



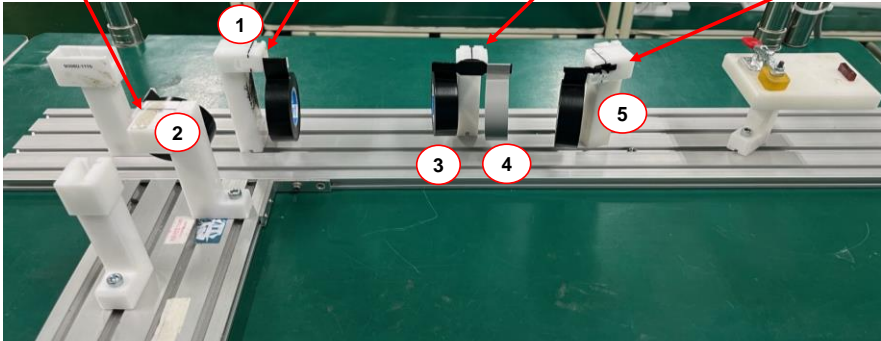
	WORK INSTRUCTION				Effectivity Date:	September 4, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 410D/412D / 7N0235-7020		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-995		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 4

PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B) 3. Clamp 82711-52090 (W) 4. Clamp 82711-3A540 (W) 5. Black tape [4pcs] 6. Gray tape				JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div>     </div>  <div> <div> 1. Get 1pc of clamp 82711-3A540 (W) using right hand then set to Clamp location 1 using both hands. 2. Get 1pc of clamp 82711-52090 (W) using right hand then set to Clamp location 1 using both hands. 3. Get 1pc of clamp 82711-48210 (B) using right hand then set to Clamp location 3 and 4 using both hands. </div> <div> 4. Get 1pc of clamp 82711-33650 (B) using right hand then set to Clamp location 5 using both hands. 5. Initially attach GRAY TAPE to location 4 using both hands. 6. Initially attach BLACK TAPE to location 1, 2, 3 and 5 using both hands. </div> </div>				

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.

Important reminders/Note/s:

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

1. No loose attachment of clamp
2. No damaged clamp
3. No missing parts

One wind for under tape



CLAMP ILLUSTRATION

GOOD
82711-52090 (W)

NG
82711-12A80 (W)

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp Assembly	<div><div>Connector receive base 1</div><div>82711-3A540 (W)</div><div>82711-52090 (W)</div><div>82711-48210 (B)</div><div>82711-33650 (B)</div><div>Connector receive base 2</div><div>Connector Setting</div><div>Stopper</div></div> <p>1. Get the assy parts using right hand then set into jig using both hands. <i>(See above picture for the correct setting)</i>. First put the connector 6189-0451 (W) into receiver base 1. Continue setting the harness in jig. Last, set the hotmelted wires (B/W-G) and terminal within the stopper jig then press by the toggle clamp.</p> <p>2. Hold the tape on the clamp location no. 1 using right hand. Make 3 windings of tape using both hands then cut the tape. Proceed to clamp location 2.</p> <p>3. Hold the tape on the clamp location no. 2 using right hand. Make 3 windings of tape using both hands then cut the tape. Proceed to clamp location 3.</p> <p>4. Hold the tape on the clamp location no. 3 using right hand. Make 3 windings of tape using both hands then cut the tape. Proceed to clamp location 4.</p> <p>5. Hold the tape on the clamp location no. 4 using right hand. Make 3 windings of tape using both hands then cut the tape.</p> <p>6. Hold the tape on the clamp location no. 5 using right hand. Make 3 windings of tape using both hands then cut the tape.</p> <p>7. After taping, conduct POINT CHECKING before removing the harness from jig</p>		<p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals 2. Make 2-3 windings for clamp taping.</p> <p>Important reminders/Notes</p> <p>1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>

