



## WORK INSTRUCTION

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

February 26, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0242-7020A

Customer:

TRJ

Car Model:

TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1217

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

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## PARTS:

1. Assy parts; Clamp 82711-16830 (B); Clamp 82711-16820 (BR); Brown tape

JIG:

1. Clamp assembly jig
2. Bando gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

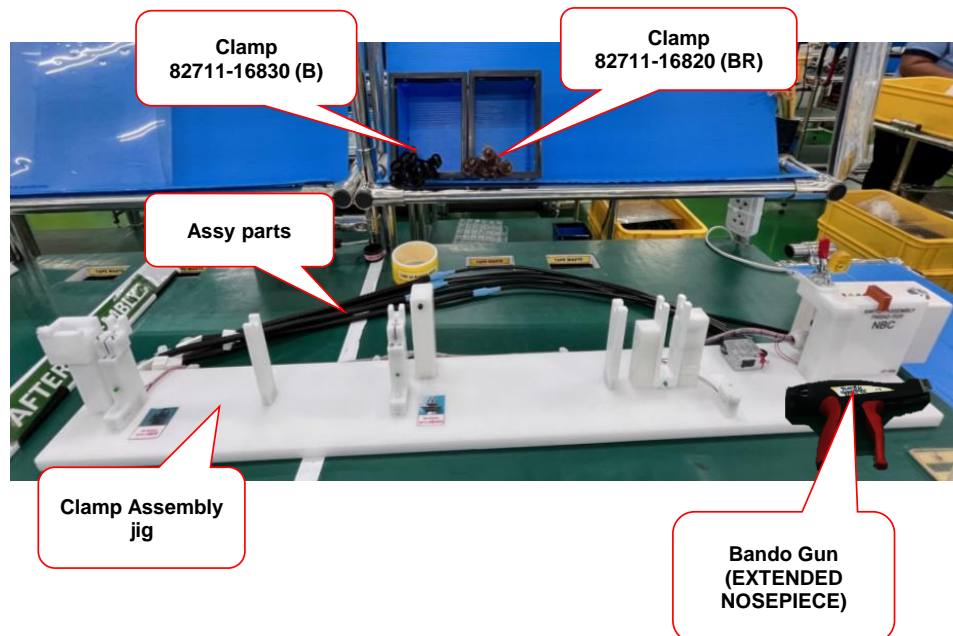
QUALITY POINTERS

1

Clamp  
Assy

Table lay-out

## TABLE LAY-OUT

**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 reference/s:**

1. Refer to **WI-ENG-PDE-1182A-B** for Taping assembly process

1. No missing parts/tools
2. No excess parts/tools

## Revision History

						Prepared by	Checked by	Reviewed by	Approved by
02/26/25	0	Initial issue.				D.Castillo	J. Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change			Revised	Checked	Reviewed	Approved	Est. Date:

February 26, 2025

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**PARTS:**

1. Clamp 82711-16830 (B)
2. Clamp 82711-16820 (BR)

JIG:

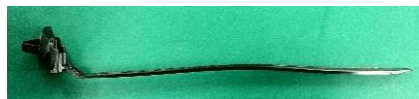
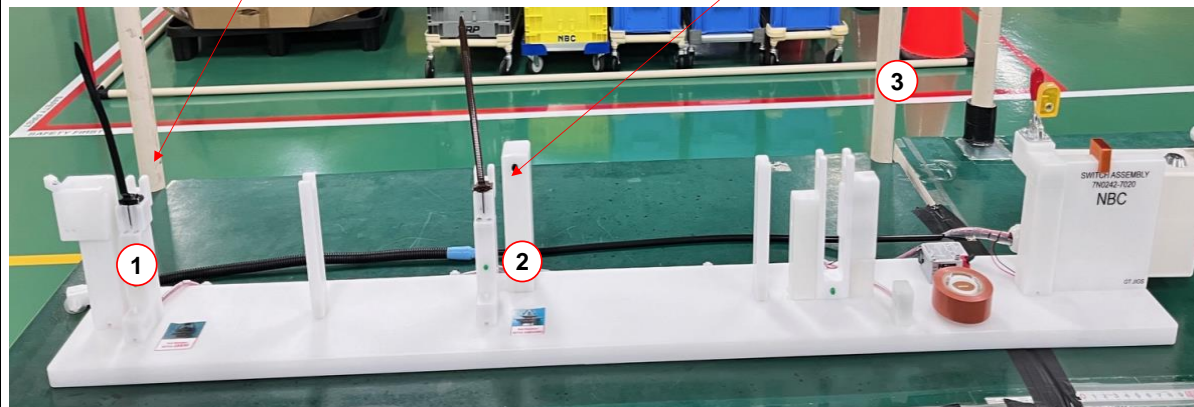
1. Clamp assembly jig

