



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

November 04, 2024

Model code/Part number:

178D / 7N0127-7021C

Customer: TRJ

Car Model: TOYOTA-COROLLA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

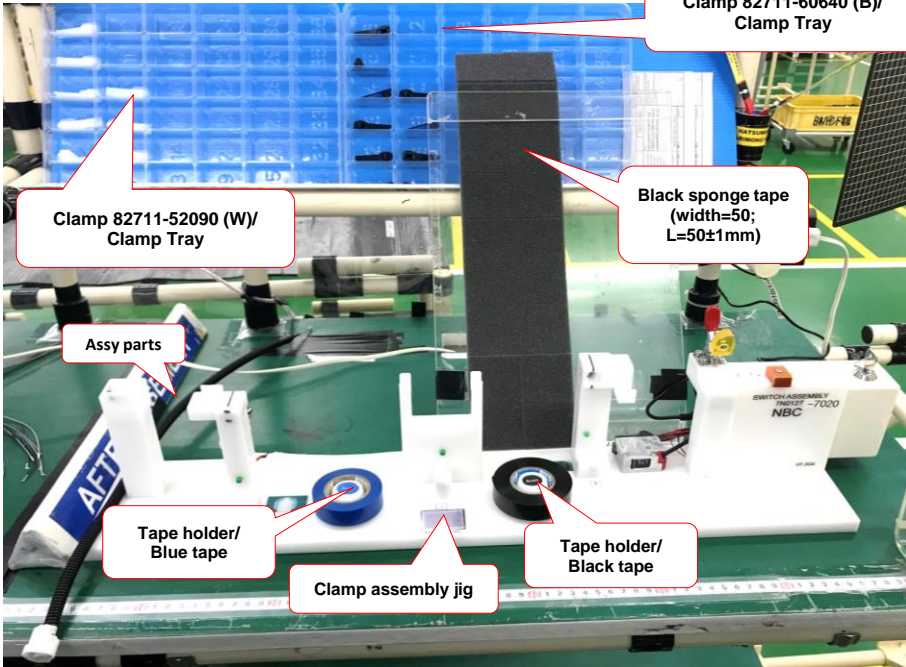




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<b>PARTS:</b>	1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-60640 (B); Black Sponge tape (width=50; L=50±1mm); Black tape; Blue tape			JIG:	1. Clamp Assembly Jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	CLAMP ASSY	Table Lay-out		<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-432</b> for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p> <p><b>CLAMP ILLUSTRATION</b></p> <p><b>GOOD</b></p>  <p><b>82711-60640 (B)</b></p> <p><b>NG</b></p>  <p><b>82711-21020 (B)</b></p> <p><b>CLAMP ILLUSTRATION</b></p> <p><b>GOOD</b></p>  <p><b>82711-52090 (W)</b></p> <p><b>NG</b></p>  <p><b>82711-12A80 (W)</b></p>
Revision History				Prepared by	Reviewed by
				Approved by	Noted by
11/04/24	1	Change pre launch to mass pro.		A.Hernandez	C.Villanueva
10/29/24	0	Initial issue.		A.Hernandez	C.Villanueva
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date:	October 29, 2024

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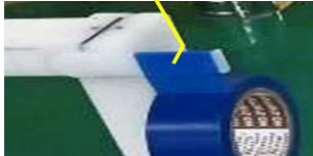




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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-60640 (B)  3. Black tape 4. Blue tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp Setting		n/a	<div>1. No loose clamp attached</div> <div>2. No damage clamp</div> <div>3. No wrong use of clamp</div> <div>4. No damage clamp</div> <div>5. No flip-out tape</div> <div>6. No peel-off tape</div> <div>8. No missing tape</div> <div>9. No wrong use of tape</div> <div>10. No wrong use of clamp</div> <div>Important reminders/Note/s:</div> <div>1. Please check the clamp before start of assembly to avoid wrong use of parts.</div> <div>STANDARD TAPING FOR CLAMP</div> <div>One wind for clamp taping</div> <div></div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div></div><div>82711-60640 (B)</div><div>NG</div><div></div><div>82711-21020 (B)</div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div>

