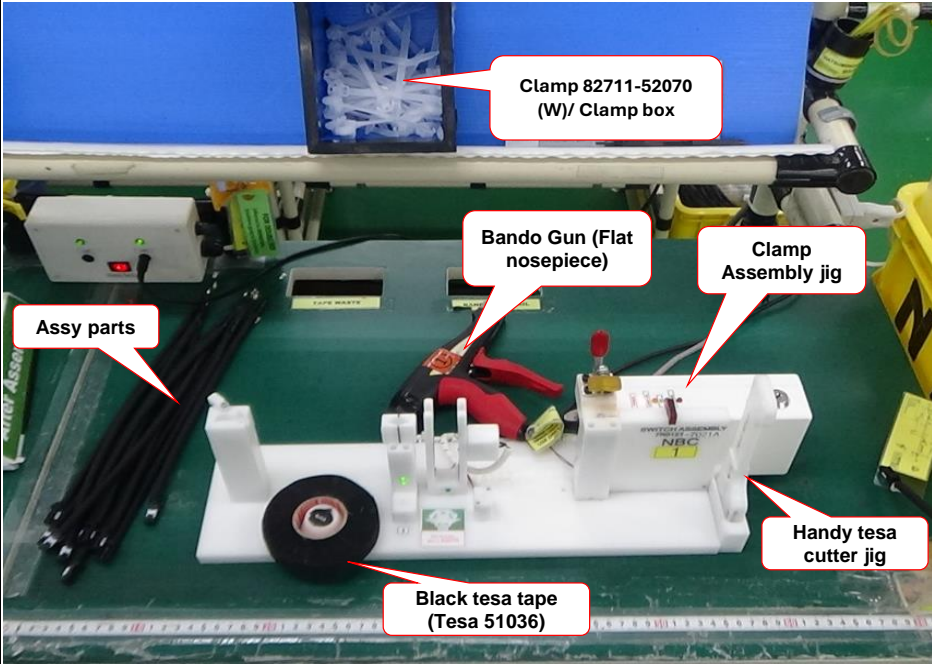
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	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 920B / 7R0121-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-976	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 7

PARTS:		1. Assy parts; Clamp 82711-52070 (W);Black tesa tape (Tesa 51036)			JIG:		1.Clamp assembly jig 2. Handy tesa cutter jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div>Table Lay-out</div> 			<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Important reminders/Note/s: 1. Please refer to WI-ENG-PDE-652A-B for TAPING ASSEMBLY PROCESS</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/21/24	0	Initial issue. Seprate 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 21, 2024	
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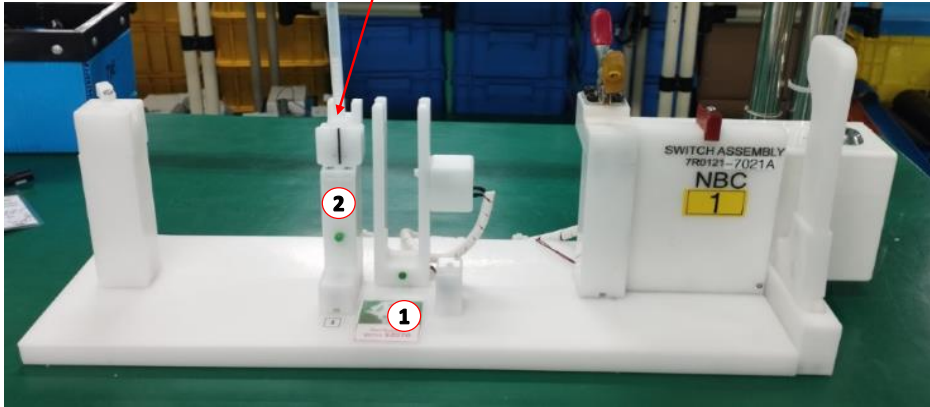




