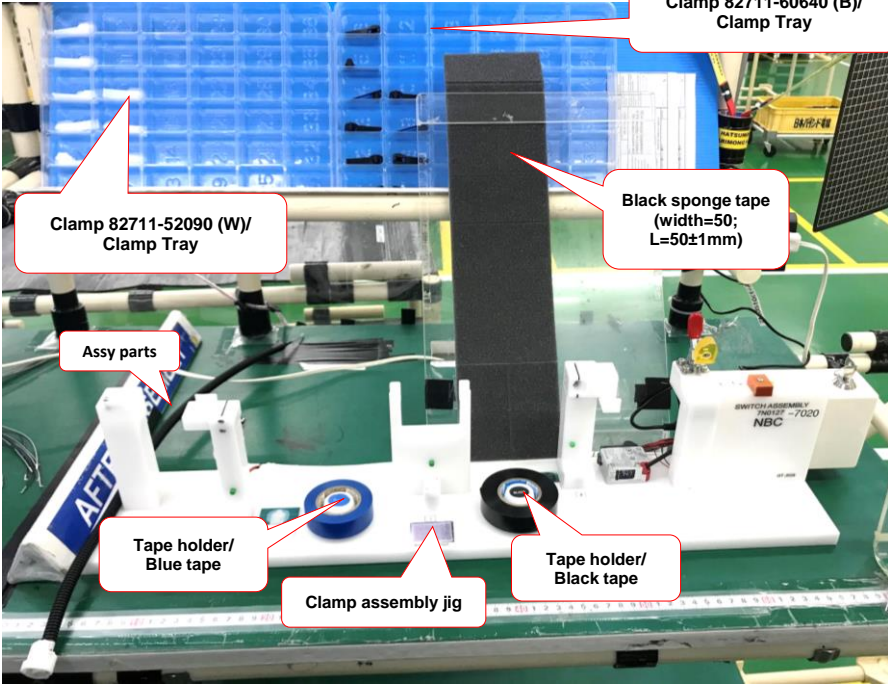

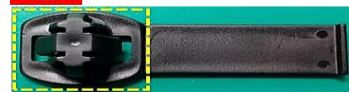


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PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-60640 (B); Black Sponge tape (width=50; L=50±1mm); Black tape; Blue tape				JIG:		1. Clamp Assembly Jig		
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	Table Lay-out	<div><div>TABLE LAY-OUT</div></div>				<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>Document reference/s:</div><div>1. Refer to WI-ENG-PDE-432 for Taping assembly process</div><div>1. No missing parts/tools 2. No excess parts/tools</div></div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-60640 (B)</div></div><div><div>NG</div><div>82711-21020 (B)</div></div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div>	
Revision History										
							Prepared by	Reviewed by	Approved by	Noted by
08/15/24	0	Initial issue. Separate Clamp setting and 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: August 15, 2024

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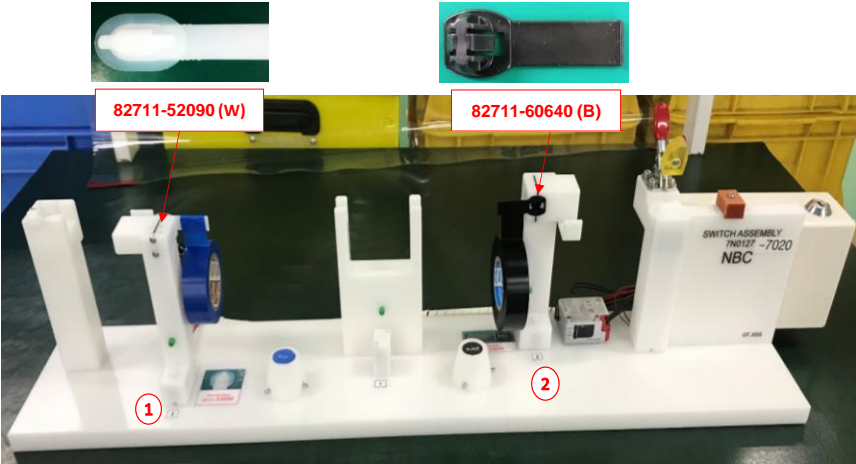


