



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Process Name/Title:

Model code/Part number:

780 / 7R0105-7023B

Customer:

TRMX

Car Model:

TOYOTA-TUNDRA

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



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Revision No.:

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## PARTS:

1. All parts: Clamp 82711-52090 (W); Clamp 82711-16830 (B); Clip type clamp 82711-1E360 (W);

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

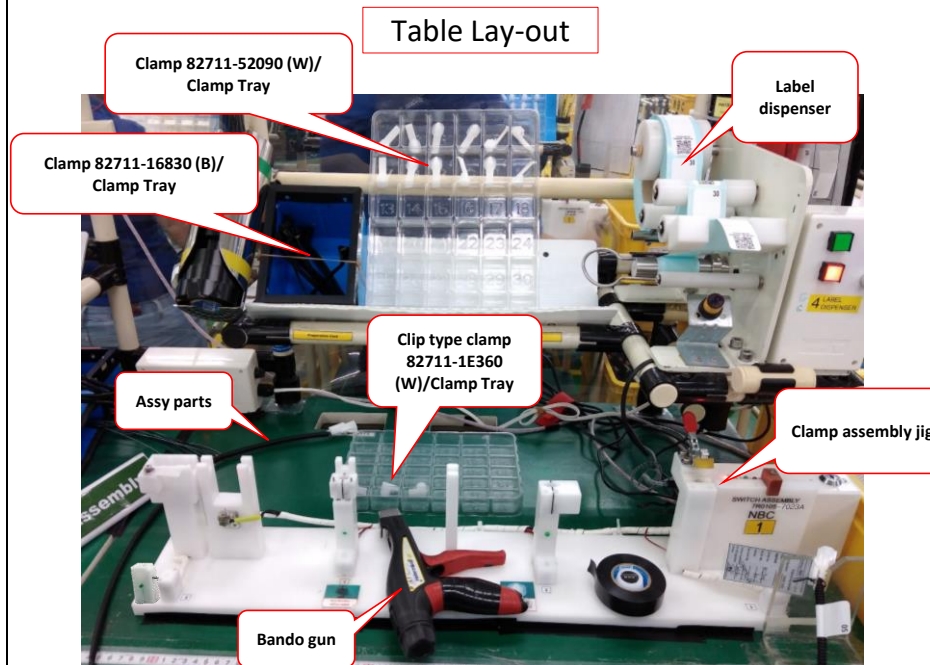
TOOLS/PPE

QUALITY POINTERS

1

P2

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.

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

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a
10/14/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a

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PARTS:		1. Clamp 82711-16830 (B) 2. Clamp 82711-52090 (W) 3. Black tape 4. Clamp 82711-1E360 (W)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Setting	<div><div></div><div></div><div></div><div><div>1. Get 1pc. of clamp <b>82711-16830 (B)</b> using right hand then set to location <b>1</b> using both hands.</div><div>2. Get 1pc. of clamp <b>82711-52090 (W)</b> using right then set to location <b>2</b> using both hands.</div><div>3. Initially attach <b>Black tape</b> on clamp location <b>2</b> using both hands.</div></div><div><div>STANDARD TAPING FOR CLAMP</div><div></div></div></div> <div>n/a</div> <td><div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape</div><div><b>Important reminders/Note/s:</b> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div><div><div>BAND CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-16830 (B)</div></div><div><div>NG</div><div></div><div>82711-34490 (B)</div></div></div><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div></div></div></td>		<div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape</div> <div><b>Important reminders/Note/s:</b> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-16830 (B)</div></div><div><div>NG</div><div></div><div>82711-34490 (B)</div></div></div><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div></div></div>	
3	Clamp attachment (Clip type clamp) 82711-1E360 (W)	<div><div></div><div><div>CLIP CLAMP ORIENTATION</div></div><div><div></div><div><div>1. Hold the connector using left hand. Get the clip type clamp <b>82711-1E360 (W)</b> then insert the clamp using right hand. <i>Note: Follow above instruction. Sound will be heard if properly inserted.</i></div></div></div><div>n/a</div><td><div>1. No wrong use of parts 2. Must be fully inserted</div><div><div>CLIP CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-1E360 (W)</div></div><div><div>NG</div><div></div><div>82711-12B10 (W)</div></div></div></div></td></div>		<div>1. No wrong use of parts 2. Must be fully inserted</div> <div><div>CLIP CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-1E360 (W)</div></div><div><div>NG</div><div></div><div>82711-12B10 (W)</div></div></div></div>	

