



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 27, 2024

Model code/Part number:

241B / 7L0050-7023

Customer:

TRQSS

Car Model:

LEXUS ES

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-897

Revision No.:

0

Page No.:

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PARTS: 1. Clamp 82711-52090 (W); Black Tape; Sample parts

JIG:

1. Clamp assembly jig

NO.

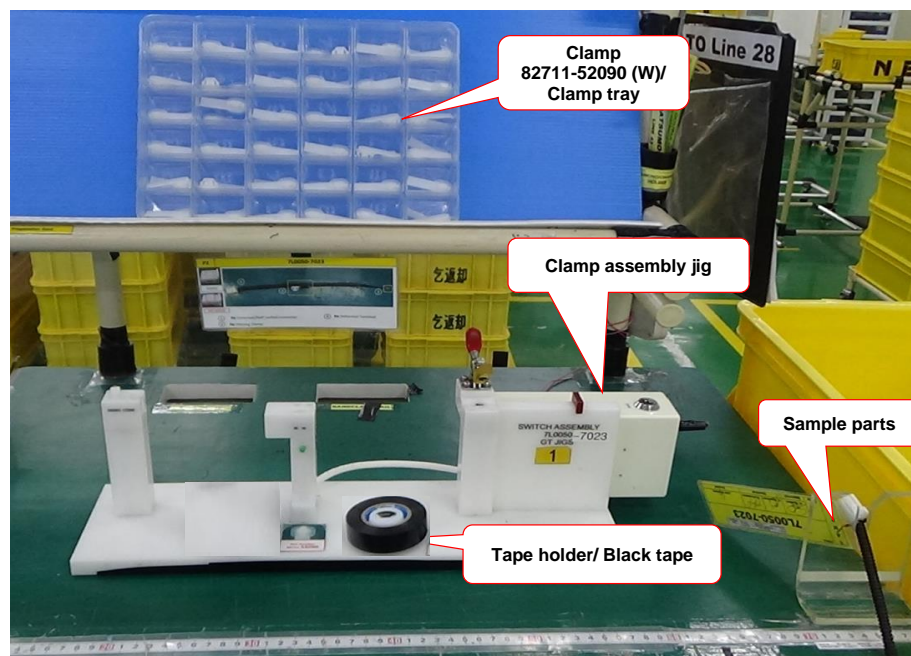
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/27/24	0	Initial issue. Transfer Clamp process to from taping Assembly process to Clamp Assembly Process.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a

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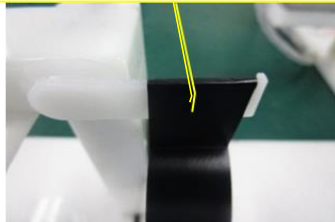
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Clamp 82711-52090 (W) 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	<div>Clamp Setting</div> <div></div> <div>1. Get 1pc of clamp 82711-52090 (W) using right hand and set to clamp location 1 using both hands.</div> <div>2. Get Black tape using right hand and put pre-tape on clamp in location 1 using both hands.</div>		n/a	<div>1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape 4. No missing tape</div> <div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp. 2. Must be no gap between terminal and stopper jig. 3. make 2-3 windings for clamp taping.</div>

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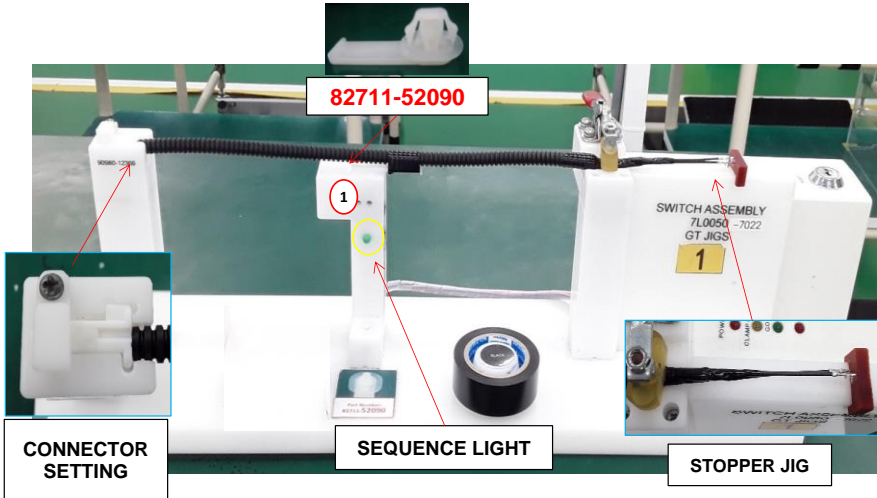

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	<div><div><p>82711-52090</p><p>1</p><p>CONNECTOR SETTING</p><p>SEQUENCE LIGHT</p><p>STOPPER JIG</p></div><div><p>1. Get the assy parts using right hand. First, put the connector to receiver base. Second, put the terminal to stopper jig then pull down the toggle clamp.</p><p>2. Check if LED light for Power, Clamp on and Sequence light in location 1 was ON. If encountered abnormality, STOP the process, CALL the leader and WAIT for instruction.</p><p>3. Hold the Black tape on location 1 using right hand. Combine the COT and clamp. Make 3 winds and cut the tape. Press the SW button after taping. GO sound will be heard.</p><p>4. Conduct POINT CHECKING before removal from jig.</p></div></div>			<div><p>Important reminders/Note/s:</p><p>1. <i>Make sure no gap between stopper and terminals.</i></p><p>1. No wrong use of tape 2. No loose tape 3. No flip-out tape 4. No peel-off tape 5. No missing tape 6. No wrong dimension</p></div>

