



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

November 4, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

930B / 7N0202-7020B

Customer: TRJ

Car Model: TOYOTA 4RUNNER

Document No.:

WI-ENG-PDE-1150

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts

2. Clamp 82711-33650 (B)

3. Clamp 82711-48210 (B)

4. Clamp 82711-52090 (W)

5. Brown tape

6. Black tape [3 pcs.]

JIG:

1. Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

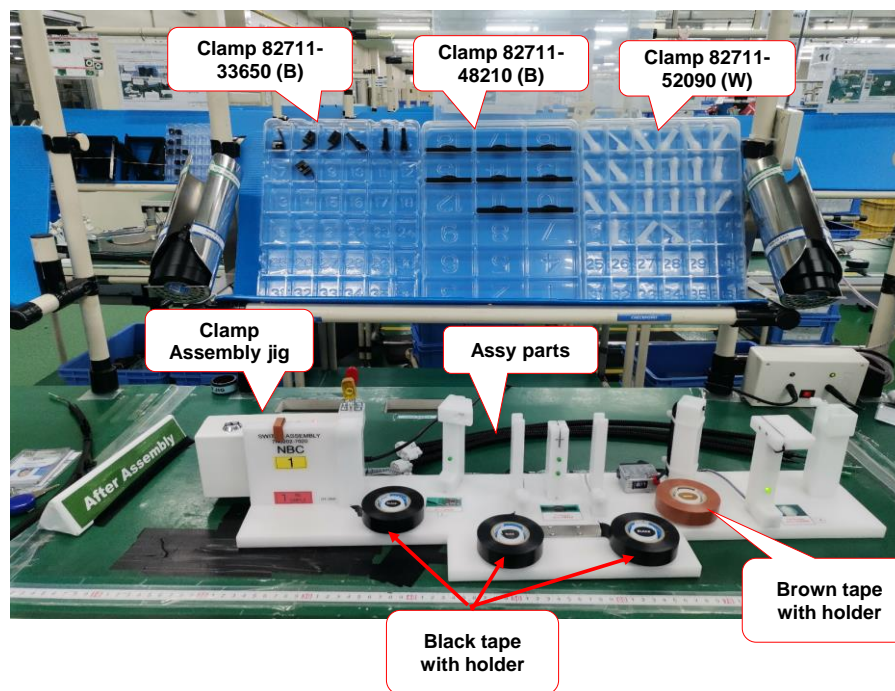
TOOLS/PPE

QUALITY POINTERS

1

Clamp
Assy

TABLE LAY-OUT

**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.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/04/24	1	Change pre-lunch to mass pro.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C.Villanueva	A. Arañes	n/a
10/29/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C.Villanueva	A. Arañes	n/a

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PARTS:		1. Assy parts 2. Clamp 82711-33650 (B) 3. Clamp 82711-48210 (B) 4. Clamp 82711-52090 (W) 5. Brown tape 6. Black tape [3 pcs.]		JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Clamp Setting	<div><div> 82711-33650 (B)</div><div> 82711-48210 (B)</div><div> 82711-52090 (W)</div><div> 1. Get 1pc of clamp 82711-33650 (B) using right hand then set to Clamp location no. 4 using both hands. 2. Get 1pc of clamp 82711-48210 (B) using right hand then set to Clamp location no. 2 and 3 using both hands. 3. Get 1pc of clamp 82711- 52090 (W) using right hand then set to Clamp location no. 1 using both hands. 4. Initially attach BROWN TAPE to location 4 using both hands. 5. Initially attach BLACK TAPE to location 1,2, and 3 using both hands.</div><div><div>STANDARD TAPING FOR CLAMP</div><div>One side tape under clamp</div><div></div></div></div>			<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> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-48210 (B)</div></div><div><div>NG</div><div> 82711-3F290 (B)</div></div></div>

