



## WORK INSTRUCTION

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 11, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

TM3 / 7L0116-7020

Customer: TRQSS

Car Model: SUBARU ASCENT

Document No.:

WI-ENG-PDE-1023

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 6

## PARTS:

1. Assy parts; Gray Urethane foam t=4; 75mm X 30mm; Clamp 82711-16830 (B)

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

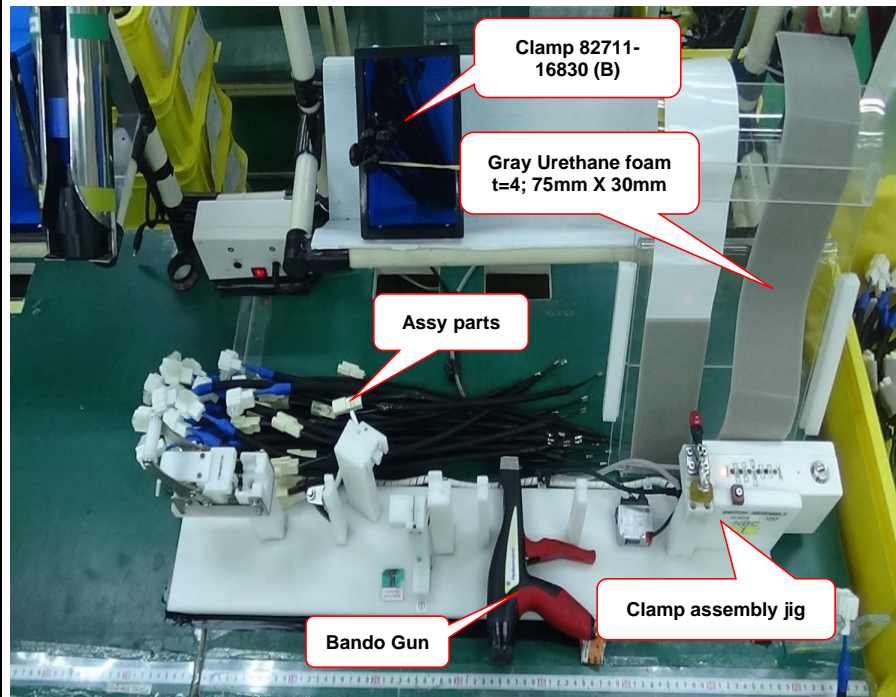
QUALITY POINTERS

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

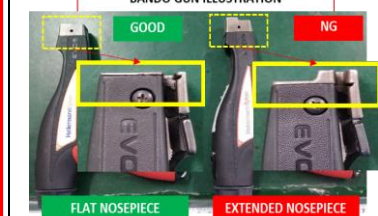
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

## Document reference/s:

1. Refer to **WI-ENG-PDE-341A-B** for Taping assembly process

## BANDO GUN ILLUSTRATION



## BAND CLAMP ILLUSTRATION



## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
09/11/24	0	Initial issue. Separate clamp assy from Taping assembly process.	D. Castillo	C. Villanueva	A. Arañes	n/a

Prepared by

Reviewed by

Approved by

Noted by

  
D. Castillo  
C. Villanueva  
A. Arañes

n/a


Est. Date:

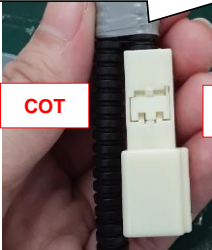
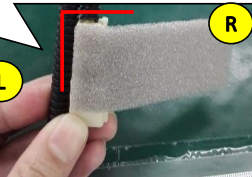



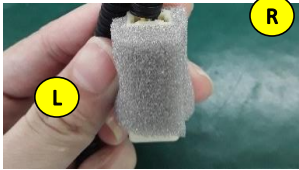
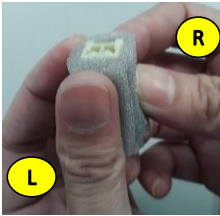
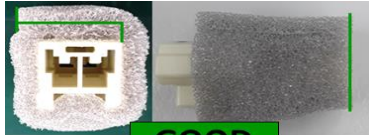
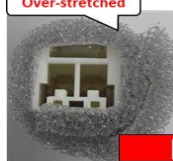
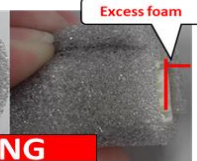
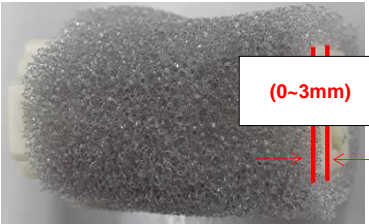
September 11, 2024

