



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 20, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0117-7025

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-983

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:		1. Clamp 82711-12A80 (W); Clamp 82711-58020 (W);Clamp 82711-3A640 (B); Clamp 82711-12A60 (W); Black tape [2pcs]; Label 7V4240-0020				JIG:		1. Clamp assembly jig 2. Label dispenser	
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	<div>TABLE LAY-OUT</div> <div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>				<div>Important reminders/Note/s: 1. No missing parts/tools 2. No excessive parts/tools</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>BAND CLAMP ILLUSTRATION CLAMP ILLUSTRATION </div>			
Revision History						Prepared by	Reviewed by	Approved by	Noted by
08/20/24	1	Change from Pre-launch to Masspro. Update Table lay-out and Work/procedure illustration.				M. Ariola	C.Villanueva	A.Arañes	n/a
07/19/24	0	Initial issue.				M. Ariola	C.Villanueva	A.Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	July 19, 2024		

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PARTS:		1. Clamp 82711-12A80 (W) 2. Clamp 82711-58020 (W) 3. Clamp 82711-3A640 (B) 4. Clamp 82711-12A60 (W) 5. Black tape [2pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp setting	<div></div> <div>1. Get 1pc. of clamp 82711-12A80 (W) then set to clamp location 3 using both hands.</div> <div>2. Get 1pc. of clamp 82711-3A640 (B) then set to clamp location 4 using both hands.</div> <div>3. Get 1pc. of clamp 82711-58020 (W) then set to clamp location 1 using both hands.</div> <div>4. Get 1pc. of clamp 82711-12A60 (W) then set to clamp location 2 using both hands then lock.</div> <div>5. Initially attach Black tape on clamp location 3 and 4 using both hands.</div>			<div>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</div> <div><i>Important reminders/Note/s:</i> 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>82711-12A60 (W)</div><div>82711-52070 (B)</div></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>82711-12A80 (W)</div><div>82711-52090 (W)</div></div></div></div>

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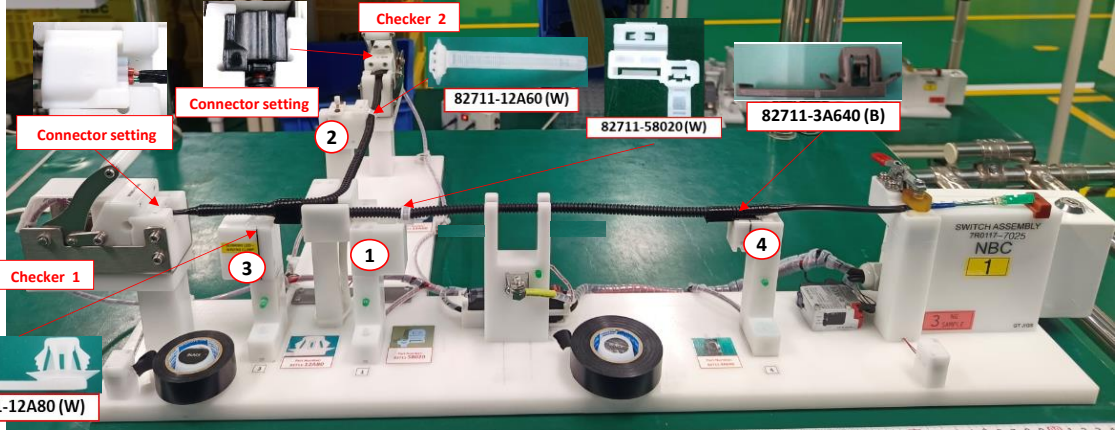

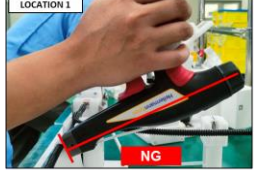
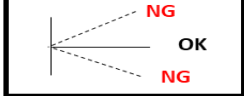

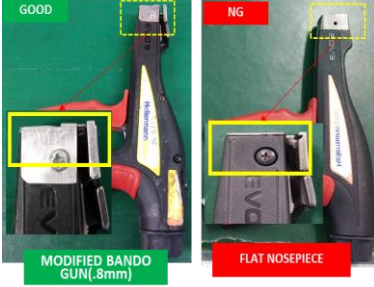
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Assy part 2. Black tape [2pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp assembly	 <p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6189-1161 (B) to receiver base 1. Continue to set the harness into jig. Set the end of PCB within the stopper jig then press the toggle clamp. Last, set the connector 6189-1142 (W) to receiver base 2.</p> <p>2. Initially tighten the band clamp on clamp location 1 using both hands.</p> <p>3. Get the Bando gun (MODIFIED NOSEPIECE) using right hand then cut the clamp on location 1 using both hands. Press the SW button after cut. Continue if the clamp location 2 was ON.</p> <div data-bbox="1160 868 1413 1091"><p>PROPER CUTTING POSITION OF BANDO GUN</p></div> <div data-bbox="1429 868 1682 1091"><p>IMPROPER CUTTING POSITION OF BANDO GUN</p></div> <div data-bbox="1160 1155 1402 1315"><p>BANDO GUN PERPENDICULARITY</p></div> <p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p>	 <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Make sure no gap between stopper and PCB2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~43. Make 2-3 windings for clamp taping. <div data-bbox="1742 995 2114 1315"><p>BANDO GUN ILLUSTRATION</p></div>	<p>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</p>

