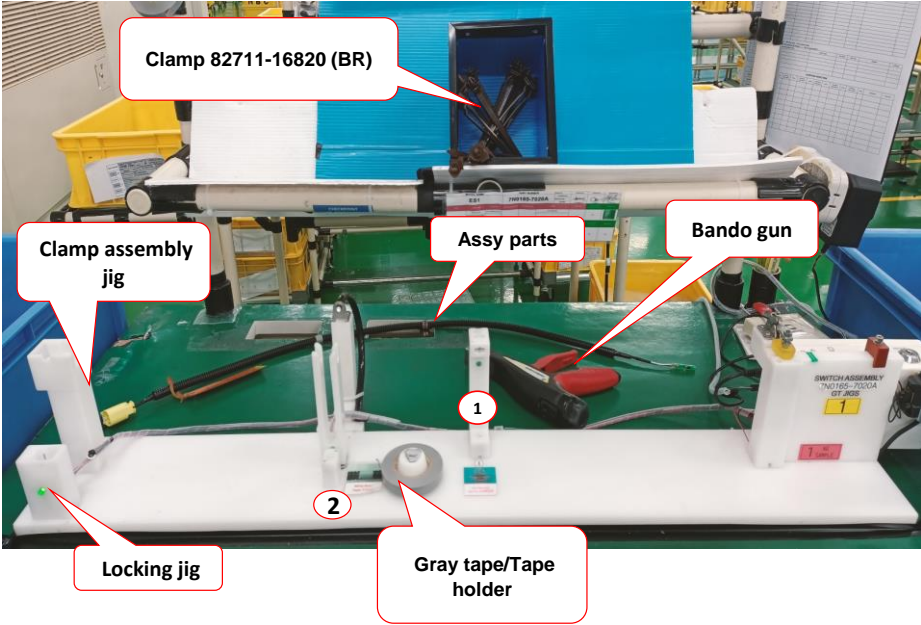



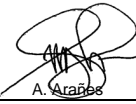
	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: ES1 / 7N0165-7020A		Customer: TRJ	Car Model: SUBARU-FORESTER	Document No.:		WI-ENG-PDE-820	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 6

PARTS:		1. Assy parts: Clamp 82711-16820 (BR) ; Gray tape (10mm)		JIG:		1. Clamp assembly jig with locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	<div>Table Lay-out</div> 		<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div> <b>BANDO GUN</b></div>		1. No missing parts/tools 2. No excess parts/tools	


Revision History								Prepared by		Reviewed by		Approved by		Noted by	
															
06/11/24	0	Initial issue.						D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date: June 11, 2024			

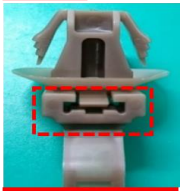
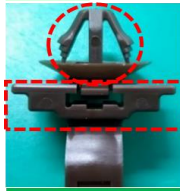
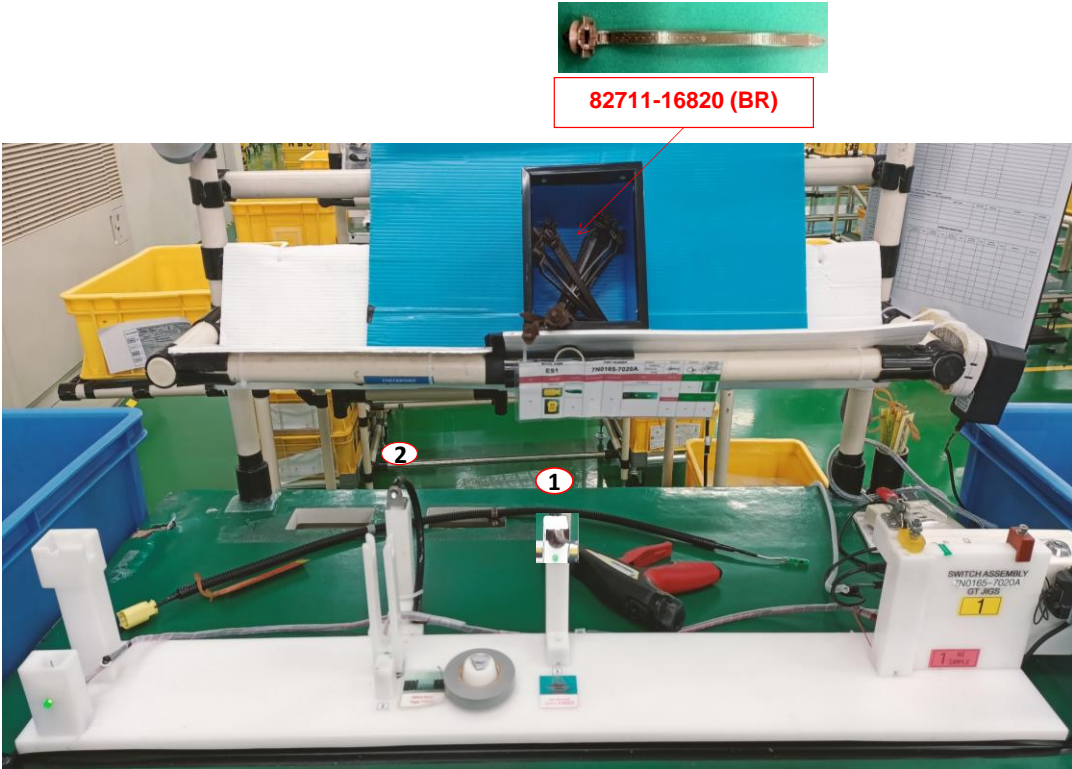
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 6

