



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

December 21, 2023

Model code/Part number:

220D / 7R0127 - 7022

Customer:

TRMX

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-762

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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PARTS:

1. All parts: Assy parts; Clamp 82711-16830 (B)

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 82711-16830 (B)/
Clamp Box

Assy parts

Clamp
assembly jig

Bando gun

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.

BANDO GUN



Document references:

1. Refer to WI-ENG-PDE-596 7R0127-7022 - Taping Assembly Process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

12/21/23

0

Initial issue. Transfer Clamp setting to Measurement process from Taping assembly process (WI-ENG-PDE-596) due to process improvement.

D. Castillo

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

December 21, 2023

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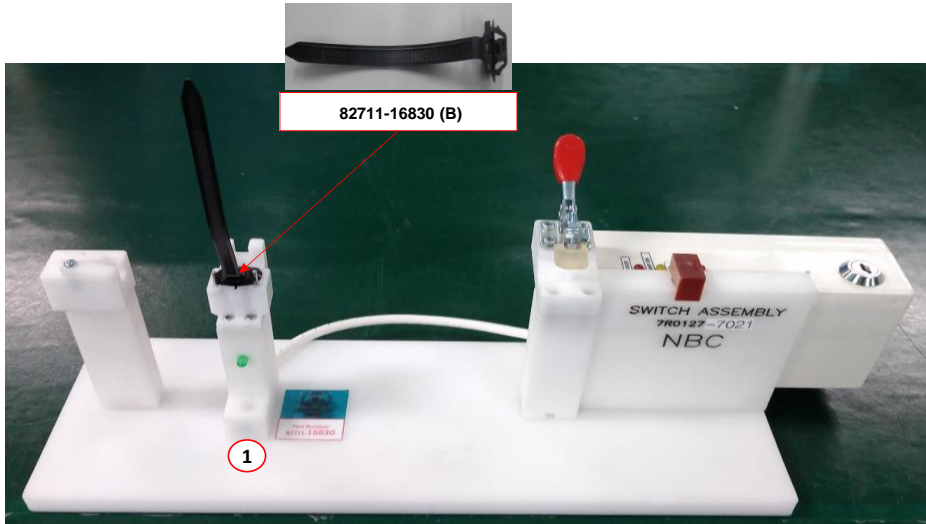


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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| | | | | |
|--------|---------------------------------|--|-----------|-----------------------|
| PARTS: | 1. Clamp 82711-16830 (B) [1pc.] | | JIG: | 1. Clamp Assembly Jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 2 | Clamp Assy | <div>Clamp Setting</div> <div><div>1. Get 1pc. of band clamp 82711-16830 (B) then set to clamp location 1 using both hands.</div></div> <div>n/a</div> <div><div>Important reminders/Note/s:</div><div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div><div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div><div>82711-16830 (B)</div></div><div>NG</div><div><div>82711-34490 (B)</div></div></div></div></div> | | |

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PARTS:

1. Assy parts ; Clamp 82711-16830 (B) [1pc.]

JIG:

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

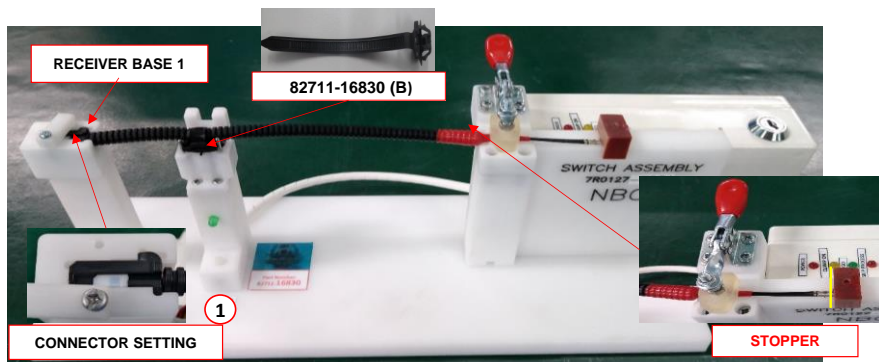
TOOLS/PPE

QUALITY POINTERS

3

Clamp Assy

Clamp Assembly



1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector **6098-6663 (B)** in **Receiver base 1** then lock. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of location ① was **ON**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

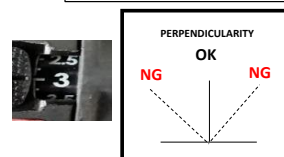
2. Initially tighten the band clamp on location **1** using both hands.

3. Get the bando gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cut. **Go** sound will be heard.

Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: $\phi 5$ - 1~2, $\phi 7$ - 3~4

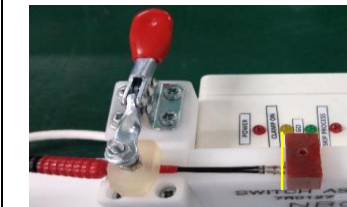


BANDO GUN ALIGNMENT



4. Conduct **POINT CHECKING** before removing the harness from jig.

BANDO GUN

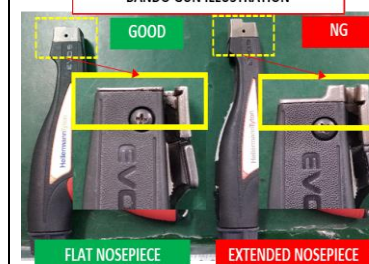


Important reminders/Note/s:

1. Make sure no gap between stopper and terminals.

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

BANDO GUN ILLUSTRATION



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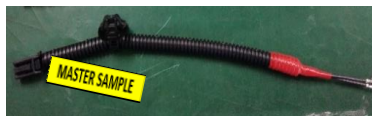
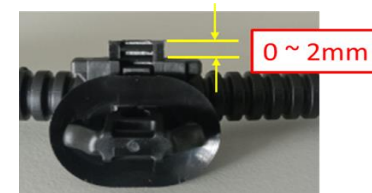
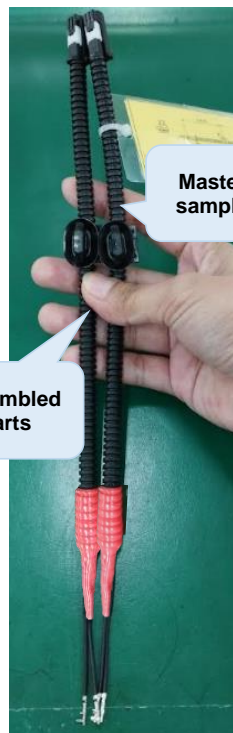
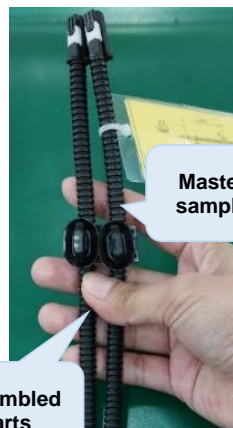

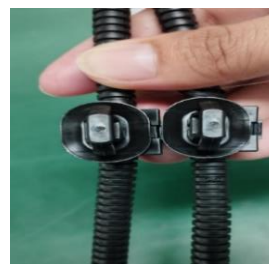
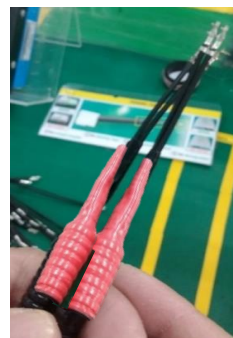
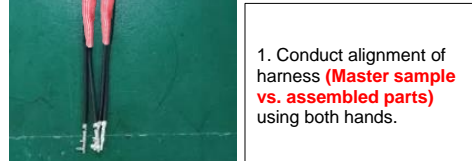
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|---|--------------|-------------------------------|---|-----------|---|
| PARTS: | | 1. Assy parts ; Master Sample | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Clamp Assy | Visual / By two's Inspection |  <div>ACTUAL PRODUCT</div> | |  <div>MASTER SAMPLE</div> <div>1. No skip process</div> <div><div>0 ~ 2mm</div><div>Important reminders/Note/s: 1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div></div> |
| | | |  <div>Assembled parts</div> | | |
| | | |  <div>Master sample</div> | | |
| | | |  <div>2. Check the connector lock condition and insertion.</div> | | |
| | | |  <div>3. Check the presence of clamp attachment.</div> | | |
|  <div>4. Check the taping condition and terminal appearance. Must be no deformed terminal.</div> | | | | | |
|  <div>1. Conduct alignment of harness (Master sample vs. assembled parts) using both hands.</div> | | | | | |

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PARTS:

Assy Parts

JIG:

n/a

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

5

Clamp
Assy

Measurement

**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

1.No wrong dimension

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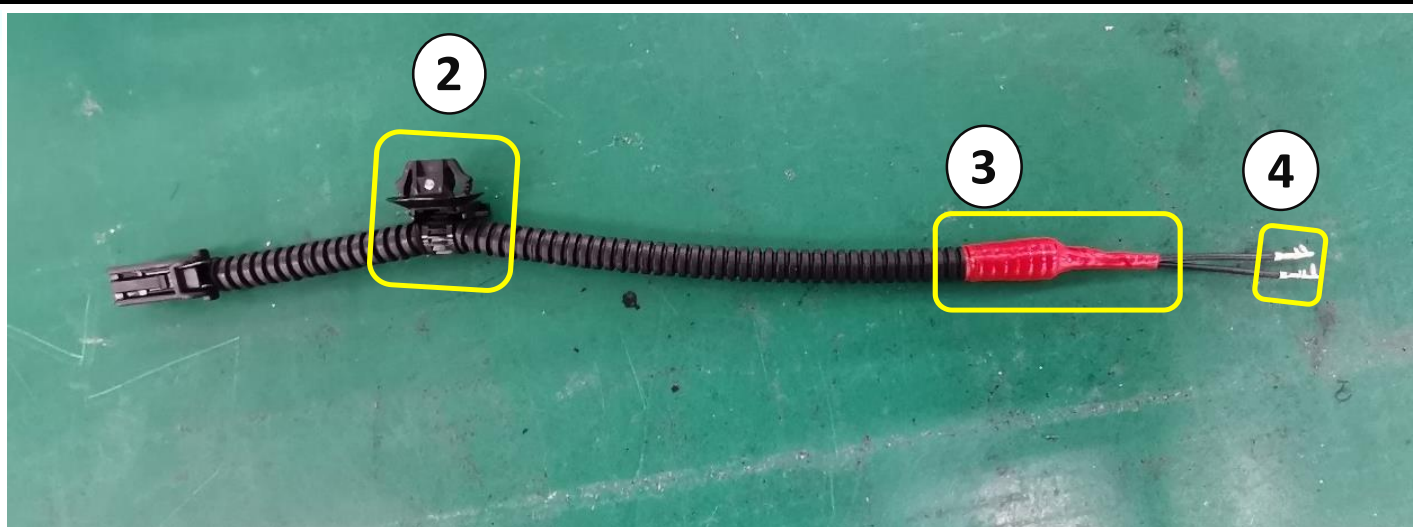
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PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS**P1****7R0127-7022****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/**
Halflock Connector**2** No **Missing band**
clamp**3** No **Missing Tape****5** No **Terminal Backing**
Out**4** No **Deformed**
Terminal

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