

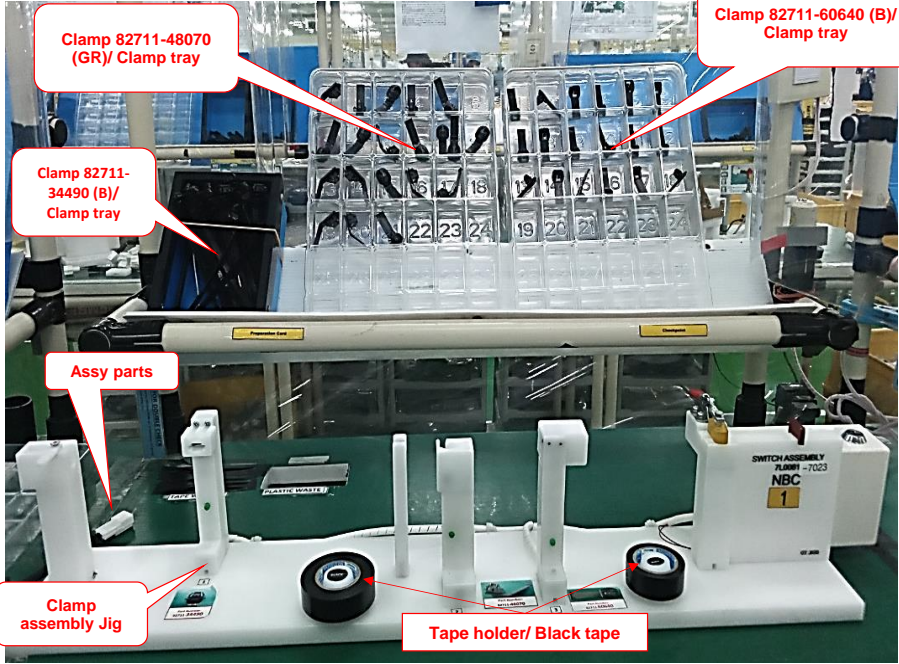





WORK INSTRUCTION
CLAMP ASSEMBLY PROCESS

Effectivity Date:	July 18, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-904		
Revision No.:	0	Page No.:	1 of 6

Process Name/Title:	CLAMP ASSEMBLY PROCESS		
Model code/Part number:	550B / 7L0081-7023	Customer:	TRQSS
Car Model:	TOYOTA-HIGHLANDER		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1.All Parts; Assy parts; Clamp 82711-34490 (B); Clamp 82711-48070 (GR); Clamp 82711-60640 (B); Black tape [2pcs.]	JIG:	1. Clamp Assembly jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy Table Lay-out		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
								 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
07/18/24	0	Initial Issue. Transfer Clamp process from taping assembly process to Clamp Assembly Process.			A.Hernandez	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 18, 2024

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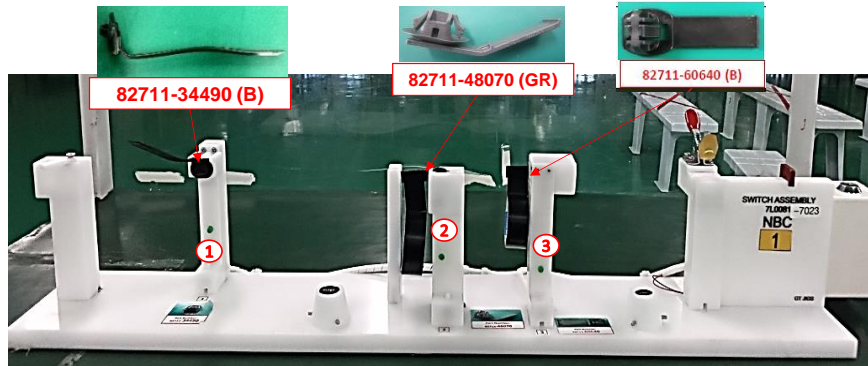

