



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Validity Date:

-

Model code/Part number: 900B/910B / 7N0070-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

WI-ENG-PDE-679

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-33380 (B); Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Black tape [5pcs] ; Blue tape [2pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

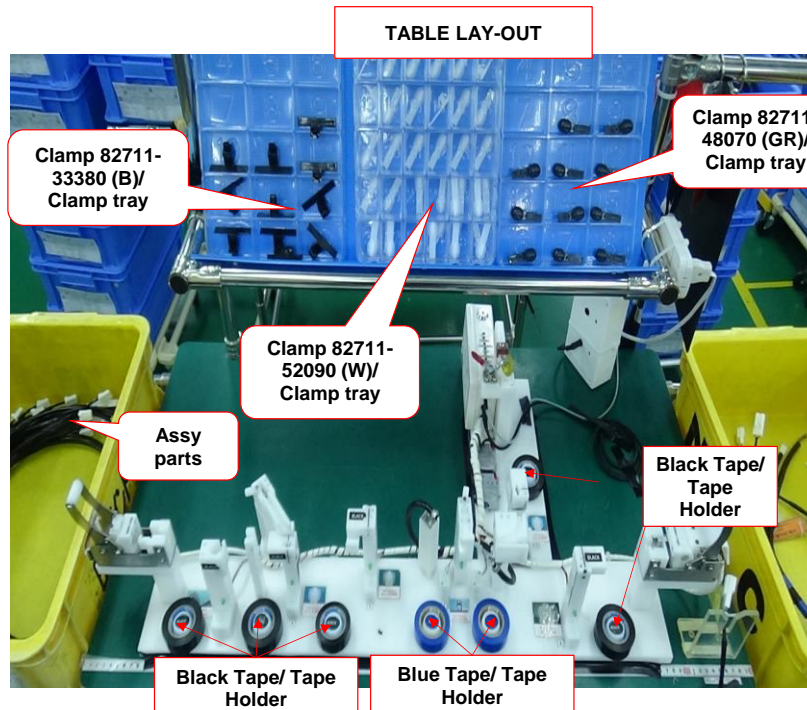
TOOLS/PPE

QUALITY POINTERS

1

Clamp
assy

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

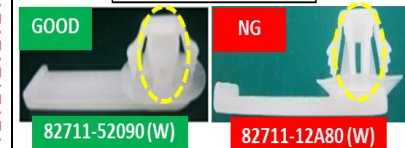
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Important reminders/Note/s:

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

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

CLAMP ILLUSTRATION



Revision History

Prepared by

Reviewed by

Approved by

Noted by

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 15, 2023
06/11/24	1	Transferred to new format. Improvement from customer feedback of detached/peel off tape, additional note for the clamp assembly location 6 and 7.	M. Ariola	C. Villanueva	A. Arañes	n/a		
08/15/23	0	Initial Issue. Excluded process from P2. Change Process name/Title from "TAPING ASSEMBLY PROCESS" to CLAMP ASSEMBLY PROCESS" due to process improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		

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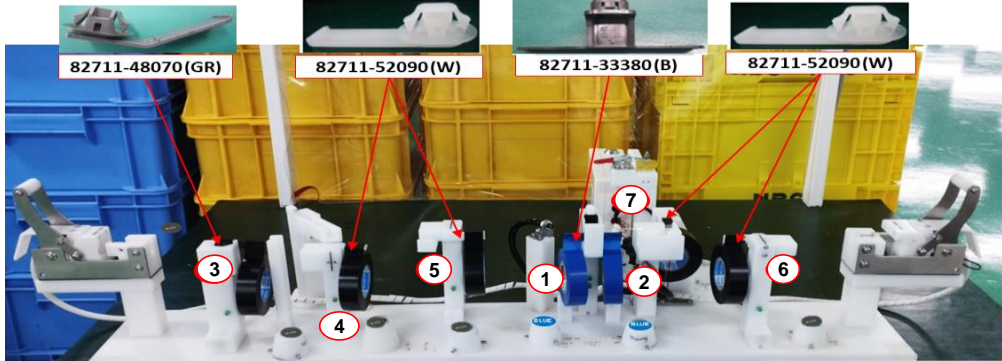


