



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 04, 2024

Model code/Part number:

922B / 7L0124-7022

Customer:

TRQSS

Car Model:

LEXUS NX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-943

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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## PARTS:

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

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

CLAMP  
ASSY

Table Lay-out

## TABLE LAY-OUT

Clamp tray/ Clamp  
82711-52090 (W)Clamp tray/ Clamp  
82711-48070 (GR)

Clamp Assembly jig

Locking jig

Black tape/ Tape holder

**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-266A-D** 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
07/04/24	0	Initial issue. Separate Clamp assembly from Taping assembly process. Integrate connector lock process to assembly jig.	D.Castillo	C.Villanueva	A. Arañes	n/a	D.Castillo	C.Villanueva	A. Arañes	n/a

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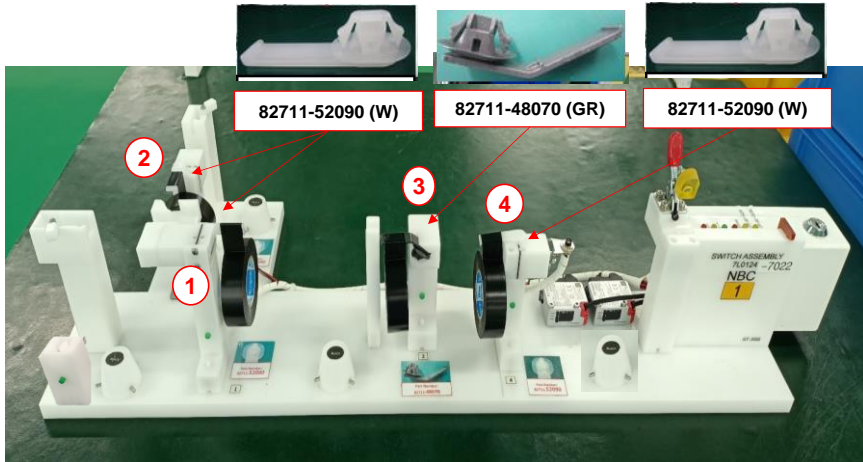



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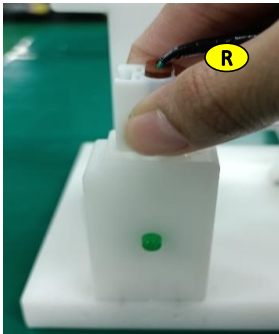
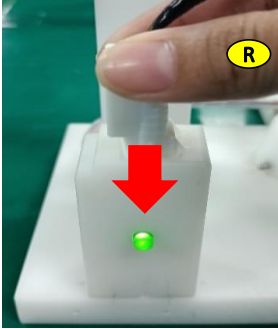
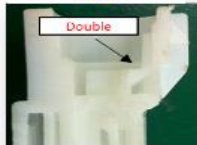
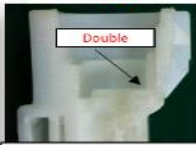
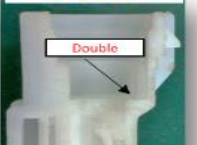


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PARTS:		1. Clamp 82711-48070 (GR) 2. Clamp 82711-52090 [3pcs]		3. Black tape [4pcs]	JIG:	1. Clamp asssembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	CLAMP ASSY	Clamp Setting	<div></div> <div>1. Get <b>3pcs</b> of clamp <b>82711-52090 (W)</b> using right hand then set to clamp <b>location 1, 2 and 4</b> using both hands.</div> <div>2. Get <b>1pc</b> of clamp <b>82711-48070 (GR)</b> using right hand then set to clamp <b>location 3</b> using both hands.</div> <div>3. Initially attach <b>Black tape</b> to clamp location <b>1, 2, 3 and 4</b> using both hands.</div>			n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</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>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-52090 (W)</div></div> <div><div>NG</div><div>82711-12A80 (W)</div></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 7

PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
3	CLAMP ASSY	<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><p>Coupler Cross Sectional View</p><div><div>NG</div><p>Double</p><p>Unlock Condition</p></div><div><div>NG</div><p>Double</p><p>Half Lock Condition</p></div><div><div>GOOD</div><p>Double</p><p>Full Lock Condition</p></div></div> <div><p>Before lock</p><p>After lock</p></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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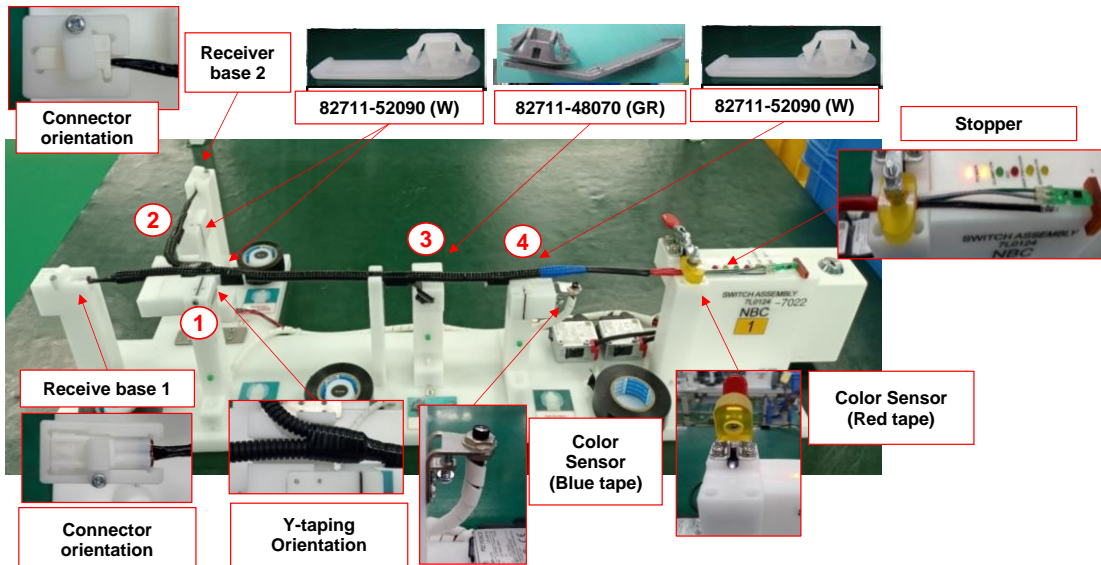

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PARTS:	1. Assy parts		JIG:	1. Clamp Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Clamp Assembly	<div></div> <div>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6189-0407 (W) to Receiver base 1 then lock. 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 1 will beep/buzz if sensor detects Blue tape. Color sensor 2 will beep/buzz if sensor detects Red tape. Last, set the hotmelted wires and terminal end together within the stopper then press by Toggle clamp.</div> <div>2. Check if all LED light for Power On, Clamp On, Wire1 &amp; Wire2, Color sensor 1 and Color sensor 2 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.</div> <div>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.</div>		<div></div> <div>Important reminders/Note/s:</div> <div>1. Make sure no gap between stopper jig and PCB</div> <div>2. Make 2-3 windings for clamp taping</div> <div>1. No damaged clamp</div> <div>2. No wrong usage of parts</div> <div>3. No missing clamp</div> <div>4. No missing tape</div>

