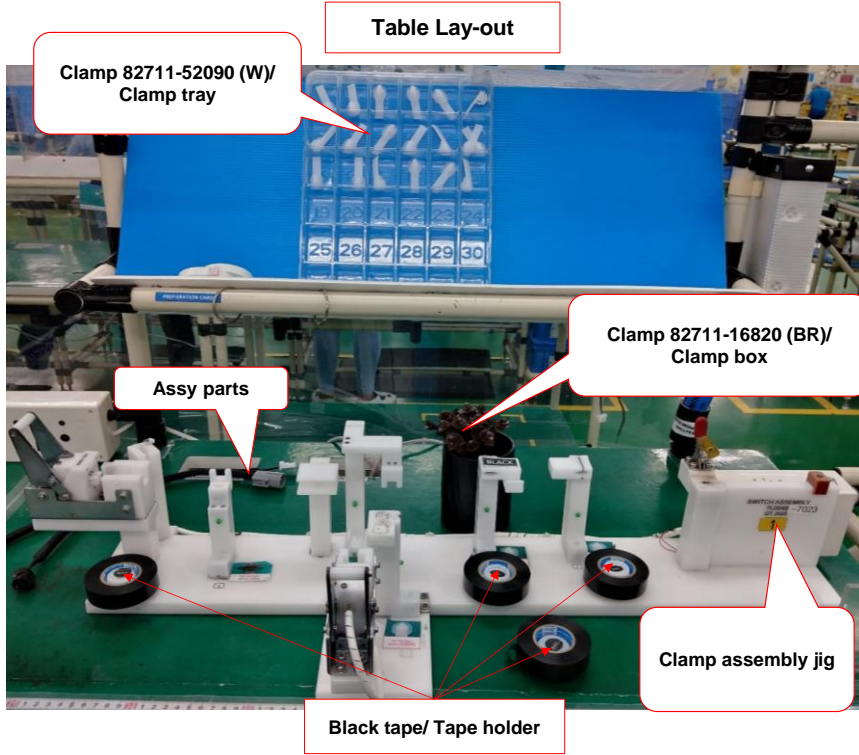

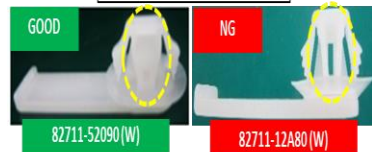
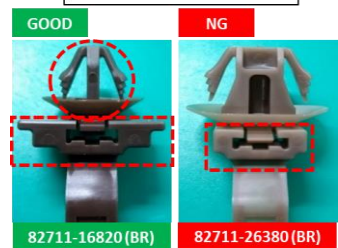
	WORK INSTRUCTION Process Name/Title: CLAMP ASSEMBLY PROCESS				Effectivity Date: September 4, 2024	
	Model code/Part number: 241B / 7L0049-7023		Customer: TRQSS		Car Model: LEXUS-ES	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-1013		Revision No.: 0	
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PARTS: 1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-16820 (BR); Black tape [4pcs.]		JIG: 1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	Clamp Assy Table Lay-out		<div> Safety Instruction Be sure to wear required 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> Bando Gun  </div>
		QUALITY POINTERS <div> Document reference/s: 1. Refer to WI-ENG-PDE-422A-C for Taping assembly process </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div> <div> CLAMP ILLUSTRATION  </div> <div> BAND CLAMP ILLUSTRATION  </div>	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
09/04/24	0	Initial issue. Separate Clamp setting and Clamp assembly 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 4, 2024



WORK INSTRUCTION

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CLAMP ASSEMBLY PROCESS

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Customer:

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Car Model:

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Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

