

**WORK INSTRUCTION**Process Name/Title: **CLAMP ASSEMBLY PROCESS**

Effectivity Date:

September 08, 2023Model code/Part number: **700B / 7N0039-7020A** Customer: **TRJ** Car Model: **TOYOTA-LAND CRUISER**

Validity Date:

n/aPurpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

WI-ENG-PDE-732

Revision No.:

0

Page No.:

1 of 6**PARTS:**

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-3A540 (W)

JIG:

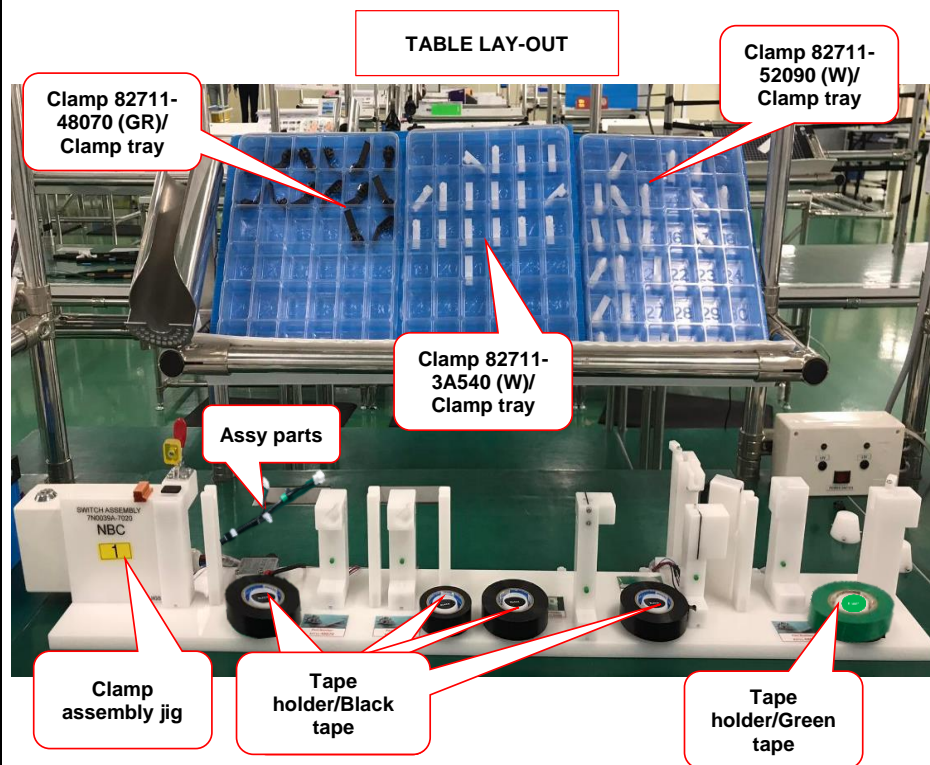
1. Clamp assembly jig

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

1

n/a

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

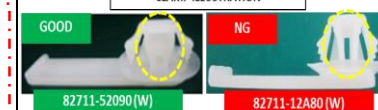
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

CLAMP ILLUSTRATION

**Important reminders/Note/s:**

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/08/23

0

Initial Issue.
Excluded process from **WI-ENG-PDE-715** due to separation of process; Change process name from **TAPING ASSEMBLY PROCESS** to **CLAMP ASSEMBLY PROCESS**; Additional table lay-out. Improve Work procedure/Illustration on process no.2 and 3

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Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 08, 2023

