



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

920B / 7R0116-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-1030

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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## PARTS:

1. Assy parts: Clamp 82711-3A640 (B) ; Black tape 20mm; Label 7V3200-0020

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

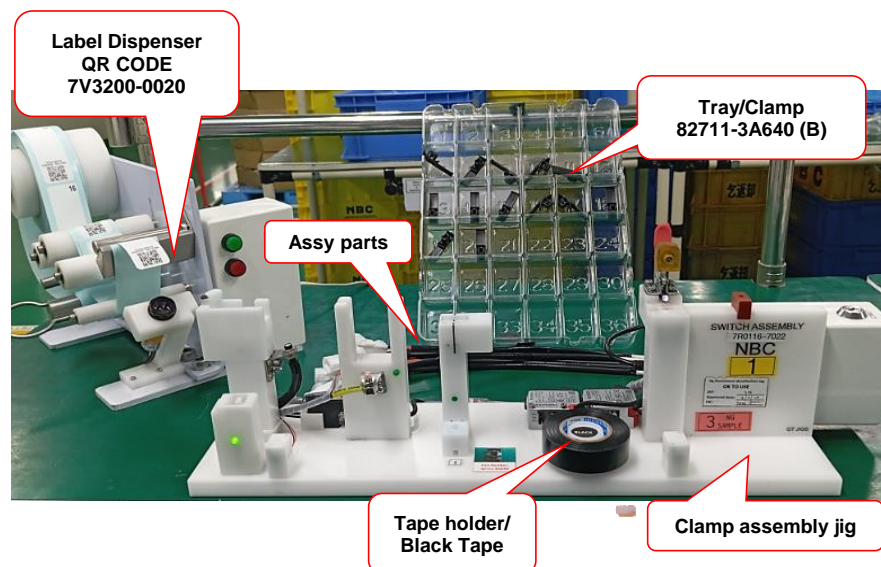
QUALITY POINTERS

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 missing parts/tools
2. No excess parts/tools

**Document reference/s:**

1. Refer to **WI-ENG-PDE-650A-B** for Taping assembly process

## Revision History

Revision History							Prepared by	Reviewed by	Approved by	Noted by
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
09/12/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
09/09/24	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				

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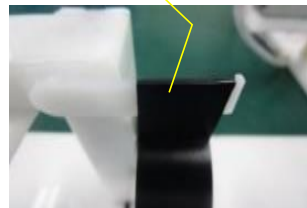

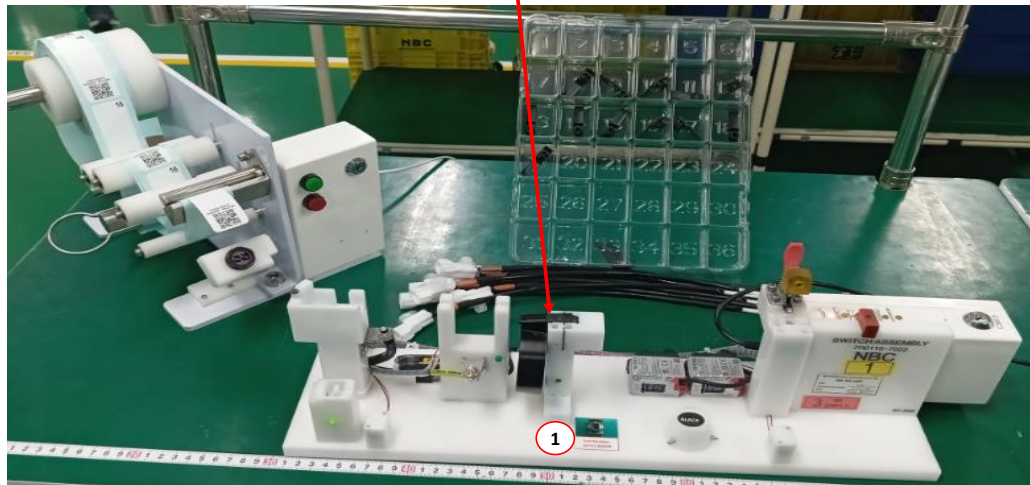
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PARTS:		1. Clamp 82711-3A640 (B) 2. Black tape 20mm		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting		<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div></div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</div>	
		<div> 82711-3A640 (B)</div> <div></div> <div>1. Get 1pc. of clamp 82711-3A640 (B) using both hands then set to clamp location 1 using both hands.</div> <div>2. Initially attach Black tape on clamp location 1 using both hands.</div>			