PARTS:	1. Clamp 82711-16820 (BR)			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	CLAMP ASSY	Clamp setting			<div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div><div>82711-16820 (BR)</div><div>82711-26380 (BR)</div></div></div> <div><b>Important reminders/Note/s:</b> 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.  1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</div>		
 <div>1. Get 1pc. of clamp 82711-16820 (BR) using right hand then set to clamp location 1 using both hands.</div>							

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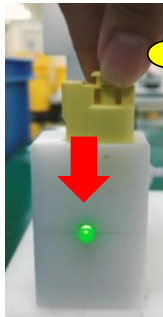
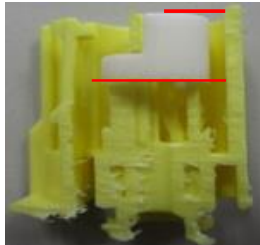
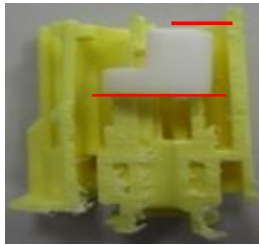
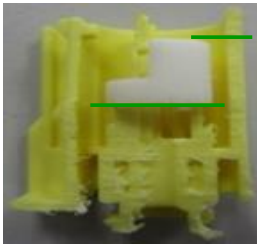
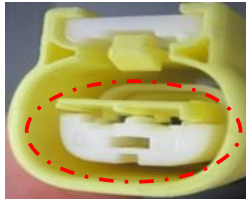
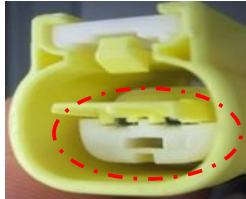

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PARTS:		1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	<div><div><div></div><div><div>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</div></div></div><div><div>CROSS SECTIONAL VIEW</div><div><div><div>NG</div><div>Unlock</div></div><div><div>NG</div><div>Half-locked</div></div><div><div>GOOD</div><div>Fully locked</div></div><div><div><div>Before Pressing</div></div><div><div><div>After Pressing</div></div></div></div></div><div><div>LOCKING JIG</div></div><div><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</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>			