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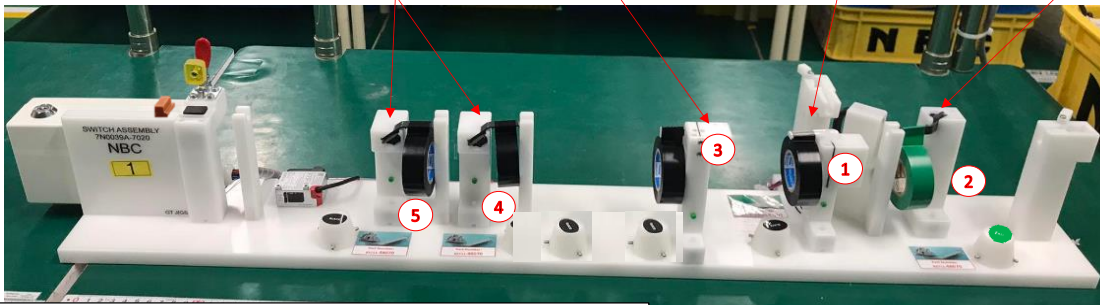
Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 6

PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-48070 (GR) [3pcs] 3. Clamp 82711-3A540 (W)		4. Black tape 5. Green tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	n/a	Clamp setting	<div><div> 82711-48070 (GR)</div><div> 82711-3A540 (W)</div><div> 82711-52090 (W)</div><div> 82711-48070 (GR)</div><div></div><div>1. Get [2pcs] of clamp 82711-48070 (GR) using right hand and set to Clamp location 4 and 5 using both hands.</div><div>2. Get [1 pc.] of clamp 82711-48070 (GR) using right hand and set to Clamp location 2 using both hands.</div><div>3. Get [1 pc.] of clamp 82711-3A540 (W) using right hand and set to Clamp location 3 using both hands.</div><div>4. Get [1 pc.] of clamp 82711-52090 (W) using right hand and set to Clamp location 1 using both hands.</div><div>5. Initially attached Green tape on location no. 2 using both hands.</div><div>6. Get the Black tape using right hand then initially attached to clamp location 5, 4, 3 and 1 using both hands.</div></div>				<p>Important reminders/Note/s:</p> <p>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <div><div>GOOD</div><div> 82711-52090 (W)</div><div>CLAMP ILLUSTRATION</div><div>NG</div><div> 82711-12A80 (W)</div></div>

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Revision No.:

0

Page No.:

3 of 6

PARTS:	1. Assy parts 2. Black tape [4pcs]	3. Green tape	JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Clamp assembly	 <p>1. Get the assy parts and set into jig using both hands. (See above picture illustration for correct setting of harness). First, set the connector 6098-3802 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Continue to set the harness in jig then set the terminal end within the stopper then press by toggle clamp.</p> <p>2. Hold the Black tape on clamp location 1 then start taping using both hands. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 2 was ON.</p> <p>3. Set the connector 6098-3810 (W) to Receiver base 2 then lock. On clamp location 2 hold the tape then start taping using both hands. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 3 was ON.</p> <p>4. Hold the Black tape on clamp location 3. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 4 was ON.</p> <p>5. Hold the Black tape on clamp location 4. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 5 was ON.</p> <p>6. Hold the Black tape on clamp location 5. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping.</p> <p>7. After taping, Check the taping. Conduct POINT CHECKING before removing of harness from jig.</p>		<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p>  <p>One side tape under clamp</p> <p>Important reminders/Note/s:</p> <p>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</p>

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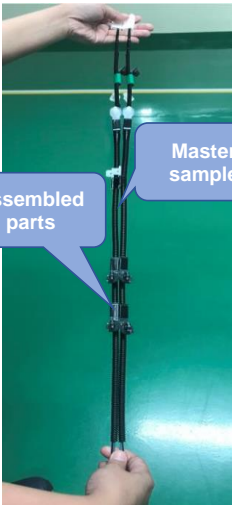


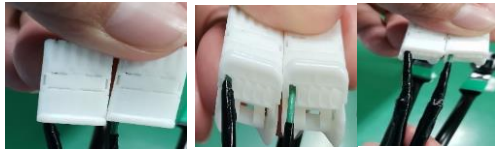

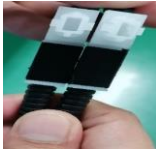
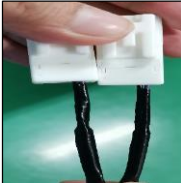



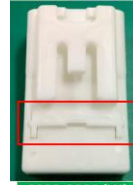




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Revision No.:

0

Page No.:

4 of 6

PARTS:		1. Assembled parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div><div><div><div></div><div>Assembled parts</div></div><div><div></div><div>ACTUAL PRODUCT</div></div></div><div><div><div><div></div><div>2. Check the terminal, connector lock condition, Insertion and taping condition. (Connector 1)</div></div><div><div></div><div>4. Check the terminal, connector lock condition, Insertion and taping condition.</div></div><div><div></div><div>5. Check the presence of clamp 3, and taping condition.</div></div><div><div></div><div>6. Check the taping condition of Y-taping.</div></div></div><div><div><div></div><div>3. Check the presence of clamp 1, and taping condition.</div></div><div><div></div><div>7. Check the terminal appearance. Must be no deformed terminal</div></div></div></div></div><div><div><div><div><div></div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div></div><div>NG</div><div>6098-5677 (W)</div></div></div><div><div><div></div><div>GOOD</div><div>6098-3802 (W)</div></div><div><div></div><div>NG</div><div>6098-5668 (W)</div></div></div><div><div><div></div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div></div><div>NG</div><div>82711-12A80 (W)</div></div></div></div><div>CONNECTOR ILLUSTRATION</div><div>CONNECTOR ILLUSTRATION</div><div>CLAMP ILLUSTRATION</div></div><div>1. No skip checking during inspection</div><div>MASTER SAMPLE</div><div>CONNECTOR ILLUSTRATION</div><div>GOOD</div><div>NG</div><div>6098-3810 (W)</div><div>6098-5677 (W)</div><div>CONNECTOR ILLUSTRATION</div><div>GOOD</div><div>NG</div><div>6098-3802 (W)</div><div>6098-5668 (W)</div><div>CLAMP ILLUSTRATION</div><div>GOOD</div><div>NG</div><div>82711-52090 (W)</div><div>82711-12A80 (W)</div></div>			

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Page No.:

5 of 6

PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

n/a

Measurement



Important reminders/Note/s:

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

1. No wrong dimension

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Revision No.:

0

Page No.:

6 of 6

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS

CLAMP
ASSY

7N0039-7020A



GOOD



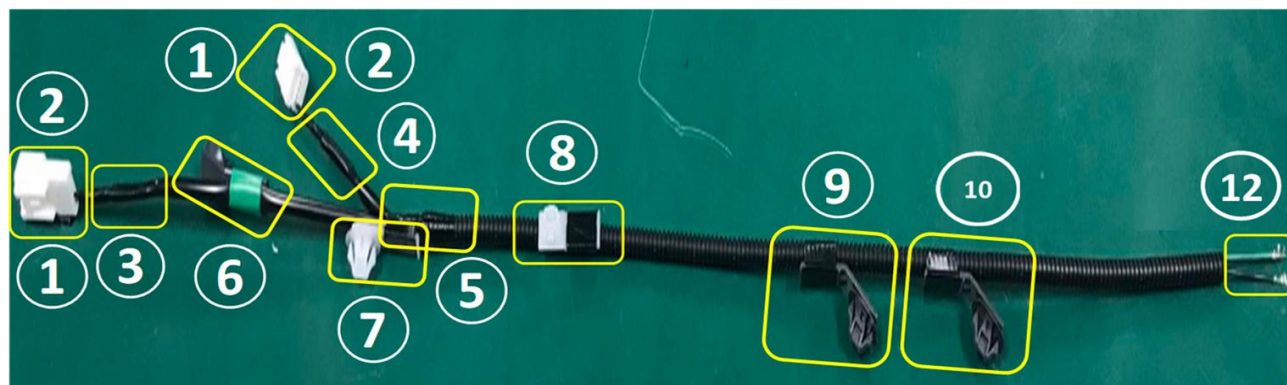
GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

3 4 5 No Wrong use of tape

1 No Unlock/
Halflocked Connector
(on 3 connector)

6 7 8 9 10 No missing Clamp/No wrong
color of tape

12 No Deformed
terminal

2 No Wrong Insert
(on 2 connector)

11 Checking of Clamp alignment/
orientation

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