



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

November 18, 2024

Process Name/Title:

Model code/Part number:

930B

/

7N0205-7020C

Customer: TRJ

Car Model:

TOYOTA-4RUNNER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-871

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48210(B); Clamp 82711-3A540(W); Clamp 82711-33650 (W); Black tape [5pcs]; Orange tape

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

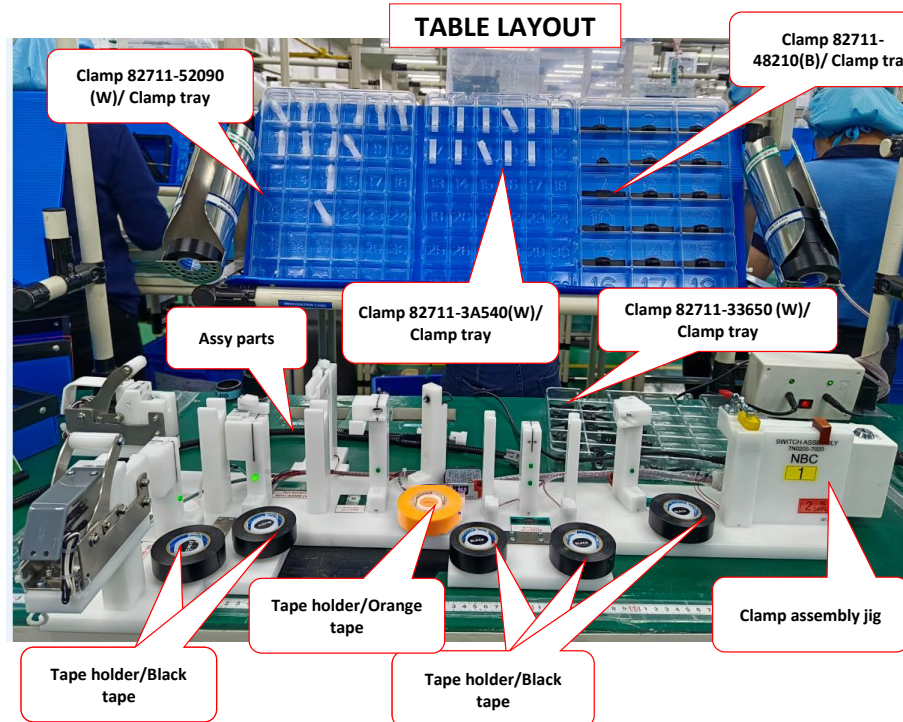
TOOLS/PPE

QUALITY POINTERS

1

n/a

Table layout

**Safety Instruction**

Be sure to wear required 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

Important reminders/Notes:

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

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/18/24	1	Change purpose from Pre-launch to Masspro. Update the Visual Inspections/Quality Checkpoints	M. Ariola	C. Villanueva	A. Arañes	n/a				
04/16/24	0	Initial issue. Change color of clamp tape from Violet to Orange.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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DCC Stamp



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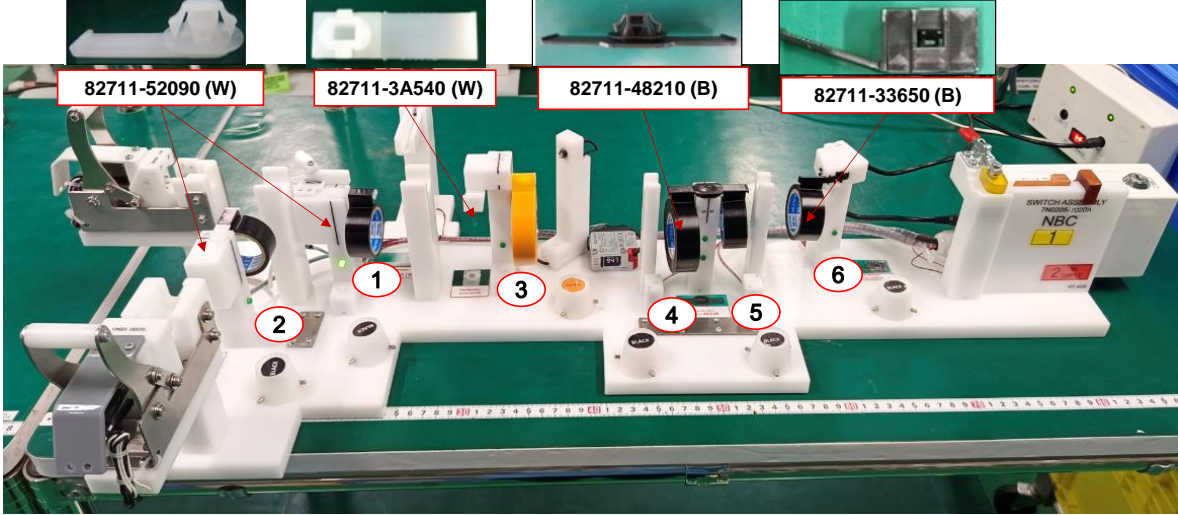
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Clamp 82711-33650 (B) 2. Clamp 82711-48210 (B) 3. Clamp 82711-3A540 (W)	4. Clamp 82711-52090 (W) 5. Orange tape 6. Black tape [5pcs]	JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Clamp setting	 <div data-bbox="546 922 1133 1011">1. Get 2pcs of clamp 82711-52090 (W) using right hand and set to clamp location 1 and 2 using both hands.</div> <div data-bbox="546 1034 1133 1123">2. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</div> <div data-bbox="546 1145 1133 1235">3. Get 1pc of clamp 82711-48210 (B) using right hand and set to clamp location 4 and 5 using both hands.</div> <div data-bbox="1142 922 1720 1011">4. Get 1pc of clamp 82711-33650 (B) using right hand and set to clamp location 6 using both hands.</div> <div data-bbox="1142 1034 1720 1123">5. Initially attach Orange tape to clamp location 3 using both hands.</div> <div data-bbox="1142 1145 1720 1235">6. Initially attach Black tape to clamp location 1,2,4,5 and 6 using both hands.</div>		Important reminders/Notes: 1. Please check the clamp first before start of assembly to avoid wrong use of clamp. 1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig