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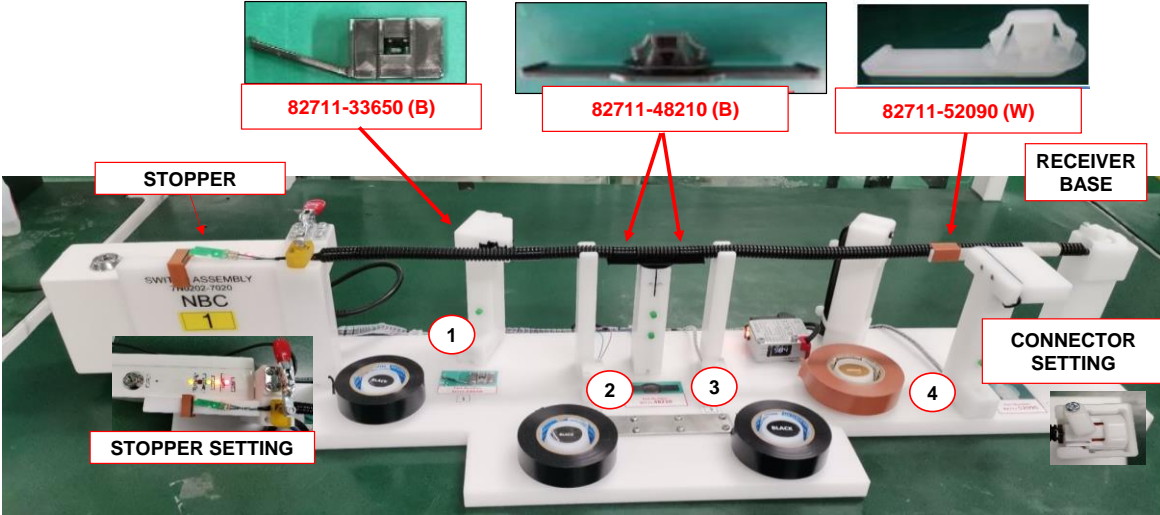

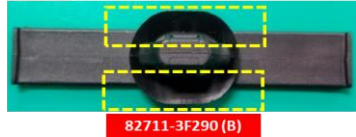
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly	<div></div>	<div><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></div> <div><p>CLAMP ILLUSTRATION</p><div><p>GOOD</p><p>82711-48210 (B)</p></div><div><p>NG</p><p>82711-3F290 (B)</p></div></div>
		<div><p>1. Get the assy part and set to jig.(See above picture for the correct setting). First, set the connector 6189-0451 (W) to Receiver base and lock. Continue to set the harness in jig. Last, set B/W-G wires with PCB end together within stopper then press by toggle clamp.</p></div>	<div><p>4. Hold the tape on clamp location 2 and 3, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue if sequence on clamp location 4 was ON.</p></div>	
		<div><p>2. Check if LED light for POWER ON and CLAMP ON was ON. Check also the clamp location 1 sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader, WAIT for further instruction then continue the process.</p></div>	<div><p>5. 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. Go sound will be heard.</p></div>	
		<div><p>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 if sequence on clamp location 2 was ON.</p></div>	<div><p>6. Conduct POINT CHECKING before removing the harness from jig.</p></div>	

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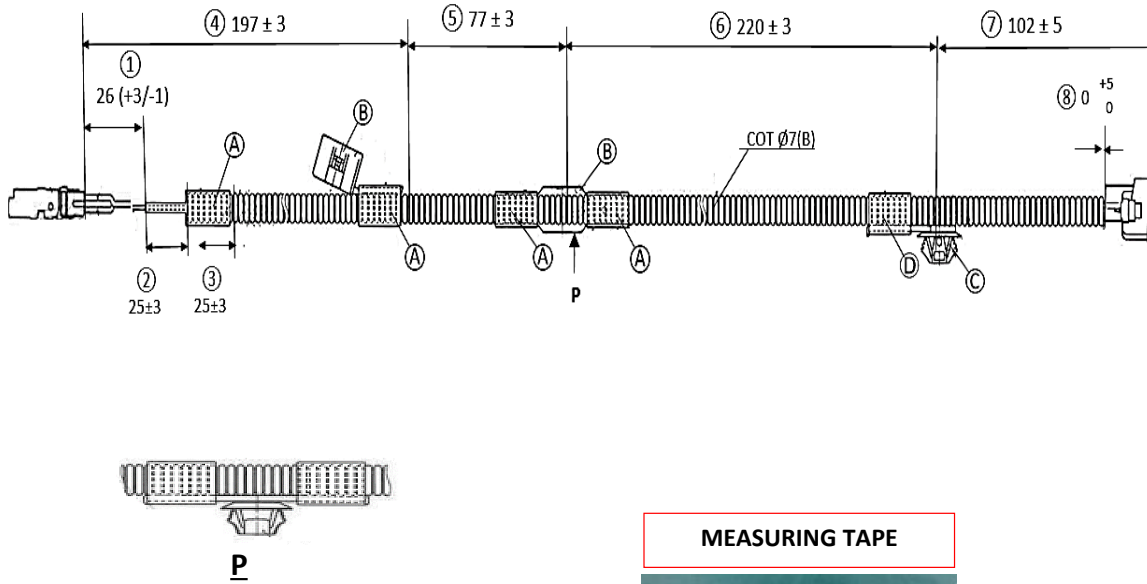

☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement			MEASURING TAPE 	1. No wrong dimension Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsumono, Nakamono, and Owarimono Inspection.

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n/a

JIG:

n/a

QUALITY CHECKPOINTS**CLAMP ASSY****7N0202-7020B**

1 **No Check the Clamp Alignment**

2 **No Wrong used of Tape (BROWN) Clamp Taping**

3 **No Missing Tape**

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