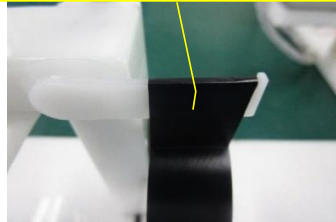


☒ MASSPRO

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PARTS:		1. Clamp 82711-52090 (W) [4pcs] 2. Clamp 82711-48070 (GR)	3. Clamp 82711-33380 (B) 4. Black tape [5pcs]	5. Blue tape [2pcs]	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	Clamp setting	<div></div> <div><p>1. Get 1pc. of clamp 82711-33380 (B) using right hand and set to clamp location 1 and 2 using both hands.</p><div><p>Guide Lock</p></div><p>2. After setting of clamp 82711-33380 (B), hold the guide lock then lock using right hand.</p><p>3. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 4 and 5 using both hands.</p><p>4. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 6 and 7 using both hands.</p><p>5. Get 1pc. of clamp 82711-48070 (GR) using right hand and set to clamp location 3 using both hands.</p><p>6. Initially attach Blue Tape to clamp location 1 and 2 using both hands.</p><p>7. Initially attach Black tape to clamp location 3,4,5, 6 and 7 using both hands.</p></div> <div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No wrong use of 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><p>One wind for under tape</p><div></div><p>CLAMP ILLUSTRATION</p><div><div><p>GOOD</p><p>82711-52090 (W)</p></div><div><p>NG</p><p>82711-12A80 (W)</p></div></div></div> <td></td>			

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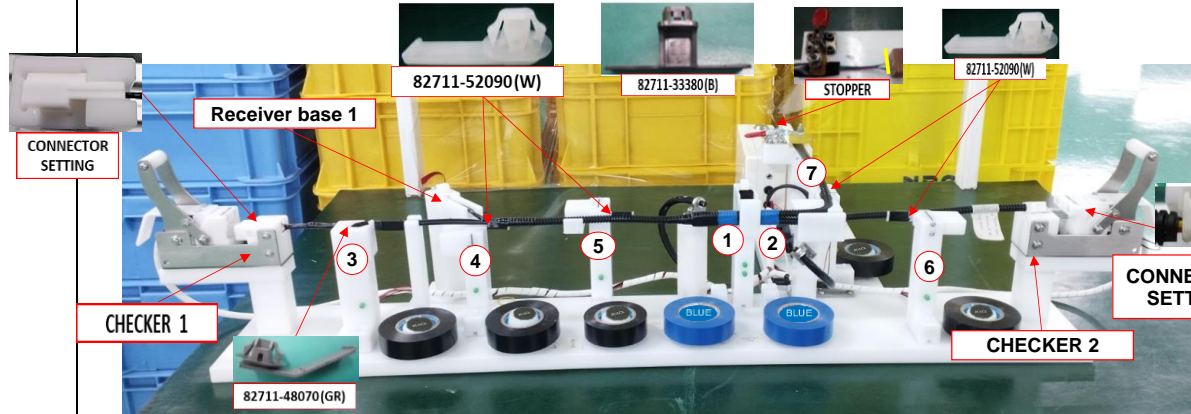

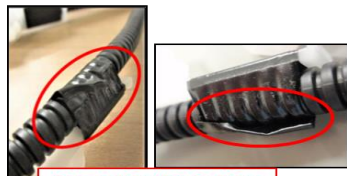
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [5pcs]	3. Blue tape [2pcs]	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly		<div></div> <div>1. Put the assy into jig. <i>(See above picture for the correct setting)</i>. First, set the connector 6098-3802 (W) to Checker 1. Second, set the next connector 6098-2220 (W) to Checker 2. Set the connector 6098-3810 (W) to receiver base 1. Continue to set the harness into jig. Last, set the B-G-V wires together within stopper then press by toggle clamp.</div> <div>2. Hold the tape on location 1, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in location 2 was ON.</div> <div>3. Hold the tape on location 2, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location 3 was ON.</div> <div>4. Hold the tape on location 3, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location 4 was ON.</div> <div>5. Hold the tape on location 4, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location 5 was ON.</div>	<div>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</div> <div>Important reminders/Note/s: 1. Make sure no gap between the terminal and stopper jig. 2. Do not apply extra force during taping and do not touch the end of tape upon tape cutting specially on clamp assembly location 6 and 7. 3. Make 2-3 windings of tape.</div> <div>Illustration for GOOD and NG clamp taping GOOD  NO GOOD  Detached Tape/Peel Off Tape</div>