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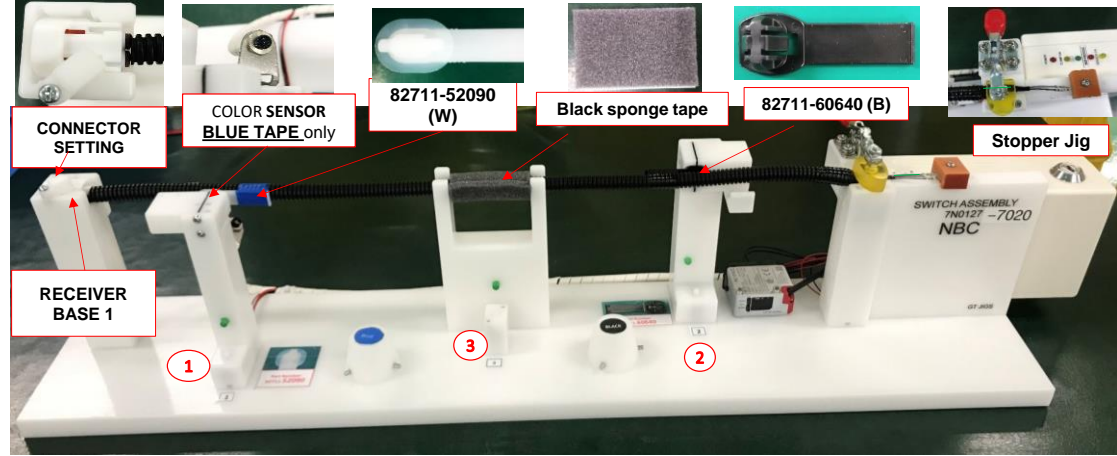
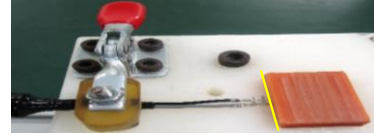
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PARTS:		1. Assy parts		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly		<div></div> <div>1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6189-0451 (W) to Receiver base 1. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Blue tape. Last, set the end of G-B/W wire together within the stopper then press by Toggle clamp then continue if the sequence light on clamp location 1 was ON.</div> <div>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON. SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Continue the process on clamp location 2.</div> <div>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Continue the process on attachment of sponge tape. (Proceed on next page for the instruction of sponge tape attachment.)</div> <div>5. Conduct POINT CHECKING before removing the harness from jig.</div>	<div></div> <div>Important reminders/ Note/s: 1. Make sure no gap between terminal and stopper jig. 2. Make 2-3 windings for clamp taping</div> <div>1. No loose clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of clamp/tape</div>

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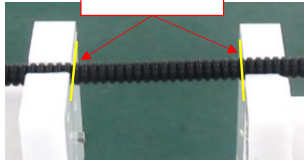
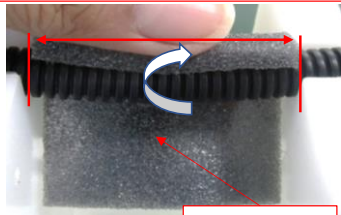
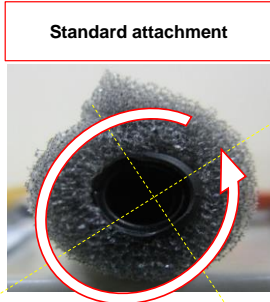





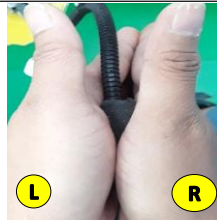
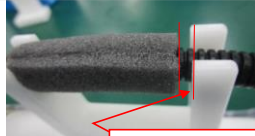
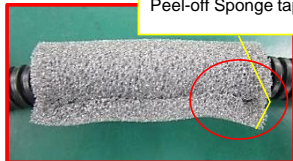
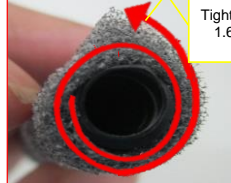
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PARTS:		1. Black sponge tape (width=50; L=50±1mm) 2. Assy Parts		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY  Sponge Tape Attachment	<div><div><p>GUIDE</p></div><div><p>Size of sponge tape should fit the jig</p></div><div><p>Standard attachment</p></div><div><p>1 Get <b>sponge tape( width=50; L=50±1mm)</b> then attach to corrugated tube using left hand and slowly wrap to COT. Follow the guide for the correct location of sponge tape. <b>Note: Do not stretch or pull the sponge tape</b></p></div><div><div></div><div></div></div><div><p>2. Press the sponge tape using both palm and roll 3 times to make sure that the sponge tape attachment is GOOD.</p></div></div> <div><p>1. No peel-off attachment 2. No loose/tight attachment 3. No wrong attachment 4.No missing sponge 5.No wrong use of sponge 6.No damage sponge</p><div><p><b>NO GOOD ATTACHMENT OF SPONGE TAPE</b></p><p>With gap on guide of jig.</p><p>Peel-off Sponge tape</p><p>Tight Attachment 1.6-1.7 Wrap</p></div></div>			

