



## WORK INSTRUCTION

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Process Name/Title:

Model code/Part number:

920B / 7R0120-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-928

Revision No.:

0

Page No.:

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PARTS: 1. Assy parts; Clamp 82711-3A640 (B); Black Tape

JIG:

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

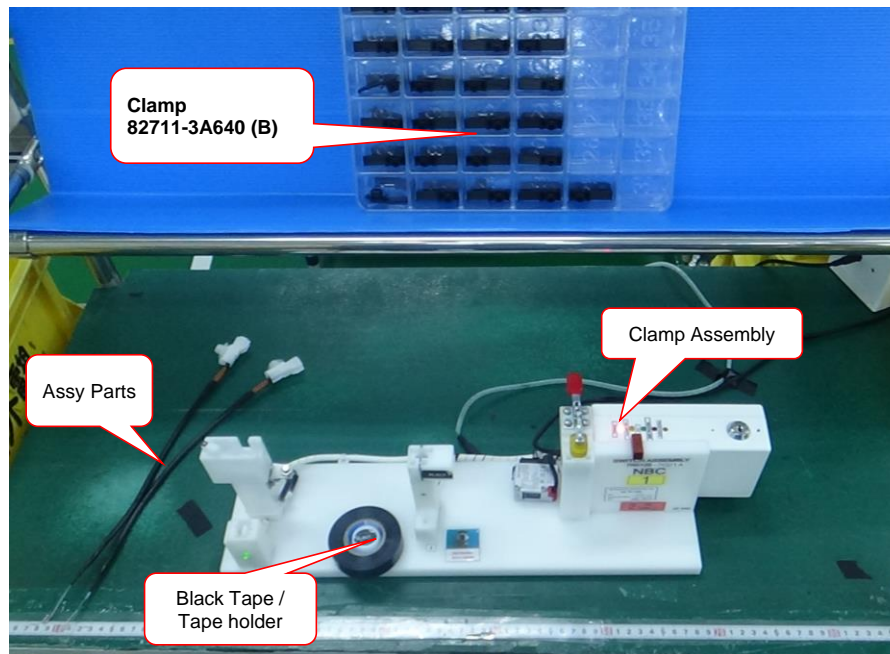
QUALITY POINTERS

1

Clamp  
Assy

Table Lay-out

## Table Lay-out



## Safety Instruction

Be sure to wear required 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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/24/24 0 Initial issue. Tranfer Clamp process from Taping Assembly Process.

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:

June 24, 2024

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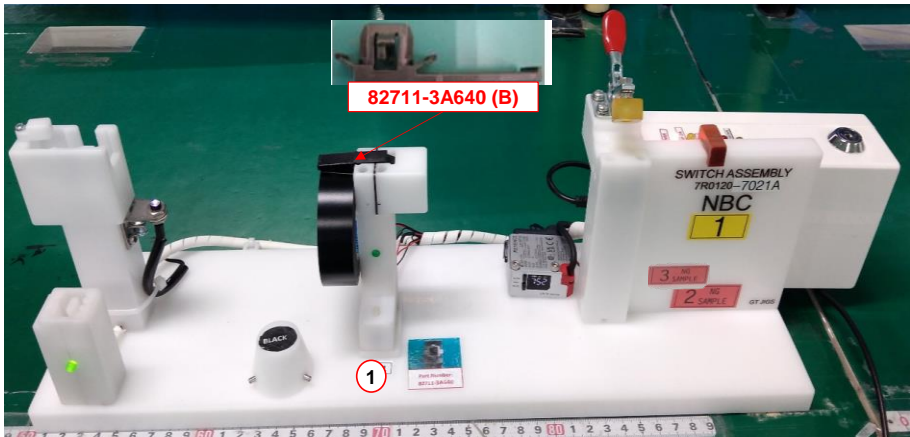

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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
2	Clamp Assy	Clamp setting	<div></div> <div>1. Get 1pc. of clamp <b>82711-3A640 (B)</b> using both hands then set to clamp location <b>1</b> using both hands.</div> <div>2. Initially attach <b>Black tape</b> on clamp location <b>1</b> using both hands.</div>	n/a	<div><div>One wind for under tape</div></div> <div><b>Important reminders/Note/s:</b></div> <div>1. <b>Please check the clamp first before start of assembly to avoid wrong use of clamp.</b></div> <div>2. <b>Must be no gap between terminal and stopper jig.</b></div> <div>3. <b>Make 2-3 windings for clamp taping.</b></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH