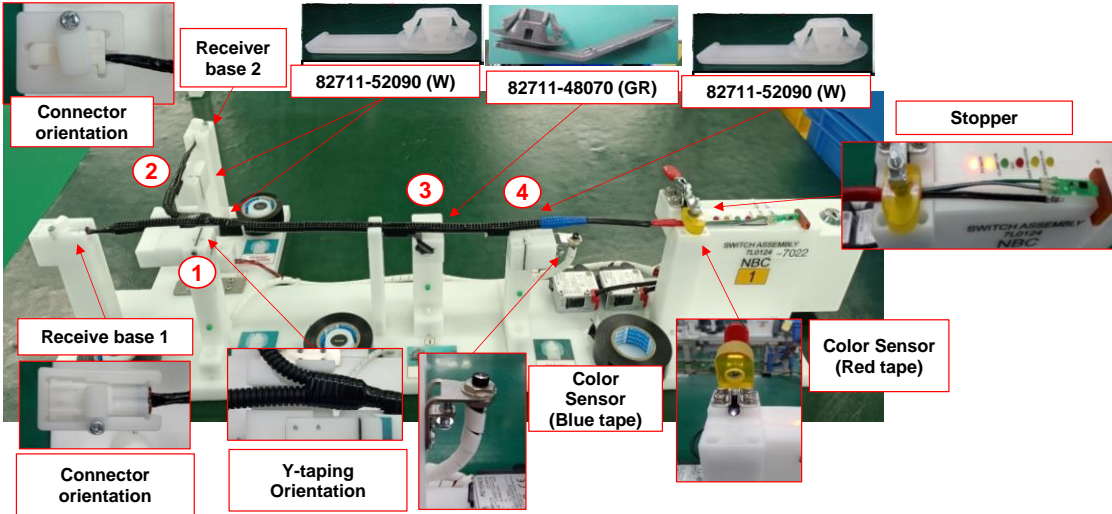

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:

<b>PARTS:</b>		1. Assy parts		JIG:	1. Clamp Assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
4	CLAMP ASSY	<div>Clamp Assembly (Continuation)</div> <div></div> <div>4. Hold the tape on clamp <b>location 2</b>. Make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light in clamp <b>location 3</b> was <b>ON</b>.</div> <div>5. Hold the tape on clamp <b>location 3</b>. Make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. Continue the process if sequence light in clamp <b>location 4</b> was <b>ON</b>.</div> <div>6. Hold the tape on clamp <b>location 4</b>. Make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. <b>GO</b> sound will be heard.</div> <div>7. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</div> <div>8. For removal of harness from jig. First, remove the connector to Receiver base 1 and 2. Then, release the wire to toggle clamp. Last, remove the harness to Y-taping guide.</div>		<div></div> <div><b>Important reminders/Note/s:</b></div> <div>1. <b>Make sure no gap between stopper jig and PCB</b></div> <div>2. <b>Make 2-3 windings for clamp taping</b></div> <div>1. No damaged clamp</div> <div>2. No wrong usage of parts</div> <div>3. No missing clamp</div> <div>4. No missing tape</div>		

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**PARTS:**

1. All parts (Assy parts; Clamp 82711-52090(W); Clamp 82711-48070(GR); Black tape)

JIG:

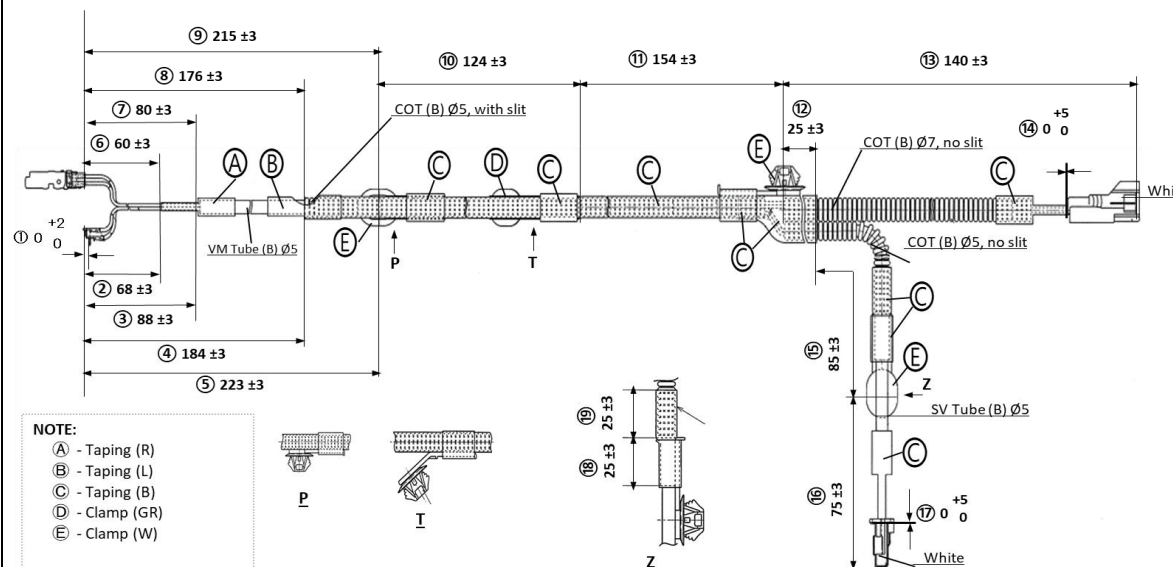
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**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