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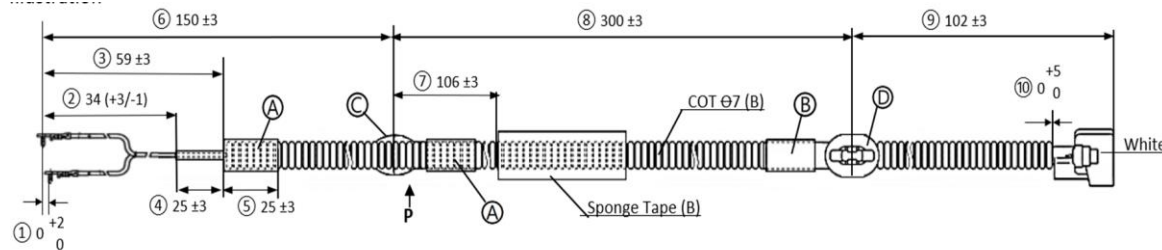
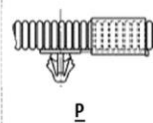
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PARTS:		1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	CLAMP ASSY	Measurement	<div><div>MEASURING TAPE</div></div>  <div><p>NOTE:</p><ul style="list-style-type: none"><li>(A) Taping (B)</li><li>(B) Taping (L)</li><li>(C) Clamp (B)</li><li>(D) Clamp (W)</li></ul><p>for item number ② , Dimension tolerance is different from the master drawing due to Internal change only.</p></div> 		<div><p><b>Important reminders and note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. For Hatsumono, Nakamono and Owarimono.</p><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p></div>

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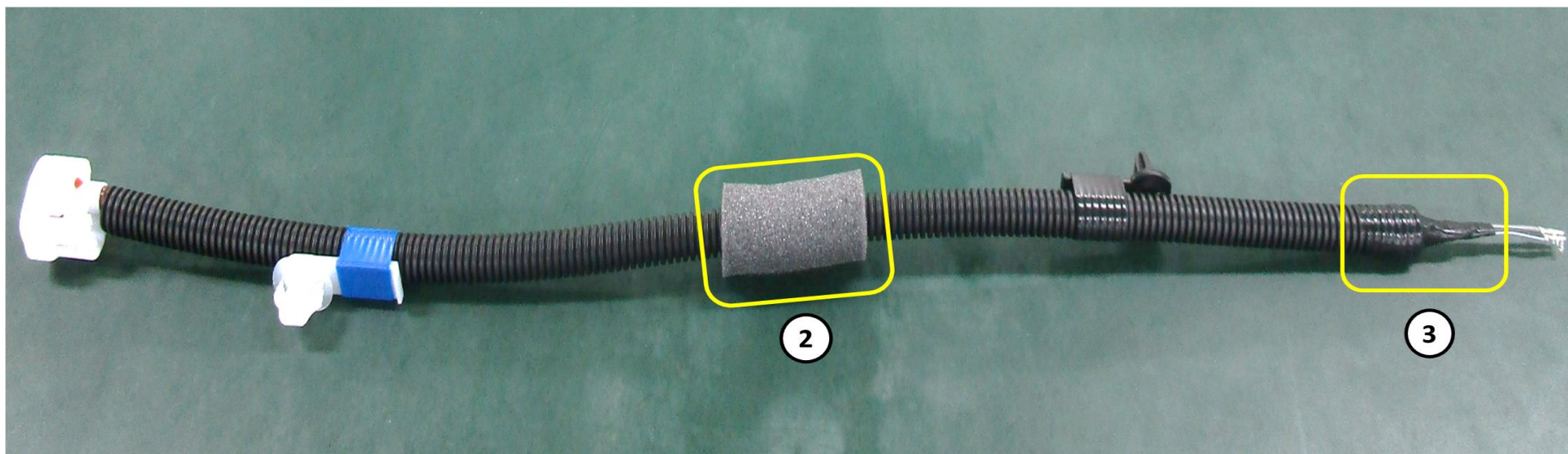
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**PARTS:**

1. Assy Parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0127-7021C****① No Wrong Facing of Clamp****② No Missing Urethane Foam****③ No Missing Tape ( Black Tape )**

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