



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Model code/Part number:

220D / 7L0134-7020B

Customer:

TRQSS

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-1100

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts; Clamp 82711-52090(W); Clamp 82711-48070 (GR); Black tape [4pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

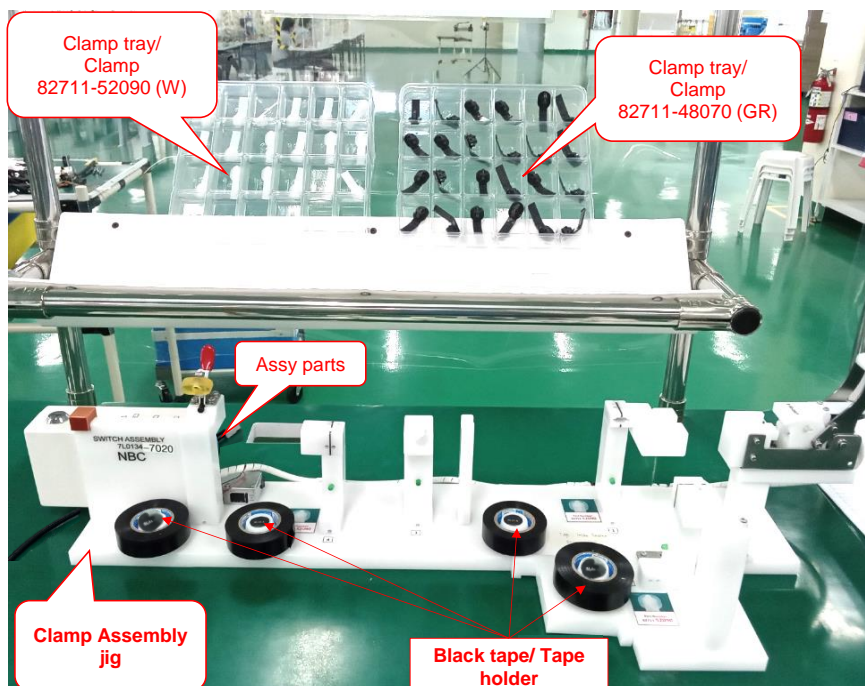
QUALITY POINTERS

1

CLAMP
ASSY

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear 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.

Document reference/s:

1. Refer to **WI-ENG-PDE-1099A-C** for Offline assembly process

1. No missing parts/tools
2. No excess parts/tools
3. No wrong positions of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.	D.Castillo	C.Villanueva	A. Arañes	n/a				n/a
10/09/24	0	Initial issue. Separate 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:	October 09, 2024		

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DCC Stamp



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PARTS:		1. Clamp 82711-48070 (GR) 2. Clamp 82711-52090 [3pcs]		3. Black tape [4pcs]		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> 82711-52090 (W)</div></div> <div><p>1. Get 3pcs of clamp 82711-52090 (W) using right hand then set to clamp location 1, 2 and 4 using both hands.</p><p>2. Get 1pc of clamp 82711-48070 (GR) using right hand then set to clamp location 3 using both hands.</p><p>3. Initially attach Black tape to clamp location 1, 2, 3 and 4 using both hands.</p></div>			n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>Important reminders/Note/s: 1. Check the Clamp first before start of assembly to avoid wrong use of clamp.</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><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-52090 (W)</div></div><div><div>NG</div><div> 82711-12A80 (W)</div></div></div>

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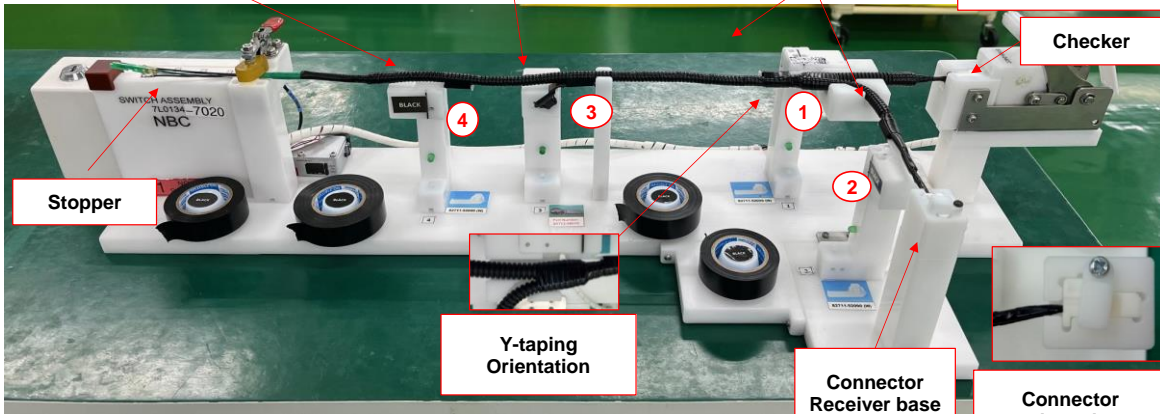

