



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 13, 2024

Validity Date:

n/a

Model code/Part number: 241B / 7L0051-7023

Customer: TRQSS

Car Model: LEXUS ES

Document No.:

WI-ENG-PDE-923

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS: 1. Assy part 1 &amp; part 2; Clamp 82711-52090 (W); Black tape(2pcs.)

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

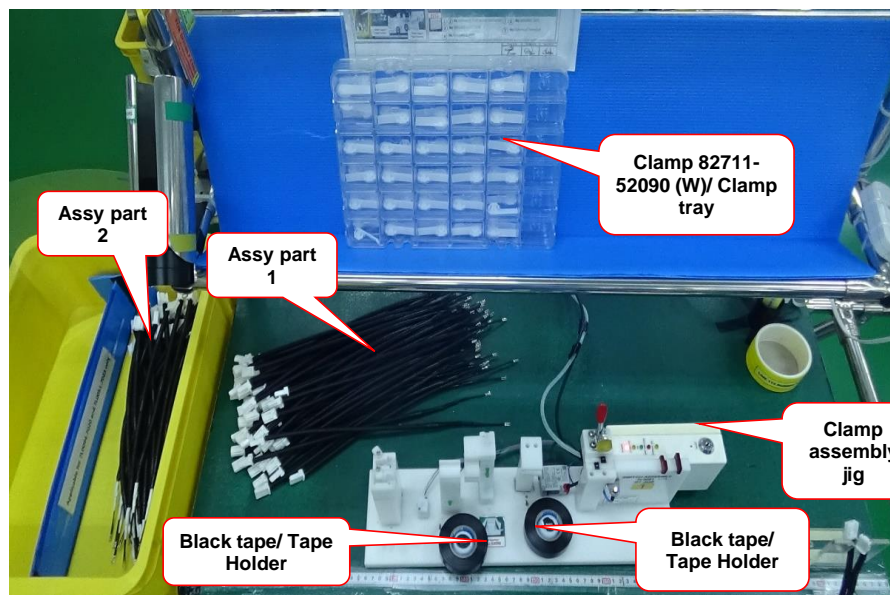
QUALITY POINTERS

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.

**Document references**

1. Please refer to WI-PRO-CNC-017 for the Wire and Strip Length tolerance.

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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

08/13/24 0 Initial issue. Transfer clamp process from Taping assembly process to Clamp 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:

August 13, 2024

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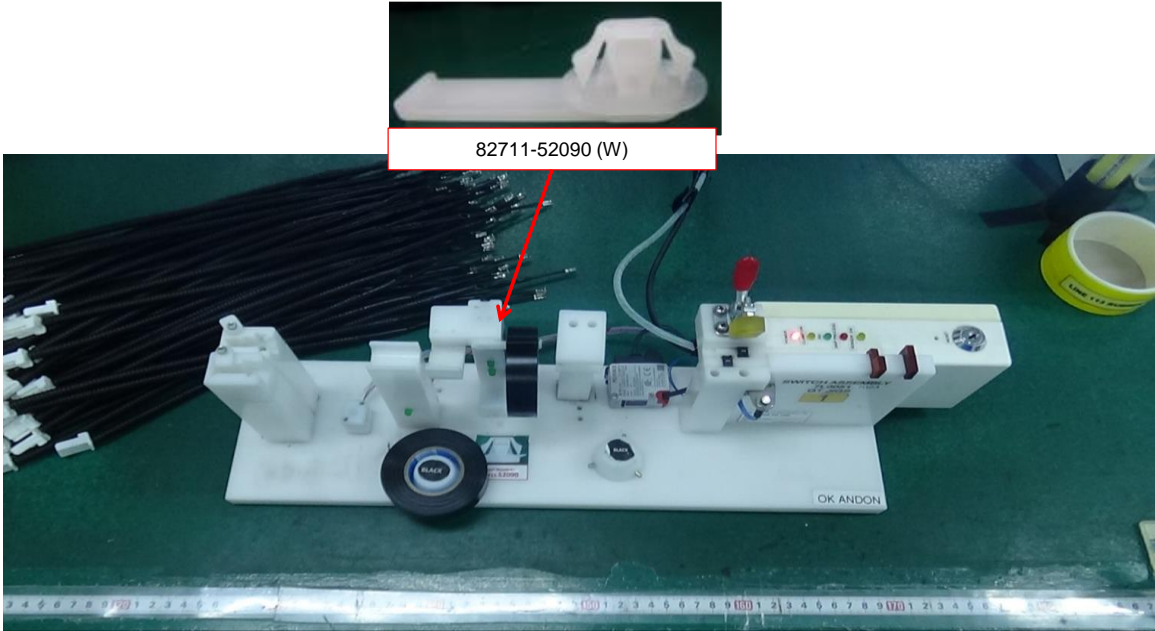
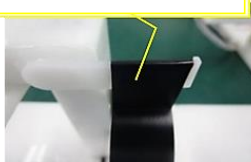