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PARTS:

1. Assy parts

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

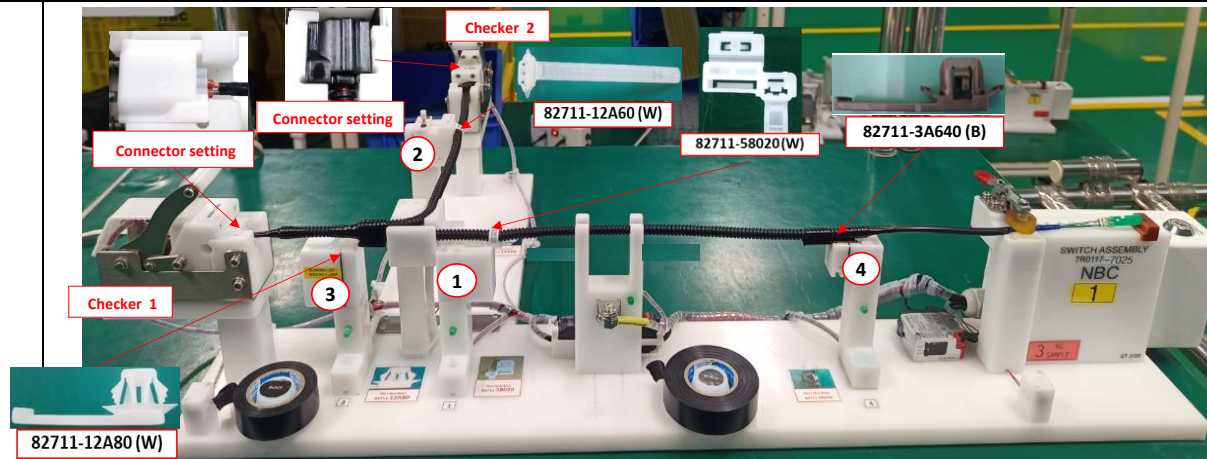


WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

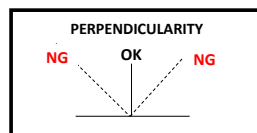
QUALITY POINTERS

2

CLAMP
ASSYClamp assembly
(Continuation)

4. Get the Bando gun (**MODIFIED NOSEPIECE**) using right hand then cut the clamp on location **2** using both hands. Press the **SW button** after cut Continue if the clamp location **3** was **ON**.

5. Hold the tape on clamp location **3** then start taping using both hands. Make **3 windings** of tape then cut the tape. Continue in clamp location **4**.



Fixed setting
of band clamp
cutter: 1~ 2

6. Hold the tape on clamp location **4** then start taping using both hands. Make **3 windings** of tape then cut the tape.

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

PROPER CUTTING
POSITION OF BANDO GUNIMPROPER CUTTING POSITION
OF BANDO GUN

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



Important reminders/Note/s:

1. Make sure no gap between stopper and PCB
2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: $\phi 5$ - 1~2, $\phi 7$ - 3~4
3. Make 2-3 windings for clamp taping.

BANDO GUN ILLUSTRATION



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PARTS:

1. Assy parts
2. Label 7V4240-0020

JIG:

1. Clamp assembly jig
2. Label dispenser

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

CLAMP
ASSY

Label Attachment

Model Code	Item No.	Item Name
7R0116-7022	73240-AK020	DRIVER PWR/ISO D
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



Model code

1. Get the label.
Note: Check the model code, item no. & name

Item no. & name



2. Align the end part of label in the jig.



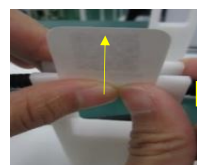
3. Fold the center part of the label



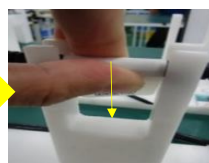
4. Align both end part of label .



