



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

December 03, 2024

Model code/Part number:

410D/412D / 7N0235-7020A

Customer: TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1122

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-33650 (B); Clamp 82711-52090 (W); Clamp 82711-3A540 (W); Black tape; Gray tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

CLAMP
ASSY

Table Lay-out

TABLE LAY-OUT

Clamp tray/
Clamp 82711-52090 (W)Clamp tray/
Clamp 82711-3A540 (W)Clamp tray/
Clamp 82711-33650 (B)

Assy parts

Clamp tray/
Clamp
82711-48210 (B)

Locking jig

Black tape/ Tape holder

Gray tape/ Tape holder

Clamp assembly jig

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 references:

1. Refer to WI-ENG-PDE-1121A-C for Taping assembly process

1. No missing parts/tools
2. No excess parts/tools
3. No wrong positions of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/03/24	1	Change from Pre-launch to Masspro.	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/22/24	0	Initial issue.	D.Castillo	C.Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 22, 2024		

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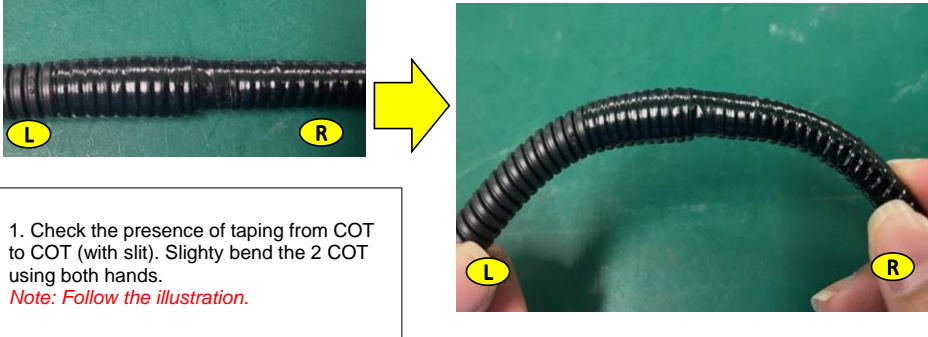
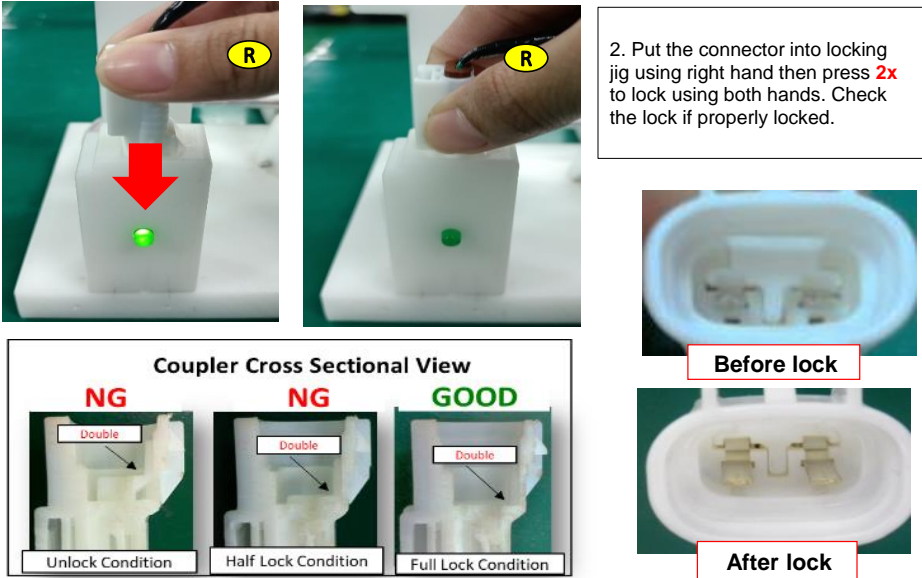

PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B) 3. Clamp 82711-52090 (W)		4. Clamp 82711-3A540 (W) 5. Black tape [4pcs] 6. Gray tape		JIG:	1. Clamp assembly jig				
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS			
2		CLAMP ASSY		Clamp setting		<div><div><p>82711-52090 (W)</p></div><div><p>82711-3A540 (W)</p></div><div><p>82711-48210 (B)</p></div><div><p>82711-33650 (B)</p></div><div></div></div>		<div><div><p>1. Get 1pc of clamp 82711-52090 (W) using right hand then set to Clamp location 1 using both hands.</p></div><div><p>2. Get 1pc of clamp 82711-3A540 (W) using right hand then set to Clamp location 1 using both hands.</p></div><div><p>3. Get 1pc of clamp 82711-48210 (B) using right hand then set to Clamp location 3 and 4 using both hands.</p></div></div> <div><div><p>4. Get 1pc of clamp 82711-33650 (B) using right hand then set to Clamp location 5 using both hands.</p></div><div><p>5. Initially attach GRAY TAPE to location 4 using both hands.</p></div><div><p>6. Initially attach BLACK TAPE to location 1, 2, 3 and 5 using both hands.</p></div></div>		<div><p>Important reminders/Note/s:</p><p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p><div><p>One wind for under tape</p></div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><div><div><p>CLAMP ILLUSTRATION</p><div><div><p>GOOD</p><p>82711-52090 (W)</p></div><div><p>NG</p><p>82711-12A80 (W)</p></div></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.:	1	Page No.:	3 of 7


PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	<div></div> <div></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process 4. No missing tape</p>

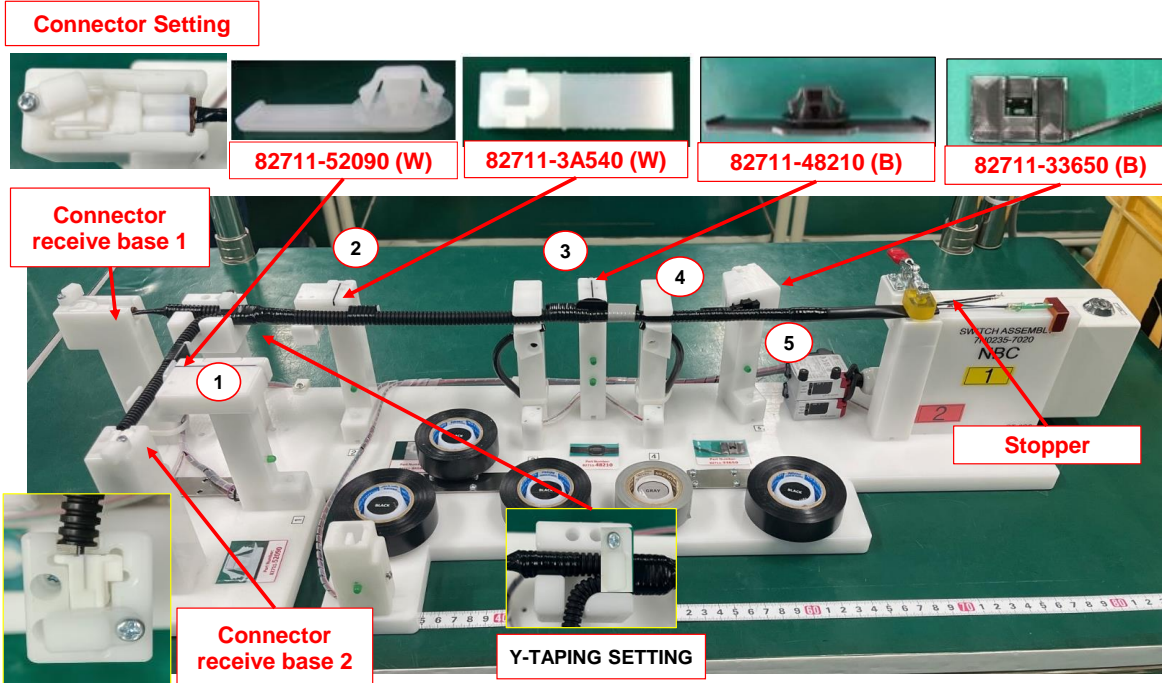
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PARTS:	1. Assy part		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	CLAMP ASSY	<div>Clamp assembly</div> <div></div> <div><p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6189-0407 (W) to Receiver base 1 then lock. Second, set the connector 6098-3810 (W) to Receiver base 2 . Third, set the Y-taping guide then lock and continue to set the harness in jig. Last, set the hotmelted and B wires together within stopper then press by toggle clamp. Continue if the sequence light of location 1 was on.</p><p>2. Checked if all LED light for POWER ON and CLAMP ON was ON. IF encountered problem, STOP and immediately CALL the attention of leader. WAIT for further instruction nad continue the process.</p><p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Press the SW button. Continue if the sequence light of location 2 was on.</p></div>			



Important reminders/Note/s:
1. Make sure no gap between stopper and terminals
2. Make 2-3 windings for clamp taping.