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

2

Clamp  
Assy

Clamp Setting

**82711-16830 (B)****82711-16820 (BR)**

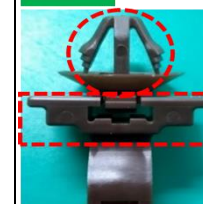
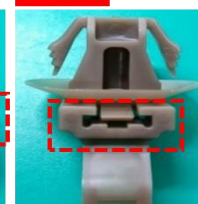
1. Get 1pc of band clamp 82711-16830 (B) then attach to clamp location **1**.

2. Get 1pc of band clamp 82711-16820 (BR) then attach to clamp location **2**.

**Important reminders/Notes/:**

**1. Please check the clamp first before start of assembly to avoid wrong use of clamp.**

1. No damaged clamp
2. No wrong use of clamp
3. No missing clamp

**BAND CLAMP ILLUSTRATION****GOOD****82711-16820 (BR)****NG****82711-26380 (BR)**

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## PARTS:

1. Assy parts
2. Brown tape

JIG:

1. Clamp assembly jig
2. Bando gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

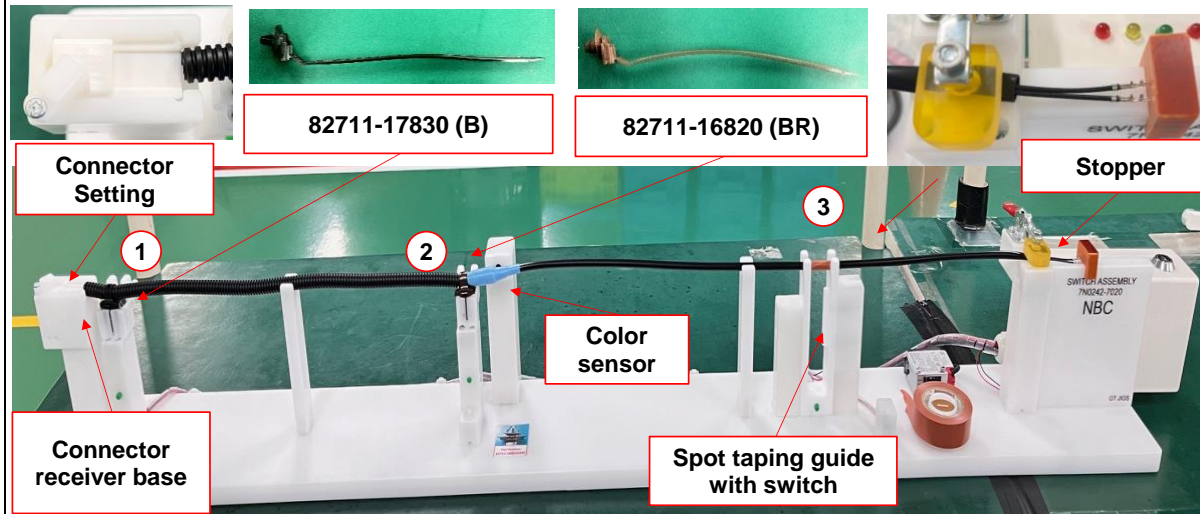
TOOLS/PPE

QUALITY POINTERS

3

Clamp  
Assy

Clamp Assembly



1. Put the assy into jig. **(See above picture for the correct setting)**. First, set the connector **6098-3802 (W) with Clip** to **Receiver base 1** then lock. Last, set the **terminals** together within stopper then press by **toggle clamp**. Continue if the sequence light of location **1** was on.

2. Checked if all **LED light** for **POWER ON, COLOR SENSOR** and **CLAMP ON** was **ON**. IF encountered problem, **STOP** and immediately **CALL** the attention of leader. **WAIT** for further instruction nad continue the process.

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

4. Get the Bando Gun using right hand and cut the band clamp on location **1** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **2** was on.

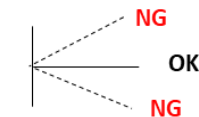
5. Cut the band clamp on clamp location **2** using both hands. Press the **SW button** after cutting of band clamp. Continue the process if clamp location **3** was on.