5. After alignment , Press the label with both fingers .



6. Press the label upside down using finger.



GOOD

Acceptable overlap
0-1mm



NG



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PARTS: 1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

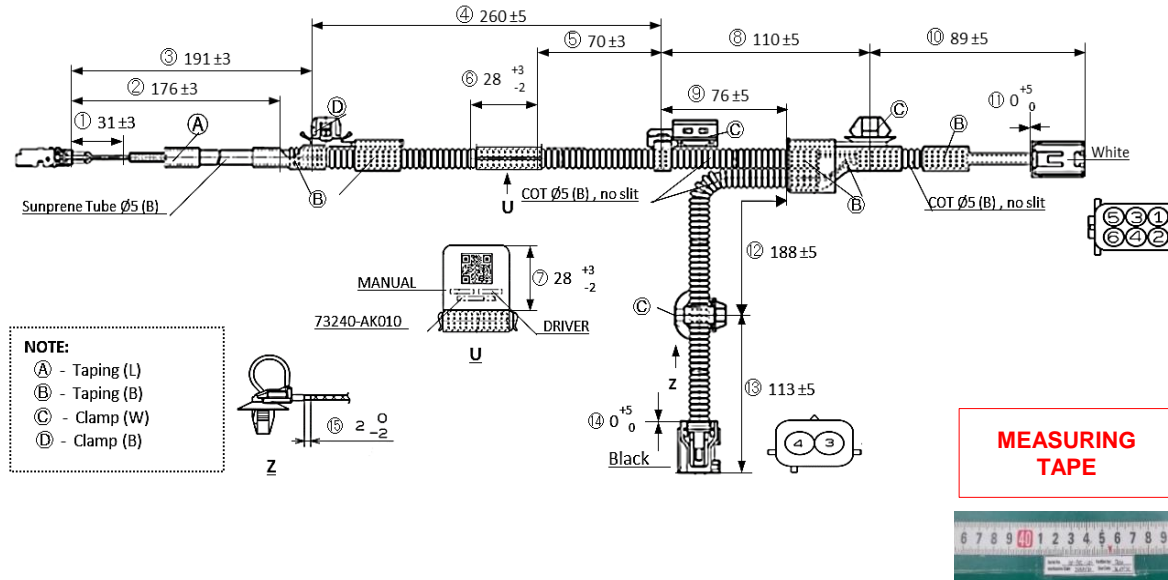
TOOLS/PPE

QUALITY POINTERS

4

CLAMP
ASSY

Measurement



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PARTS:

1. Assy parts

JIG:

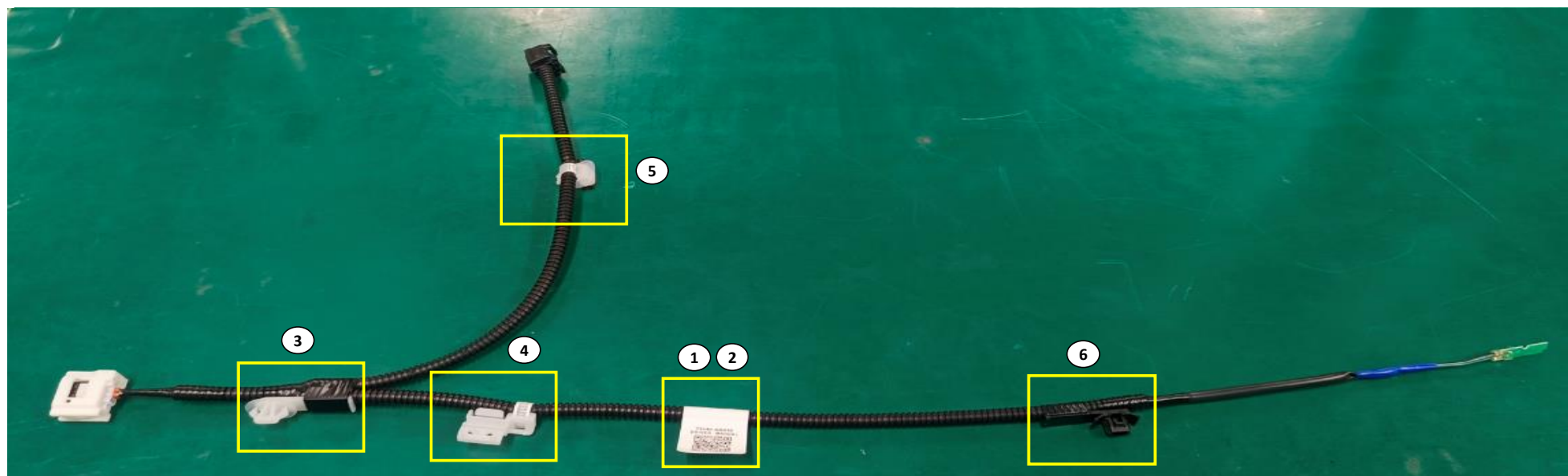
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VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7R0117-7025



①

NO MISSING QR CODE LABEL

②

NO WRONG ORIENTATION OF QR CODE LABEL

③

④

⑤

⑥

NO WRONG FACING OF CLAMP

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