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PARTS:		1. Clamp 82711-34490 (B) 2. Clamp 82711-48070 (GR)	3. Clamp 82711-60640 (B) 4. Black tape [2pcs.]	JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div></div> <div>1. Get 1 pc. Band clamp 82711-34490 (B) using right hand then set to clamp location 1 using both hands.</div> <div>2. Get 1 pc clamp 82711-48070 (GR) using right hand and set to clamp location 2 using both hands.</div> <div>3. Get 1 pc clamp 82711-60640 (B) using right hand and set to clamp location 3 using both hands.</div> <div>4. Initially attach Black tape to clamp location 2 and 3.</div> <div>Note: Please check the clamp first before start of assembly to avoid wrong use of clamp.</div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div></div> <div>1. No loose attachment of clamp 2. No wrong use of clamp 3. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Must be no gap between terminal and stopper jig. 2. Make 2-3 windings for clamp taping.</div>

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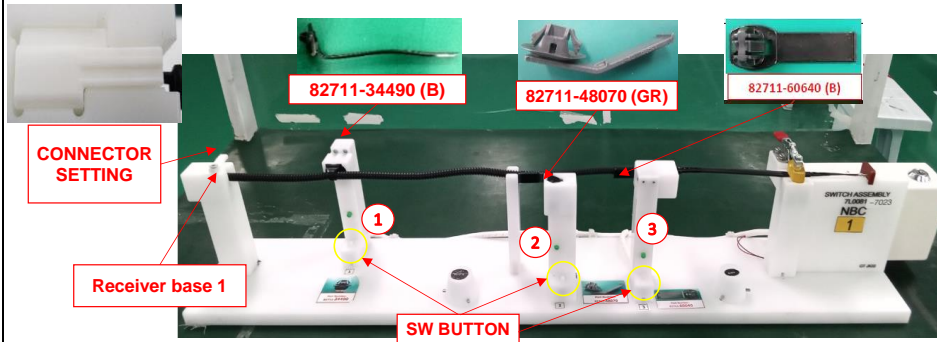


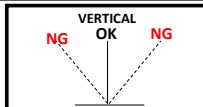


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PARTS:		1. Assy parts		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div></div><div><div>1. Get the assy parts and then put into jig. (See above picture for correct setting). First, set the connector 6098-3802 (W) to Receiver base 1. Continue to set the harness in jig. Last, set the B/B wires together within the stopper jig and then press by toggle clamp. Continue the process if sequence light in location 1 was ON.</div><div>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div><div><div>3. Initially tighten the band clamp on clamp location 1 using right hand.</div><div>4. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after cut. Continue if the sequence light on location 2 was ON.</div><div><div></div><div></div></div><div><div>BANDO GUN ALIGNMENT</div><div></div></div><div><div>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.</div><div>For: ø5 - 1~2, ø7 - 3~4</div></div></div></div><div><div></div><div>1. No missing tape</div><div>2. No damaged clamp</div><div>3. No missing clamp</div><div>4. No loose/tight clamp</div><div>5. No wrong attachment of clamp</div><div>6. No wrong use of clamp</div></div></div>		<div></div> <div>Make sure no gap between terminal and stopper jig.</div>	

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PARTS:		1. Assy parts 2. Black Tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Clamp Assembly (Continuation)	<div></div> <div>5. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape. Press the SW button after every taping. Continue the process on clamp location 2.</div> <div>6. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape. Press the SW button after taping. Go sound will be heard.</div> <div>7. Conduct POINT CHECKING before removing the harness from jig.</div>		<div></div> <div>Bando Gun</div>	<div></div> <div>Make sure no gap between terminal and stopper jig.</div> <div>1. No missing tape 2. No damaged clamp 3. No missing clamp 4. No loose/tight clamp 5. No wrong attachment of clamp 6. No wrong use of clamp</div>

