



## WORK INSTRUCTION

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Process Name/Title:

Model code/Part number:

177D / 7L0129-7020A

Customer: TRQSS

Car Model: TOYOTA COROLLA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

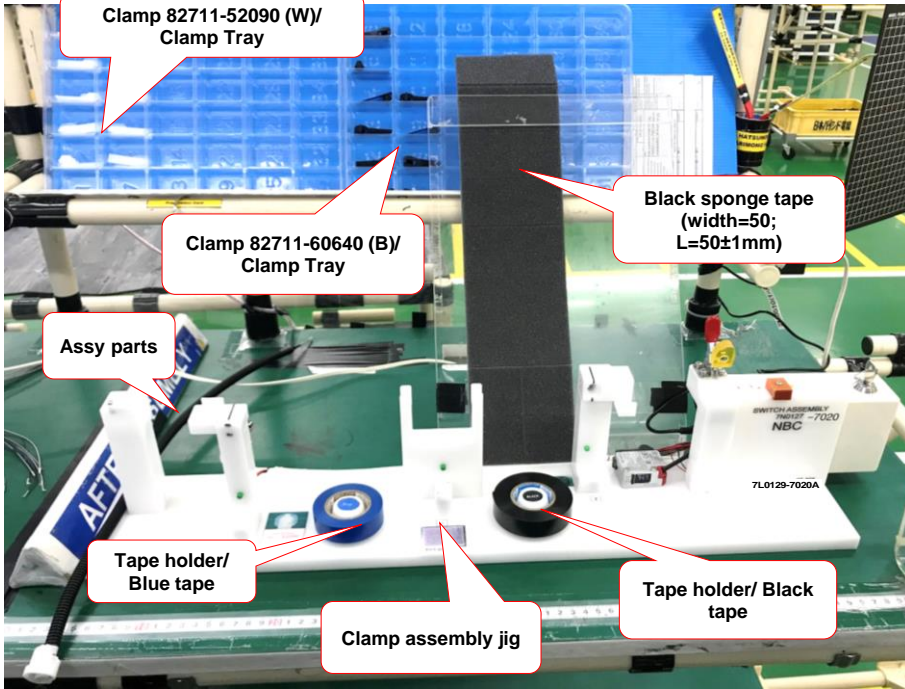
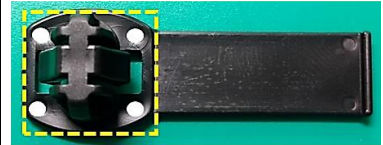
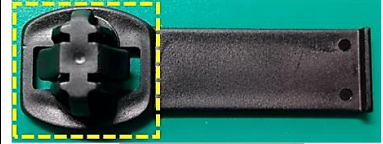


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PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-60640 (B); Black sponge tape 7M0531-0021 (width=50; L=50±1mm); Black tape; Blue tape				JIG:		1. Clamp Assembly Jig									
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS							
1		Clamp Assy		<div>TABLE LAY-OUT</div> 				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>1. No missing parts/tools 2. No excess parts/tools</div> <div>CLAMP ILLUSTRATION</div> <div><b>GOOD</b>  82711-60640 (B)</div> <div><b>NG</b>  82711-21020 (B)</div> <div>CLAMP ILLUSTRATION</div> <div><b>GOOD</b>  82711-52090 (W)</div> <div><b>NG</b>  82711-12A80 (W)</div>							
Revision History										Prepared by		Reviewed by		Approved by		Noted by	
08/15/24 0 Initial issue. Separate clamp assy to 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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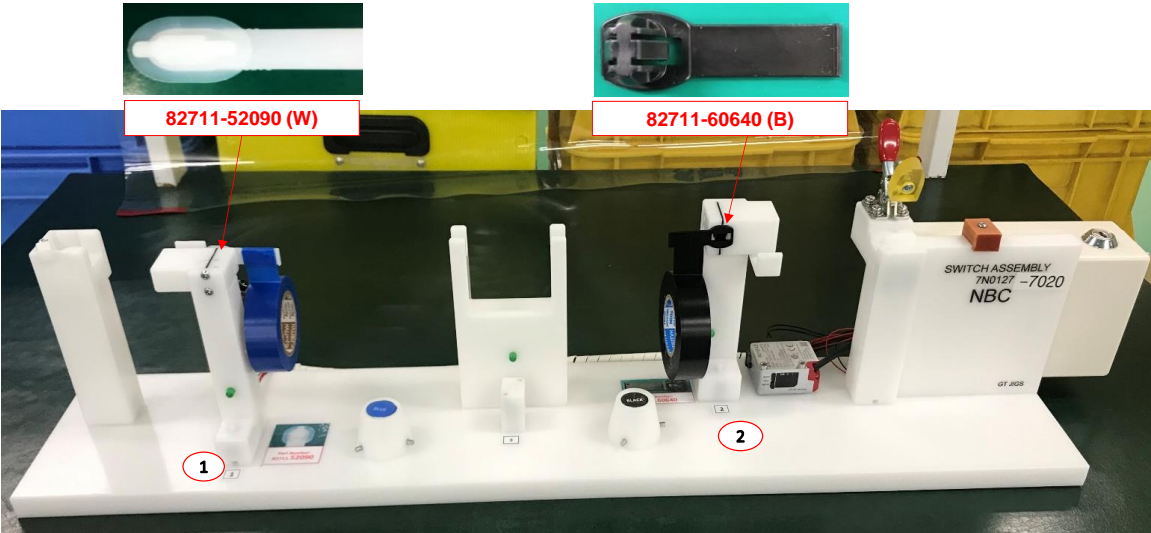
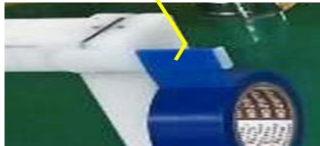




