



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 4, 2024

Model code/Part number:

380D / 7L0141-7020A

Customer:

TRQSS

Car Model:

TOYOTA CAMRY

Document No.:

WI-ENG-PDE-971

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 7

PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-16820 (B); Label 7V8120-0020; Black tape

JIG:

1. Clamp assembly jig
2. Label dispenser

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

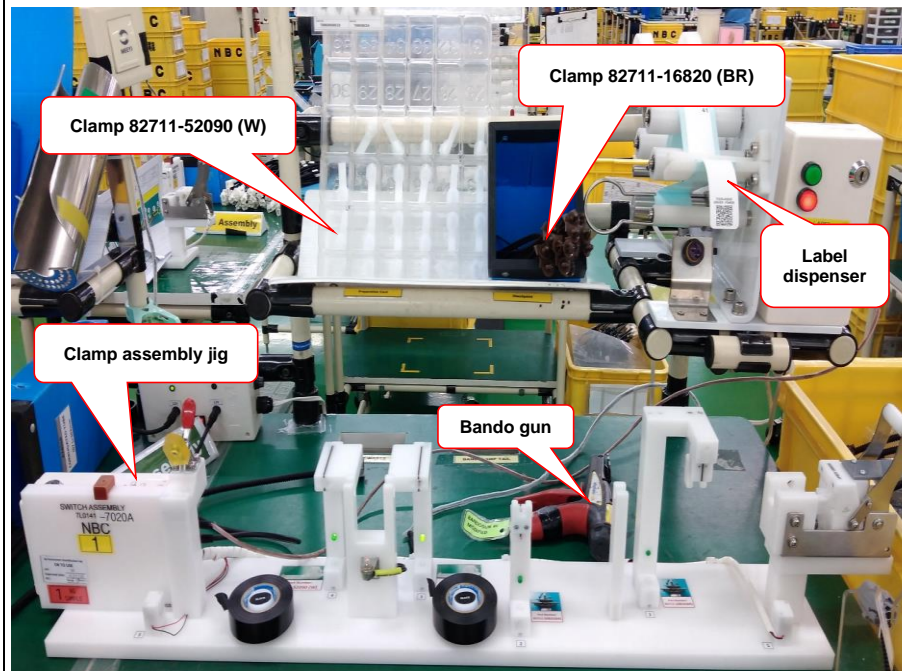
QUALITY POINTERS

1

Clamp Assy

Table Lay-out

TABLE LAY-OUT

**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-610** for Taping assembly process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/04/24 0 Initial issue. Separate clamp assy from Taping assembly process.

D.Castillo C.Villanueva A. Arañes N/A

Eff. Date Rev. No

Details of Change

Revised Reviewed Approved Noted

Est. Date:

September 4, 2024

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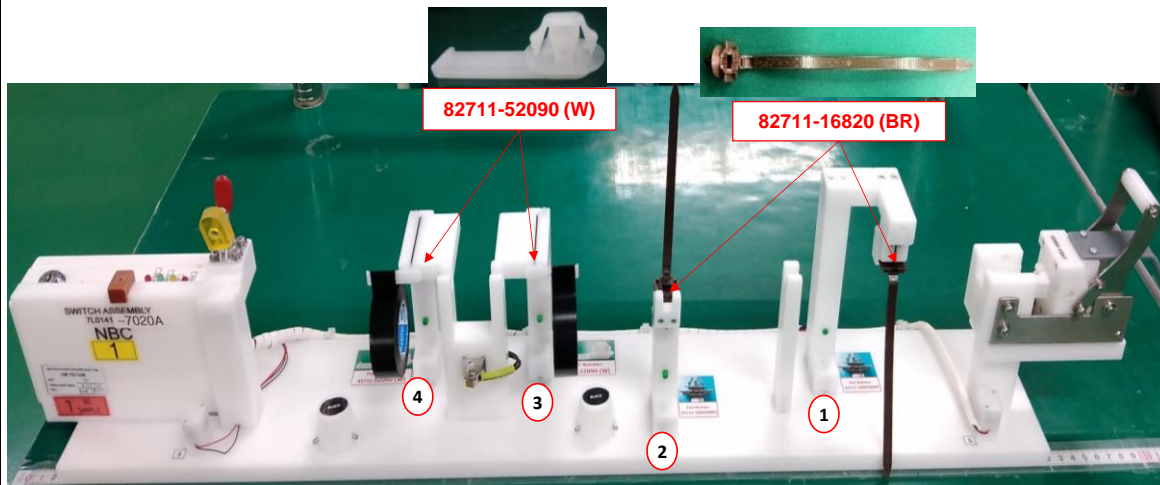