☒ MASSPRO

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PARTS:		1. Clamp 82711-52090 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<div><div></div><div><p>1. Get 1pc of clamp 82711-52090 (W) using right hand and set it to clamp location 2 using both hands.</p><p>2. Initially attach BLACK TAPE to location 2 using both hands.</p></div></div>			<p><b>Important reminders/Note/s:</b></p> <p><b>1. Make sure no gap between the terminal and stopper jig.</b></p> <p>1. No loose attachment of clamp 2. No lacking/excess tape windings 3. No missing tape 4. No wrong use of tape</p> <div><div>STANDARD TAPING FOR CLAMP</div><div><div>One wind for under tape</div><div></div></div><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div><div>82711-52090 (W)</div></div><div><div>NG</div><div><div>82711-12A80 (W)</div></div></div></div></div></div></div>

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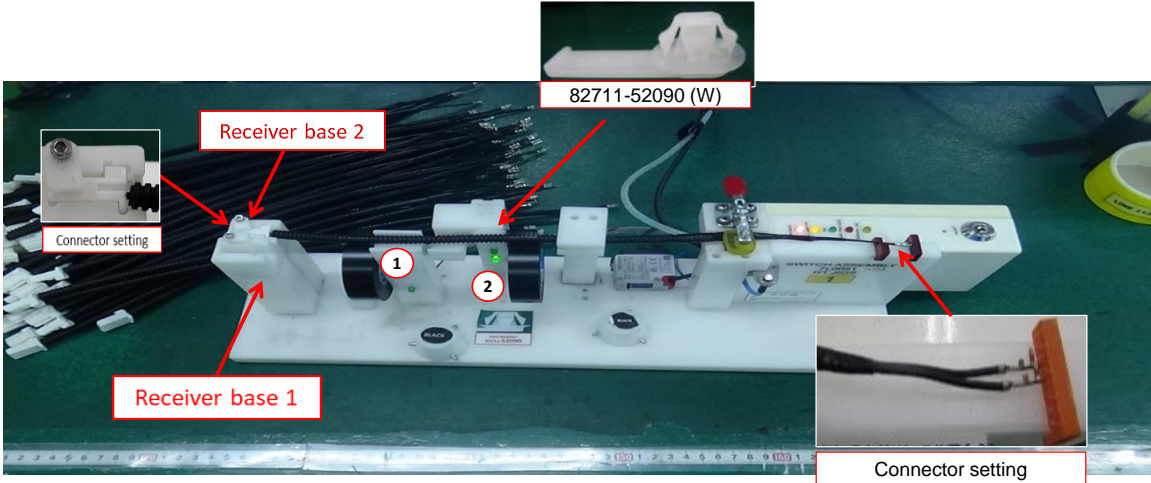
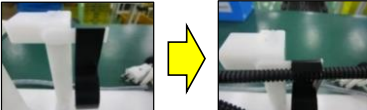

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PARTS:		1. Assy parts 1 & 2 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly			
		<div><p>82711-52090 (W)</p><p>Receiver base 2</p><p>Connector setting</p><p>Receiver base 1</p><p>1</p><p>2</p><p>Connector setting</p></div> <div><p>1. Get the assy parts (2) and set into jig. (See above picture for correct setting). <i>Note: Assy parts with Black tape on Vinyl to wire near terminal.</i> First, set the connector 6098-3810 (W) to Receiver base 2 and Lock using left hand. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location 2 was on.</p><p>2. Get Black tape using right hand, conduct pre-taping of COT on location 1 using both hands. Make 2 windings. Press the <b>SW button</b> using both hands. Proceed to location 2 after taping. <i>Note: Do not cut the tape.</i></p><p>3. Hold the tape on clamp location 2 then start taping using both hands. Make 2 windings. Press the <b>SW button</b> using both hands. <i>Note: Do not cut the tape.</i></p><p>4. Get the assy parts (1) and set into jig. (See above picture for correct setting). <i>Note: Assy parts with white tape on Vinyl to wire near terminal.</i> First, set the connector 6098-5577(W) to Receiver base 1. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp.</p></div>			
				<div><p>1. No loose attachment of clamp 2. No lacking/excess tape windings 3. No missing tape 4. No wrong use of tape</p><p><i>Important reminders/Note/s:</i></p><p>1. Make sure no gap between the terminal and stopper jig.</p><div></div></div>	