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WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

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November 18, 2024

Process Name/Title:

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Model code/Part number: 930B / 7N0205-7020C

Customer: TRJ

Car Model: TOYOTA-4RUNNER

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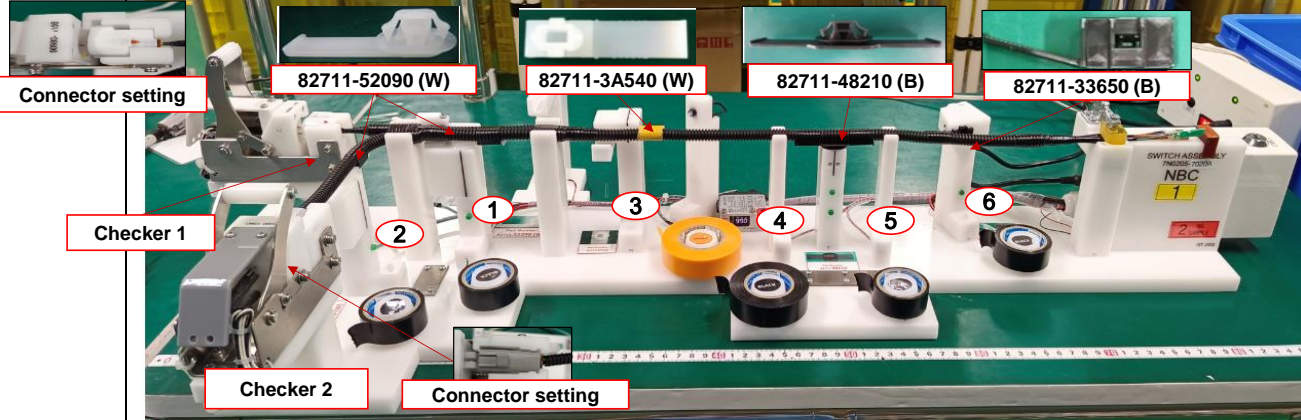


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Orange tape 3. Black tape [5pcs]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly			
		<div><div><div></div><div><div><p>1. Put the assy parts into jig. (See above picture for the correct setting). First, set the connector 6189-0451 (W) to Checker 1, Second set the Connector 6188-0066 (GR) to Checker 2, Third, set the connector 6098-3810 (W). Last, set the hotmelted wire and B-B wires together within stopper then press by toggle clamp.</p><p>2. Check if all LED light for Wire 1 and Wire 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Continue the process if the sequence light on location 1 was ON.</p></div><div><div><p>Clamp receiver base 1</p></div><div><p>1</p></div><div><p>3. On clamp location 1 conduct spot taping using both hands. Make 2 windings of tape. Press the SW button after taping. Sequence light will be OFF. (NOTE: DO NOT CUT THE TAPE)</p><p>4. Remove the connector 6098-3810 (W) using right hands and set to clamp receiver base 1 using both hands then lock. Sequence light will be ON.</p></div></div></div></div></div>			<div>1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig</div>