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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> 82711-52090 (W)</div><div> 82711-48070 (GR)</div><div> 82711-52090 (W)</div><div> Connector orientation</div><div> Stopper Y-taping Orientation Checker Connector Receiver base Connector orientation</div></div>			<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper jig and PCB</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>
		<div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0407 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the Y-taping into Y-taping guide. Third, set 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 Green tape. Last, set the hotmelted wires and terminal end together within the stopper then press by Toggle clamp.</p><p>2. Check if all LED light for Power On, Clamp On and Color sensor was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Check if the sequence light of location 1 was ON.</p><p>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 2 was ON.</p></div>			

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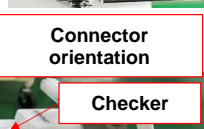
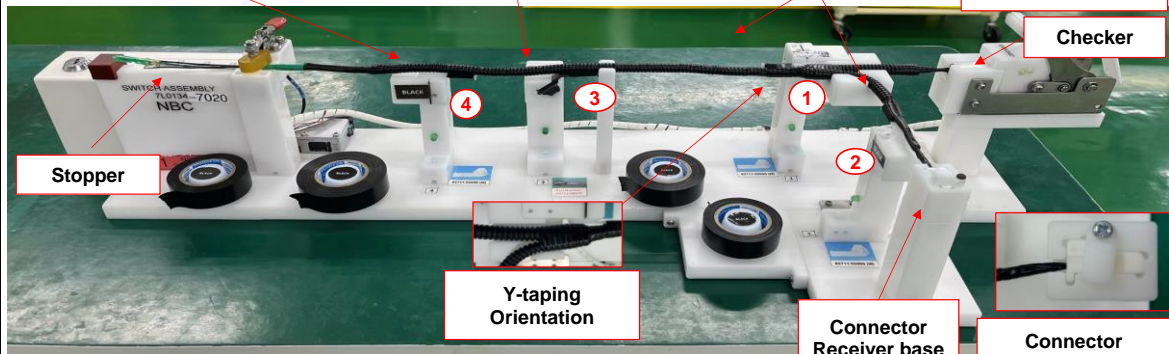

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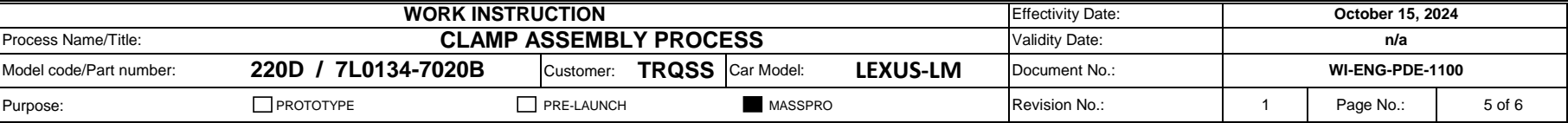
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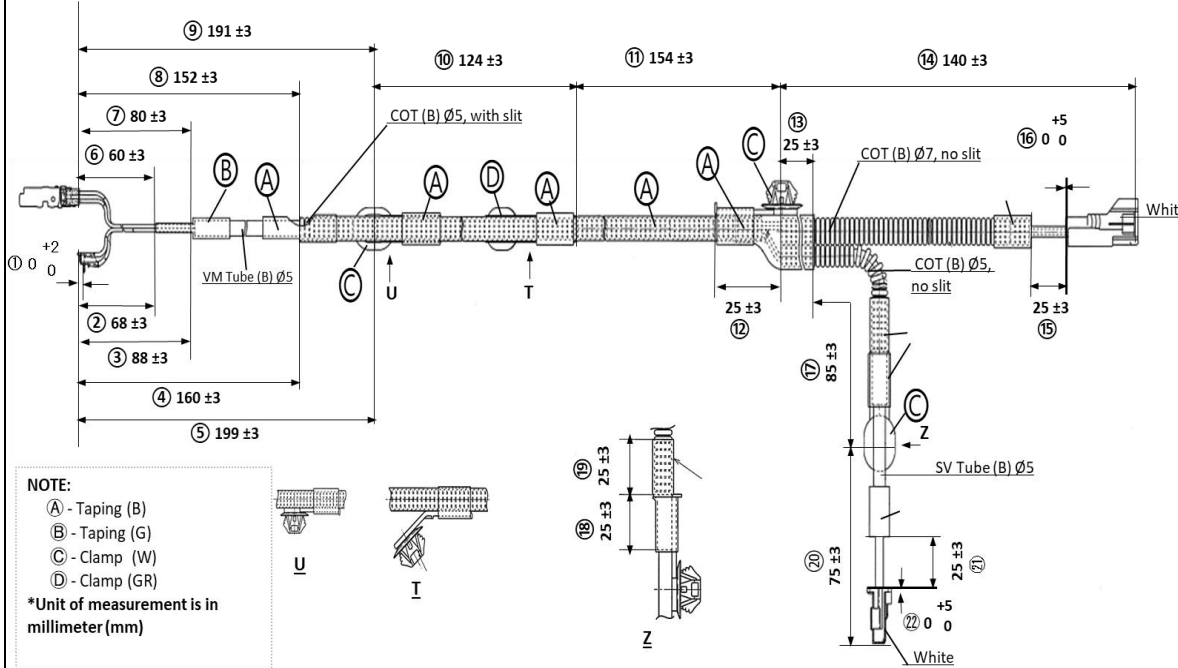