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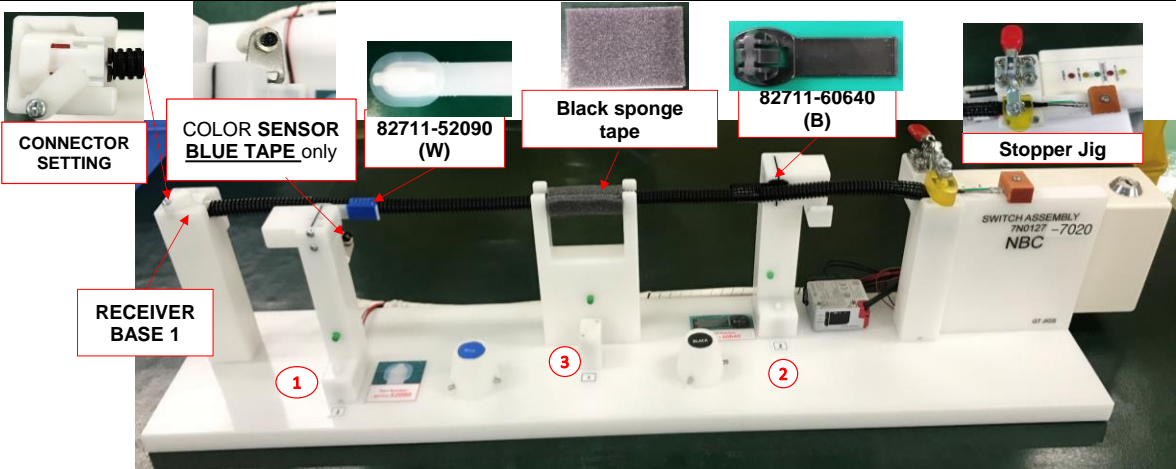
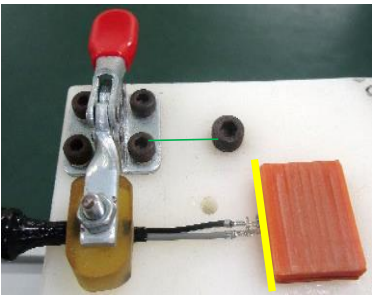
PARTS:	1. Clamp 82711-52090 (W) 2. Clamp 82711-60640 (B)	3. Black tape 4. Blue tape	JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting   <div>1. Get 1 pc. of clamp <b>82711-52090 (W)</b> then set to clamp location <b>1</b> using both hands.</div> <div>2. Get 1 pc. of clamp <b>82711-60640 (B)</b> then set to clamp location <b>2</b> using both hands.</div> <div>3. Get the <b>Blue tape</b> then attach to clamp location <b>1</b> using both hands.</div> <div>4. Get the <b>Black tape</b> then attach to clamp location <b>2</b> using both hands.</div>	SWITCH ASSEMBLY 7N0127 - 7020 NBC GT JGS	<div>1. No loose clamp attached</div> <div>2. No damage clamp</div> <div>3. No wrong use of clamp</div> <div>4. No damage clamp</div> <div>5. No flip-out tape</div> <div>6. No peel-off tape</div> <div>8. No missing tape</div> <div>9. No wrong use of tape</div> <div>10. No wrong use of clamp</div> <div><b>Important reminders/Note/s:</b> 1. Please check the clamp before start of assembly to avoid wrong use of parts.</div> <div><b>STANDARD TAPING FOR CLAMP</b> <div>One wind for under tape</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>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-60640 (B)</div></div><div><div>NG</div><div>82711-21020 (B)</div></div></div>

