



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

April 8, 2025

Model code/Part number:

736D / 7R0119-7022

Customer:

TRMX

Car Model: TOYOTA-TACOMA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Document No.:

WI-ENG-PDE-1247

Revision No.:

0

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PARTS:

1. Assy parts: Clamp 82711-3A640 (B); Clamp 82711-26380 (BR); Black tape; Red tape; QR Code label 7V3240-0020

JIG:

1. Clamp assembly jig
2. Bando Gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

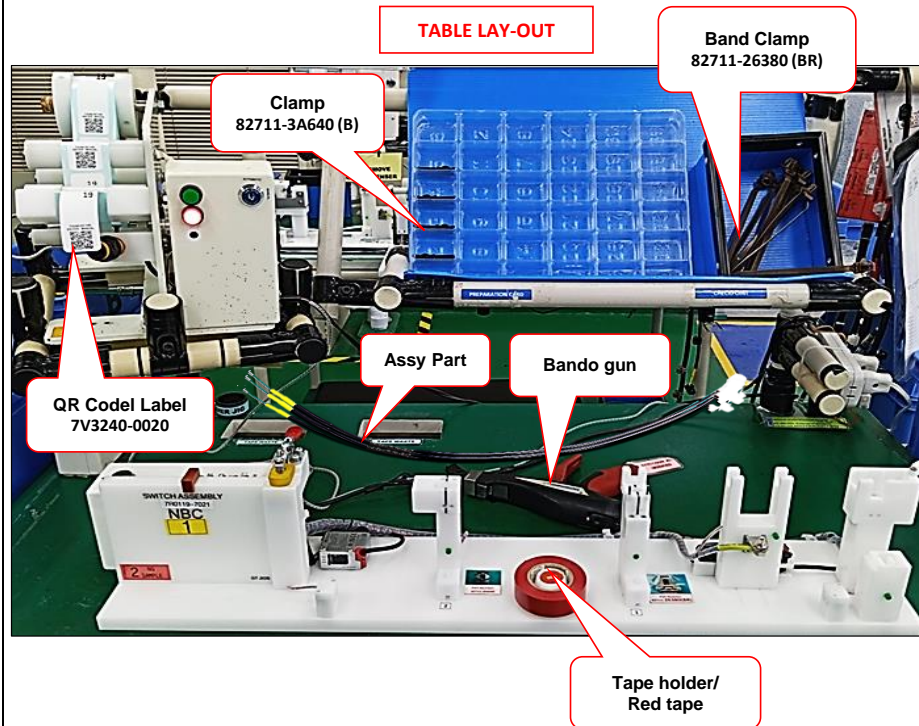
TOOLS/PPE

QUALITY POINTERS

1

Clamp

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.

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

Revision History

Prepared by

Checked by

Reviewed by

Approved by

04/08/25 0 Initial issue.

A.Hernandez

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Eff. Date

Rev. No

Details of Change

Revised

Checked

Reviewed

Approved

Est. Date:

April 8, 2025

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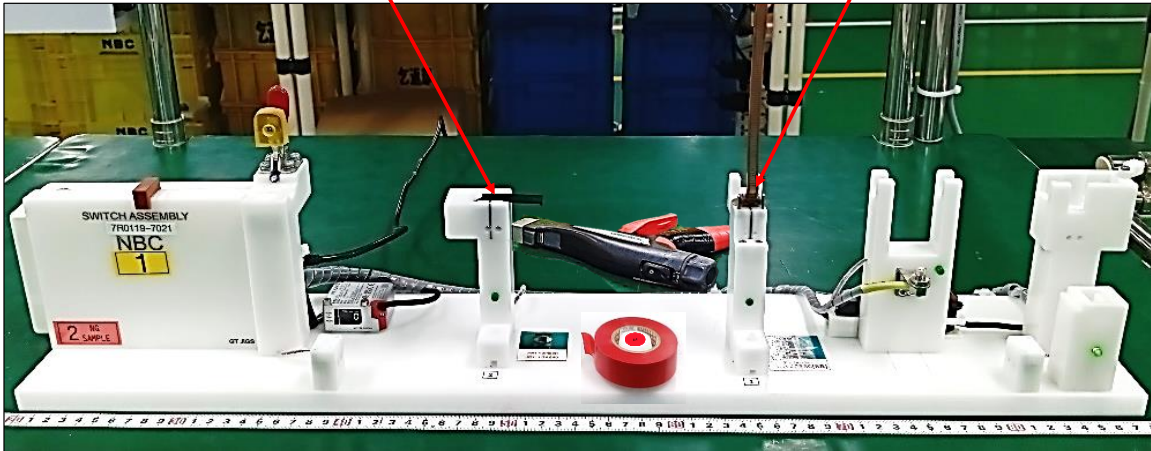
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PARTS:		1. 82711-3A640 (B) 2. Red tape		3. 82711-26380 (BR)		JIG:		1. Clamp assembly jig 2. Bando Gun			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
2		Clamp		<div><div></div><div>82711-3A640 (B)</div><div></div><div>82711-26380 (BR)</div><div></div><div>1. Get 1pc. of clamp 82711-3A640 (B) using both hands then set to clamp location 2 using both hands.</div><div>2. Get 1pc. of clamp 82711-26380 (BR) using both hands then set to clamp location 1 using both hands.</div><div>3. Initially attach Red tape on clamp location 2 using both hands.</div></div> <td colspan="2"></td> <td colspan="2">1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</td>						1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector	

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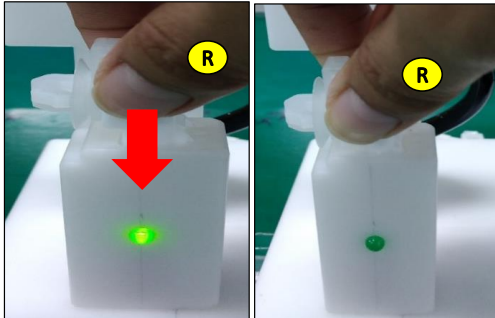



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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp	<div>Connector lock</div> <div></div> <div><div>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</div></div> <div><div>Coupler Cross Sectional View</div><div><div><div>NG</div><div>Double</div><div>Unlock Condition</div></div><div><div>NG</div><div>Double</div><div>Half Lock Condition</div></div><div><div>GOOD</div><div>Double</div><div>Full Lock Condition</div></div></div></div> <div><div></div><div></div><div><div>Before lock</div><div>After lock</div></div></div>	<div>LOCKING JIG</div> <div></div>	<div><div>1. Use the provided locking jig per model</div><div>2. No unlock/half-locked connector</div><div>3. No skip of locking process</div></div> <div><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div></div>

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PARTS:		1. Assy parts 2. Red tape		JIG:	1. Clamp assembly jig 2. Bando Gun
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp	Clamp assembly	<div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Yellow tape. Last, set the terminal end together within the stopper then press by Toggle clamp.</p><p>2. Check if all LED light for Power On, Clamp ON, Sensor ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p></div> <div><p>3. Initially tighten the band clamp on location 1 using both hands.</p><p>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.</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div> <div><p>BANDO GUN POSITION ON CLAMP LOCATION 1</p><p>BANDO GUN ALIGNMENT</p><p>BANDO GUN ILLUSTRATION</p></div>		<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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PARTS:

1. Assy Parts
2. Red tape

JIG:

1. Clamp assembly jig
2. Bando Gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Clamp

Clamp assembly
(Continuation)



5. 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. **Go** sound will be heard

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Important reminders/Note/s:

1. Make sure no gap in stopper and terminals

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PARTS:		1. Assy Parts 2. QR Code label 7V3240-0020		JIG:	n/a																		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																		
5	Clamp	Label Attachment																					
		<table><tr><th>Model Code</th><th>Item No.</th><th>Item Name</th></tr><tr><td>7R0117-7022</td><td>73240-AK020</td><td>DRIVER PWR/ISO D</td></tr><tr><td>7R0117-7025</td><td>73240-AK010</td><td>DRIVER MANUAL</td></tr><tr><td>7R0118-7025</td><td>73240-AK020</td><td>DRIVER PWR/ISO D</td></tr><tr><td>7R0119-7022</td><td>73240-AK050</td><td>PASSENGER ISO D/PWR</td></tr><tr><td>7R0120-7022</td><td>73230-AK030</td><td>PASSENGER FOLD-FLAT</td></tr></table> <div><p>Model code</p><p>1. Get the label. Note: Check the model code, item no. & name</p><p>Item no. & name</p><p>2. Align the end part of label in the jig.</p><p>3. Fold the center part of the label</p><p>4. Align both end part of label .</p><p>5. After alignment , Press the label with both fingers .</p><div><p>Acceptable overlap 0-1mm</p><p>GOOD</p><p>NG</p></div><p>6. Press the label upside down using finger.</p><p>7. After taping, conduct POINT CHECKING before removing the harness from the jig.</p></div>		Model Code	Item No.	Item Name	7R0117-7022	73240-AK020	DRIVER PWR/ISO D	7R0117-7025	73240-AK010	DRIVER MANUAL	7R0118-7025	73240-AK020	DRIVER PWR/ISO D	7R0119-7022	73240-AK050	PASSENGER ISO D/PWR	7R0120-7022	73230-AK030	PASSENGER FOLD-FLAT		<div><p>1. No bubbles</p><p>2. No damage</p><p>3. No peel off</p><p>4. No wrong use of label</p><p>5. No missing parts</p><p>6. No loose attachment</p><p>7. No wrong usage of label</p></div>
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7R0117-7022	73240-AK020	DRIVER PWR/ISO D																					
7R0117-7025	73240-AK010	DRIVER MANUAL																					
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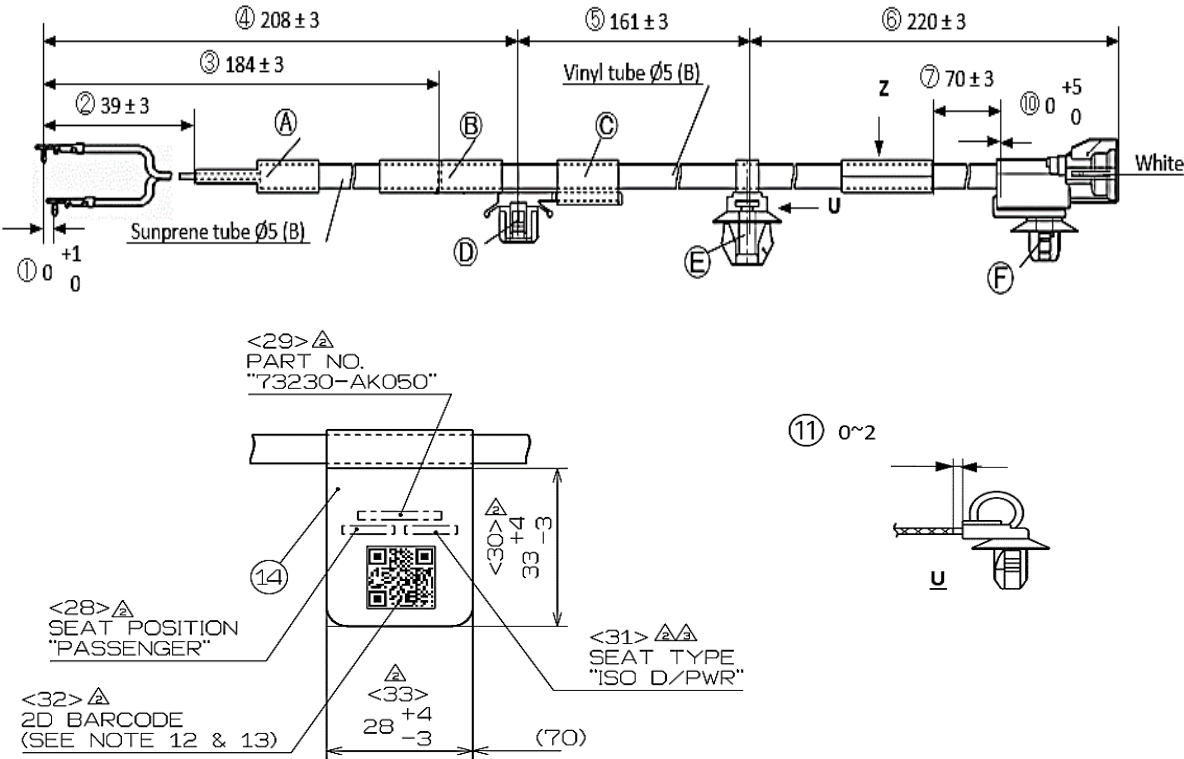

