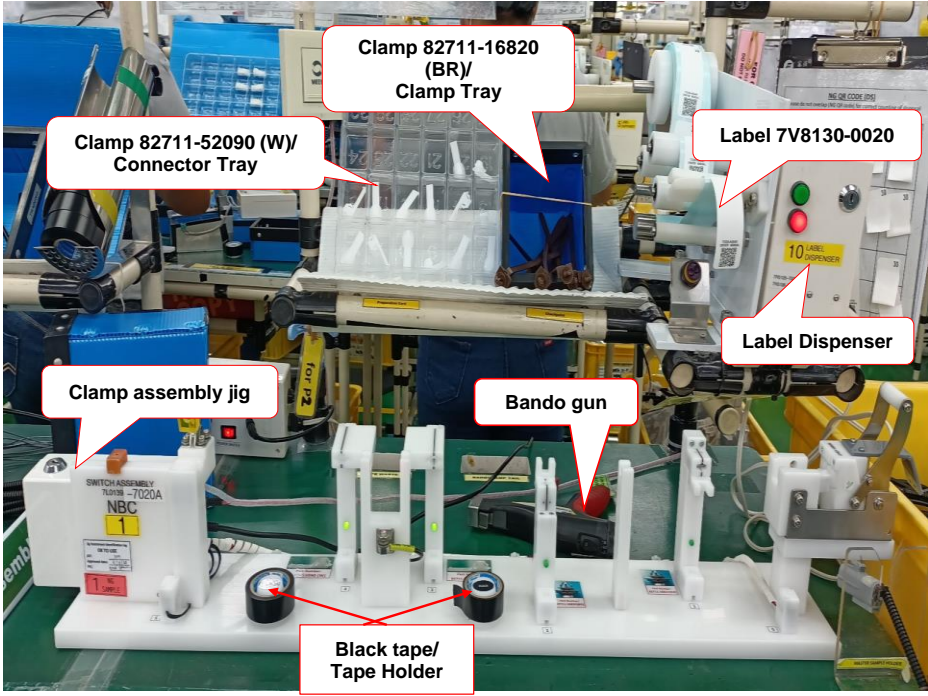
	WORK INSTRUCTION				Effectivity Date:	September 25, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 380D / 7L0139-7020A		Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-969		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 7

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-16820 (B); Label 7V8130-0020; Black tape				JIG:		1. Clamp assembly jig 2. Label Dispenser	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div> <div>TABLE LAY-OUT</div>  </div>				<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-ENG-PDE-649 for Taping assembly process	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/25/24	0	Initial issue. Separate clamp assy 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:	September 25,2024		

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PARTS:

1. Clamp 82711-16820 (BR) [2pcs.]
2. Clamp 82711-52090 (W) [2pcs.]

3. Black tape [2pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

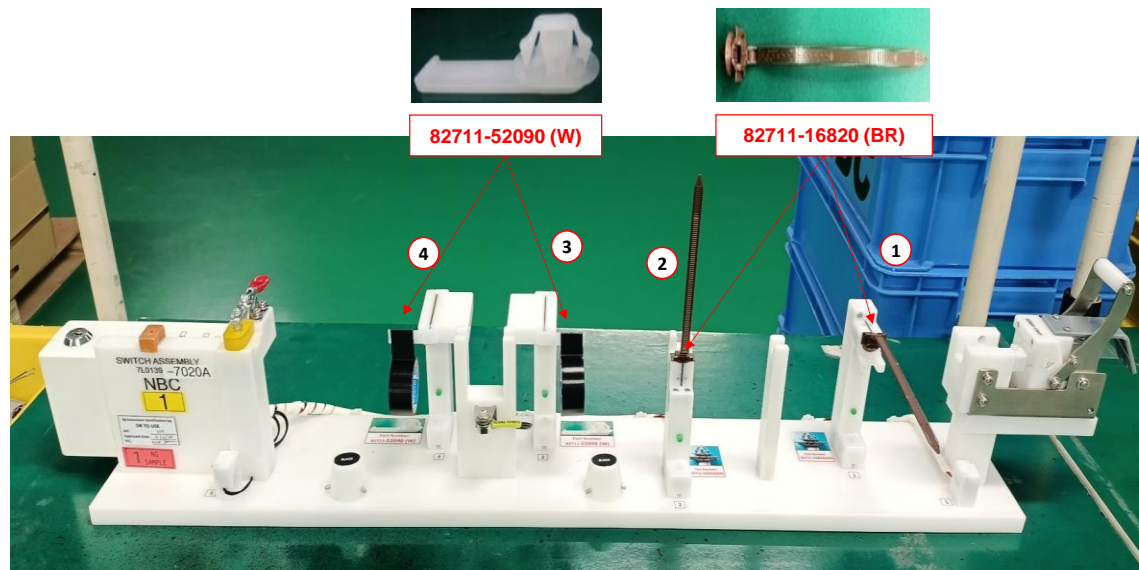
TOOLS/PPE

QUALITY POINTERS

2

Clamp Assy

Clamp setting



1. Get 2pcs. of clamp **82711-52090 (W)** using both hands then set to clamp location **3 and 4** using both hands.

2. Get 2pcs. of clamp **82711-16820 (BR)** using both hands then set to clamp location **1 and 2** using both hands.

3. Initially attach **Black tape** on clamp location **3 and 4** using both hands.

1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

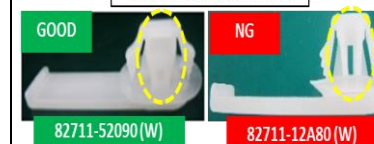
STANDARD TAPING FOR CLAMP

One wind for under tape

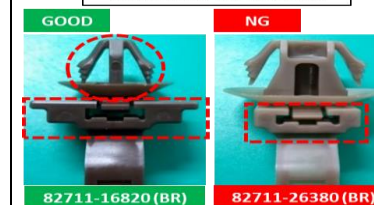


Important reminders/Note/s:
1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

CLAMP ILLUSTRATION



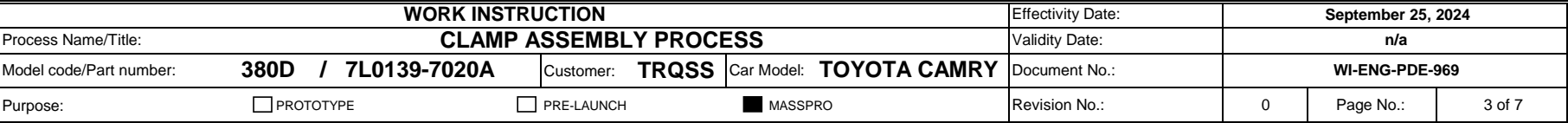
BAND CLAMP ILLUSTRATION



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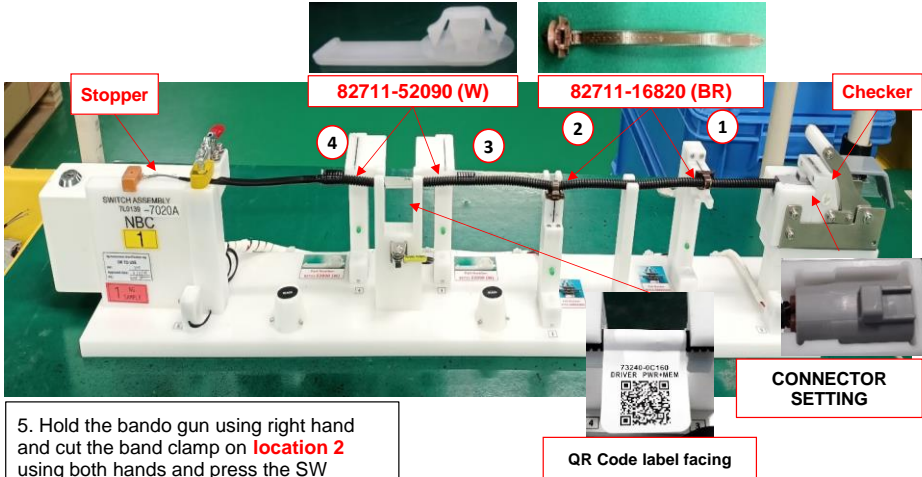


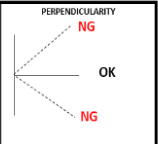

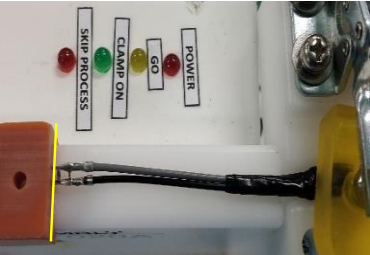
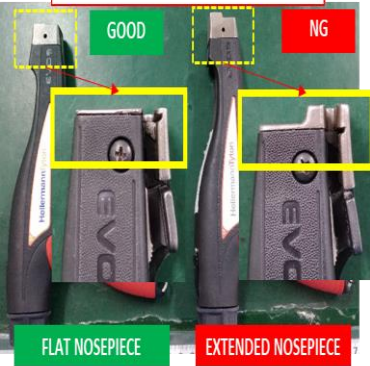
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 7