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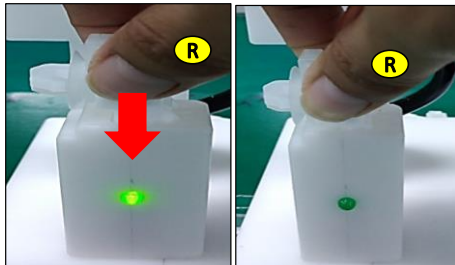
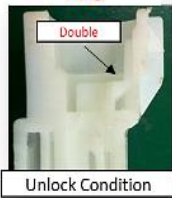

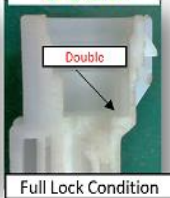



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PARTS:	1. Assy parts		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy  Connector lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</p></div><div><div><p>Unlock Condition</p><p>Half Lock Condition</p><p>Full Lock Condition</p></div><div><div><p>Before lock</p><p>After lock</p></div><div><div>LOCKING JIG</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></div></div>		

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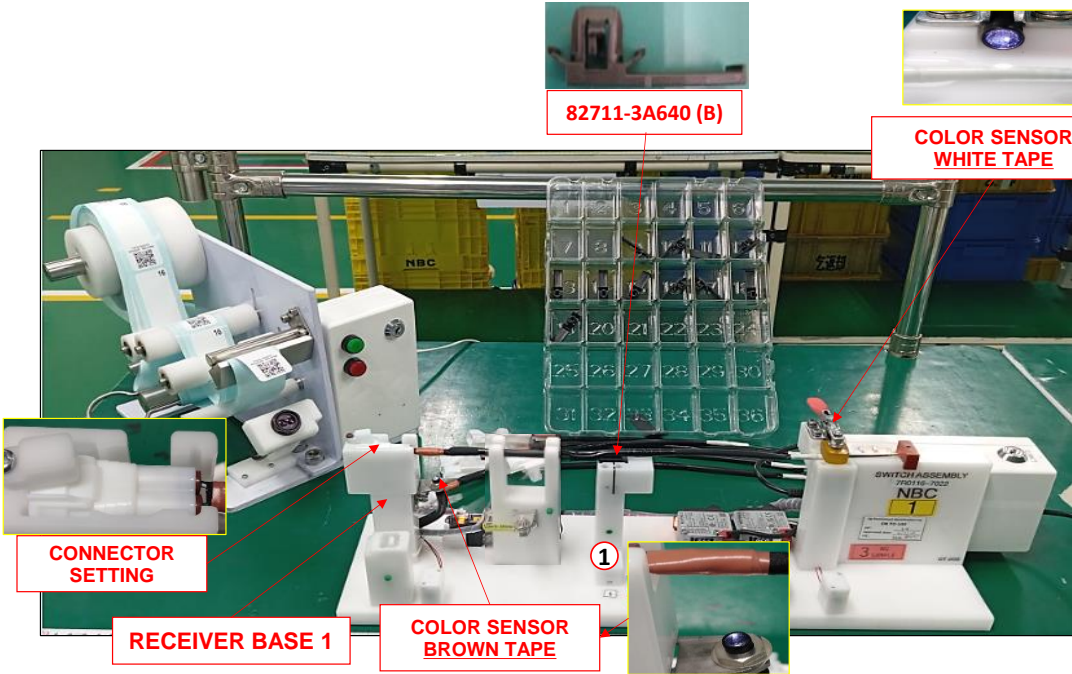

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PARTS:		1. Assy parts 2. Black tape 20mm		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Clamp assembly	 <p>82711-3A640 (B)</p> <p>COLOR SENSOR WHITE TAPE</p> <p>CONNECTOR SETTING</p> <p>RECEIVER BASE 1</p> <p>COLOR SENSOR BROWN TAPE</p> <p>1</p>		 <p><b>Important reminders/Note/s:</b> <b>1. Make sure no gap in stopper and terminals</b></p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>

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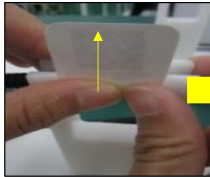
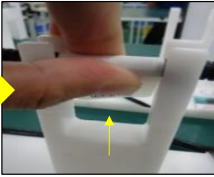
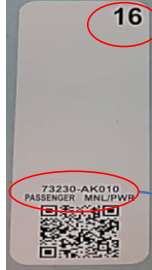
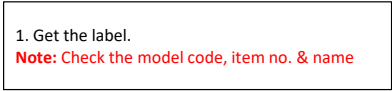
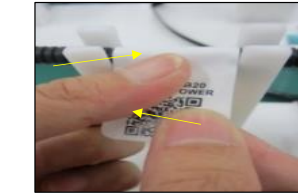
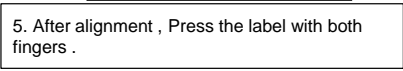
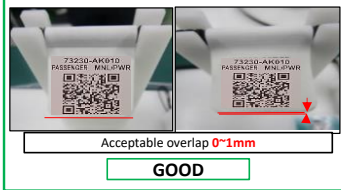