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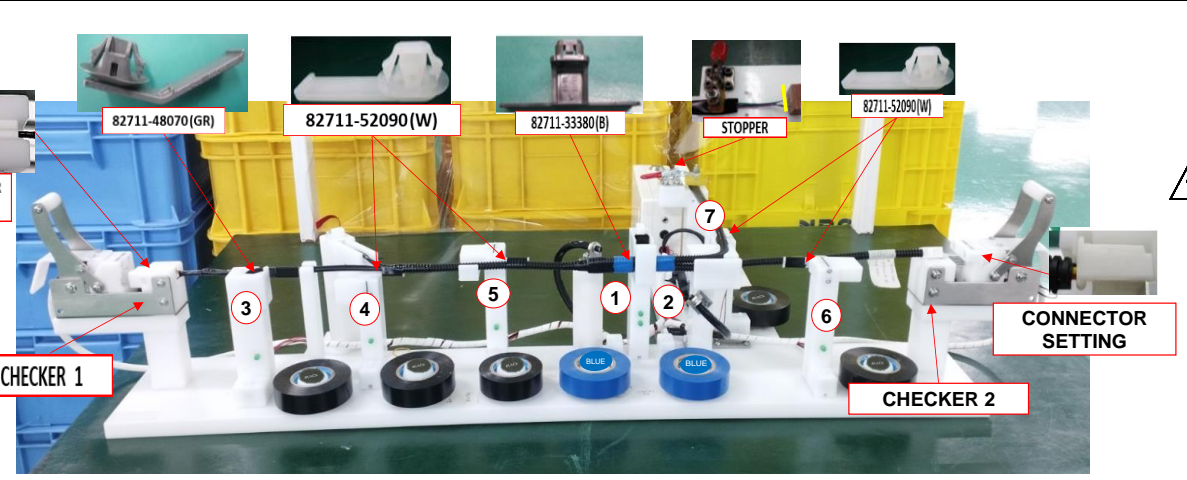


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PARTS:	1. Assy parts 2. Black tape [5pcs] 3. Blue tape [2pcs]	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
3	Clamp assy Clamp assembly (Continuation)	<div data-bbox="544 379 1727 861"></div> <div data-bbox="544 868 1727 1321"><div data-bbox="544 868 1066 1011">6. Hold the tape on clamp location 5, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in clamp location 6 was ON.</div><div data-bbox="544 1018 1066 1197">7. Hold the tape on clamp location 6, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in clamp location 7 was ON.</div><div data-bbox="1075 868 1727 1011">8. Hold the tape on clamp location 7, then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping.</div><div data-bbox="1075 1018 1727 1197">9. Conduct POINT CHECKING before removing the harness from jig.</div></div>	<div data-bbox="1491 379 2130 533"><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 data-bbox="1491 539 2130 766"><p>1 Important reminders/Note/s:</p><p>1. Make sure no gap between the terminal and stopper jig. 2. Do not apply extra force during taping and do not touch the end of tape upon tape cutting specially on clamp assembly location 6 and 7. 3. Make 2-3 windings of tape.</p></div> <div data-bbox="1491 772 2130 861"><p>Illustration for GOOD and NG clamp taping</p></div> <div data-bbox="1491 868 2130 1321"><p>GOOD</p><p>NO GOOD</p><p>Detached Tape/Peel Off Tape</p></div>