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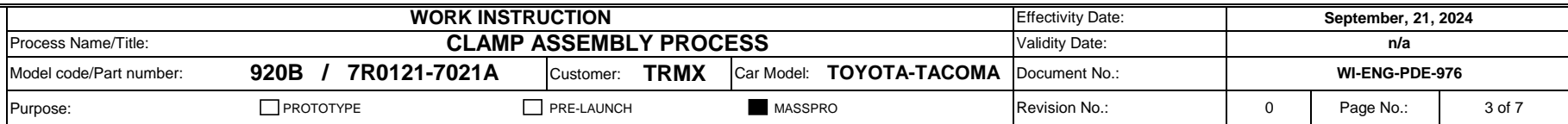
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PARTS:		1. Assy parts 2. Clamp 82711-52070 (W)		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div></div> <div>1. Get 1pc of Band clamp 82711-52070(W) using right hand and set to clamp location 2 using both hands.</div>		<div></div> <div>82711-52070 (W)</div> <div></div> <div>MEASURING TAPE</div>	<div>Important reminders/Note/s</div> <div>1. Please check the clamp first before start assembly to avoid wrong use of clamp.</div> <div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div>82711-52070 (B)</div><div>82711-12A60 (W)</div></div></div>


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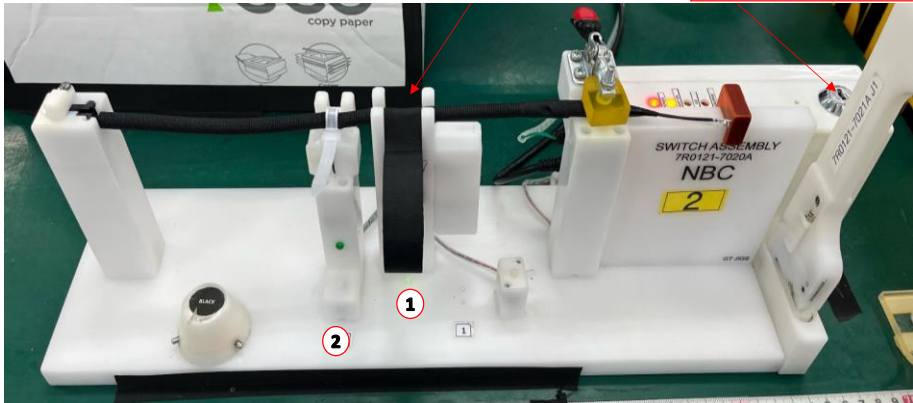



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PARTS:	1. Assy parts 2. Black tesa tape (Tesa 51036)			JIG:	1. Clamp Assembly jig 2. Handy Tesa cutter jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS			
3	Clamp Assy	Clamp Assembly (Continuation)	<div><div>Black tesa tape (Tesa 51036)</div><div>Handy Tesa cutter jig</div></div> <div><div>Handy Tesa cutter</div></div> <div><p>4. Get the Tesa tape using right hand and attach in the twist tube. Wind the tape (1 wind only) and cut using both hands. Press the SW button after cut. Continue the process on clamp location 2. (Note: No excess winding of tesa tape)</p></div>			<div><div>HANDY TESA CUTTER JIG</div></div> <div><div>MEASURING TAPE</div></div>	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Important reminders/note/s:</p> <p>1.Please use calibrated/verified measuring tape when getting the measurement.</p>		

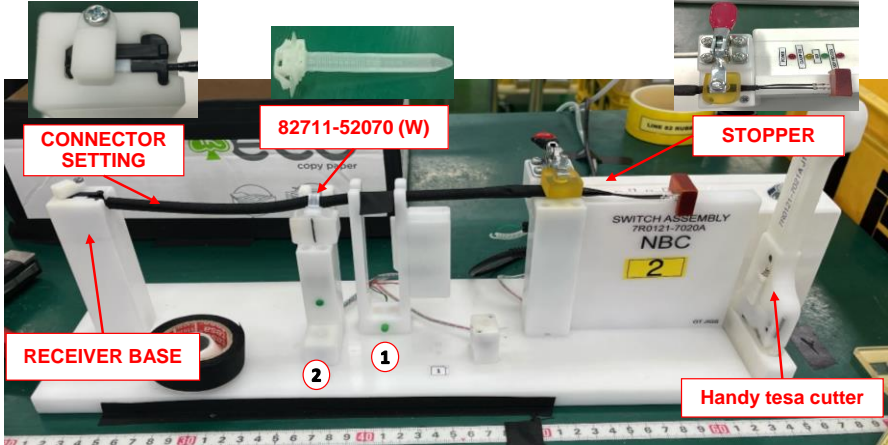

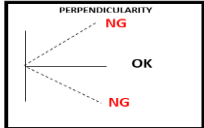
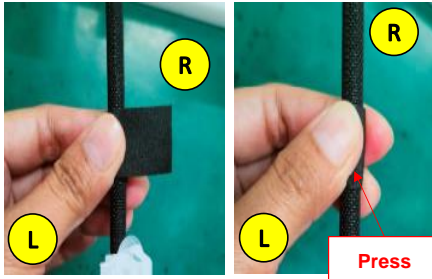