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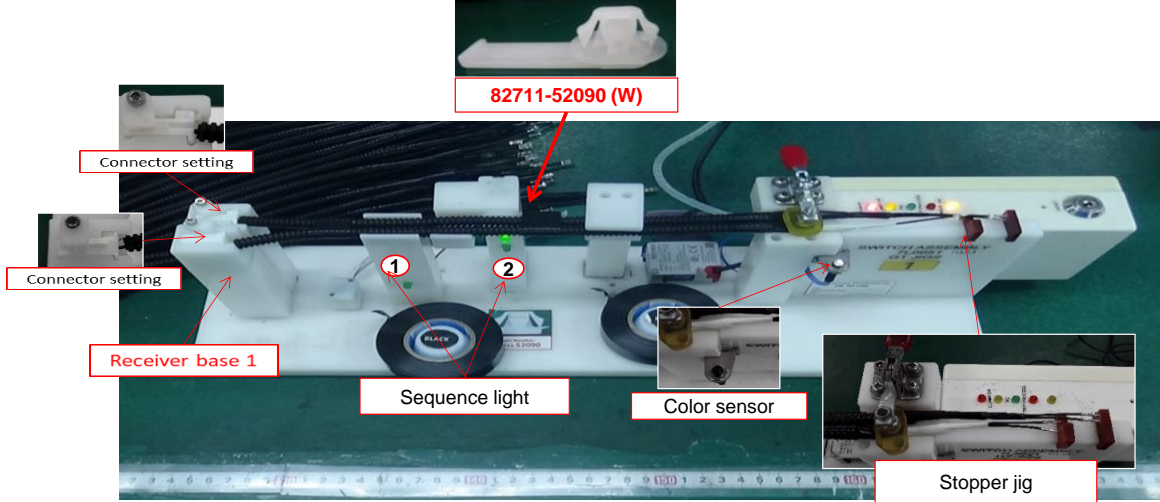

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PARTS:		1. Assy parts 2. Black Tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly (continuation)	<div></div>		<p><b>Important reminders/Note/s:</b></p> <p><b>1. Make sure no gap between the terminal and stopper jig.</b></p> <div></div>
			<div>5. Check if all <b>LED light</b> for <b>POWER ON</b>, and <b>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 and continue the process.</div> <div>6. Combine the COT of assy parts (1) and assy parts (2) using both hands on location <b>1</b>. Make <b>3</b> windings and cut the tape. Press the <b>SW button</b> after taping. Proceed to location <b>2</b> after taping.</div>	<div>7. Proceed the attachment of COT to clamp on location <b>2</b> using both hands. Make 3 windings and cut the tape. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard.</div> <div>8. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div>	<p>1. No loose attachment of clamp 2. No lacking/excess tape windings 3. No missing tape 4. No wrong use of tape</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Make sure no gap between stopper and terminals</b> <b>2. Make 2-3 windings for clamp taping.</b></p>

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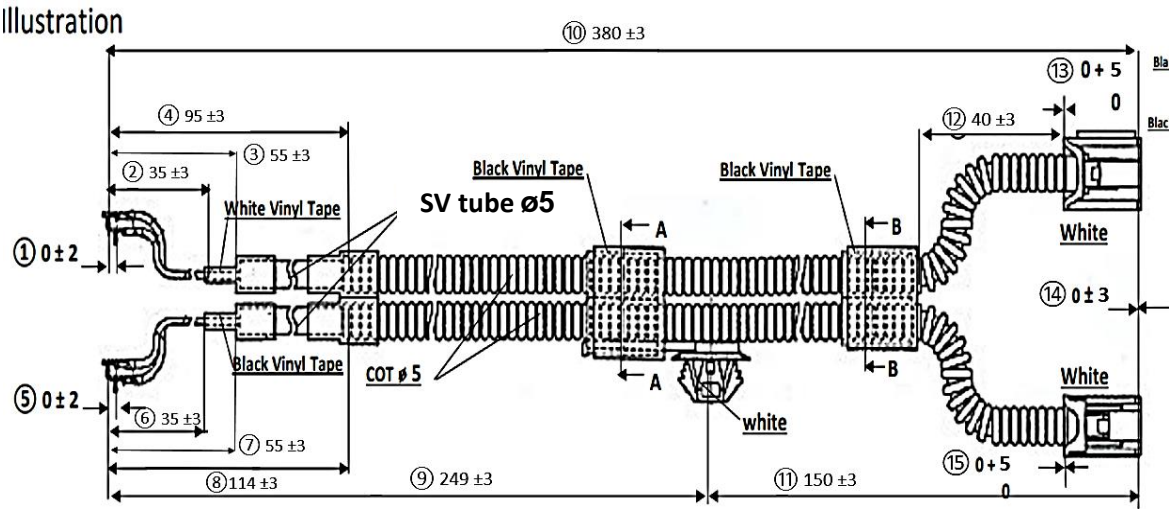
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp assy  Measurement	<p>Illustration</p> 		<p>1. No wrong dimension</p> <p><b>Important reminders/Notes</b></p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono</p> <p><b>Document reference/s:</b></p> <p>1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.</p>