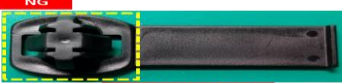


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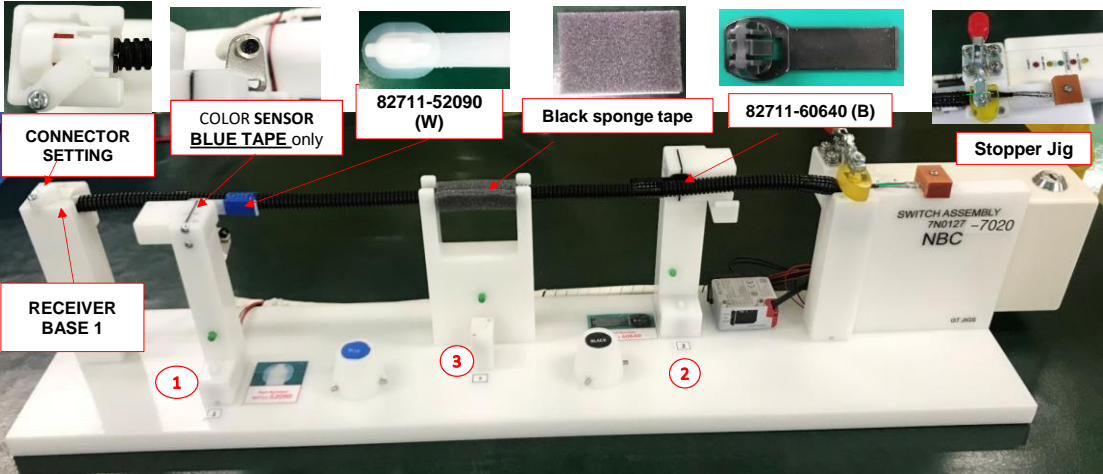
PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-60640 (B) 3. Black tape 4. Blue tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp Setting	<div></div> <div><div>1. Get 1 pc. of clamp 82711-52090 (W) then set to clamp location 1 using both hands.</div><div>2. Get 1 pc. of clamp 82711-60640 (B) then set to clamp location 2 using both hands.</div><div>3. Get the Blue tape then attach to clamp location 1 using both hands.</div><div>4. Get the Black tape then attach to clamp location 2 using both hands.</div></div>		n/a	<div>1. No loose clamp attached 2. No damage clamp 3. No wrong use of clamp 4. No damage clamp 5. No flip-out tape 6. No peel-off tape 8. No missing tape 9. No wrong use of tape 10. No wrong use of clamp</div> <div>Important reminders/Note/s: 1. Please check the clamp before start of assembly to avoid wrong use of parts.</div> <div>STANDARD TAPING FOR CLAMP One wind for clamp taping</div> <div> CLAMP ILLUSTRATION <div><div>GOOD</div></div><div><div>NG</div></div><div>CLAMP ILLUSTRATION <div><div>GOOD</div></div><div><div>NG</div></div></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.:	3 of 6

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><div><div><p>1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6189-0451 (W) to Receiver base 1. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Blue tape. Last, set the end of G-B/W wire together within the stopper then press by Toggle clamp then continue if the sequence light on clamp location 1 was ON.</p></div><div><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON. SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></div><div><p>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Continue the process on clamp location 2.</p></div><div><p>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Continue the process on attachment of sponge tape. (Proceed on next page for the instruction of sponge tape attachment.)</p></div><div><p>5. Conduct POINT CHECKING before removing the harness from jig.</p></div></div></div> <div><p>Important reminders/ Note/s:</p><p>1. Make sure no gap between terminal and stopper jig.</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No loose clamp attached</p><p>2. No damage clamp</p><p>3. No missed tape</p><p>4. No missing parts</p><p>5. No wrong use of clamp/tape</p></div>			

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☐ PRE-LAUNCH

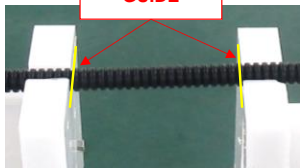
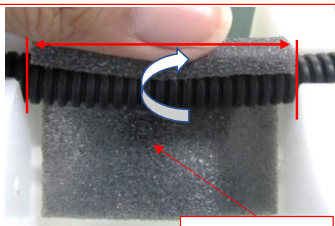
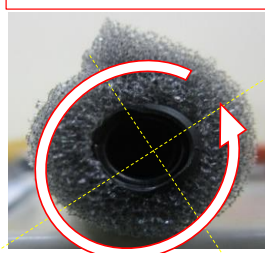





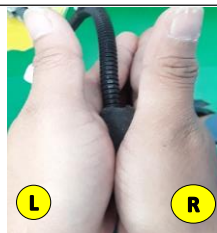
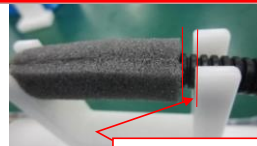
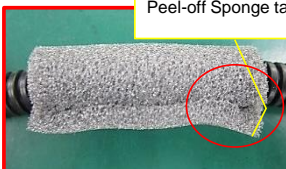
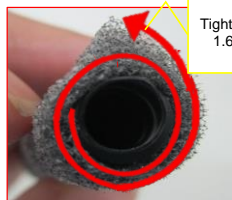
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PARTS:		1. Black sponge tape (width=50; L=50±1mm) 2. Assy Parts		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY Sponge Tape Attachment	<div><div><p>GUIDE</p></div><div><p>Size of sponge tape should fit the jig</p></div><div><p>Standard attachment</p></div><div><p>1 Get sponge tape(width=50; L=50±1mm) then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape. Note: Do not stretch or pull the sponge tape</p></div><div><div></div><div></div></div><div><p>2. Press the sponge tape using both palm and roll 3 times to make sure that the sponge tape attachment is GOOD.</p><p>L R</p></div></div> <div><p>1. No peel-off attachment 2. No loose/tight attachment 3. No wrong attachment 4.No missing sponge 5.No wrong use of sponge 6.No damage sponge</p><div><p>NO GOOD ATTACHMENT OF SPONGE TAPE</p><p>With gap on guide of jig.</p><p>Peel-off Sponge tape</p><p>Tight Attachment 1.6-1.7 Wrap</p></div></div>			

