



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 09, 2024

Model code/Part number:

220D / 7L0135-7021

Customer:

TRQSS

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-1024

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape (5pcs.)				JIG:		1. Clamp Assembly Jig																																																			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS																																																	
1		CLAMP ASSY		<div><div>Table Lay-out</div><div>Black Tape/ Tape Holder</div></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></div>		<div><div>Document reference/s: 1. Refer to WI-ENG-PDE-661A-B for Offline assembly process</div><div>1. No missing parts/tools 2. No excess parts/tools</div></div>																																																	
Revision History																																																											
<table><tr><td colspan="4"></td><td colspan="2">Prepared by</td><td colspan="2">Reviewed by</td><td colspan="2">Approved by</td><td colspan="2">Noted by</td></tr><tr><td colspan="4"></td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="4">10/09/24</td><td colspan="2">0</td><td colspan="2">Initial issue. Separate clamp assy from Taping assembly process.</td><td colspan="2">D.Castillo</td><td colspan="2">C. Villanueva</td></tr><tr><td colspan="4">Eff. Date</td><td colspan="2">Rev. No</td><td colspan="2">Details of Change</td><td colspan="2">Revised</td><td colspan="2">Reviewed</td></tr></table>																Prepared by		Reviewed by		Approved by		Noted by														10/09/24				0		Initial issue. Separate clamp assy from Taping assembly process.		D.Castillo		C. Villanueva		Eff. Date				Rev. No		Details of Change		Revised		Reviewed	
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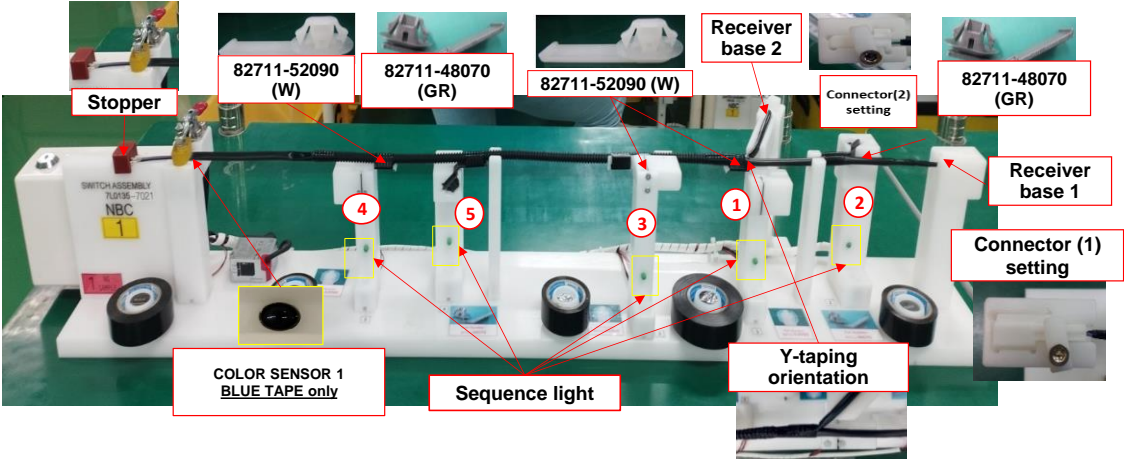

PARTS:		1. Clamp 82711-52090 (W) [3pcs.] 2. Clamp 82711-48070 (GR) [2pcs.]		3. Black Tape [5pcs.]	JIG:	1. Clamp Assembly Jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp Setting	<div><div> 82711-52090 (W)</div><div> 82711-48070 (GR)</div><div></div><div>1. Get the clamp 82711-52090 (W) using right hand and put to location 5, 3 and 1 using both hands.</div><div>2. Get the clamp 82711-48070 (GR) using right hand and put to location 4 and 2 using both hands.</div><div>3. Initially attach black tape to location 5, 4, 3, 1 and 2 using both hands.</div></div>			n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1.Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-52090 (W)</div><div>NG</div><div> 82711-12A80 (W)</div></div></div>

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	Model code/Part number: 220D / 7L0135-7021		Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1024		
	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 jig		 <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals</p> <p>2. Make 2-3 windings for Clamp taping</p> <p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p>	
		<p>1. Get the assy parts and set to jig using both hands. First, put the connector 6098-3802 (W) to Receiver base 1 then lock. Second, put the connector 6098-3810 (W) to Receiver base 2 then lock. Continue to set the harness in jig. Color sensor will beep/buzz if sensor detects Blue tape. Last, set the terminal to stopper jig then pull down the toggle clamp. Continue if the sequence light of Location 1 is ON. <i>Note: Refer to the above illustration for the correct setting.</i></p> <p>2. Check if all LED light for POWER ON and CLAMP ON was ON. Check if clamp location ① sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>3. Hold the tape on clamp location 1. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 2 was ON.</p> <p>4. Hold the tape on clamp location 2. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 3 was ON.</p>			