CLAMP  
ASSY

Measurement



1. No wrong dimension

**Important reminders and 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:

1. Assy parts

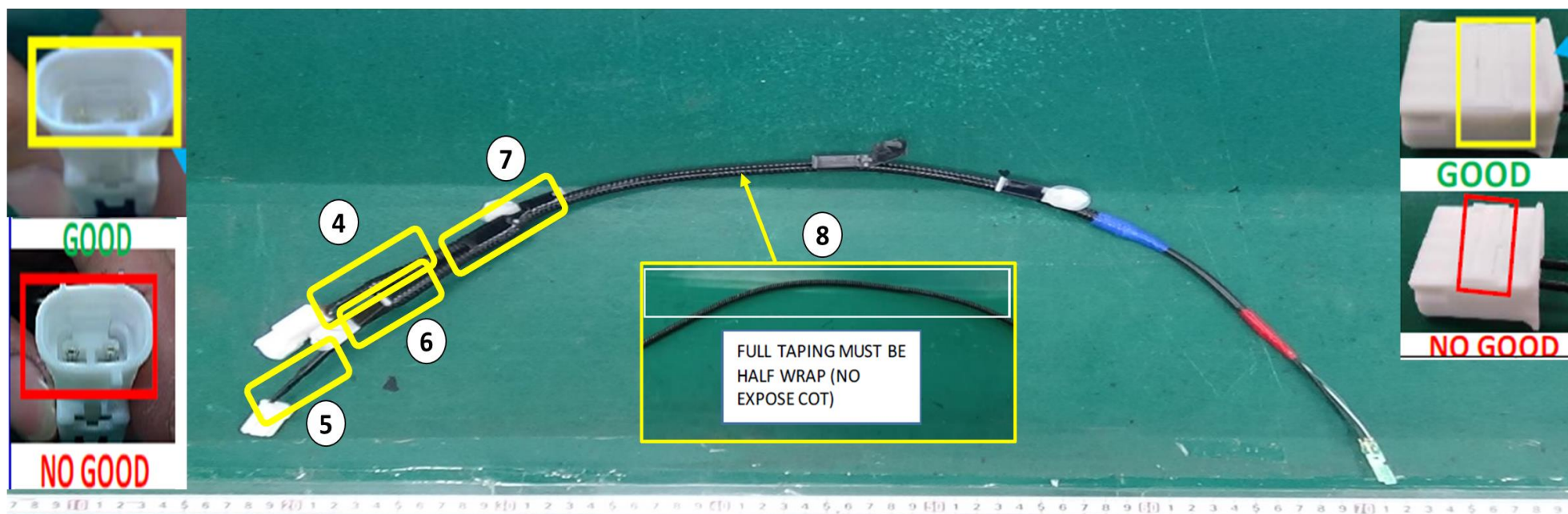
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7L0124-7022



① No Wrong facing of clamp

② ③ No Unlock/Halflock connector

④ ⑤ ⑥ ⑦ ⑧ No Missing Tape (Black tape)

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