



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 12, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

780B / 7R0106-7022B

Customer:

TRMX

Car Model:

TOYOTA TUNDR

Document No.:

WI-ENG-PDE-1105

Purpose:



PROTOTYPE



PRE-LAUNCH



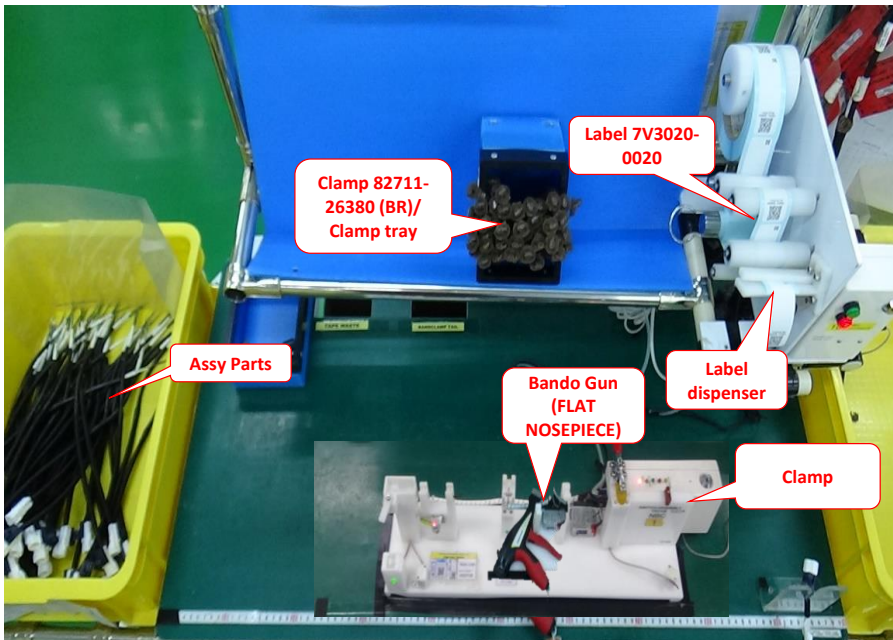

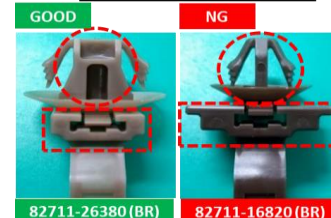
MASSPRO

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1

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PARTS:		1. Assy parts; Clamp 82711-26380 (BR); Label 7V3020-0020				JIG:		1. Label dispenser 2. Clamp Assembly Jig						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS						
1	Clamp assy	<div>Table Lay-out</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <div>BANDO GUN</div> 		<div>BAND CLAMP ILLUSTRATION</div>  <div>1. No missing parts/tools 2. No excess parts/tools</div>						
Revision History						Prepared by		Reviewed by		Approved by		Noted by		
10/12/24	1	Change Pre launch to mass pro.				A.Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez		C. Villanueva	A. Arañes	n/a
10/11/24	0	Initial issue.				A.Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez		C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		October 11, 2024		

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2 of 8**PARTS:**

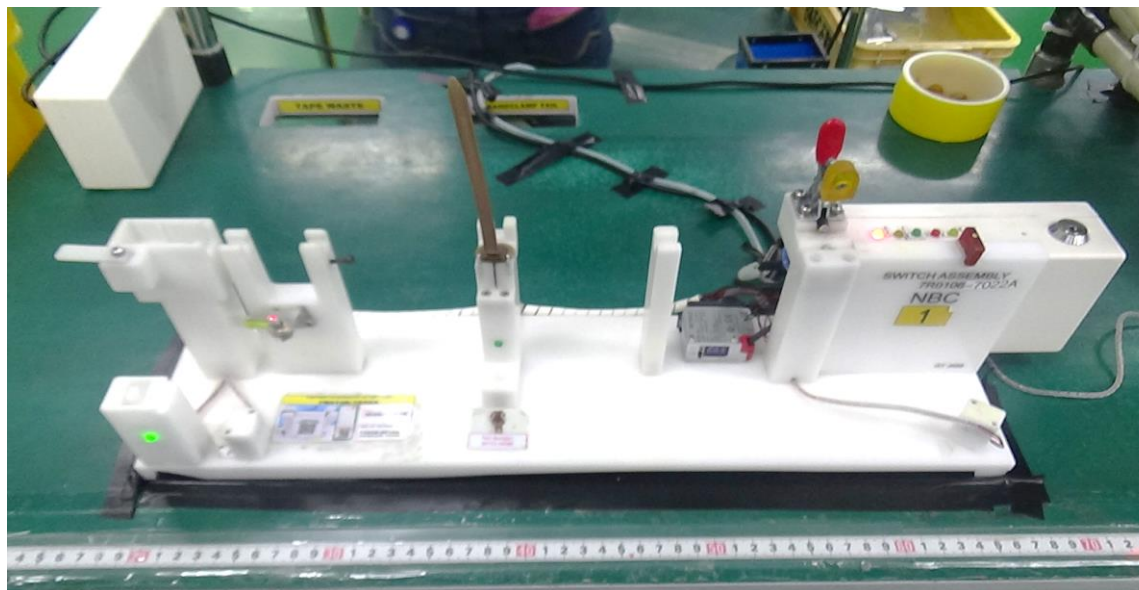
JIG:

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

2

Clamp
assy

Clamp setting



Get 1pc of Band clamp 82711-26380 (BR) using right hand and set to clamp location 1.

1. No wrong use of clamp
2. No damaged clamp

Important reminders/Note/s:

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

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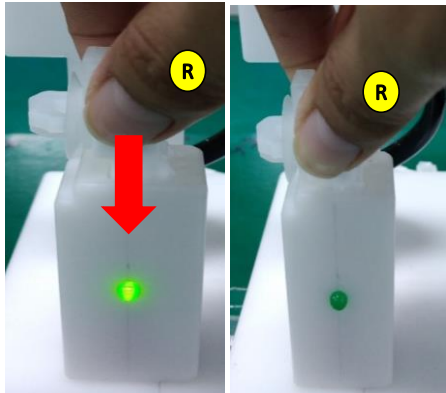
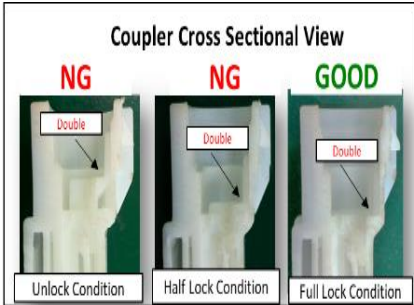
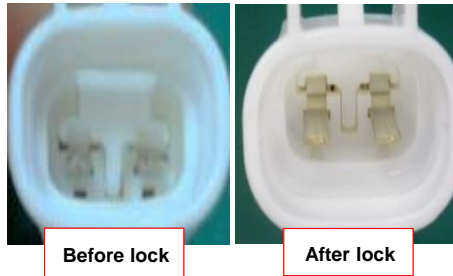


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PARTS:		1. Clamp 82711-3A640 (B) 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	<div><div></div><div>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</div></div> <div><div></div><div></div></div> <td><div>LOCKING JIG</div></td> <td><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div><div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div></td>		<div>LOCKING JIG</div> 	<div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div>

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PARTS:

1. Assy parts
2. Clamp 82711-26380 (BR)

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

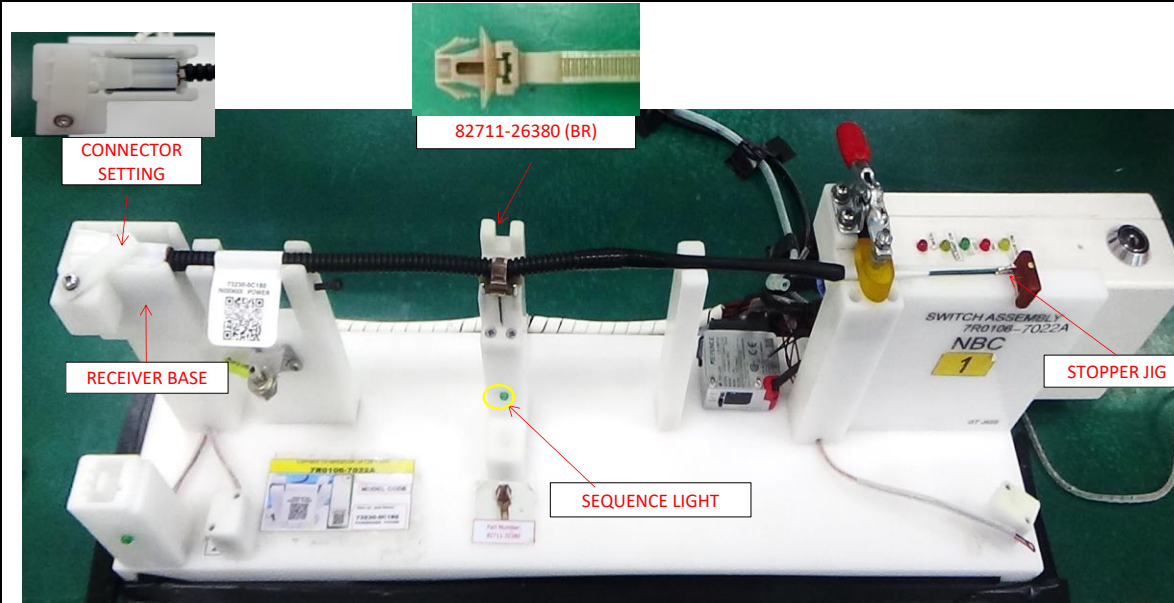
TOOLS/PPE

QUALITY POINTERS

4

Clamp
assy

Clamp Assembly



Important reminders/Note/s:
1. Make sure no gap in stopper and terminals

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

1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector **6188-0407 (B)** in **Receiver base 1** then lock using right hand. Continue to set the harness then last, set the **G-B/W wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of location ① was **ON**. the **CLAMP ON**.

2. Check if LED light for **POWER, CLAMP**, and **SEQUENCE LIGHT** is **ON**. If encountered abnormality, **STOP** the process, **CALL** the Leader and **WAIT** for instruction.

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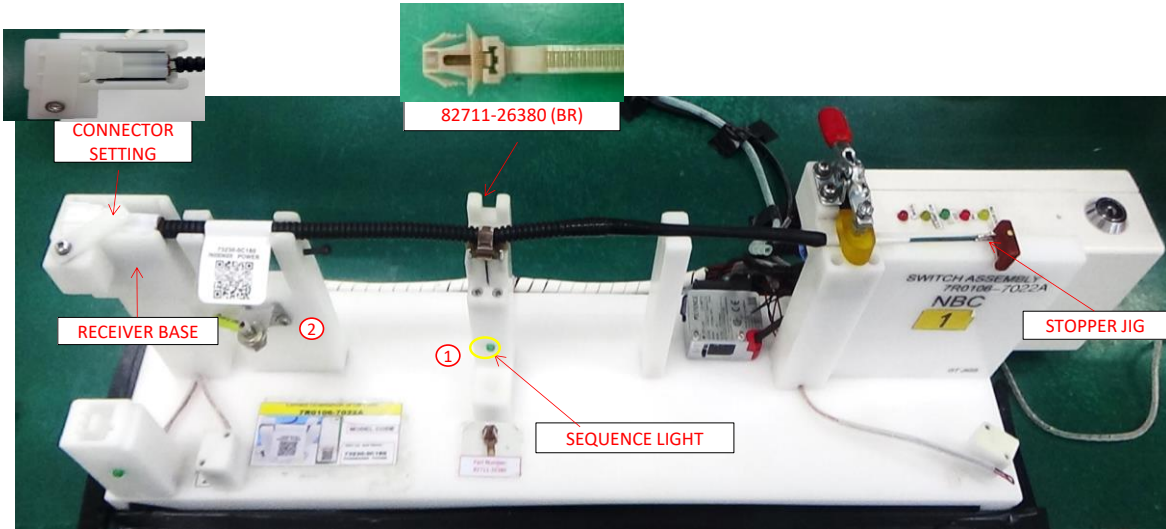