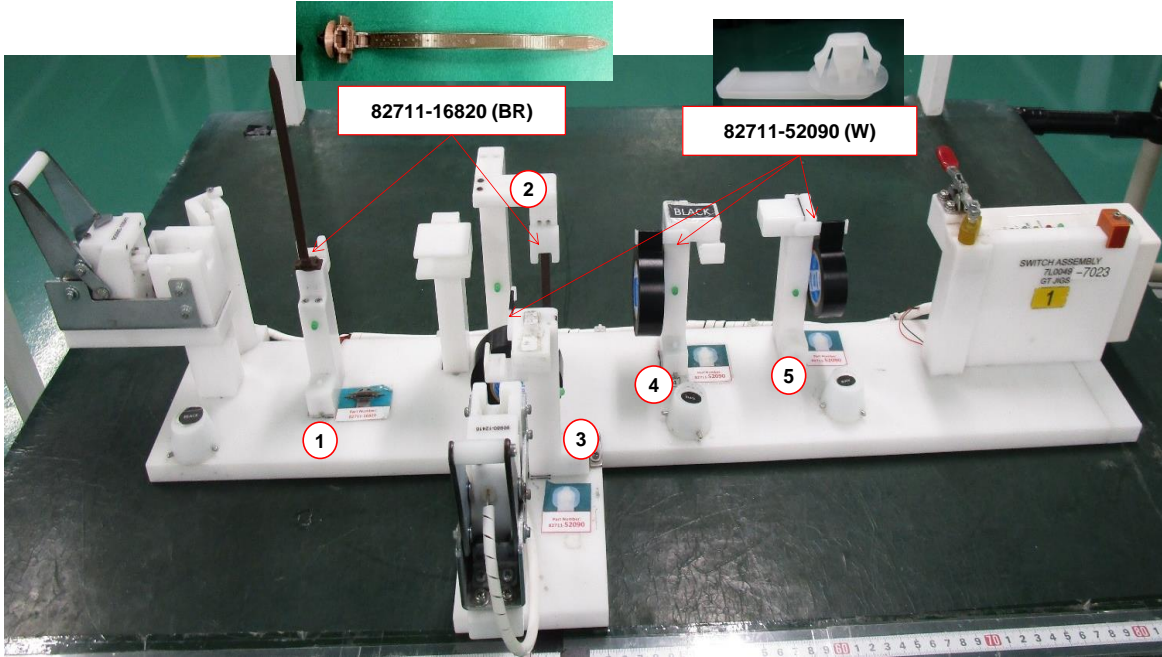













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PARTS:		1. Clamp 82711-52090 (W) [3pcs.] 2. Clamp 82711-16820 (BR) [2pcs.]		3. Black tape [2pcs]	JIG:	Clamp assembly jig													
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS												
2	Clamp Assy	Clamp setting	<div></div> <div>1. Get 3pcs. of clamp 82711-52090 (W) using both hands and insert to location 3, 4 and 5 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-16820 (BR) using both hands and insert to location 1 and 2 using both hands.</div> <div>3. Get Black tape using right hand and conduct pre-taping on clamp location 3, 4 and 5 using both hands.</div>				<div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>STANDARD TAPING FOR CLAMP One wind for under tape</div> <div></div> <div>CLAMP ILLUSTRATION</div> <table><tr><td>GOOD</td><td>NG</td></tr><tr><td></td><td></td></tr><tr><td>82711-52090 (W)</td><td>82711-12A80 (W)</td></tr></table> <div>BAND CLAMP ILLUSTRATION</div> <table><tr><td>GOOD</td><td>NG</td></tr><tr><td></td><td></td></tr><tr><td>82711-16820 (BR)</td><td>82711-26380 (BR)</td></tr></table> <div>1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No wrong use of clamp</div>	GOOD	NG			82711-52090 (W)	82711-12A80 (W)	GOOD	NG			82711-16820 (BR)	82711-26380 (BR)
GOOD	NG																		
																			
82711-52090 (W)	82711-12A80 (W)																		
GOOD	NG																		
																			
82711-16820 (BR)	82711-26380 (BR)																		

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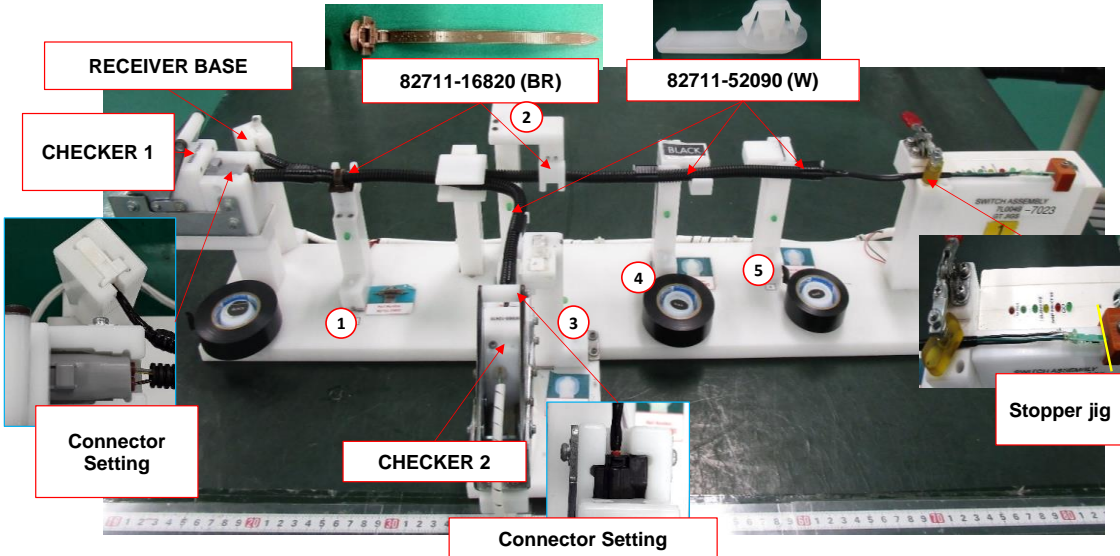