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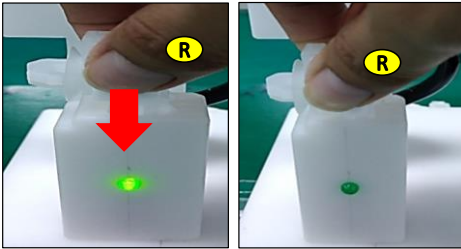


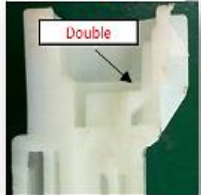
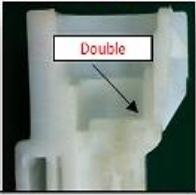
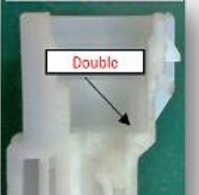

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2  Connector lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</p></div><div><div><div>Before lock</div></div><div><div>After lock</div></div></div><div><div><p>Coupler Cross Sectional View</p><div><div>NG</div><div>Double</div><div>Unlock Condition</div></div><div><div>NG</div><div>Double</div><div>Half Lock Condition</div></div><div><div>GOOD</div><div>Double</div><div>Full Lock Condition</div></div></div></div></div>	<div><div>Locking Jig</div></div>	<div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div> <div><div>Important reminders/Note/s:</div><div>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</b></div></div>

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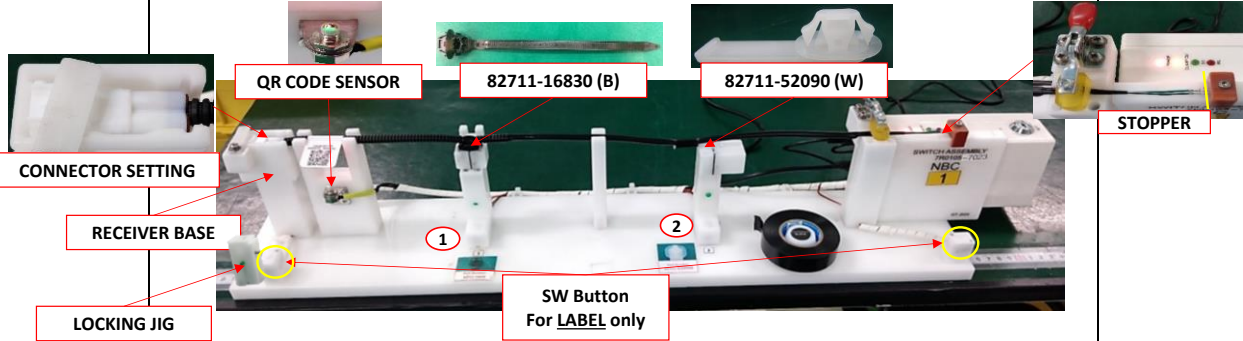
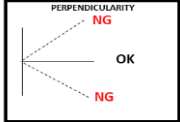


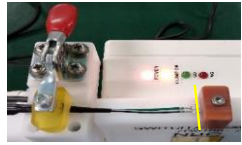
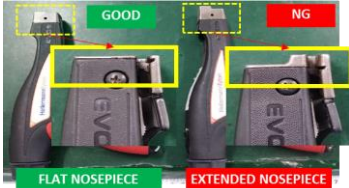
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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Clamp assembly	<div></div> <div><p>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6188-0407 (W) to Receiver base then lock. Continue to set the harness in jig. Last, set the end of G-B/W hotmelted wires together within the stopper then press by Toggle clamp. Continue if the sequence</p><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 and continue the process.</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><p>Fixed setting of band clamp cutter: 3~4</p><div><p>BANDO GUN ALIGNMENT</p></div><div><p>BANDO GUN POSITION ON CLAMP LOCATION 1</p></div></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><p>3. Initially tighten the band clamp on location 1 using both hands.</p></div>	<div></div>	<div></div> <p><b>Important reminders/Note/s:</b> 1. Make sure no gap between stopper and terminals</p> <p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</p> <div></div>