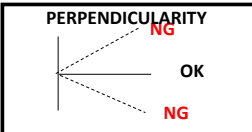


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PARTS:		1. Assy parts 2.Clamp 82711-26380 (BR)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp assy Clamp assembly (Continuation)	<div></div> <div><p>4. Get the bando gun and cut the clamp on location 1. Press the SW button after cutting. Continue on label Attachment. <i>(Refer to the next page for label attachment).</i></p><p>5. For label attachment, color sensor will light if detects the label code. After attachment, press the SW button using both index finger (same timing). Go sound will be heard.</p><p>6. Conduct POINT CHECKING before removing the harness from jig.</p></div> <div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>Fixed setting of band clamp cutter: 3 ~ 4</p></div>		<div><p>Important reminders/Note/s:</p><ol style="list-style-type: none">1. Make sure no gap between the terminal and stopper jig.2. You will hear the NG buzzer if the sensor detect the wrong use of tape and missing tape.3. Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</div> <div><p>BANDO GUN</p></div> <div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div>	

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PARTS:		1. Assy parts 2. Label 7V3020-0020		JIG:	1. Clamp Assembly jig 2. Label dispenser
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Clamp assy	Label attachment		n/a	

Model	Items	Item Name
7R0102	73240-0C140	Driver Manual
7R0103	73240-0C150	Driver Power
7R0104	73240-0C160	Driver PWR-MEM
7R0105	73230-0C170	Passenger Manual
7R0106	73230-0C180	Passenger Power

02

Model code

Item no. & name

1. Get the label.
Note: Check the model code, item no. & name

2. Align the end part of label in the jig.

3. Fold the center part of the label

4. Align both end part of label.

5. After alignment, Press the label with both fingers.

6. Press the label upside down using finger.

Acceptable overlap
0~1mm

GOOD

NG

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label

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

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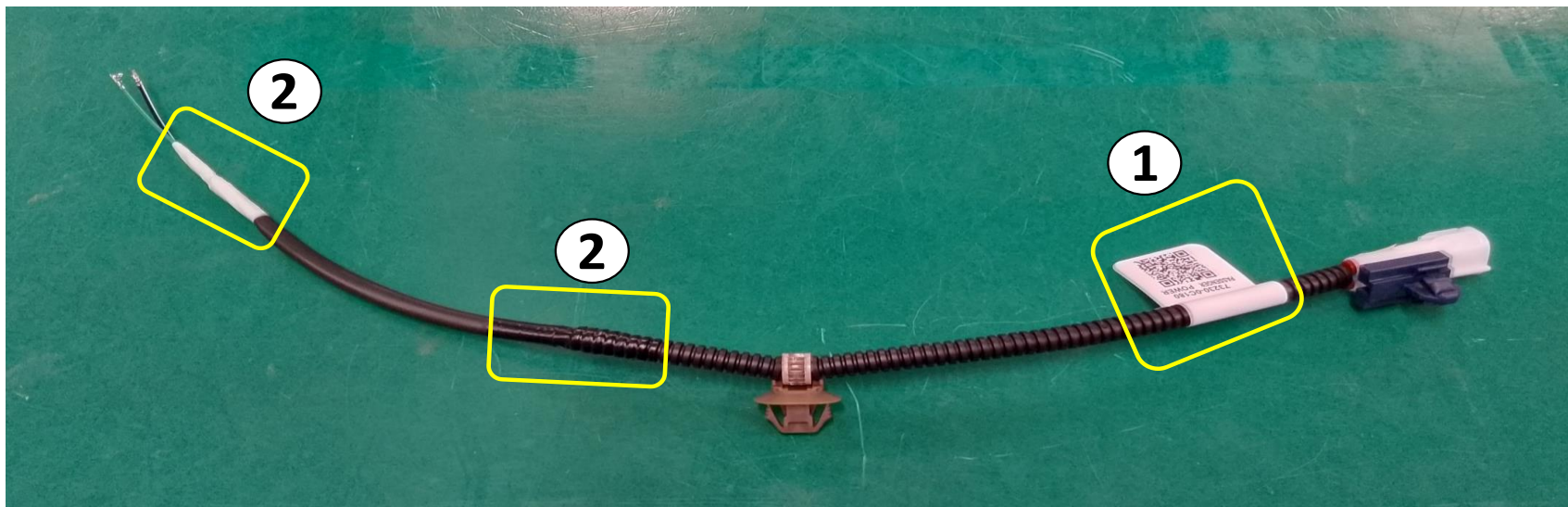
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7R0106-7022B**

① No Wrong Facing/Used of QR Code label

② No Missing tape

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