



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

524D / 7N0241-7020

Customer:

TRJ

Car Model:

TOYOTA-PROBOX

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

February 7, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1189

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. Assy parts; Clamp 82711-52090 (W); Black tape [2pcs]; Violet tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

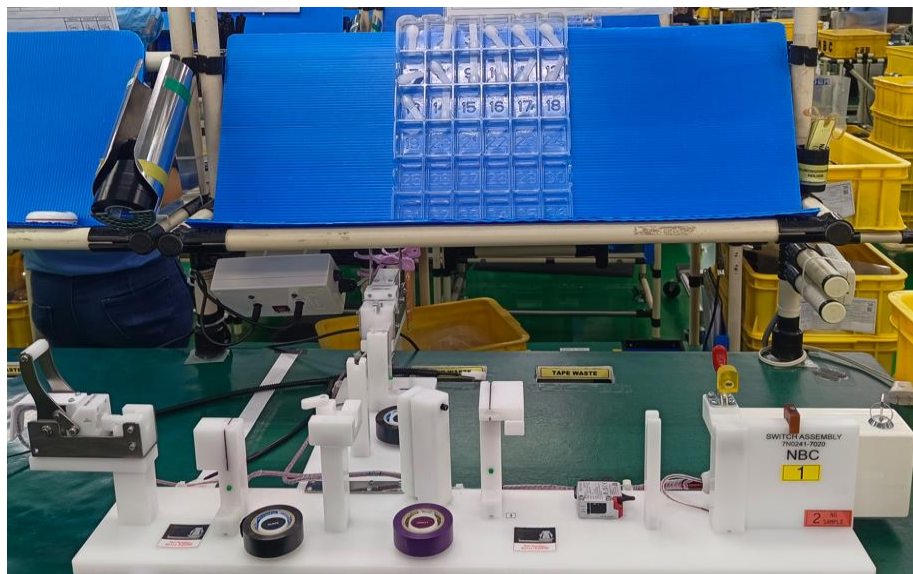
QUALITY POINTERS

1

Clamp
Assy

Table lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear 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 wrong orientation of the connector
2. No wrong use of connector
3. No damaged connector
4. No wrong insertion of wires
5. No loose insertion
6. One by one insertion
7. No deformed terminal
8. No wrong wire facing

Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
 2. Please hold the wire near terminal
- Document references:
1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

02/07/25

0

Initial issue.
Excluded process from **WI-ENG-PDE-1112** due to new process distribution; Change Purpose from pre-launch to Masspro. Inclusion of Table lay-out; Visual Inspection/Quality Checkpoints.

M. Ariola

C. Villanueva

A. Arañes

n/a

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

February 07, 2025

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DCC Stamp

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MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:

1. Clamp 82711-52090 (W) [3pcs]
2. Black tape [2pcs]
3. Violet tape

JIG:

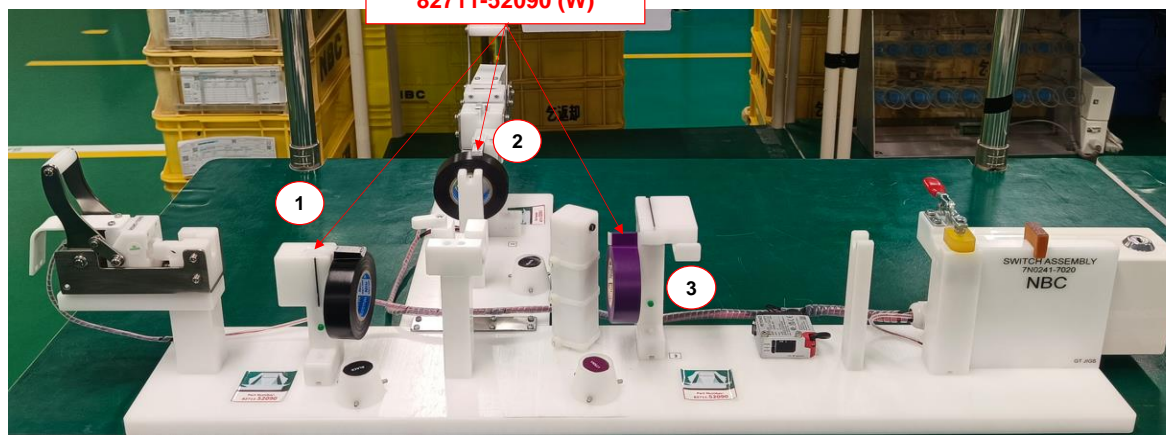
1. Clamp assembly jig

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

2

Clamp
Assy

Clamp setting



1. Get the **2pcs** of clamp 82711-52090 (W) using right hand then set to clamp **location 1** and **2** using both hands.

2. Get the **1pc.** of clamp 82711-52090 (W) using right hand then set to clamp **location 3.** using both hands.

3. Initially attach the **VIOLET TAPE** to Clamp **location 3** using both hands.

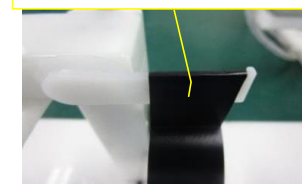
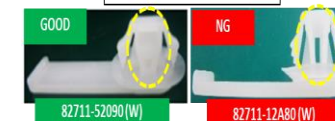
4. Initially attach the **BLACK TAPE** to **Clamp location 3** using both hands.

Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

1. No loose attachment of clamp
2. No damaged clamp
3. No Missing parts.

One wind for under tape

**CLAMP ILLUSTRATION**

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Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black tape [2pcs] 3. Violet tape [1pc]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp assembly	<div></div> <div><p>1. Put the assy parts into jig. <i>(See above picture for the correct setting)</i>. First, put the connector 6098-3802 (W) into Checker 1. Second, set the connector 6098-2220 (W) into Checker 2. Last, set the B-B wires together within stopper jig then press by the toggle clamp.</p><p>2. Check if all LED light for Wire 1 and Wire 2 was ON. If encountered abnormality, STOP and immediately CALL attention of the leader. WAIT for the further instruction and continue the process if the sequence light on location 1 was ON.</p><p>3. On clamp location no. 1 hold the BLACK TAPE using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if the sequence for Location 2 was ON.</p><p>4. On clamp location no. 2 hold the BLACK TAPE using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue the process if the sequence for Location 3 was ON.</p><p>5. On clamp location no. 3 hold the VIOLET TAPE using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. GO buzzer will be heard.</p><p>6. After taping, conduct POINT CHECKING before removing the harness from jig.</p></div>			<p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <p>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals 2. Make 2-3 windings for clamp taping.</p> <p>Important reminders/Notes 1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</p>

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Page No.:

4 of 5

PARTS: 1. Assy parts

JIG:

n/a

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

4

Clamp
Assy

Measurement

NOTE:

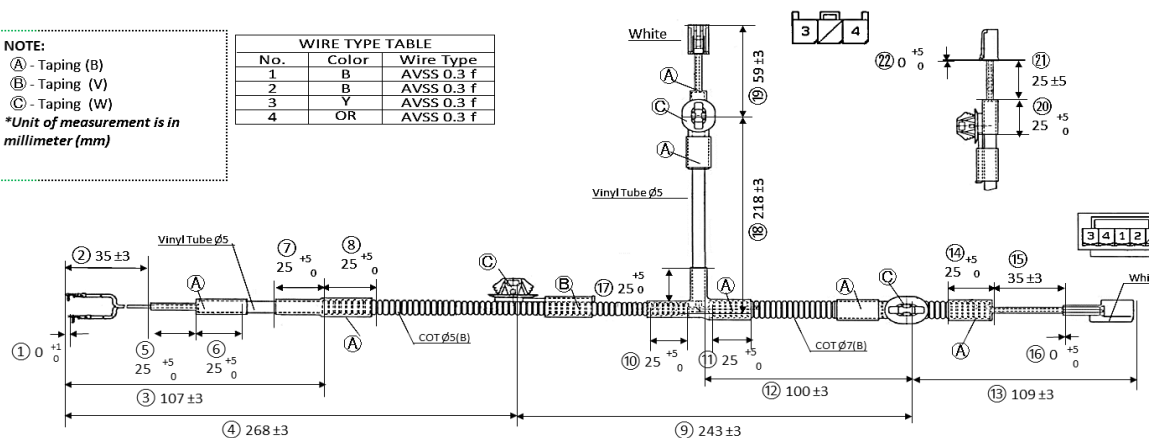
(A) - Taping (B)