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PARTS:	1. Assy parts		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly	<div></div> <div><p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting)</i>. First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6098-3810 (W) to Receiver base 1 then lock. Next, set the connector to 6189-1161 (B) to Checker 2 then push the checker fixture for continuity checking. Last, set the end of B-B-G-B/W hotmelted wire together within the stopper then press by Toggle clamp. Continue if the sequence light in location 1 was ON.</p></div> <div><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></div>	<div></div> <p>Important reminders/note/s:</p> <ol style="list-style-type: none">1. Make sure no gap between stopper jig and PCB2. Make 2-3 windings for clamp taping <div><p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape 5. No loose attachment of clamp</p></div> <div></div>

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PARTS:

1. Assy parts
2. Black tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

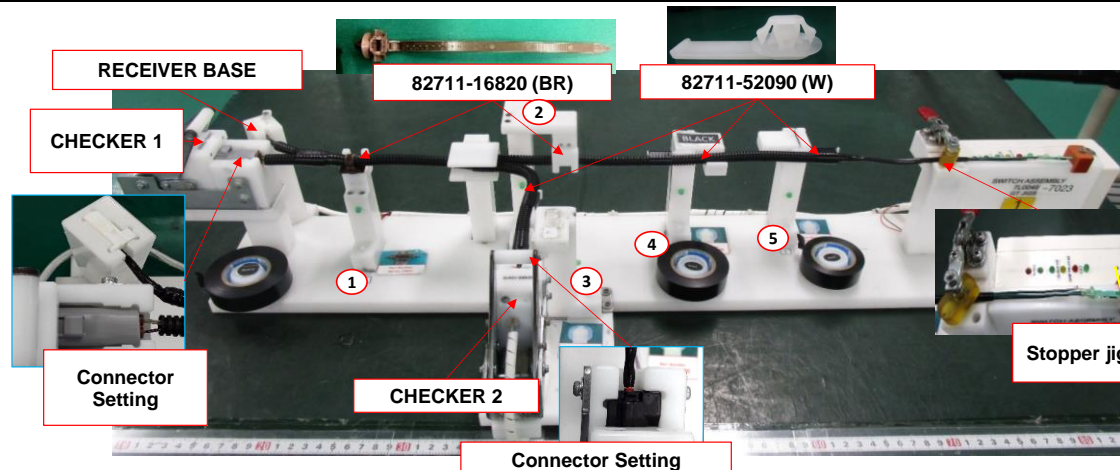
TOOLS/PPE

QUALITY POINTERS

3

Clamp Assy

Clamp Assembly
(Continuation)



3. Initially tighten the band clamp on location **1 and 2** using both hands.

4. Get the bando gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cut. Continue if the sequence light on clamp location **2** was **ON**.

5. Cut the band clamp on location **2** using both hands. Press the **SW button** after cut. Continue if the sequence light on clamp location **3** was **ON**.

BANDO GUN POSITION ON CLAMP LOCATION 1



GOOD

NG

BANDO GUN POSITION ON CLAMP LOCATION 2

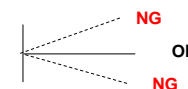


GOOD

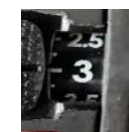
NG

BANDO GUN ALIGNMENT

PERPENDICULARITY



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



Important reminders/note/s:

1. Make sure no gap between stopper jig and PCB.

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
5. No loose attachment of clamp

