



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

December 21, 2023

Model code/Part number:

220D / 7R0128-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-763

Purpose:

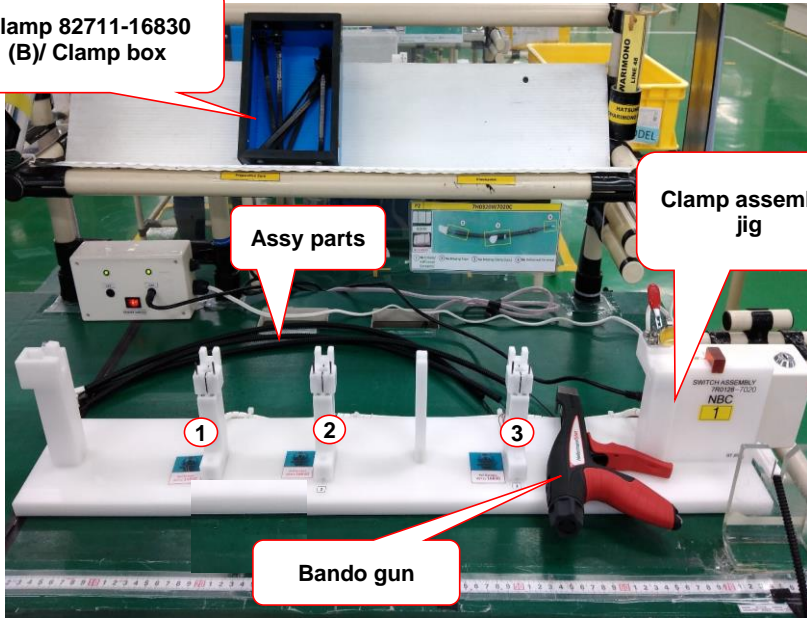

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. All parts: Assy parts: Clamp 82711-16830 (B)				JIG:		1. Clamp Assembly jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	Clamp Assy	<div>Table Lay-out</div> <div>Clamp 82711-16830 (B)/ Clamp box</div> <div>Assy parts</div> <div>Clamp assembly jig</div> <div>Bando gun</div> 				<div>Safety Instruction</div> <div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</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>Alert level</div> <div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div>BANDO GUN</div> 		<div>Document references:</div> <div>1. Refer to WI-ENG-PDE-594 for Taping Assembly Process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>					
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
12/21/2023 0 Initial issue. Transfer Clamp setting to Measurement process from Taping assembly process (WI-ENG-PDE-594) due to process improvement.						D.Castillo		C.Villanueva		A.Arañes		n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		December 20, 2023	

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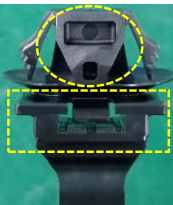

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PARTS:	1. Clamp 82711-16830 (B) [3pcs.]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div>Clamp Setting</div> <div></div> <div>1. Get 3pcs. of clamp 82711-16830 (B) using right hand and set to clamp location 1, 2 and 3 using both hands.</div>	n/a	<div><b>Important reminders/Note/s:</b></div> <div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No damaged clamp</div> <div>2. No wrong use of clamp</div> <div>3. No wrong use of tape</div> <div>4. No missing clamp</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div>82711-16830 (B)82711-34490 (B)</div></div>

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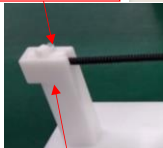