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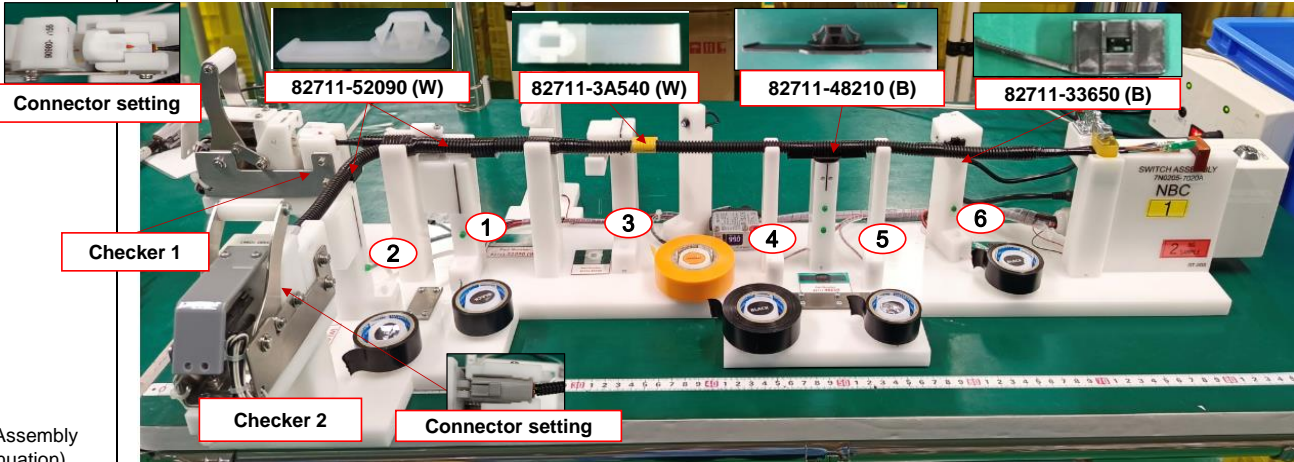
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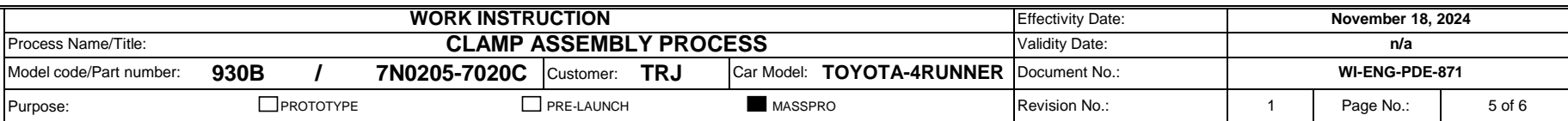
PARTS:		1. Assy parts 2. Orange tape 3. Black tape [5pcs]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Clamp Assembly (Continuation)	<div></div> <div>5. Combine the 2 COT using both hands, Hold the Black tape using right hand then start taping using both hands on clamp location 1. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on clamp location 2 was ON.</div> <div>6. On clamp location 2 hold the Black tape using right hand. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on clamp location 3 was ON.</div> <div>7. On clamp location 3 hold the Black tape using right hand. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on clamp location 4 was ON.</div> <div>8. On clamp location 5 hold the Black tape using right hand. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on clamp location 6 was ON.</div> <div>9. On clamp location 6 hold the Black tape using right hand. Make 3 windings of tape then cut the tape. Press the SW button after taping. GO buzzer will be heard.</div> <div>10. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>			1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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1

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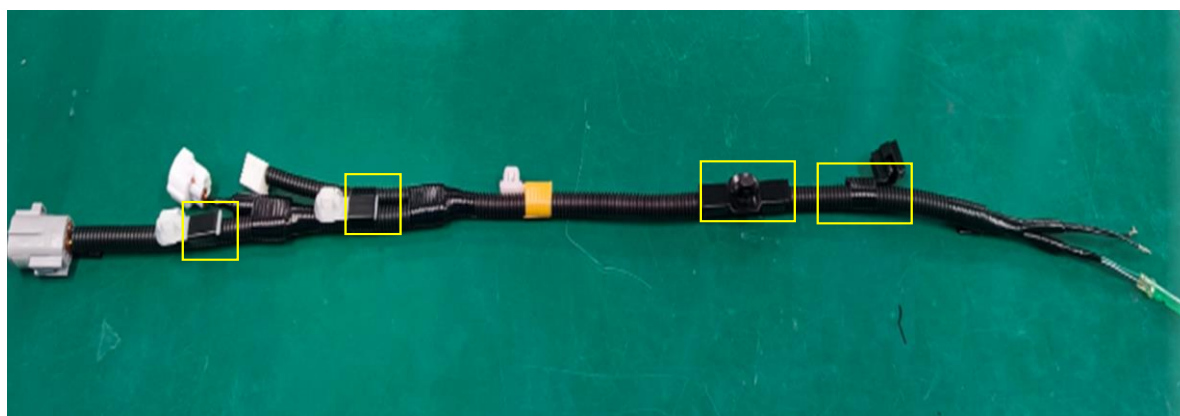
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP TAPING****7N0205-7020C**

- ① Check the **alignment of clamp**
- ② **No missing tape (Black tape)**

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