**LOCKING JIG**

**Important reminders/Note/s:**

1. **MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.**

1. Use the provided locking jig per model  
2. No unlock/half-locked connector  
3. No skip of locking process

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## CLAMP ASSEMBLY PROCESS

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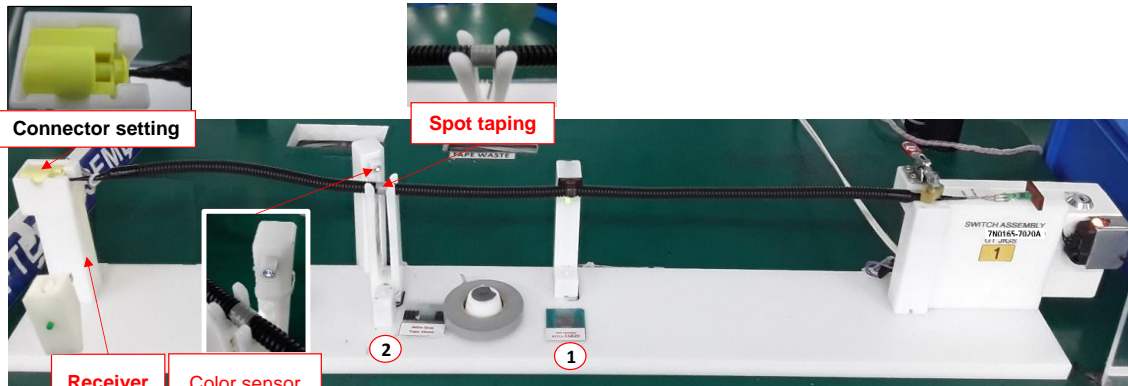
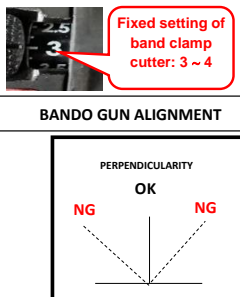

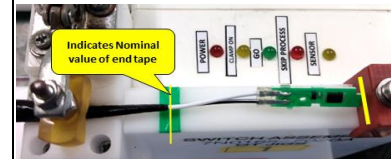

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PARTS:		1. Assy parts 2. Gray tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div><div></div><div><p>1. Get the assy parts and set into jig. <b>(See above picture for correct setting of harness).</b> First, set the connector <b>7C83-5524-70 (Y)</b> to <b>Receiver Base 1</b>. Continue to set the harness in jig then set the PCB end within the stopper then press by <b>Toggle clamp</b>. Continue if the sequence light on clamp location <b>1</b> was <b>ON</b>.</p><div><div><p><b>BANDO GUN POSITION ON CLAMP LOCATION 1</b></p><p><b>Fixed setting of band clamp cutter: 3 ~ 4</b></p><p><b>BANDO GUN ALIGNMENT</b></p><p>PERPENDICULARITY OK NG</p></div><p><b>Note:</b> Setting of band clamp depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div><div><p>2. Initially tighten the band clamp on location <b>1</b> using both hands.</p><p>3. Get the bando gun using right hand then cut the band clamp on location <b>1</b> using both hands. Press the <b>SW button</b> after cut. Continue if the sequence light on clamp location <b>2</b> was <b>ON</b>.</p><p>4. Get the <b>Gray tape (10mm)</b> then conduct <b>3 windings</b> of tape (spot taping) using both hands. <b>Color sensor</b> light will beep/buzz if sensor detects <b>Gray tape</b>. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard</p><p>5. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</p></div></div></div>		<div></div> <div><p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p><div><p><b>BANDO GUN ILLUSTRATION</b></p><p><b>GOOD</b> <b>NG</b></p><p><b>FLAT NOSEPIECE</b> <b>EXTENDED NOSEPIECE</b></p></div></div>	