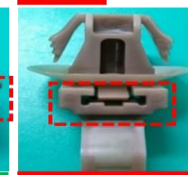
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 7

PARTS:		1. Clamp 82711-52090 (W) [2pcs.] 2. Clamp 82711-16820 (BR) [2pcs.]		3. Black tape [2pcs.]	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting	<div></div> <div>1. Get 2pcs. of clamp 82711-52090 (W) using both hands then set to clamp location 4 and 3 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-16820 (BR) using both hands then set to clamp location 2 and 1 using both hands.</div> <div>3. Initially attach Black tape on clamp location 4 and 3 using both hands.</div>			<div>STANDARD TAPING FOR CLAMP</div> <div><p>One wind for under tape</p></div> <div>Important reminders/Note/s: <i>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</i></div> <div><div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</div><div>CLAMP ILLUSTRATION<div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div><div>BAND CLAMP ILLUSTRATION<div><div>GOOD</div><div>82711-16820 (BR)</div></div><div><div>NG</div><div>82711-26380 (BR)</div></div></div></div>

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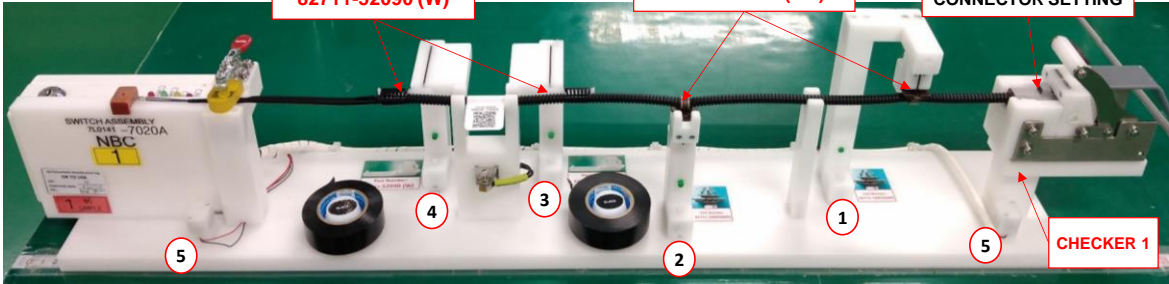
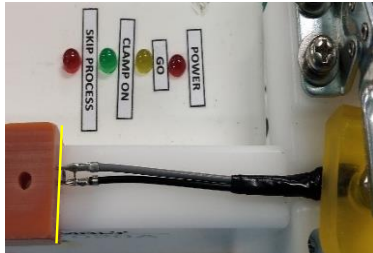
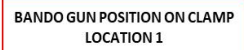

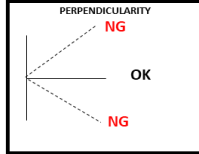

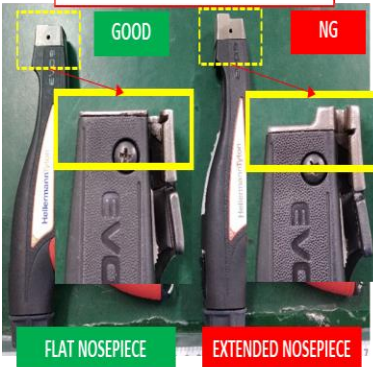
WI-ENG-PDE-971

Revision No.:

0

Page No.:

3 of 7

PARTS:		1. Assy parts 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></div><div></div><div></div></div> <div><div><p>1. Get the assy parts and set into jig. <i>(See above picture for correct setting of harness).</i> First, set the connector 6188-0066 (GR) to Checker 1 then push the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the terminal end together within the stopper then press by Toggle clamp.</p></div><div><p>2. Check if all LED light for Power On, Clamp ON, was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p></div></div>		<div></div> <div><p>Important reminders/Note/s:</p><p>1. Make sure no gap in stopper and terminals.</p></div>	
		<div><div><p>3. Initially tighten the band clamp on location 1 and 2 using both hands.</p></div><div><p>4. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 2 was ON.</p></div></div> <div><div></div><div></div><div><div><p>BANDO GUN ALIGNMENT</p></div><div></div></div></div> <div><div></div><div><p>GOOD</p><p>NG</p><p>FLAT NOSEPIECE</p><p>EXTENDED NOSEPIECE</p></div></div>			

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

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Document No.:

WI-ENG-PDE-971

Revision No.:

0

Page No.:

4 of 7

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp assembly (Continuation)	<div><div></div><div></div><div></div><div></div><div><p>5. Cut the band clamp on location 2 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 3 was ON.</p><div><div></div><div></div></div><div><div></div><div></div></div></div><div><p>6. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue if the sequence light on clamp location 4 was ON.</p></div><div><p>7. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process on label attachment</p></div><div><p>8. For label attachment, get the QR code label then attach using both hands. Press both SW button after attachment. Go sound will be heard. <i>(Refer to the next page for label attachment).</i></p></div><div><p>9. Conduct POINT CHECKING before removing the harness from jig.</p></div></div> <td><div></div><div><div></div><div></div><div></div><div></div></div></td>		<div></div> <div><div></div><div></div><div></div><div></div></div>	

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☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

5 of 7

PARTS:

1. Assy parts
2. Label 7V8120-0020

JIG:

1. Label dispenser

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Clamp Assy

Label attachment

SWITCH ASSY P/N	SWITCH ASSY PART NUMBER REFERENCE	PART NO.	TOYOTA PART NO.	SEAT POSITION	SEAT TYPE
7L0141-702	41	7V8120-0020	73230-AQ020	DRIVER	POWER
7L0140-702	40	7V8110-0020	73230-AQ010	DRIVER	PWR + MENU
7L0139-702	39	7V8130-0020	73230-AQ040	DRIVER	MANUAL



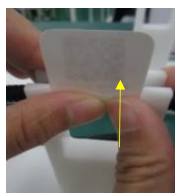
2. Align the end part of label in the jig.



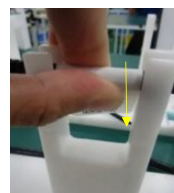
3. Fold the center part of the label



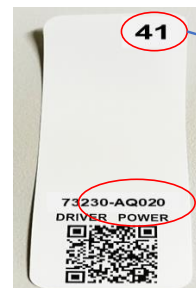
5. After alignment , Press the label with both fingers .



6. Press the label upside down using finger.



4. Align both end part of label .



Model code

Item no. & name

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



GOOD

Acceptable overlap
0~1mm



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 the label



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Page No.:

6 of 7

PARTS:	1. Assy parts		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy Measurement	<div><div>MEASURING TAPE</div></div> <div>NOTE: A - Taping (B) B - Clamp (W) C - Clamp (BR)</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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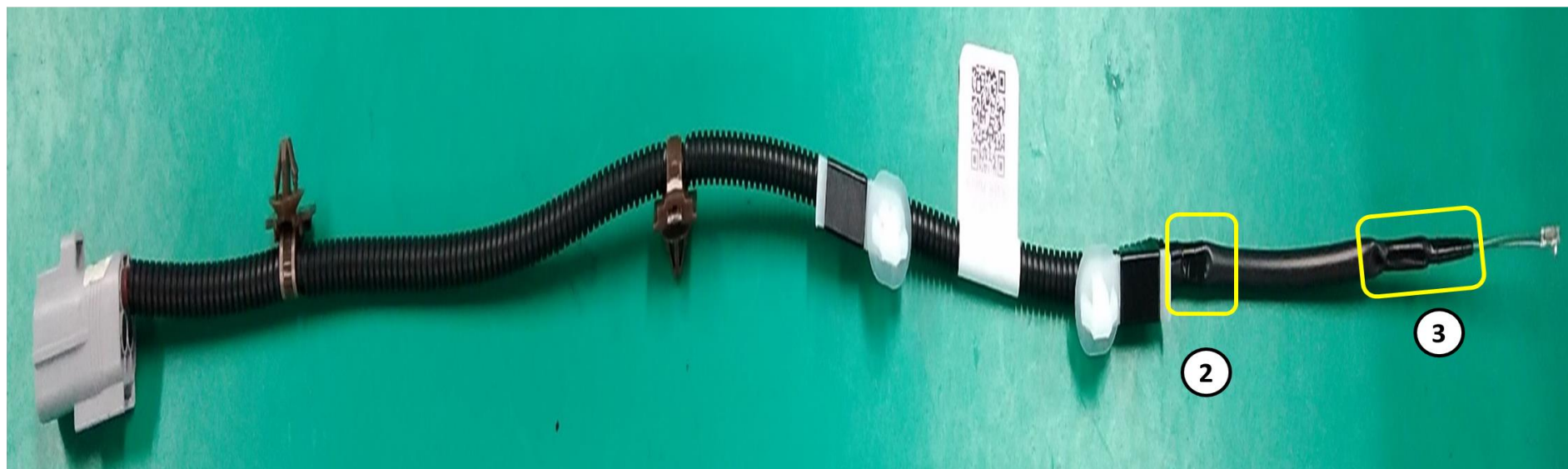
7 of 7

PARTS:

1. Assy parts

JIG:

N/A

QUALITY CHECKPOINTS**CLAMP ASSY****7L0141-7020A****1** No Wrong Facing of Clamp**2** **3** No Missing Tape (Black Tape)

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