(B) - Taping (V)

(C) - Taping (W)

**Unit of measurement is in
millimeter (mm)***WIRE TYPE TABLE**

No.	Color	Wire Type
1	B	AVSS 0.3 f
2	B	AVSS 0.3 f
3	Y	AVSS 0.3 f
4	OR	AVSS 0.3 f



1. No wrong dimension

Important reminders/Notes

1. Please use calibrated/verified measuring tape when fetting the measurement.
2. For Hatsumono, Nakamono and Owarimono

Document reference/s:

1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.

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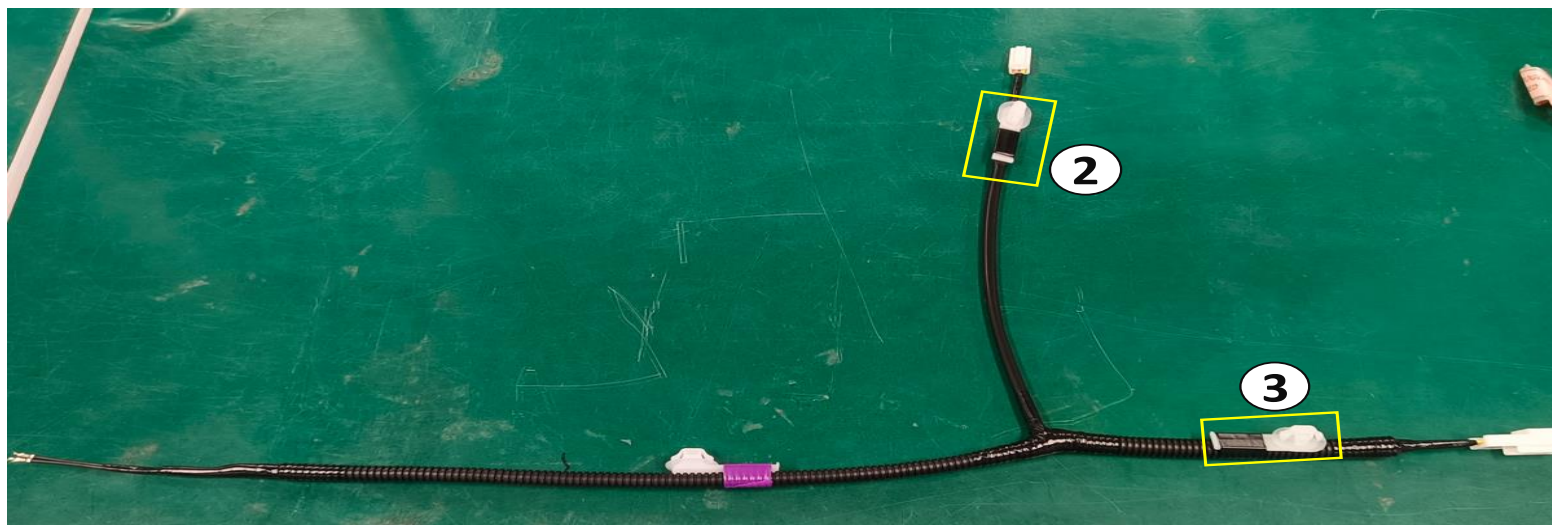
5 of 5

PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0241-7020**

① **No wrong facing of clamp**

②

③

No Missing Tape / No wrong use of tape (Black tape)

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