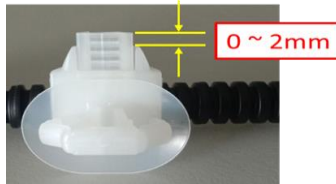

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		Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-976	
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PARTS:		1. Assy parts				JIG:		1. Clamp Assembly jig 2. Handy Tesa cutter	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
3	Clamp Assy	<div><div></div><div><p>5. Get the Bando Gun (Use FLAT NOSEPIECE) using right hand and cut the band clamp on location 1 using both hands. Press the SW button after insertion. GO sound will be heard.</p><div><p>BANDO GUN POSITION ON CLAMP LOCATION 2</p><p>GOOD NG</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p><div><p>BANDO GUN ALIGNMENT</p></div></div></div><div><p>Press</p></div><div><p>6. Remove the harness into jig. Start from the Toggle clamp to Connector receiver base.</p></div><div><p>7. After removal, fix the end tape of tesa then press 2x.</p></div></div> <div><div><p>BANDO GUN</p></div><div><p>FLAT NOSEPIECE</p></div></div> <div><p>1. No wrong use of clamp 2. No damaged clamp 3. No wrong setting of bando gun 4. No loose/tight clamp attachment</p><p>Important reminders/note/:</p><p>1. Setting the band clamp cutter depends on the size of the COT/Vinyl Tube. For: ø5 - 1~2, ø7 - 3~4</p><div><p>0 ~ 2mm</p></div><div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div></div>							

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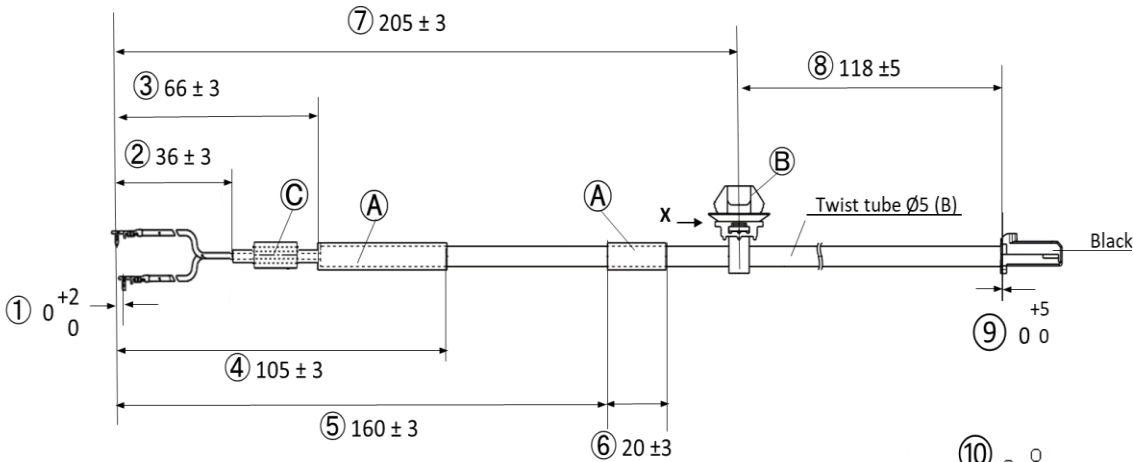
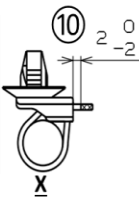
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Tesa Tape B - Clamp (W) C - Vinyl Tape (B) *** Check the presence of spot tape</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 <i>WI-PRO-ASY-056</i> for Sub-assembly Hatsumono Nakamono Owarimono Inspection 1. No wrong dimension.

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7R0121-7021A****1****No Unlocked/ Half-locked
Connector****2****No Missing Spot Tape (Black Tape)**

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