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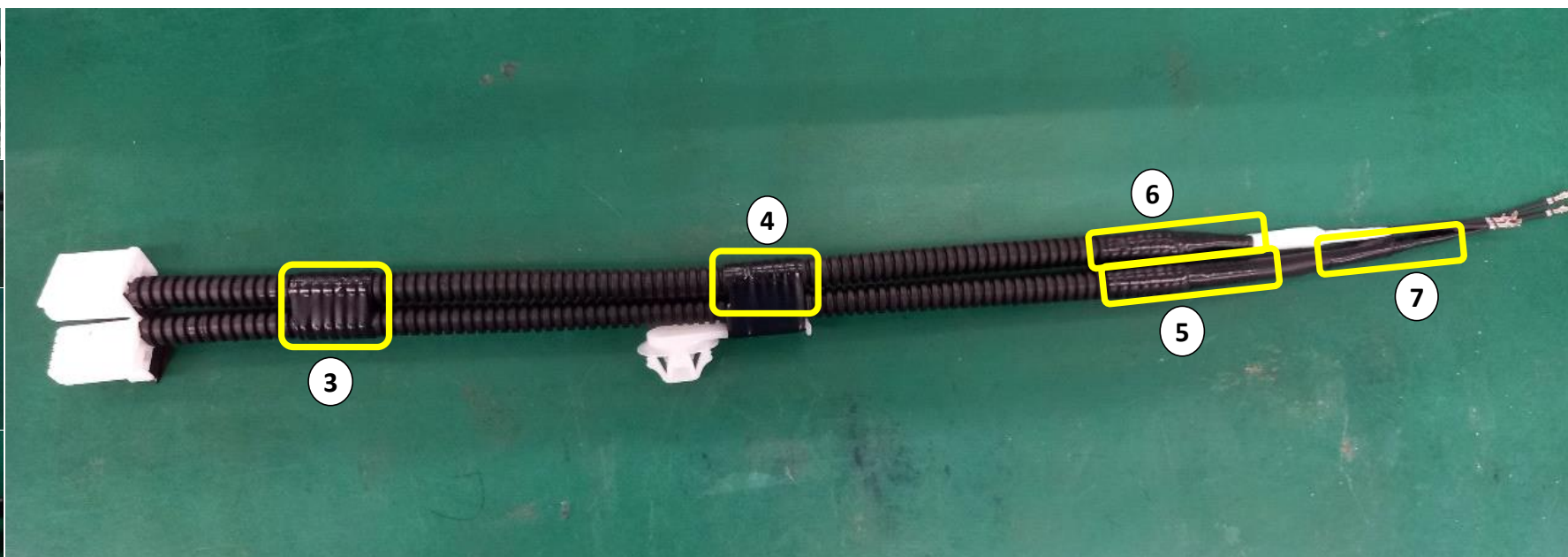
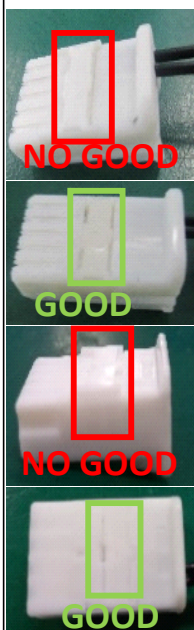
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**6 of 6****PARTS:**

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP ASSY****7L0051-7023****1** No Wrong facing of clamp**2** No Unlock/Halflock connector**3 4 5 6 7** No Missing Tape and Spot tape (Black tape)

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