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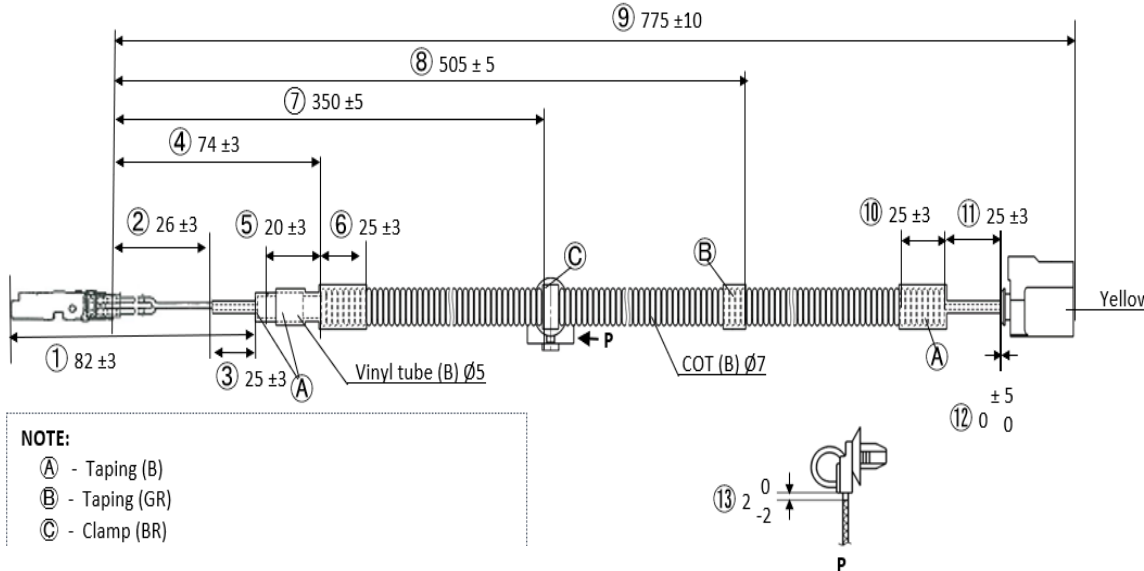
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	Measurement	<div>MEASURING TAPE</div> 		<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring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

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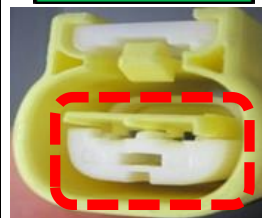
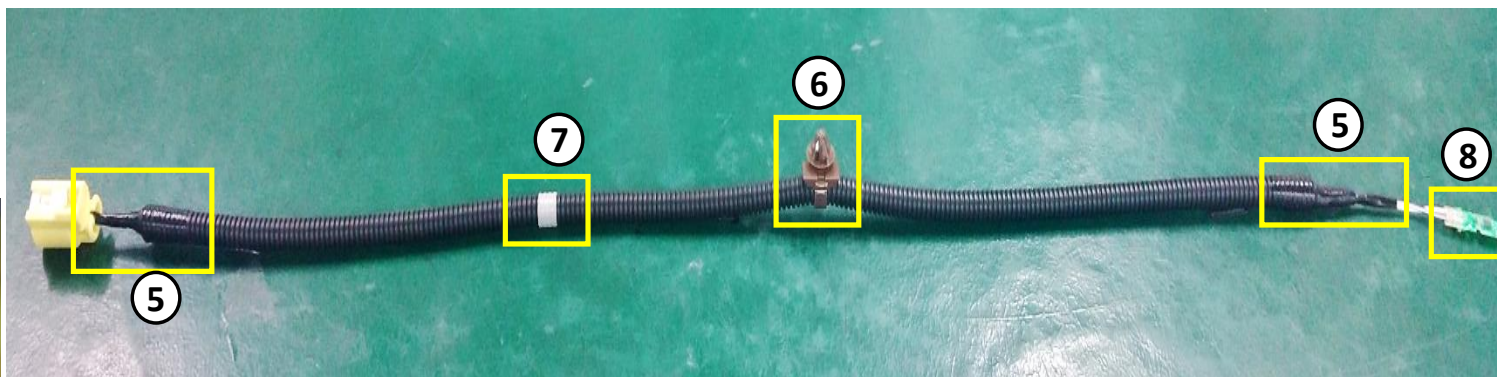
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0165-7020A****GOOD****NG****GOOD****NO GOOD****1**

No **Unlock/ Half Lock Connector**  
Check the **CONNECTOR LOCK** if properly locked.

**2**

No **Wrong Insert**

**3**

No **Terminal Backing out**

**4**

No **Missing Parts**

**5**

No **Missing tape (SV tube (Vinyl) to Wire ; COT to SV tube (Vinyl) ; COT to wire near connector**

**6**

No **Missing Clamp**

**7**

No **Missing Spot tape (Gray tape)**

**8**

No **Damaged PCB**

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