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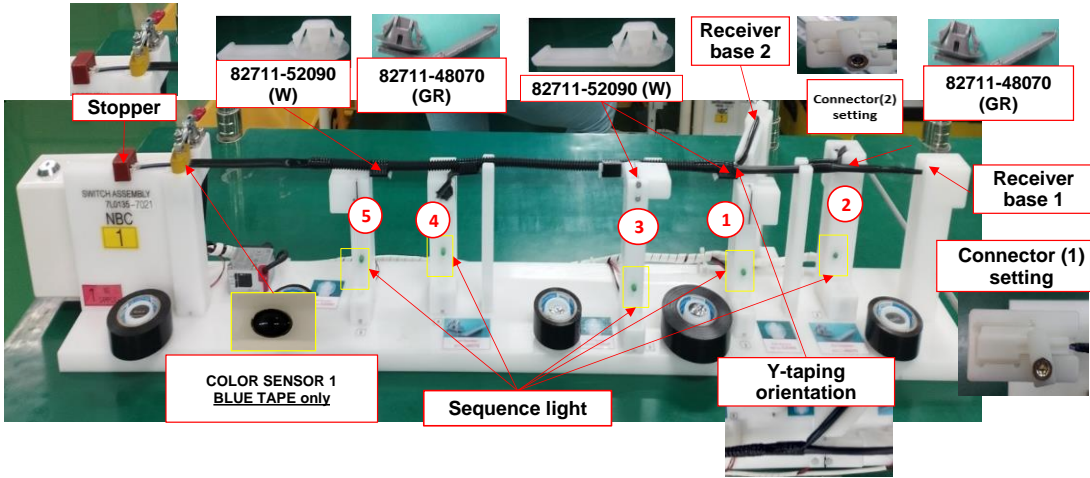

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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Clamp assembly jig (Continuation)		<div></div> <div>5. Hold the tape on clamp location 3. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 4 was ON.</div> <div>6. Hold the tape on clamp location 4. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 5 was ON.</div> <div>7. Hold the tape on clamp location 4. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if sequence light button on location 5 was ON.</div> <div>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div> <div>9. After point checking, remove toggle clamp up to connector receiver base.</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>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</div>

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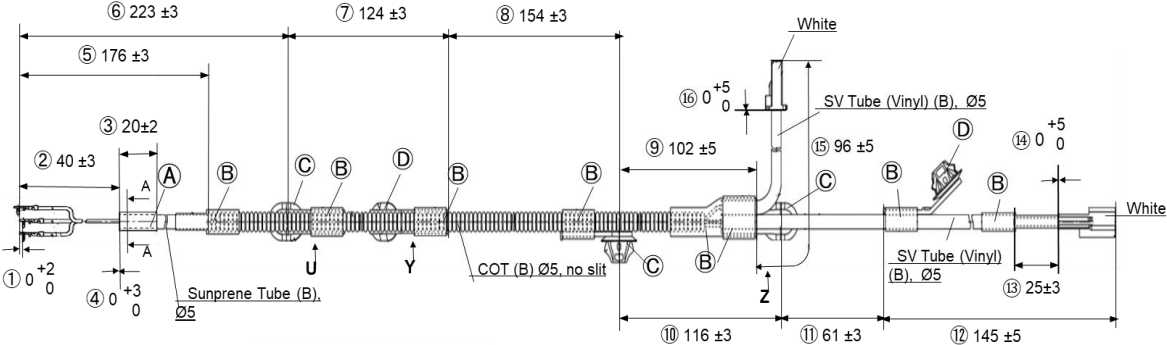
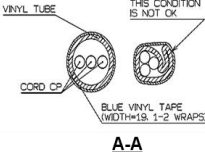

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	<div>Measurement</div> <div><div>MEASURING TAPE</div></div> <div><div><p>NOTE:</p><ul style="list-style-type: none">(A) - Taping (L)(B) - Taping (B)(C) - Clamp (W)(D) - Clamp (GR)<div></div></div></div>		<div>MEASURING TAPE</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>
					1. No wrong dimension

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0135-7021****1** No **Wrong facing of clamp****2** No **Unlocked/Half-locked connector****3** **4** **5** No **Missing Tape (Black tape)**

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