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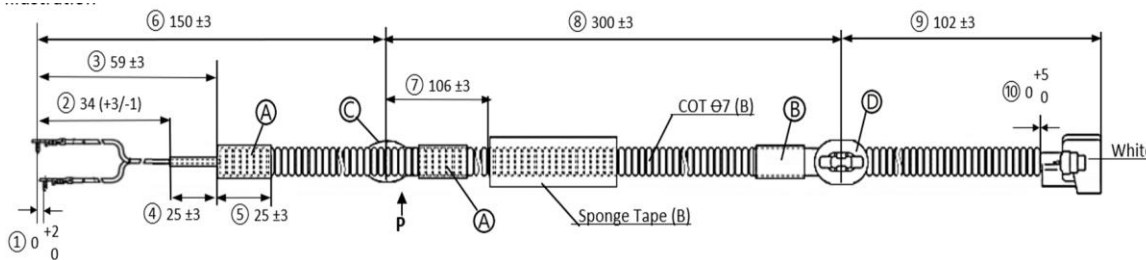
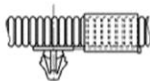
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PARTS:		1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	Measurement	<div><div>MEASURING TAPE</div></div> <div></div> <div><div>NOTE:</div><div><div>A</div> Taping (B)</div><div><div>B</div> Taping (L)</div><div><div>C</div> Clamp (B)</div><div><div>D</div> Clamp (W)</div><div>for item number ② , Dimension tolerance is different from the master drawing due to Internal change only.</div></div> <div><div>P</div></div>	<div>TOOLS/PPE</div> <div>MEASURING TAPE</div>	<div>QUALITY POINTERS</div> <div><div>Important reminders and note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div></div>

NOTE:

A Taping (B)

B Taping (L)

C Clamp (B)

D Clamp (W)

for item number ② , Dimension tolerance is different from the master drawing due to Internal change only.

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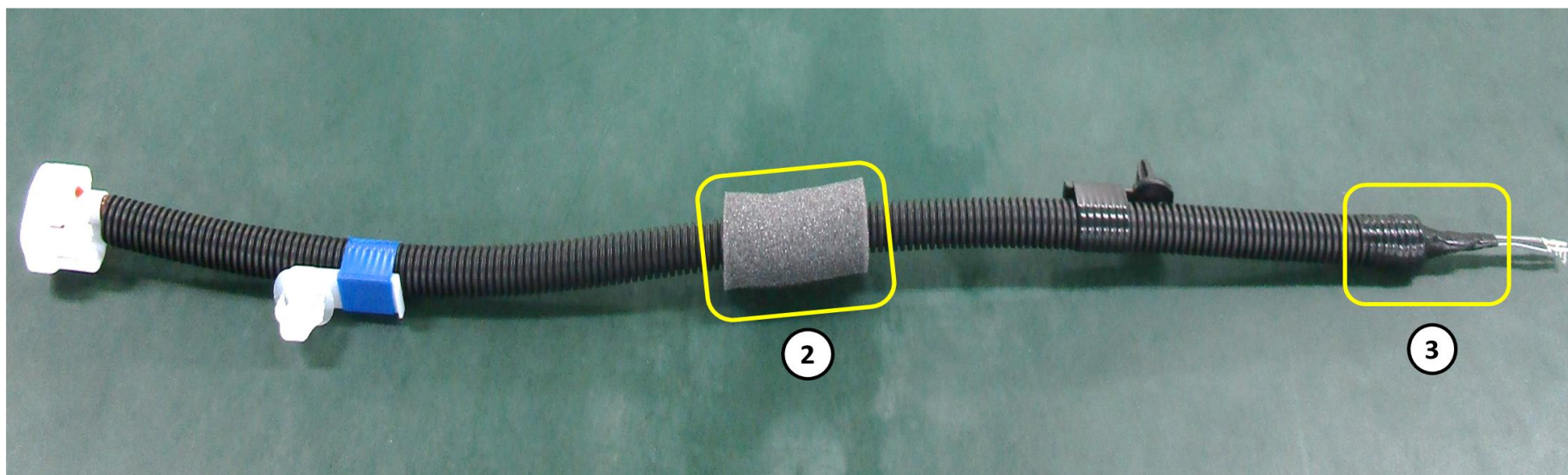
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PARTS:

1.Assty Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0127-7021A****① No Wrong Facing of Clamp****② No Missing Urethane Foam****③ No Missing Tape (Black Tape)**

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