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PARTS:		1. Assy parts 2. Label 7V3200-0020		JIG:	1. Clamp assembly jig																	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																	
5	Clamp Assy Label Attachment	<table border="1"><thead><tr><th>MODEL CODE</th><th>ITEM NO.</th><th>ITEM NAME</th></tr></thead><tbody><tr><td>7R0116-7022</td><td>73230-AK010</td><td>PASSENGER MNL/PWR</td></tr><tr><td>7R0117-7025</td><td>73240-AK010</td><td>DRIVER MANUAL</td></tr><tr><td>7R0118-7025</td><td>73240-AK020</td><td>DRIVER PWR/ISO D</td></tr><tr><td>7R0119-7021</td><td>73230-AK050</td><td>PASSENGER ISO D</td></tr><tr><td>7R0120-7022</td><td>73230-AK030</td><td>PASSENGER FOLD-FLAT</td></tr></tbody></table>           	MODEL CODE	ITEM NO.	ITEM NAME	7R0116-7022	73230-AK010	PASSENGER MNL/PWR	7R0117-7025	73240-AK010	DRIVER MANUAL	7R0118-7025	73240-AK020	DRIVER PWR/ISO D	7R0119-7021	73230-AK050	PASSENGER ISO D	7R0120-7022	73230-AK030	PASSENGER FOLD-FLAT		<ol style="list-style-type: none"><li>1. No bubbles</li><li>2. No damage</li><li>3. No peel off</li><li>4. No wrong use of label</li><li>5. No missing parts</li><li>6. No loose attachment</li><li>7. No wrong usage of label</li></ol>
MODEL CODE	ITEM NO.	ITEM NAME																				
7R0116-7022	73230-AK010	PASSENGER MNL/PWR																				
7R0117-7025	73240-AK010	DRIVER MANUAL																				
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### PARTS:

1. Assy parts

2. Label 7V3200-0020

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

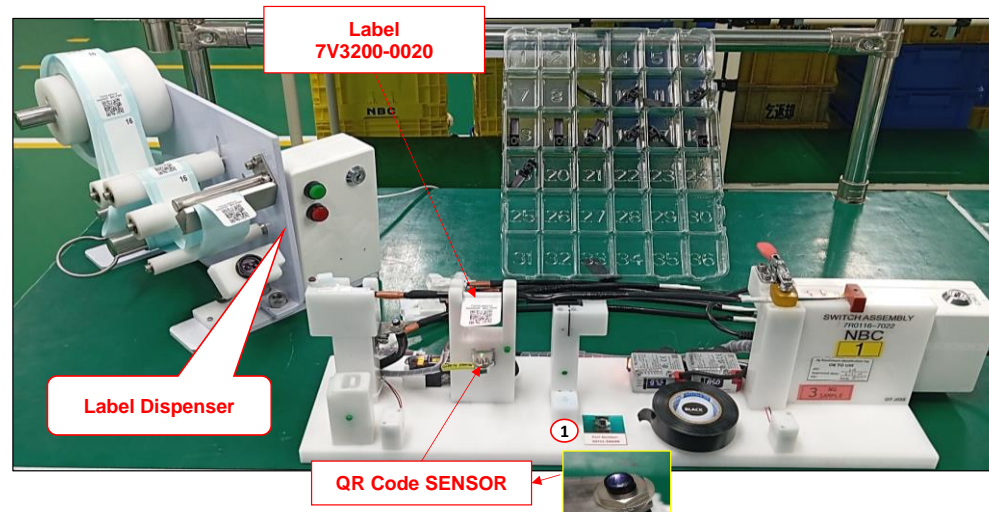
TOOLS/PPE

QUALITY POINTERS

6

Clamp  
Assy

Clamp assembly



7. After taping, conduct **POINT CHECKING** before removing the harness from the jig.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position