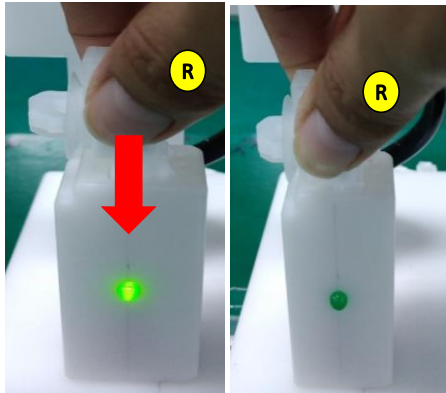
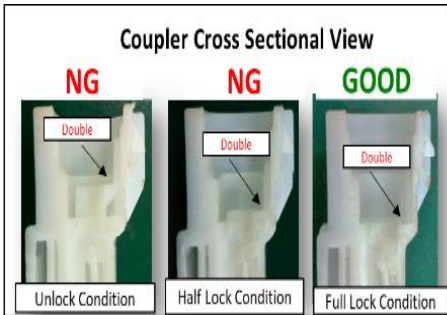
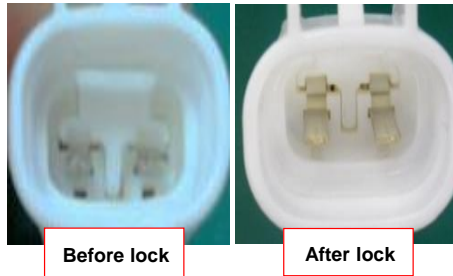

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PARTS:		1. Clamp 82711-3A640 (B) 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy  Clamp setting	<div></div> <div><p>1. Put the connector into locking jig using right hand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

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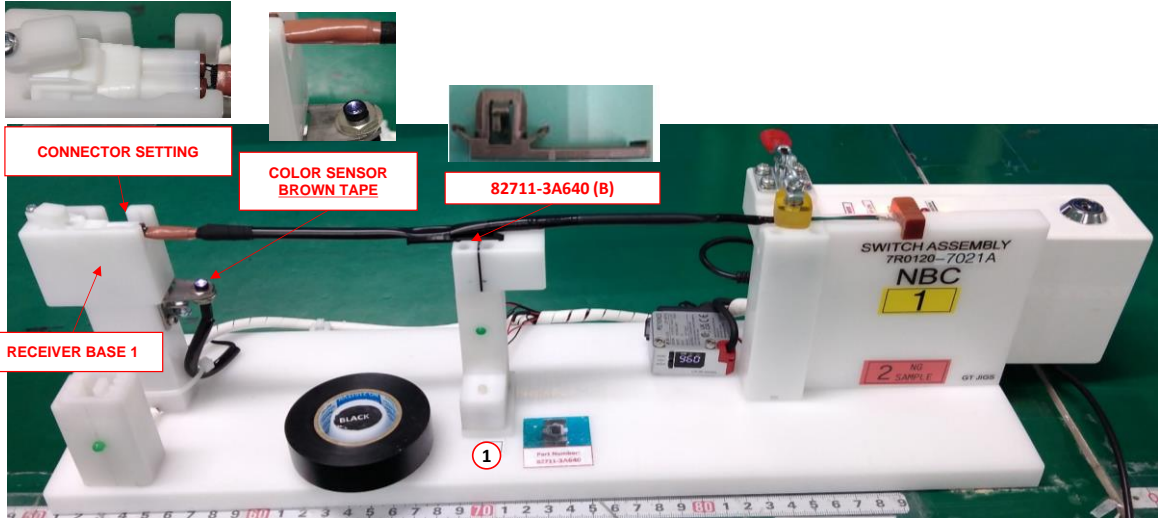

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PARTS:	1. Clamp 82711-3A640 (B) 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	<div data-bbox="555 384 1709 906"></div> <div data-bbox="555 911 1171 1110"><p>1. Get the assy parts and set into jig. <b>(See above picture for correct setting of harness).</b> First, set the connector 6098-0407 (W) to <b>Receiver base 1</b> then lock. Continue to set the harness in jig. <b>Color sensor light</b> will beep/buzz if sensor detects <b>Brown tape</b>. Last, set the terminal end together within the stopper then press by <b>Toggle clamp</b>.</p></div> <div data-bbox="555 1145 1171 1289"><p>3. Hold the tape on clamp location <b>1</b>. Make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard.</p></div> <div data-bbox="1189 911 1700 1110"><p>2. Check if all LED light for <b>Power On, Clamp ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</p></div> <div data-bbox="1189 1145 1659 1281"><p>4. After taping, <b>CONDUCT POINT CHECKING</b> before removing the harness from jig.</p></div>		<div data-bbox="1778 432 2083 655"></div> <p><b>Important reminders/Note/s:</b> <b>1. Make sure no gap in stopper and terminals</b></p> <ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No wrong use of tape</li><li>3. No damaged clamp</li><li>4. No wrong clamp position</li></ol>