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DCC Stamp

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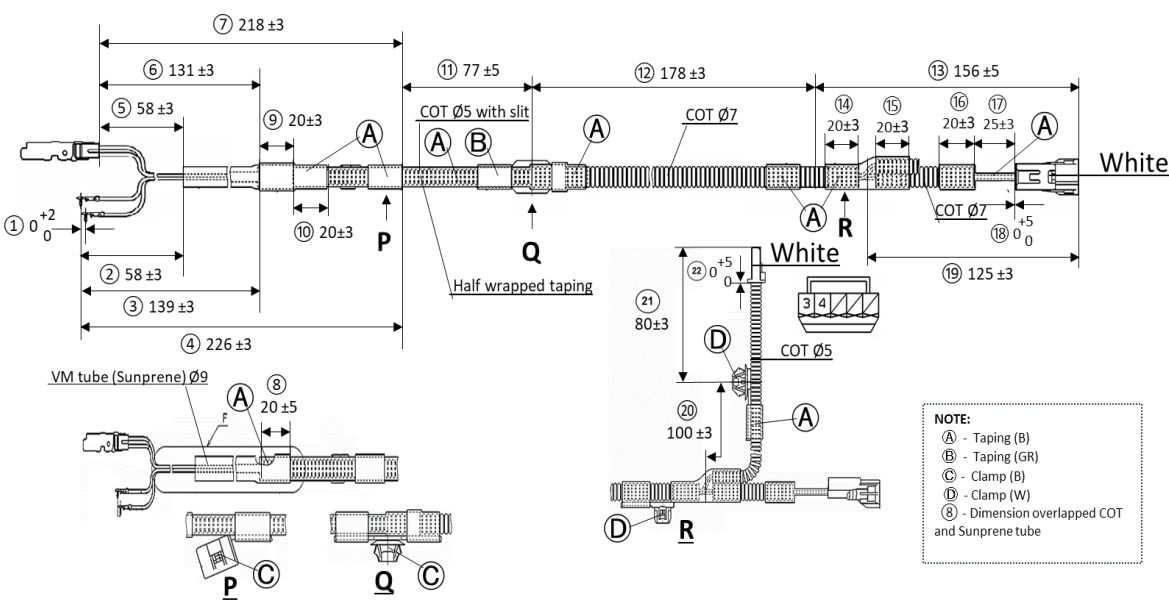
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (GR) Ⓒ - Clamp (B) Ⓓ - Clamp (W) Ⓔ - Dimension overlapped COT and Sunprene tube</div>		<p>1. No wrong dimension</p> <p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.</p>

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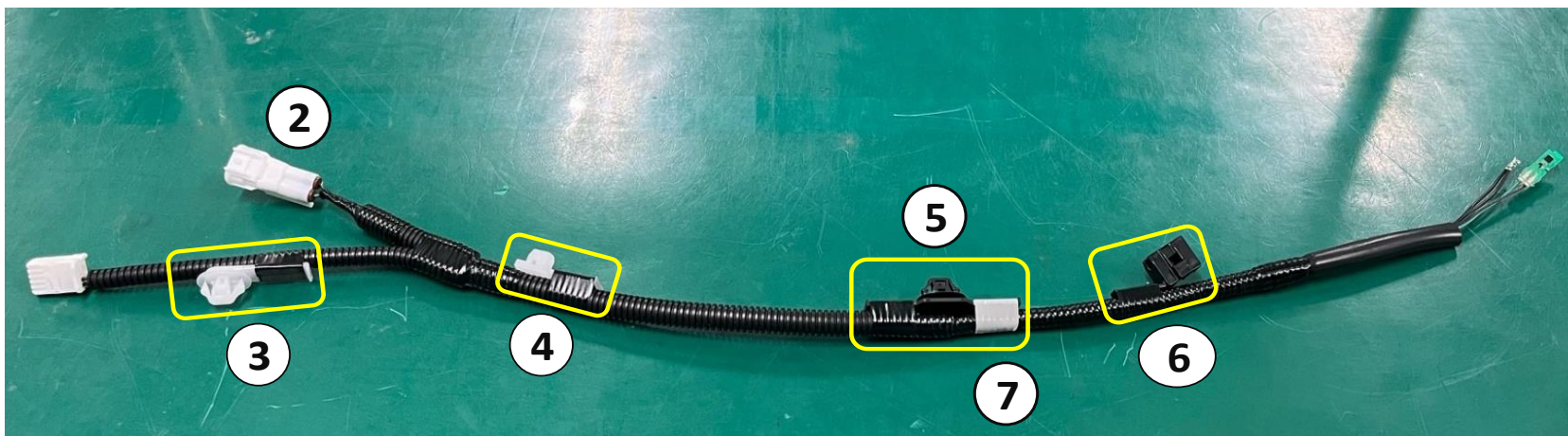
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1. Assy parts

JIG:

n/a**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP ASSY****7N0235-7020****1****GOOD****NO GOOD****1 No Unlock/Halflock Connector****2 No Deformed Terminal****3 4 5 6 No Missing Clamp****7 No Wrong use of tape (Gray tape)**

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