BANDO GUN ILLUSTRATION



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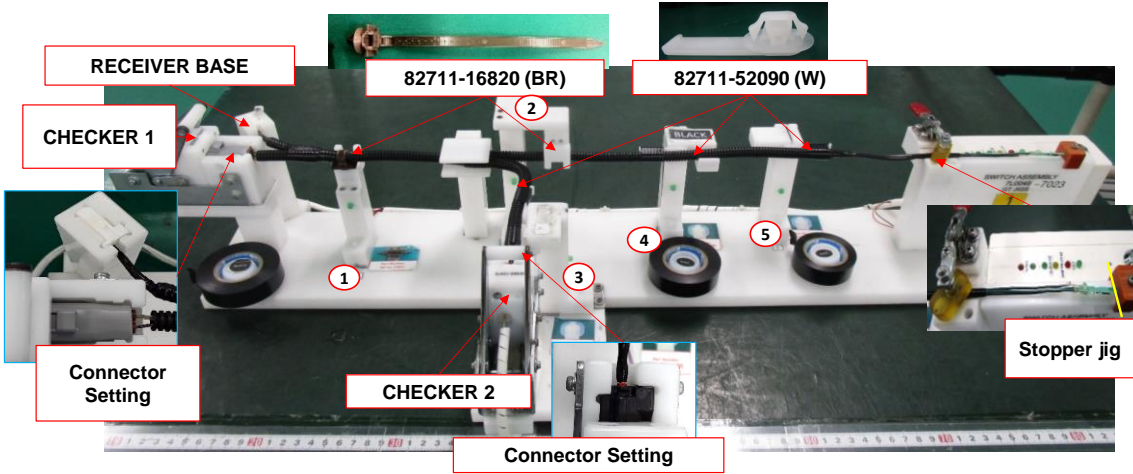


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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly (Continuation)	<div></div>	<div></div>	<div>Important reminders/note/s:</div> <div>1. Make sure no gap between stopper jig and PCB..</div> <div>2. Make 2-3 windings for clamp taping</div> <div>1. No damaged clamp</div> <div>2. No wrong usage of parts</div> <div>3. No missing clamp</div> <div>4. No missing tape</div> <div>5. No loose attachment of clamp</div> <div></div>
			<div>6. Hold the Black tape on clamp location 3 using right hand then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light on location 4 was ON.</div>	<div>8. Hold the Black tape on clamp location 5 using right hand then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Go sound will be heard.</div>	
			<div>7. Hold the Black tape on clamp location 4 using right hand then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light on location 5 was ON.</div>	<div>9. Conduct POINT CHECKING before removing the harness from jig.</div>	

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement	<div><div>MEASURING TAPE</div></div> <div>NOTE: A - Taping (B) B - Clamp (BR) C - Clamp (W)</div>	<div><div>MEASURING TAPE</div></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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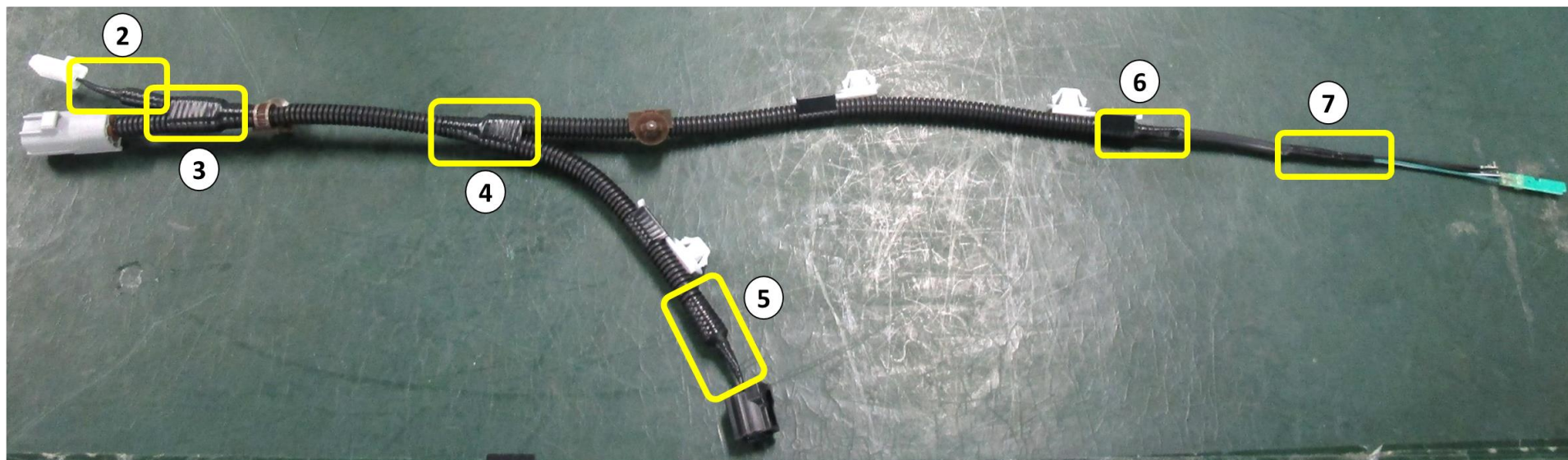
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0049-7023****① No Wrong facing of clamp****②③④⑤⑥⑦ No Missing Tape (Black tape)**

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