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

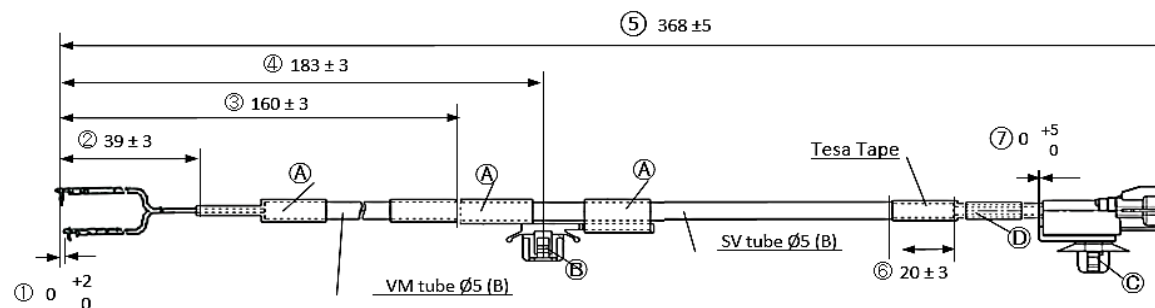
TOOLS/PPE

QUALITY POINTERS

5

Clamp  
Assy

Measurement

**NOTE:**

- A - Taping (B)
- B - Clamp (B)
- C - Clamp (W)
- D - Taping (BR) \*\*\* Check the presence of spot tape

**WIRE TYPE TABLE**

No.	Color	Wire Type
1	G	TVSS 0.3f
2	B/W	TVSS 0.3f

**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 **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection.

1. No wrong dimension

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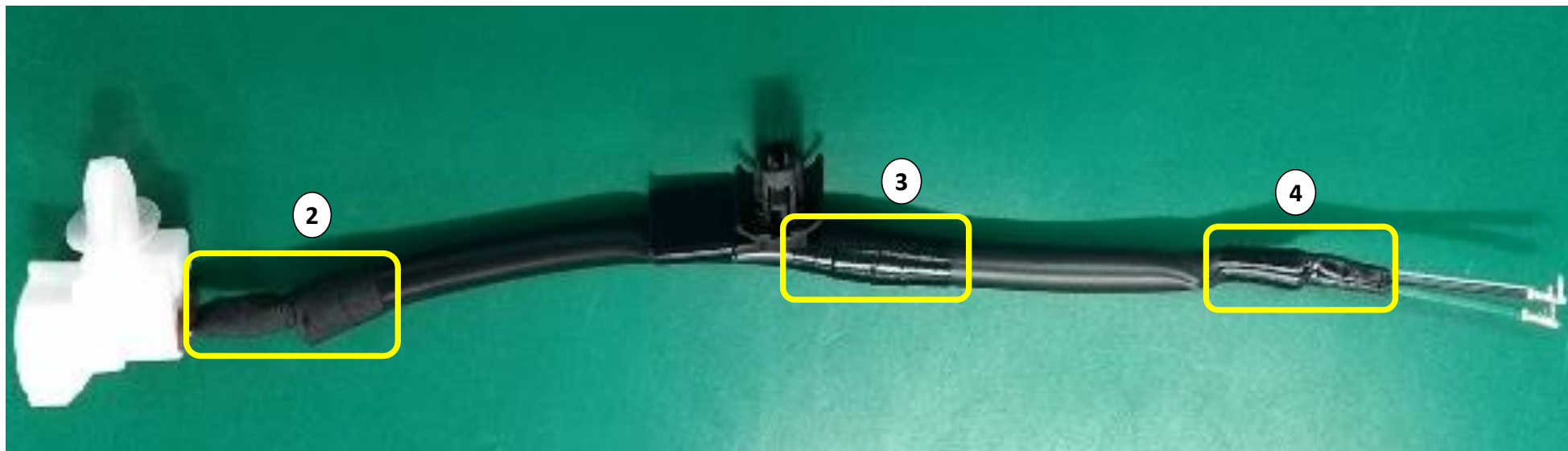
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP ASSY****7R0120-7021A****1****No Wrong facing of clamp****2****No Missing Tape (Black Tesa tape)****3****4****No Missing Tape (Black Nitto tape)**

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