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>August 15, 2024</b>		
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	Model code/Part number: <b>177D / 7L0129-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA COROLLA</b>	Document No.: <b>WI-ENG-PDE-1005</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 6

<b>PARTS:</b>	1. Assy parts 2. Black Sponge tape (7M0531-0021) t=5; width=50; L=50±1mm			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>
3	Clamp Assy	<div></div> <div>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.</div> <div>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.</div> <div>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.</div> <div>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.)</div> <div>5. Conduct POINT CHECKING before removing the harness from jig.</div>			<div></div> <div><b>Important reminders/Note/s:</b> 1. Make sure no gap between terminal and stopper jig. 2. Make 2-3 windings for clamp taping.</div> <div>1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape</div>

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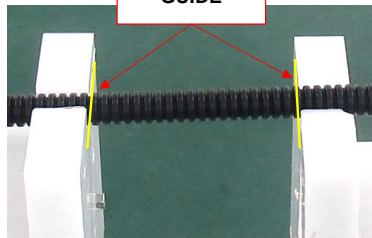
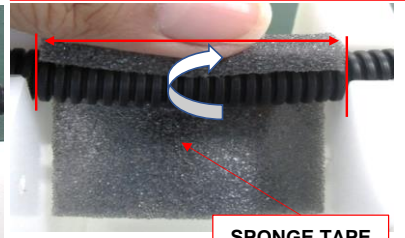
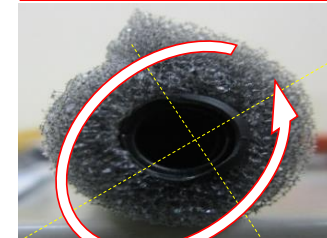
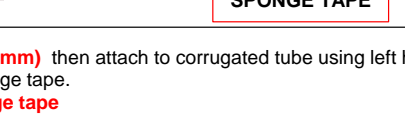






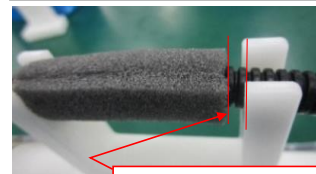
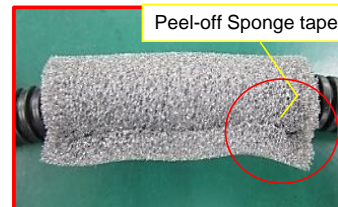
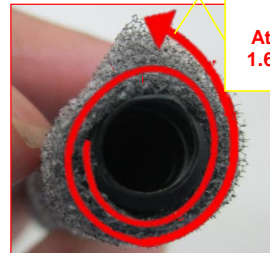
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PARTS:		1. Black Sponge tape (7M0531-0021) t=5; width=50; L=50±1mm)		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Sponge Tape Attachment	<div><div>GUIDE</div></div> <div><div>Size of sponge tape should fit the jig</div></div> <div><div>Standard attachment</div></div> <div><div>SPONGE TAPE</div></div> <div><p>1 Get <b>sponge tape( width=50; L=50±1mm)</b> then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape. <b>Note: Do not stretch or pull the sponge tape</b></p></div> <div><div><div>1</div></div><div><div>2</div></div><div><div>3</div></div><div><div>4</div></div><div><div>5</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 <b>GOOD</b>.</p></div> <div></div>		<div>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</div> <div><b>NO GOOD ATTACHMENT OF SPONGE TAPE</b></div> <div><div>With gap on guide of jig.</div></div> <div><div><b>Peel-off Sponge tape</b></div></div> <div><div><b>Tight Attachment 1.6-1.7 Wrap</b></div></div>