**Important reminders/Note/s:**  
**1. Make sure no gap in stopper and terminals**

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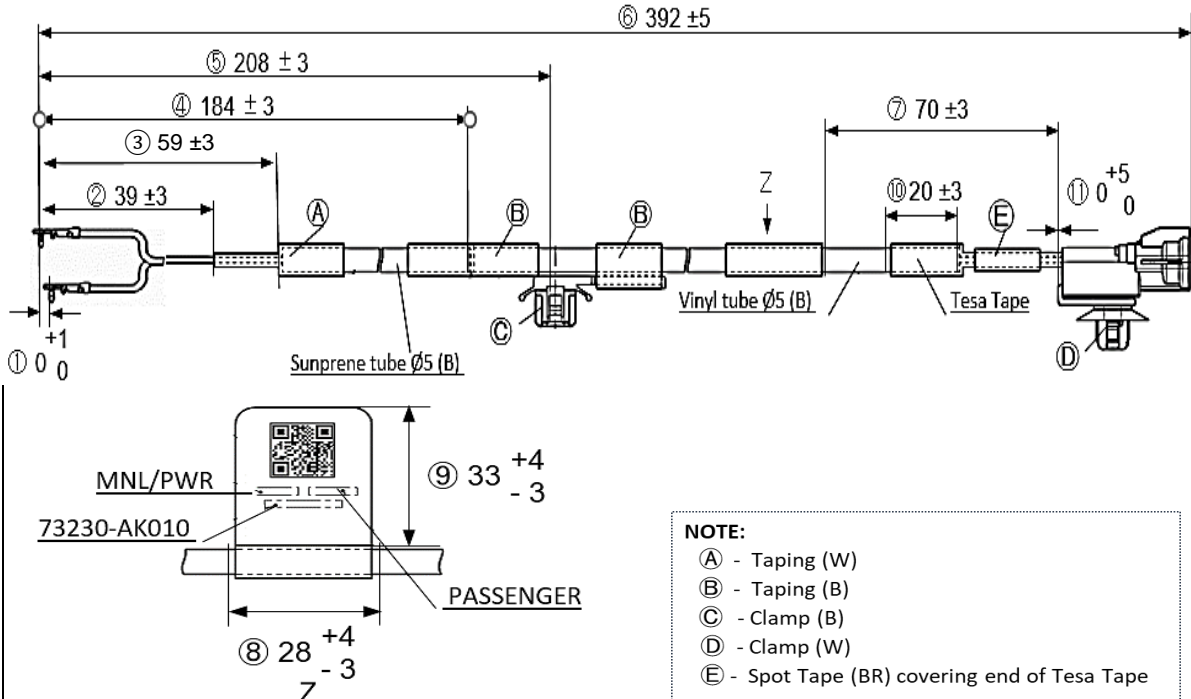

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Clamp Assy	Measurement	<div></div>	<div></div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring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

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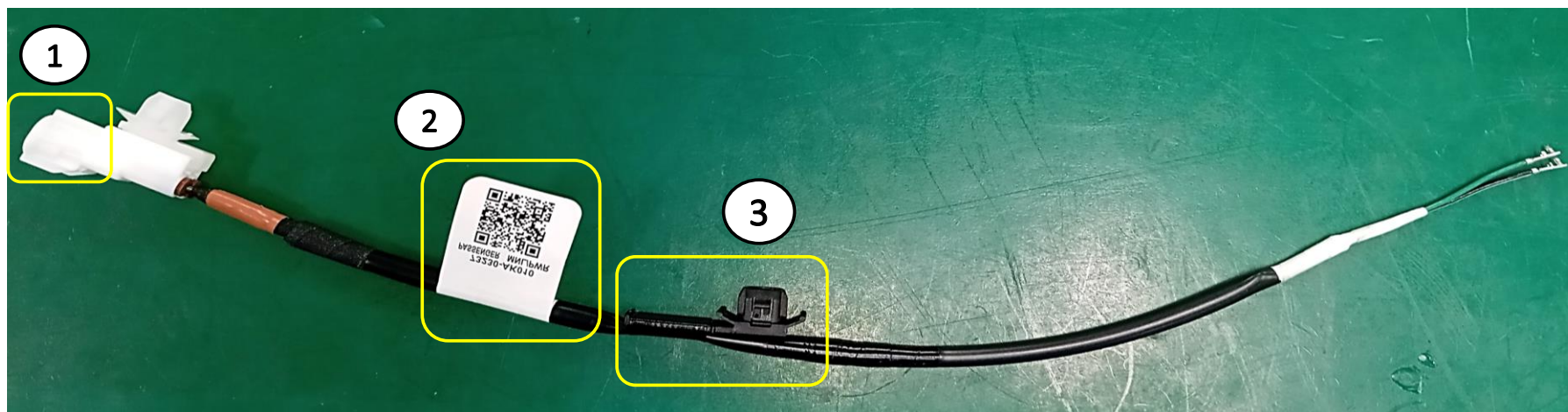
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**8 of 8****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7R0116-7022****1 No Unlocked/Half-Locked Connector****3 No Wrong facing of clamp****2 No Wrong Facing/Used of QR Code label**

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