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DCC Stamp

	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>September 11, 2024</b>		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>TM3 / 7L0116-7020</b>		Customer: <b>TRQSS</b>	Car Model: <b>SUBARU ASCENT</b>	Document No.: <b>WI-ENG-PDE-1023</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 6


<b>PARTS:</b>		1. Gray Urethane foam t=4; 75mm X 30mm 2. Assy parts		JIG:	N/A
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	Clamp Assy	<div>Urethane foam manual attachment to connector</div> <div><div><div>Step 1: Identify the right facing to attached the foam</div><div><div>COT</div><div>Connector</div></div><div>Step 2: Get the Urethane foam and begin the attachment.</div><div><div>L</div><div>R</div></div></div><div><div>Step 3: Attached the foam in all sides of the connector.</div><div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div><div><div>Step 4: Press the Urethane foam side by side after attachment.</div><div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div></div></div><div><div>N/A</div></div><div><div><div>1. No damaged Urethane foam</div><div>2. No missing Urethane foam</div><div>3. No stretched Urethane foam</div></div><div><div>GOOD</div></div><div><div><div>Over-stretched</div></div><div><div>Excess foam</div></div><div>NG</div></div><div><div>(0~3mm)</div></div><div><b>Important reminders/note/s:</b> 1. Do not stretch Urethane foam. 2. (0~3mm) tolerance from Urethane foam to Connector. 3. Follow the attachment sequence based on the illustration. 4. Foam and connector must be align.</div></div></div>			

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 6

PARTS:	1. Clamp 82711-16830 (B) 2. Assy part			JIG:	1. Clamp assembly jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	Clamp Assy	<div><div>Connector Setting</div><div>Checker 2</div><div>82711-16830(B)</div><div>Stopper</div><div>Checker 1</div><div>Color sensor</div><div>Sequence light</div><div>1</div></div> <div><p>1. Put the assy. First, set the connector to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector to <b>Checker 2</b> for continuity checking. Third, get the clamp <b>82711-16830 (B)</b> and set to clamp location <b>1</b> using both hands. Last, set the <b>B-B wires</b> with terminal end together within the stopper then press by <b>Toggle clamp</b>.</p><p>2. Check if all LED light for <b>POWER ON, WIRE1</b> and <b>WIRE2, CLAMP ON, and COLOR SENSOR</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 then continue the process. Continue if the sequence light of location <b>1</b> was <b>ON</b>.</p><p>3. Initially tighten the band clamp on location <b>1</b> using both hands.</p></div>						

1. No wrong use of clamp  
2. No wrong set of clamp  
3. No missing clamp  
4. No loose band clamp  
5. No super tight band cut

**Important reminders/note/s:**

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

2. Sequence light will On if the color sensor detect the **BLUE TAPE**.

3. Make sure no gap between the terminal and stopper jig.

BAND CLAMP ILLUSTRATION

GOOD

NG





82711-16830 (B)

82711-34490 (B)


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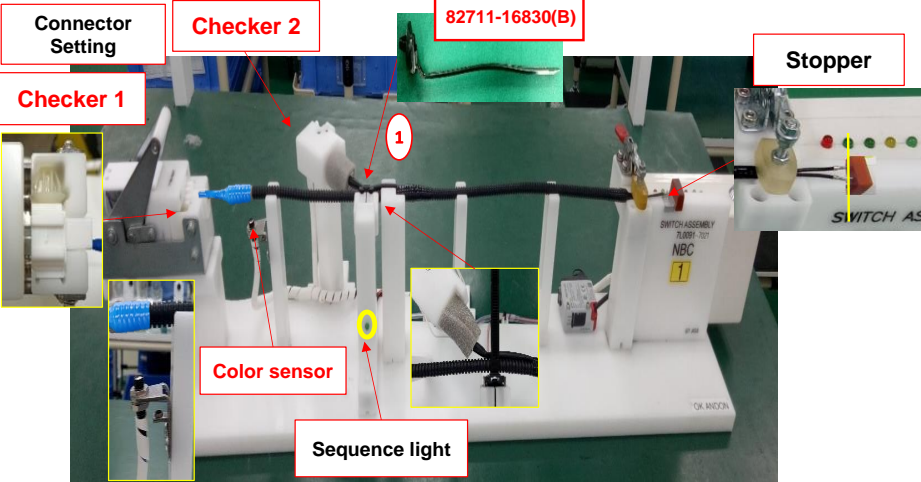
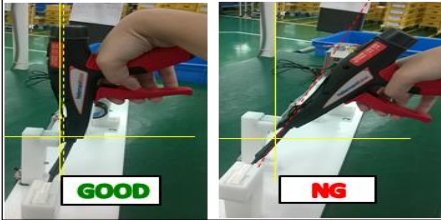
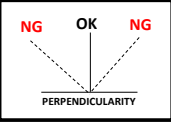