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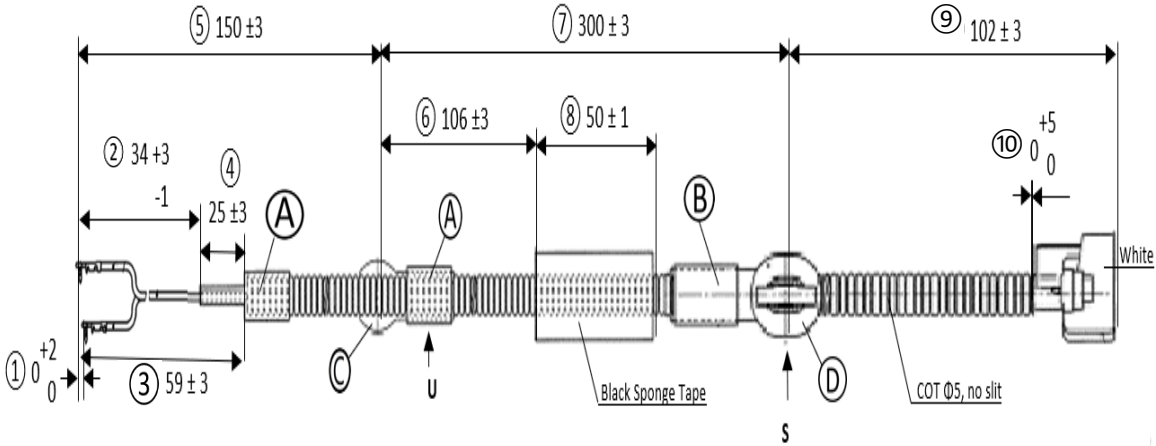
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PARTS:	1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (L) Ⓒ - Clamp (B) Ⓓ - Clamp (W)</div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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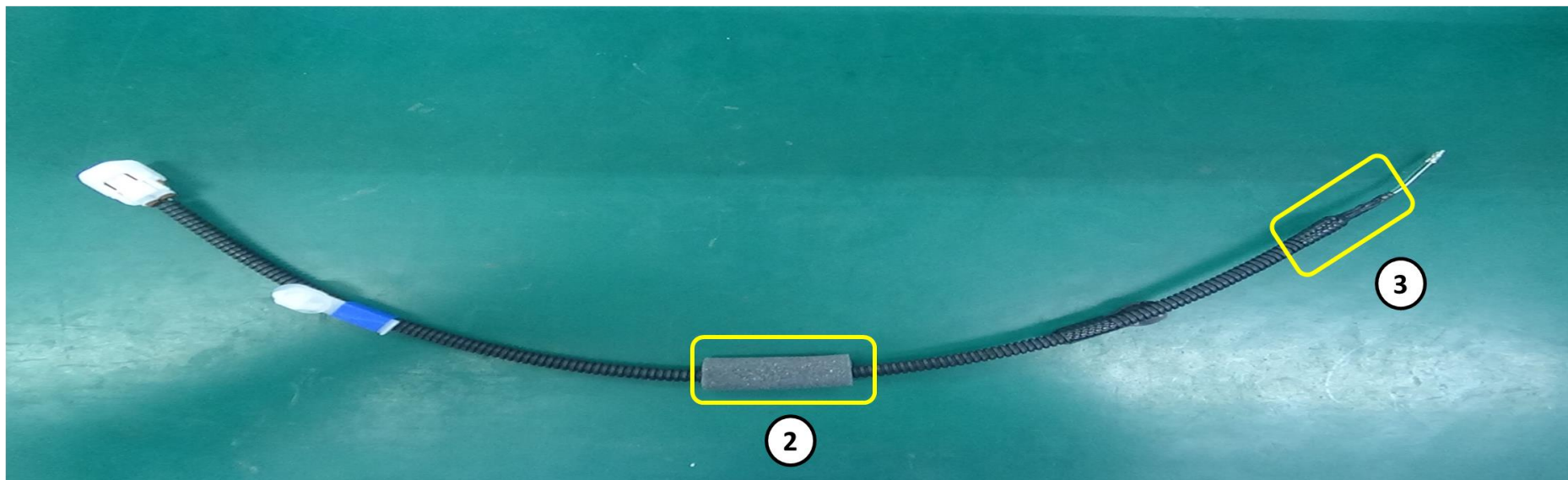
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0129-7020A****① No Wrong Facing of Clamp****② No Missing Urethane Foam****③ No Missing Tape ( Black Tape )**

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