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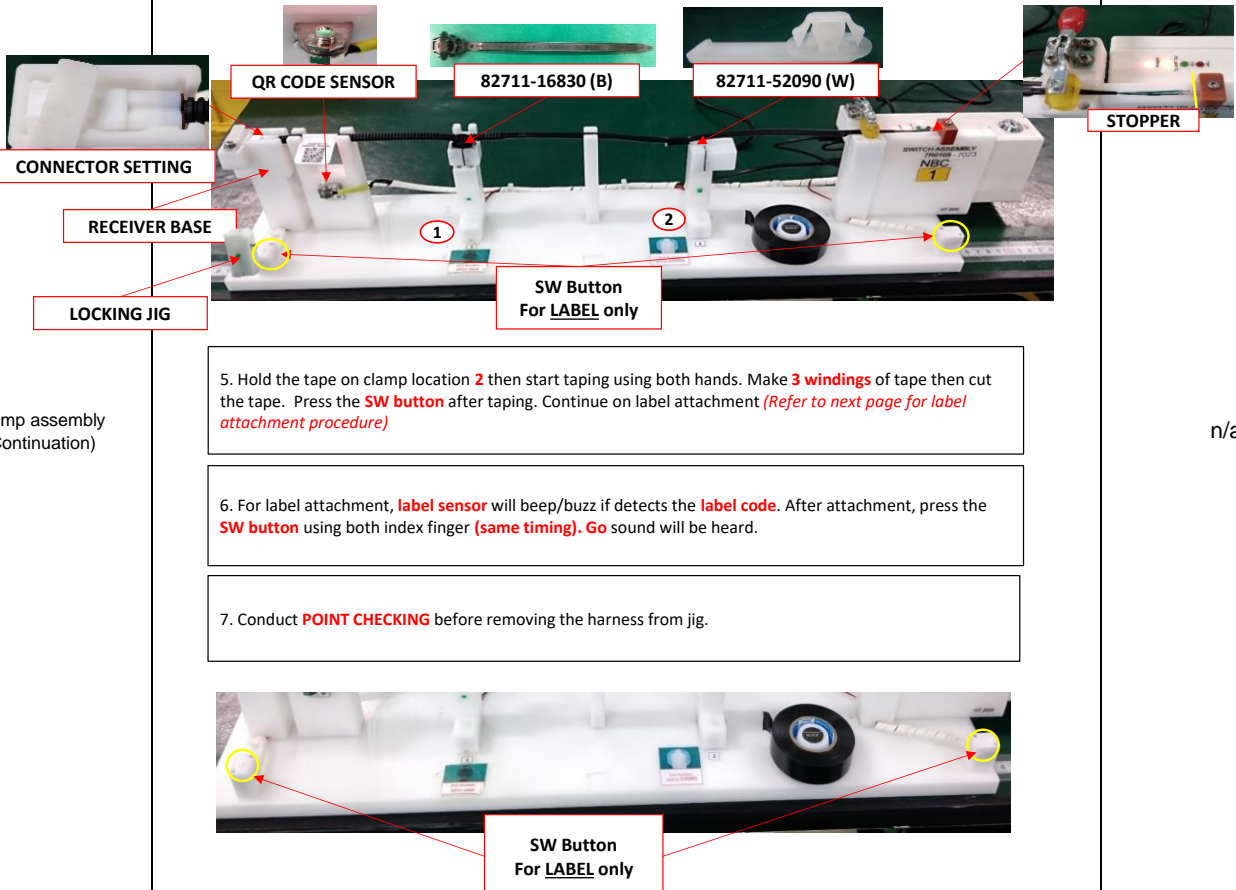

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2  Clamp assembly (Continuation)	<div></div>	n/a	<div></div> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Make sure no gap between stopper and terminals</b></p> <p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</p>

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1. Assy parts
2. Label 7V3010-0020

JIG:

1. Clamp Assembly jig
2. Label Dispenser

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

6

P2

Label attachment

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



Model code

Item no. &amp; name

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



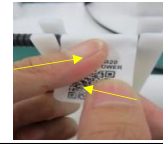
2. Align the end part of label in the jig.