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PARTS: n/a

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

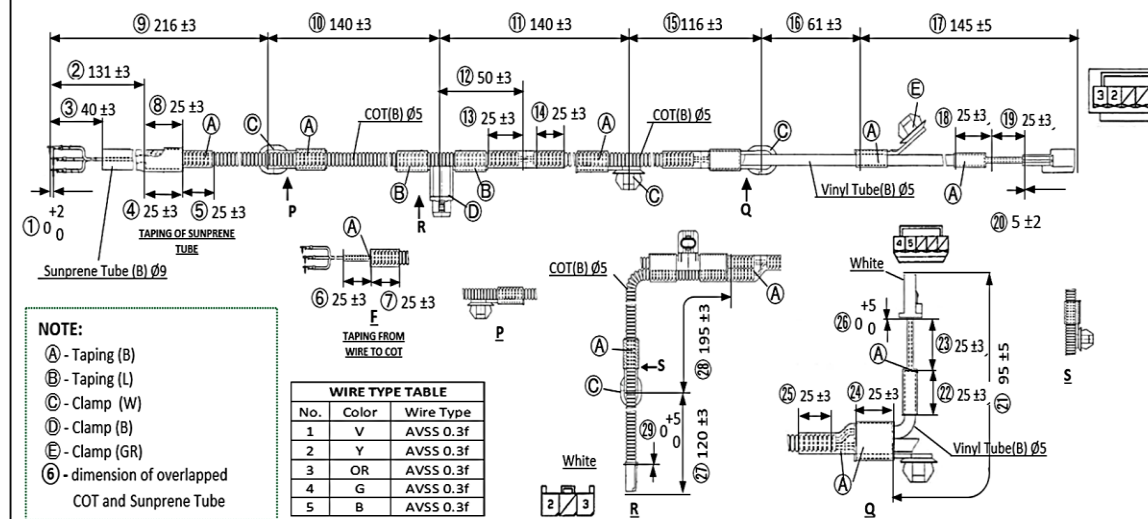
QUALITY POINTERS

4

Clamp
assy

Measurement

Illustration



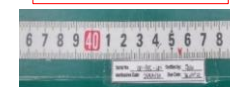
NOTE:

- A - Taping (B)
- B - Taping (L)
- C - Clamp (W)
- D - Clamp (B)
- E - Clamp (GR)
- ⑥ - dimension of overlapped COT and Sunprene Tube

WIRE TYPE TABLE

No.	Color	Wire Type
1	V	AVSS 0.3f
2	Y	AVSS 0.3f
3	OR	AVSS 0.3f
4	G	AVSS 0.3f
5	B	AVSS 0.3f

MEASURING TAPE



1. No wrong dimension.

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection

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PARTS:

n/a

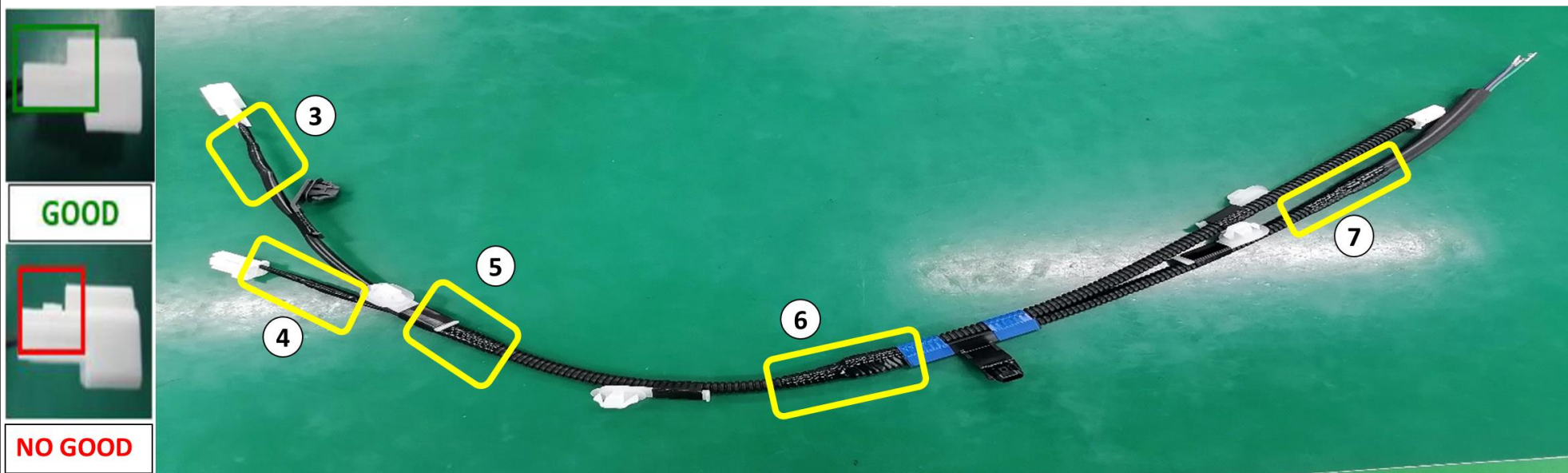
JIG:

n/a

QUALITY CHECKPOINTS

CLAMP ASSY

7N0070-7020C



1 No Wrong facing of clamp

2 No Unlock/Halflock

3 4 5 6 7 No Missing Tape (Black tape)

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