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PARTS:		n/a		JIG:	n/a											
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS											
5	Clamp Assy	<div><div>MEASURING TAPE</div></div> <div>NOTE: Ⓐ - Taping (B) Ⓑ - Clamp (GR) Ⓒ - Clamp (B)</div> <table><tr><th colspan="3">WIRE TYPE TABLE</th></tr><tr><th></th><th>Color</th><th>Wire type</th></tr><tr><td>1</td><td>B</td><td>AVSS 0.3f</td></tr><tr><td>2</td><td>B</td><td>AVSS 0.3f</td></tr></table>		WIRE TYPE TABLE				Color	Wire type	1	B	AVSS 0.3f	2	B	AVSS 0.3f	<div>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.</div> <div>1. No wrong dimension</div>
WIRE TYPE TABLE																
	Color	Wire type														
1	B	AVSS 0.3f														
2	B	AVSS 0.3f														

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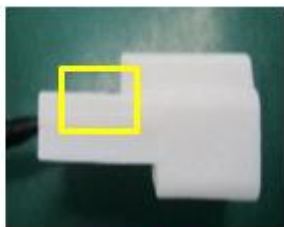
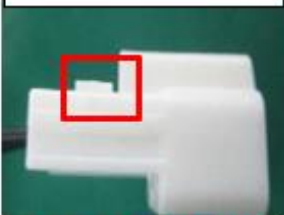
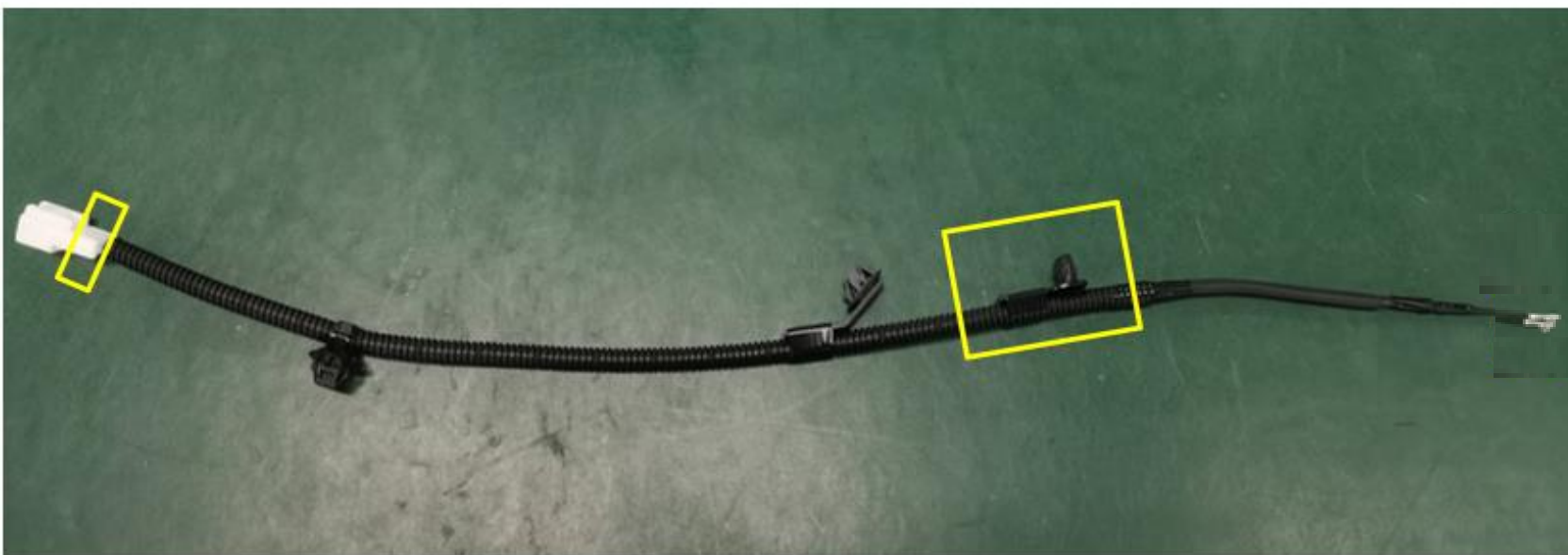
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP
ASSY****7L0081-7023****GOOD****NO GOOD****① No UNLOCKED/HALF LOCKED CONNECTOR****③ ④ No Missing Clamp****② No Missing Band Clamp****⑤ No Deformed Terminal**

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