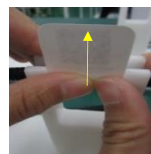
3. Fold the center part of the label



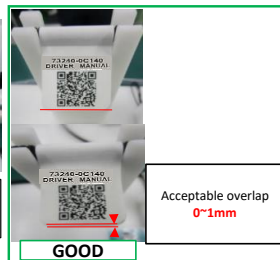
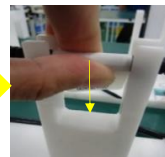
4. Align both end part of label .



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



6. Press the label upside down using

**GOOD**

n/a

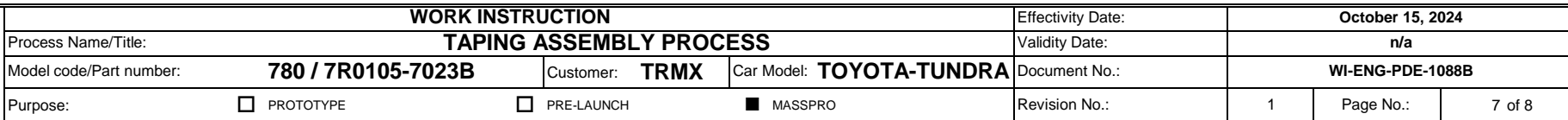
1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label



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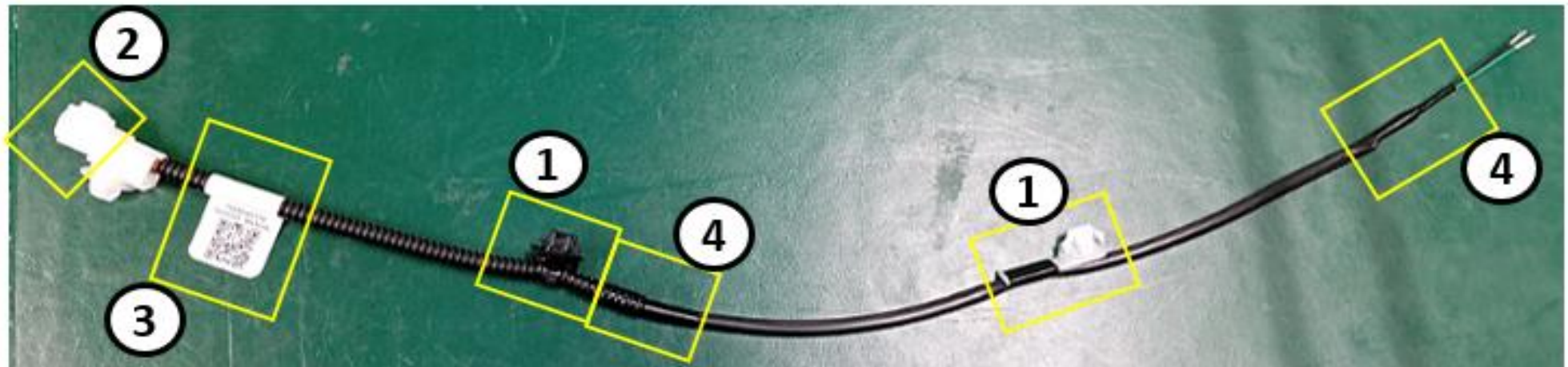
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7R0105-7023B**

- ① No Missing / Mis-align of Clamp
- ② No Unlocked/Halflocked Connector
- ③ No Missing QR code label

- ④ No Missing Tape ( Black Tape )

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