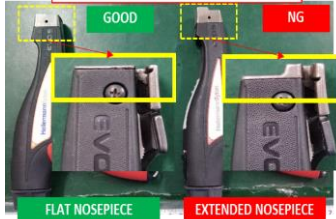

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PARTS:		1. Assy parts		JIG:	1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div>CONNECTOR SETTING</div><div></div></div> <div><div>82711-16830 (B)</div><div></div></div> <div><div>RECEIVER BASE 1</div><div></div></div> <div><div>1</div><div></div></div> <div><div>2</div><div></div></div> <div><div>3</div><div></div></div> <div><div>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector <b>6098-3802 (W)</b> to <b>Receiver base 1</b>. Continue to set the harness then last, set the <b>B-B wires</b> together within the stopper then press by <b>Toggle clamp</b>. Continue if the sequence light of <b>location ①</b> was on.</div></div> <div><div>2. Check if all <b>LED light</b> for <b>POWER ON</b>, and <b>CLAMP ON</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 and continue the process.</div></div> <div><div>3. Initially tighten the band clamp on location <b>1, 2 and 3</b> using both hands.</div></div> <div><div>4. Get the bando gun using right hand then cut the band clamp on location <b>1</b> using both hands. Press the <b>SW button</b> after cut. Continue the process if sequence light on clamp location <b>2</b> was <b>ON</b>.</div></div> <div><div>5. Cut the band clamp on location <b>2</b> using both hands. Press the <b>SW button</b> after cut. Continue the process if sequence light on clamp location <b>3</b> was <b>ON</b>.</div></div> <div><div>6. Cut the band clamp on location <b>3</b> using both hands. Press the <b>SW button</b> after cut. <b>Go</b> sound will be heard.</div></div> <div><div>7. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div></div>			<div><div>BANDO GUN</div><div></div></div> <div><div>FLAT NOSEPIECE</div><div></div></div>	<div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between stopper and terminals.</div></div> <div><div>1. No loose attachment of clamp</div><div>2. No damaged clamp</div><div>3. No missing parts</div></div> <div><div>BANDO GUN ILLUSTRATION</div><div></div></div>

BANDO GUN POSITION ON CLAMP LOCATION 2



GOOD



NG



PERPENDICULARITY



NG



OK



NG



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For: ø5 - 1~2, ø7 - 3~4

Fixed setting of band clamp cutter: 1~ 2



BANDO GUN



FLAT NOSEPIECE



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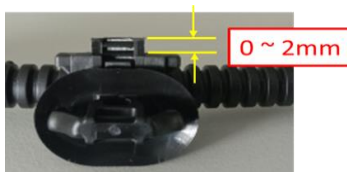

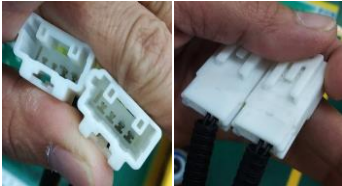

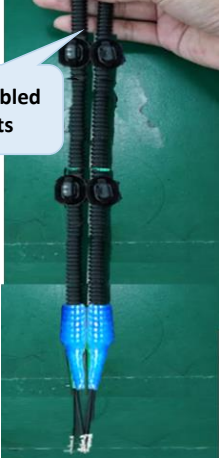

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PARTS:		1. Assembled parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Visual/By Two's Inspection	<div><p>ACTUAL PRODUCT</p></div>		<div><p>MASTER SAMPLE</p></div> <div><p>1. No skip process</p><p>0 ~ 2mm</p></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p></div>
			<div><div><p>Master sample</p></div><div><p>2. Check the <b>terminal, connector lock</b> condition and <b>insertion</b>.</p></div><div><p>3. Check the <b>presence of clamp attachment</b>.</p></div><div><p>Assembled parts</p></div><div><p>1. Conduct alignment of harness (<b>Master sample vs. assembled parts</b>) using both hands.</p></div><div><p>4. Check the <b>taping condition</b> and <b>terminal appearance</b>. Must be <b>no deformed terminal</b>.</p></div></div>		

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**PARTS:**

Assy parts

JIG:

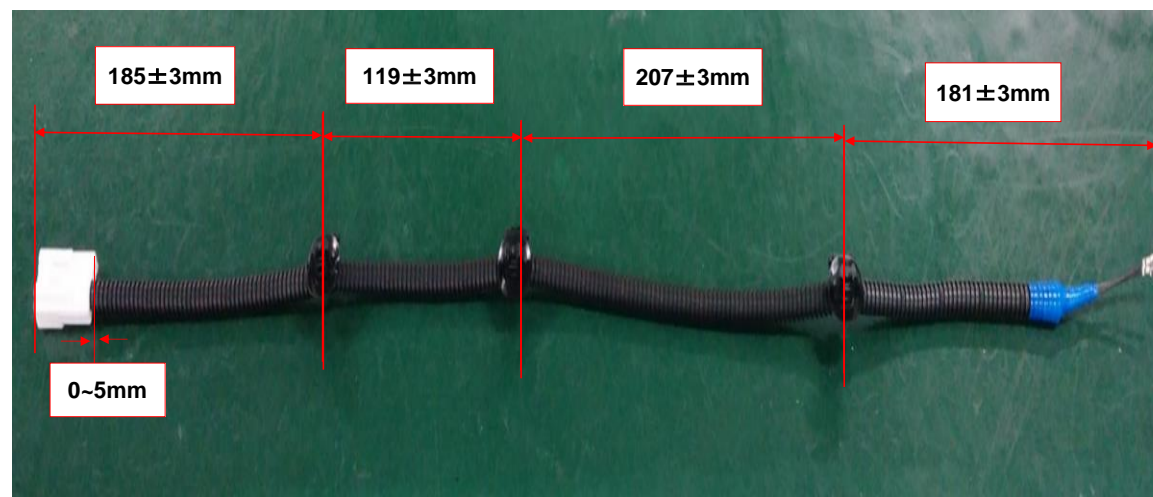
n/a

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

5

Clamp  
Assy

Measurement

**MEASURING TAPE****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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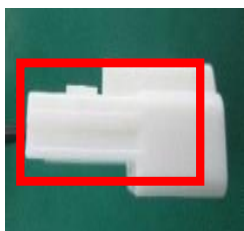
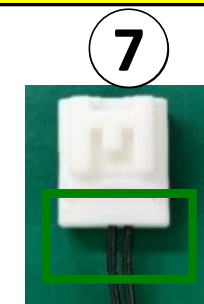
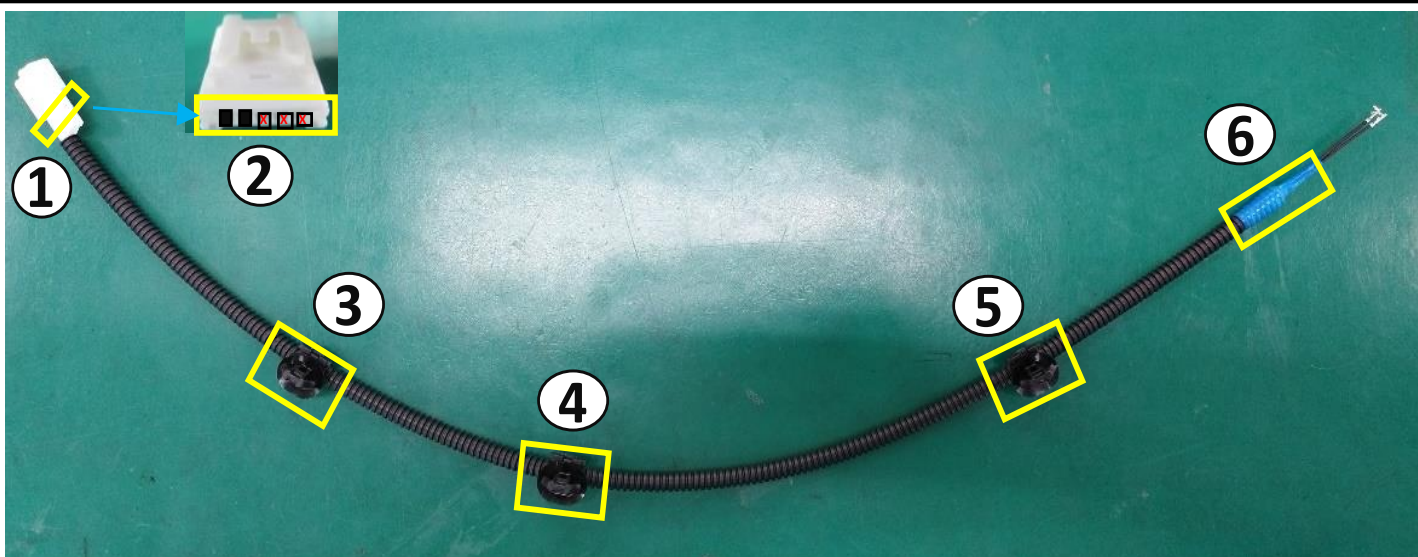
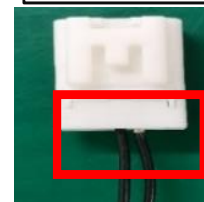
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**PARTS:**

Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7R0128-7021****GOOD****NO GOOD****GOOD****NO GOOD**

- ① No Unlock/Halflocked Connector ③ ④ ⑤ No Missing Clamp  
② No Wrong Insert ⑥ No Missing/Wrong Color of tape ⑦ No Terminal Backing Out

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