1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape

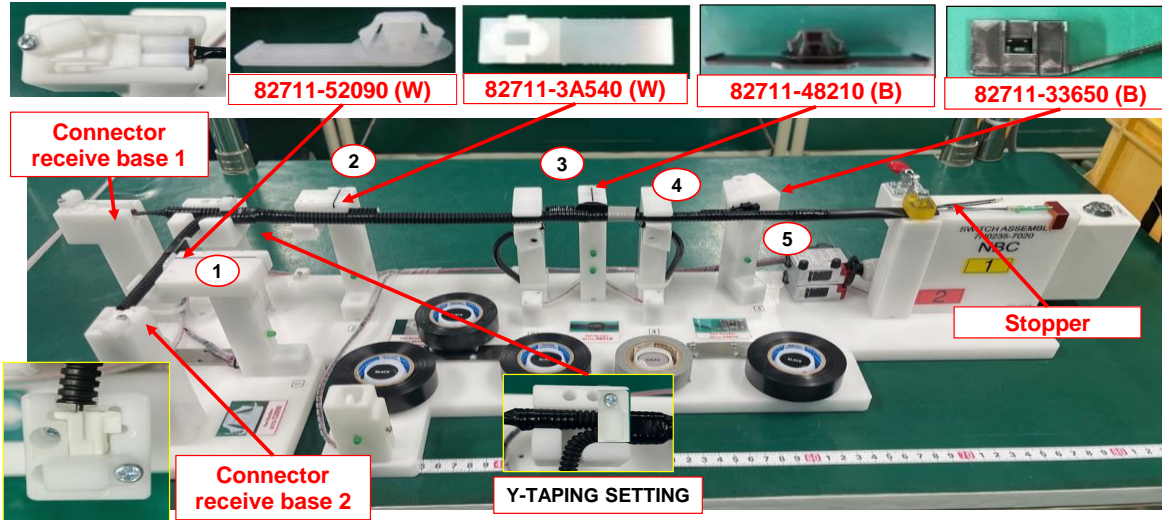

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	CLAMP ASSY Clamp assembly (Continuation)	<div><div>Connector Setting</div><div><div>Connector receive base 1</div><div>82711-52090 (W)</div><div>82711-3A540 (W)</div><div>82711-48210 (B)</div><div>82711-33650 (B)</div><div>Connector receive base 2</div><div>Y-TAPING SETTING</div><div>Stopper</div></div><div><div>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Continue if the sequence light of location 3 was on.</div><div>5. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Continue if the sequence light of location 4 was on.</div><div>6. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Continue if the sequence light of location 5 was on.</div><div>7. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the SW button. Go sound will be heard.</div><div>8. Conduct POINT CHECKING before removing the harness from jig.</div><div>9. After point checking, remove the harness from toggle clamp up to clamp up to Connector receiver base 1, Connector receiver base 2 then Y-taping.</div></div></div> <div><div><div>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals 2. Make 2-3 windings for clamp taping.</div></div><div>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</div></div>			

