
	WORK INSTRUCTION				Effectivity Date: December 21, 2023	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 200D/220D /7R0125-7022		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.: WI-ENG-PDE-751	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 0		Page No.:	1 of 6


PARTS: 1. Assy parts; Clamp 82711-35730 ; Black Tape [1pc]		JIG: 1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp assy	Table Lay-out	<div style="border: 1px solid red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px solid red; padding: 5px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px solid red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>Document references:</p> <p>1. Refer to WI-ENG-PDE-578 Taping Assembly Process</p> <p>1. No missing parts/tools. 2. No excess parts/tools.</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
12/21/2023	0	Initial issue. Transfer Clamp setting and Clamp assembly process from Taping assembly process (WI-ENG-PDE-578) to Clamp assembly process due to process improvement.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	D. Castillo
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: December 21, 2023

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PARTS:		1. Clamp 82711-35730 (B) 2. Black Tape [1pc]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<div><p>82711-35730 (B)</p><p>1. Get 1 pc.of band clamp 82711-35730 (B) then set to clamp location 1 using both hands.</p><p>2.Initially attach Black Tape on clamp location 1 using both hands</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p>

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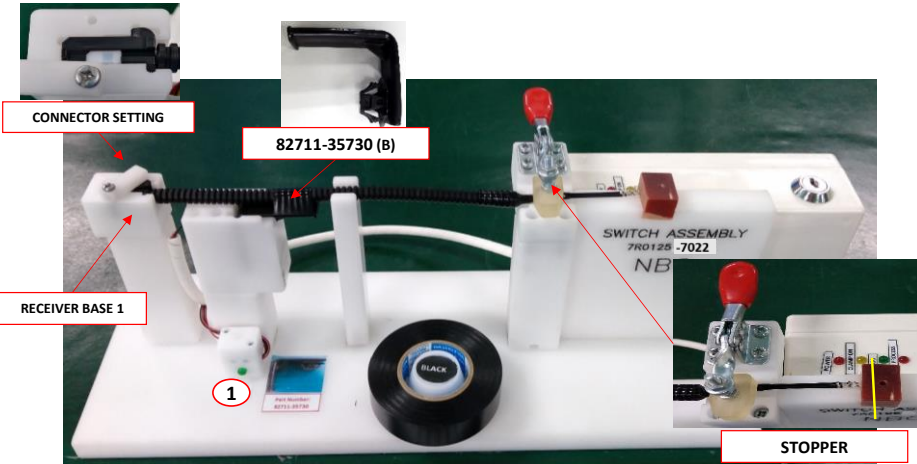

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Clamp assy	Clamp Assembly	n/a	<div></div> <div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). . First, set the connector 6098-6663 (B) in Receiver base 1 then lock. Continue to set the harness in jig. Last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was ON.</p></div> <div><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 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><p>3. Hold the tape on clamp location 1 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Go sound will be heard .</p></div> <div><p>4. Conduct POINT CHECKING before removing the harness from jig.</p></div>	<div></div> <div>STOPPER</div> <p>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals</p> <div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p></div>

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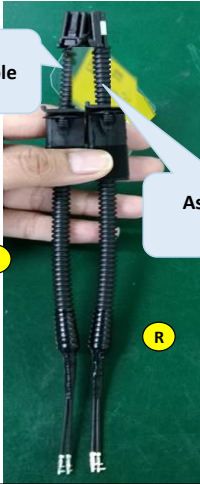



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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp assy	Visual/By Two's Inspection	 ACTUAL PRODUCT		 MASTER SAMPLE
		 Master sample Assembled parts L R	 2. Check the connector lock condition and insertion.	 3. Check the clamp attachment and taping condition.	1. No skip process
		1. Conduct alignment of harness (Master sample vs. assembled parts) using both hands.	 4. Check the taping condition and terminal appearance. Must be no deformed terminal.		

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Clamp assy	<div><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div>			<p>Important reminders/Note/s: 1. FOR HATSUMONO AND OWARIMONO</p> <p>1. No wrong dimension</p>

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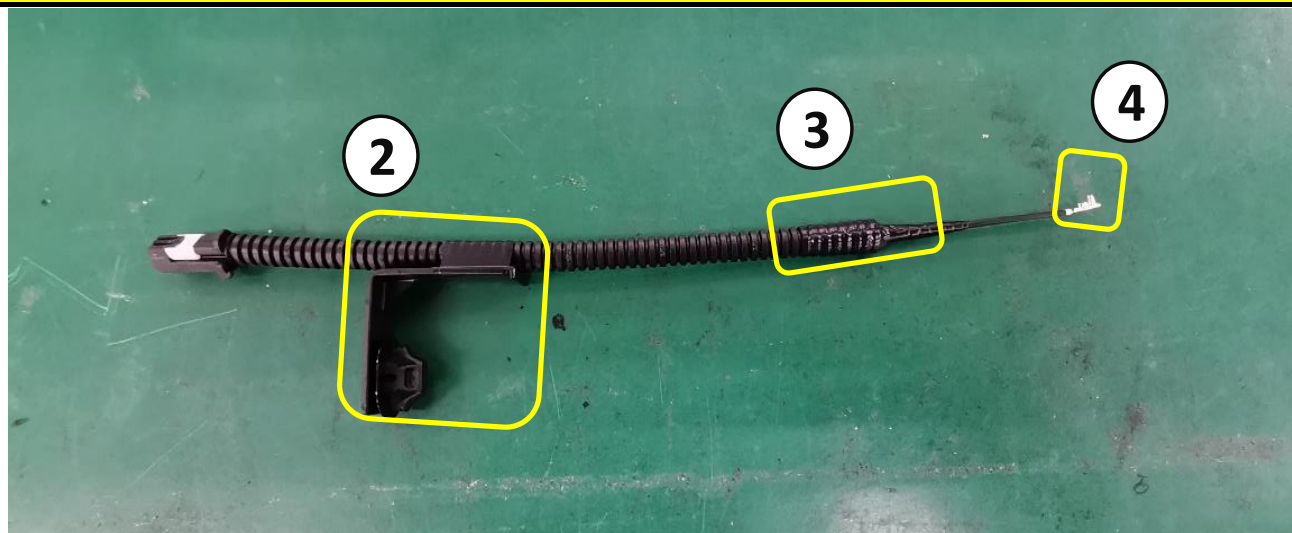
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PARTS:

1. Assy parts

JIG:

1. Clamp assembly jig

QUALITY CHECKPOINTS**P1****7R0125-7022****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/
Halflock Connector****2** No **Missing clamp****3** No **Missing Tape****5** No **Terminal Backing
Out****4** No **Deformed
Terminal**

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