PARTS:	1. Clamp 82711-52090 (W) 2. Clamp 82711-16820 (BR)			JIG:	1. Clamp assembly jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	Clamp Assy	<div><div></div><div>5. Hold the bando gun using right hand and cut the band clamp on location 2 using both hands and press the SW button. Continue if sequence light in location 3 was ON.</div><div><div>GOOD</div><div>NG</div></div><div><div>PERPENDICULARITY NG OK NG</div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</div></div></div> <div><div>6. Hold the tape on clamp location 3 then start taping using both hands. Make 3 windings of tape then cut the tape and press the SW button. Continue if sequence light in location 4 was ON.</div><div>7. Hold the tape on clamp location 4 then start taping using both hands. Make 3 windings of tape then cut the tape and press the SW button. Continue if sequence light in location 5 was ON.</div><div>8. For label attachment, get the QR code label then attach using both hands. Press both SW button after attachment. Go sound will be heard. (Refer to the next page for label attachment).</div><div>9. Conduct POINT CHECKING before removing the harness from jig.</div></div>			<div>Bando Gun</div>	<div>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals. 2. Make 2-3 windings for clamp taping 1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</div> <div>BANDO GUN ILLUSTRATION GOOD NG FLAT NOSEPIECE EXTENDED NOSEPIECE</div>		

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380D / 7L0139-7020ACustomer: **TRQSS**Car Model: **TOYOTA CAMRY**

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PARTS:

1. Assy parts
2. Label 7V8130-0020

JIG:

1. Clamp assembly jig
2. Label dispenser

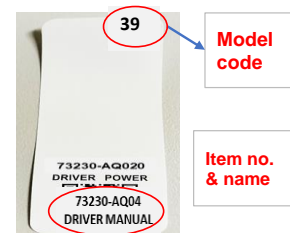
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

Clamp Assy

Label attachment

SWITCH ASSY P/N	SWITCH ASSY PART NUMBER REFERENCE	PART NO.	TOYOTA PART NO.	SEAT POSITION	SEAT TYPE
7L0141-702	41	7V8120-0020	73230-AQ020	DRIVER	POWER
7L0140-702	40	7V8110-0020	73230-AQ010	DRIVER	PWR + MEM
7L0139-702	39	7V8130-0020	73230-AQ040	DRIVER	MANUAL



1. Get the label.
Note: Check the model code, item no. & name

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label



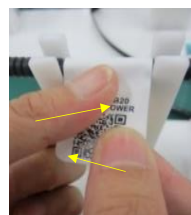
2. Align the end part of label in the jig.



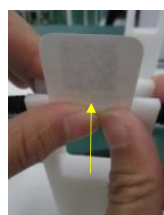
3. Fold the center part of the label



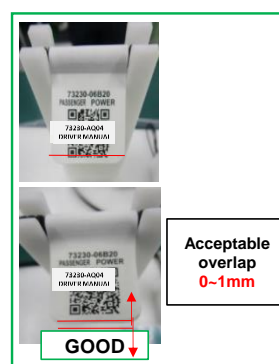
4. Align both end part of label .



5. After alignment , Press the label with both fingers .



6. Press the label upside down using finger.



Acceptable overlap 0~1mm



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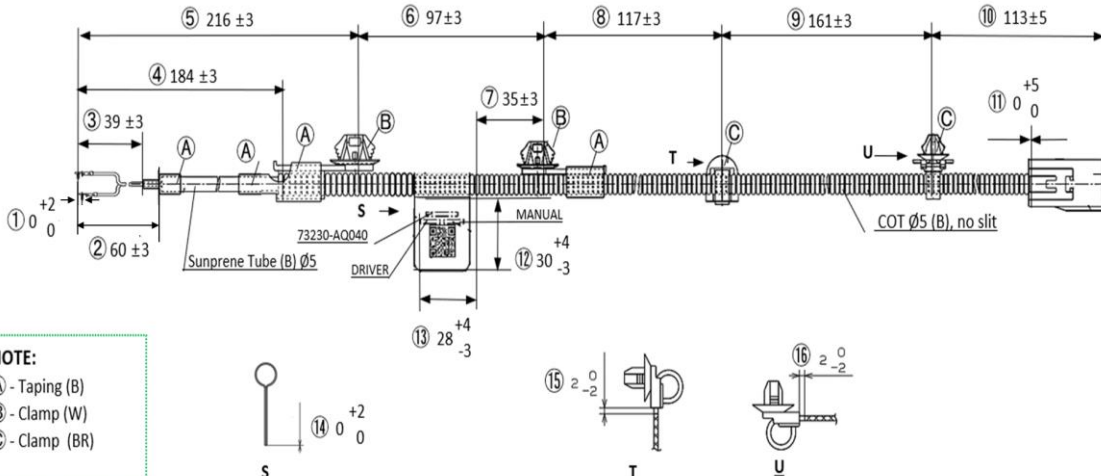
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: A - Taping (B) B - Clamp (W) C - Clamp (BR)</div>	<p>Important reminders and note/s: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

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0139-7020A**

①

No Wrong Facing of Clamp

②

③

No Missing Tape (Black Tape)

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