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JIG:

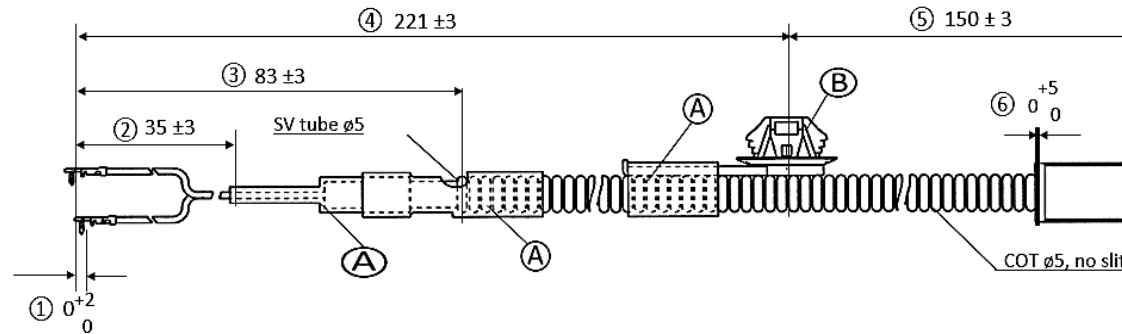
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

Clamp
Assy

Measurement

**NOTE:**

- Ⓐ - Taping (B)
Ⓑ - Clamp (W)

MEASURING TAPE**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

WIRE TYPE TABLE

	COLOUR	WIRE TYPE
1	B	AVSS0.3f
2	B	AVSS0.3f

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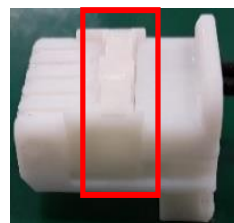
QUALITY CHECKPOINTS

CLAMP ASSY

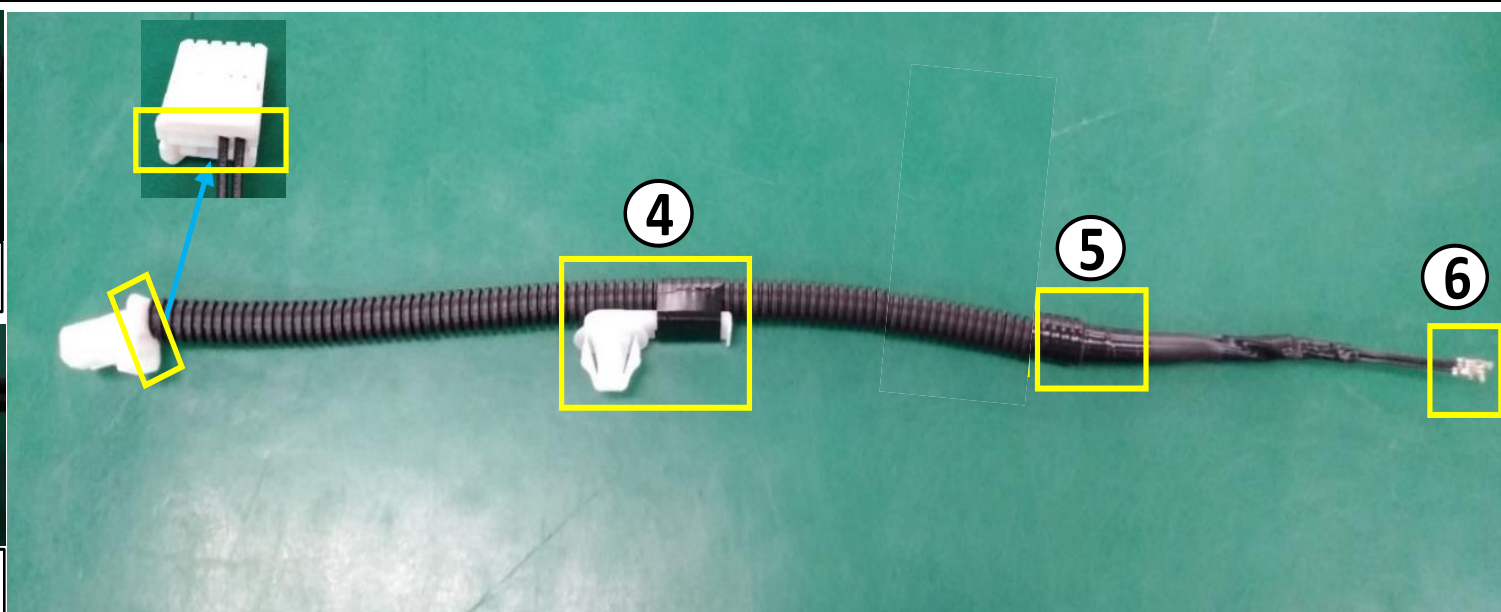
7L0050-7023



GOOD



NO GOOD



GOOD



NO GOOD

① No **Unlock/ Half Lock Connector**

③ No **Terminal Backing Out**

⑤ No **Missing Tape**

② No **Wrong Insert**

④ No **Missing Clamp**

⑥ No **Deformed Terminal**

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