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Clamp Measurement	<div></div>	<div><div>MEASURING TAPE</div></div> <div><p>Important reminders and note/s:</p><p>1. Please use calibrated/verified 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></div>	

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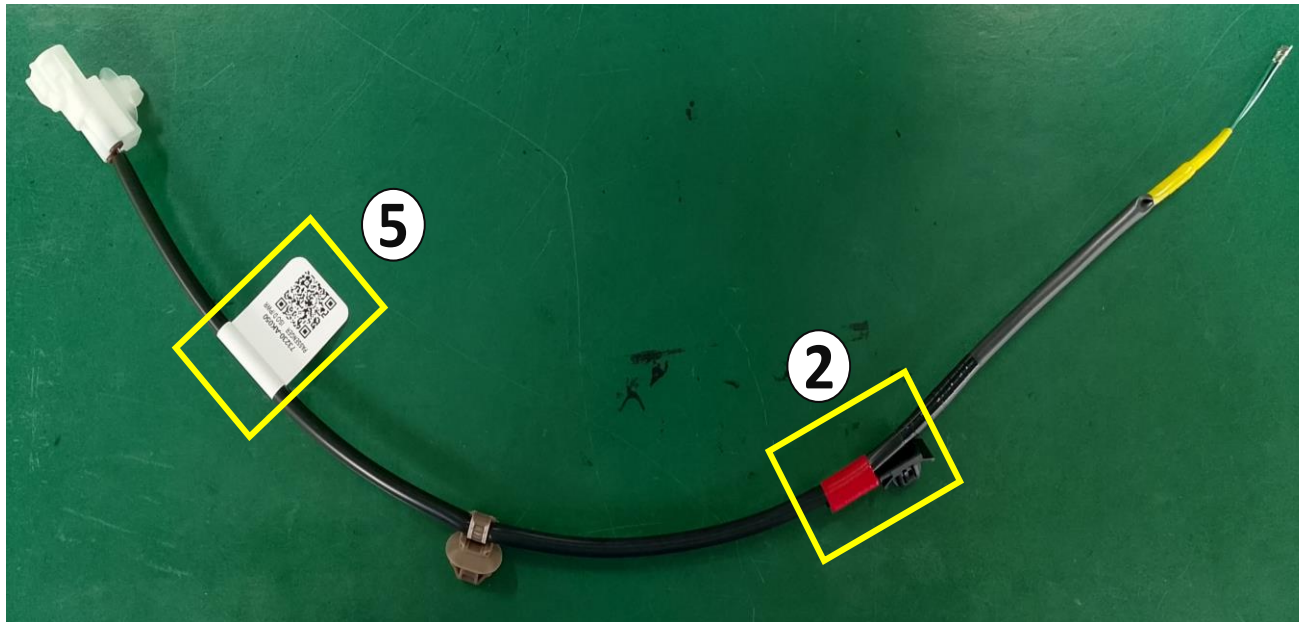
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8 of 8**PARTS:****n/a****JIG:****n/a****VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP****7R0119-7022**

- ① No Unlock/ Halflocked Connector
- ② No Wrong use to Clamp taping (red)
- ③ Check the Clamp Alignment
- ④ No Missing Clamp
- ⑤ No Wrong use of QR Code label
- ⑥ No Wrong Facing of Clamp

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