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	<b>0</b>	Page No.:	<b>4 of 6</b>

<b>PARTS:</b> 1. Clamp 82711-16830 (B) 2. Assy part				JIG: 1. Clamp assembly jig	
<b>NO.</b>  4	<b>PROCESS NAME</b>  Clamp Assy Clamp Assembly (Continuation)	<b>WORK PROCEDURE/ ILLUSTRATION</b> <div>  </div> <div> <p>4. Get the bando gun and cut the band clamp (82711-16830) using right hand. Press the sequence light button after cutting. <b>Go</b> buzzer will be heard.</p> </div> <div> <p>5. <b>CONDUCT POINT CHECKING</b> before removing from jig.</p> </div> <div> <p>6. First, pull the <b>Toggle clamp</b>. Second, remove <b>Checker 1</b>. Lastly, remove the connector to <b>Checker 2</b> together with clamp.</p> </div> <div> <p><b>BAND CLAMP CUT POSITION FOR LOCATION 1</b></p>  <p><b>BANDO GUN ALIGNMENT</b></p>  <p><b>Note:</b> Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p> </div>		<b>TOOLS/PPE</b>  <b>FLAT NOSEPIECE</b>	<b>QUALITY POINTERS</b> 1. No wrong use of clamp 2. No wrong set of clamp 3. No missing clamp 4. No loose band clamp 5. No super tight band cut <b>Important reminders/note/s:</b> 1. Please check the clamp first before start of assembly to avoid wrong use of clamp. 2. Make sure <b>NO GAP</b> between the terminal and stopper jig. 3. Setting of clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4 <div> <p><b>BANDO GUN ILLUSTRATION</b></p>  </div>

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Revision No.:

0

Page No.:

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PARTS:		1. Assy parts		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Measurement		<div>MEASURING TAPE</div> <div></div> <div></div> <div>NOTE: (A) - Taping (B) (B) - Taping (L) (C) - Clamp (B) (D) - Clamp (W)</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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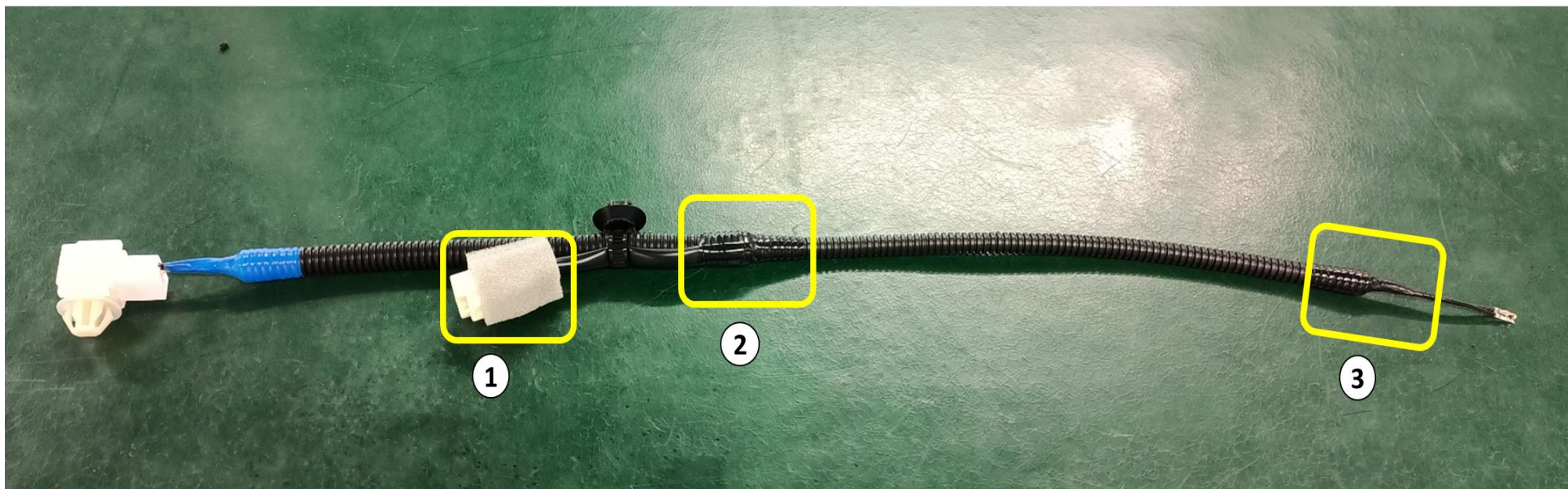
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**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0116-7020****① No Missing Urethane Foam****② ③ No Missing Tape ( Black Tape)**

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