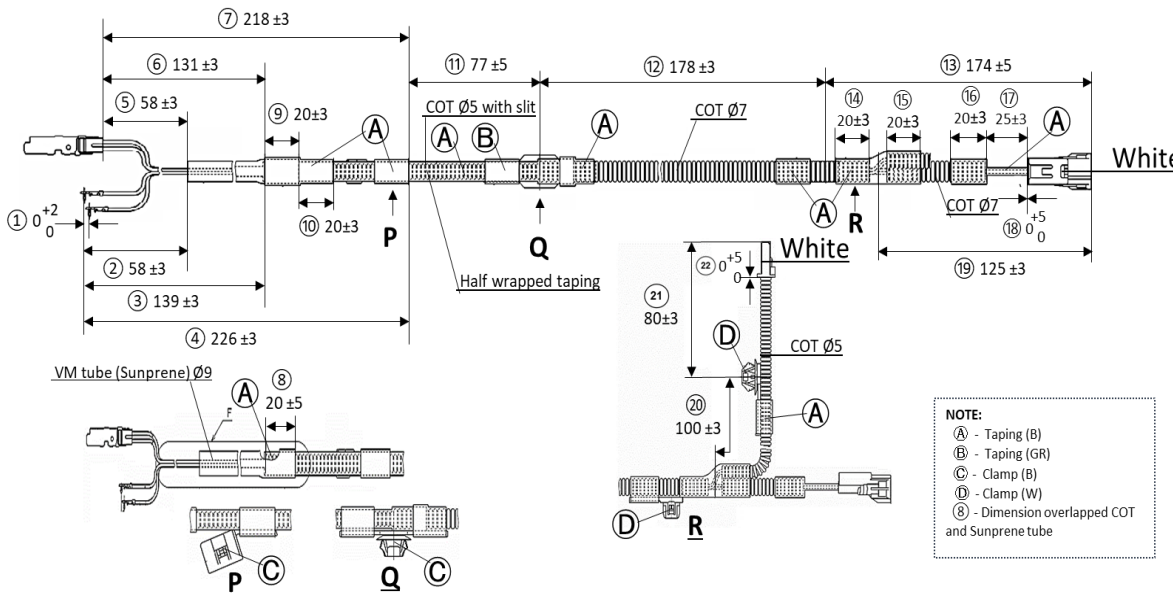

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	<div>Measurement</div> <div></div>		<div>MEASURING TAPE</div> 	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono 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>1. No wrong dimension</div>

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

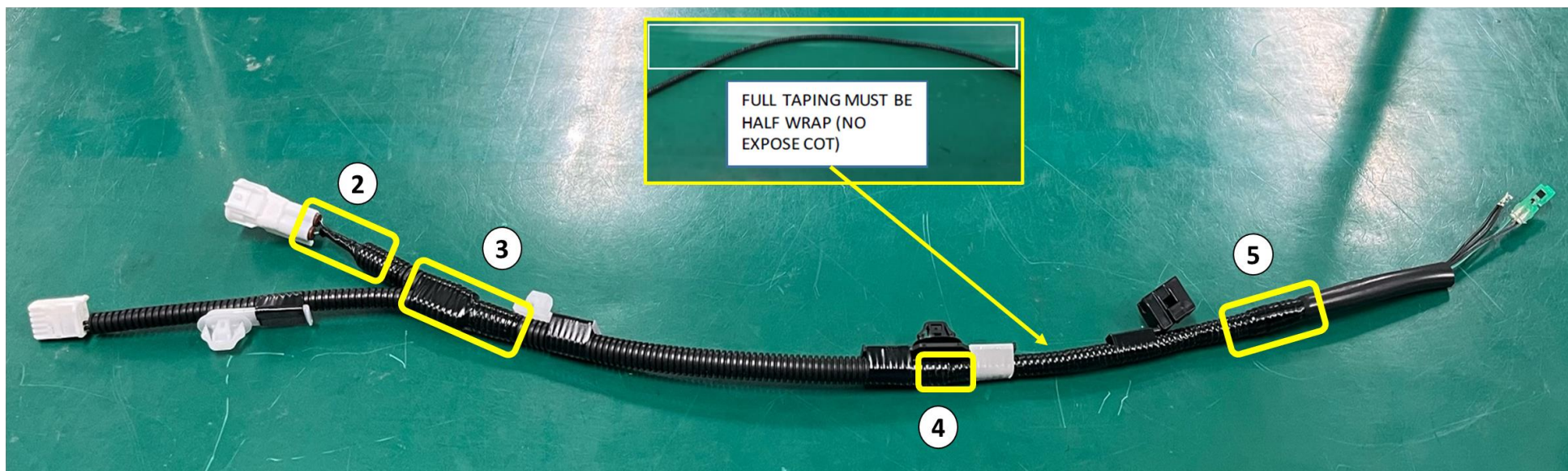
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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0235-7020A****1 No Wrong facing of clamp****2 3 4 5 No Missing Tape (Black tape)**

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