## BAND CLAMP CUT POSITION FOR LOCATION 1 &amp; 2



## BANDO GUN ALIGNMENT

## PERPENDICULARITY

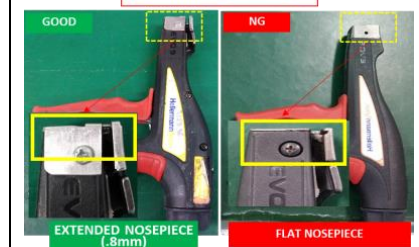


## Important reminders/Note/s:

1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).
2. Make sure no gap between the terminal and stopper jig.
3. Setting of band clamp cutter depends on the size of the **COT/Vinyl tube**.  
**For: ø5 - 1~2, ø7 - 3~4**

1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun
5. No missing Spot tape
6. No wrong color of tape


## BANDO GUN ILLUSTRATION

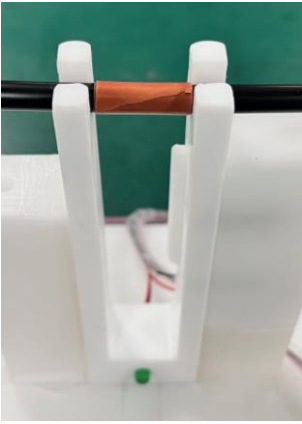

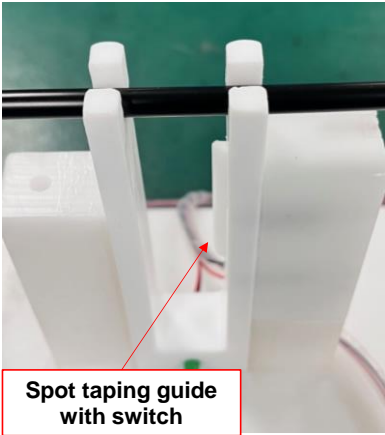


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 6

<b>PARTS:</b>	1. Assy parts 2. Brown tape			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>	
4	Clamp Assy	<div></div> <div>6. Get the <b>Brown tape</b> and start taping to Location <b>3</b>. <b>Make 3 windings</b> only of tape. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard. Note: Jig will alarm if lacking and excess winding.</div> <div>7. Conduct <b>POINT CHECKING</b>, before removing of harness from jig.</div> <div>8. Remove the harness from jig. Start from toggle clamp up to clamp up to connector receiver base.</div>				<b>Important reminders/Note/s:</b>  <i>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm). 2. Make sure no gap between the terminal and stopper jig.</i>  1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No missing Spot tape 6. No wrong color of tape	

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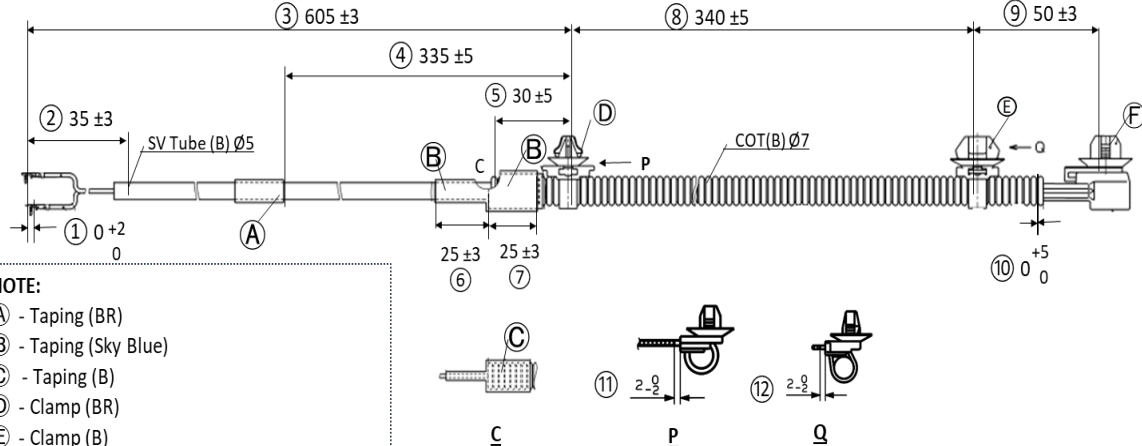
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	<div>MEASURING TAPE</div> <div></div> <div></div> <div>NOTE: (A) - Taping (BR) (B) - Taping (Sky Blue) (C) - Taping (B) (D) - Clamp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

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0242-7020A**

- ① No Wrong Facing of Clamp
- ② No Mis-align Clamp

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