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PARTS:	1. Assy parts		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp Assembly (Continuation)	<div><div> 82711-52090 (W)</div><div> 82711-48070 (GR)</div><div> 82711-52090 (W)</div><div> Connector orientation</div><div> Checker</div><div> Stopper Y-taping Orientation Connector Receiver base Connector orientation</div><div><div>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 3 was ON.</div><div>5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</div><div>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. GO sound will be heard.</div><div>7. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div><div>8. For removal of harness from jig. From toggle clamp up to Checker 1, Connector receiver base and Y-taping guide.</div></div></div>	<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper jig and PCB</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>	

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div> <div>MEASURING TAPE</div>   <div> <p>NOTE:</p> <p>(A) - Taping (B)</p> <p>(B) - Taping (G)</p> <p>(C) - Clamp (W)</p> <p>(D) - Clamp (GR)</p> <p>*Unit of measurement is in millimeter (mm)</p> </div> </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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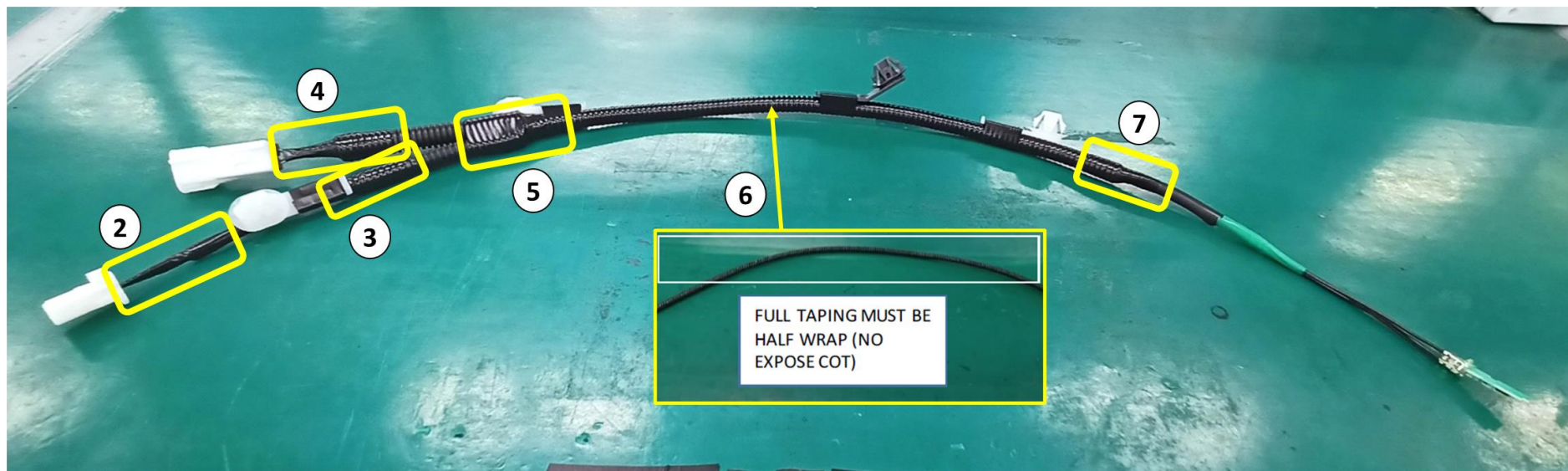
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0134-7020B****① No Wrong facing of clamp****② ③ ④ ⑤ ⑥ ⑦ No Missing Tape (Black tape)**

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