



## WORK INSTRUCTION

## CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

559D / 7N0238-7020C

Customer: TRJ

Car Model: TOYOTA HIGH-ACE

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

April 23, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1226

Revision No.:

0

Page No.:

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## PARTS:

1. Assy parts

2. Clamp 82711-16830 (B)

3. Clamp 82711-52090 (W)

4. Clamp 82711-16820 (BR)

5. Black tape [2 pcs.]

6. Brown tape

JIG:

1. Temporary Assembly jig

2. Bando Gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

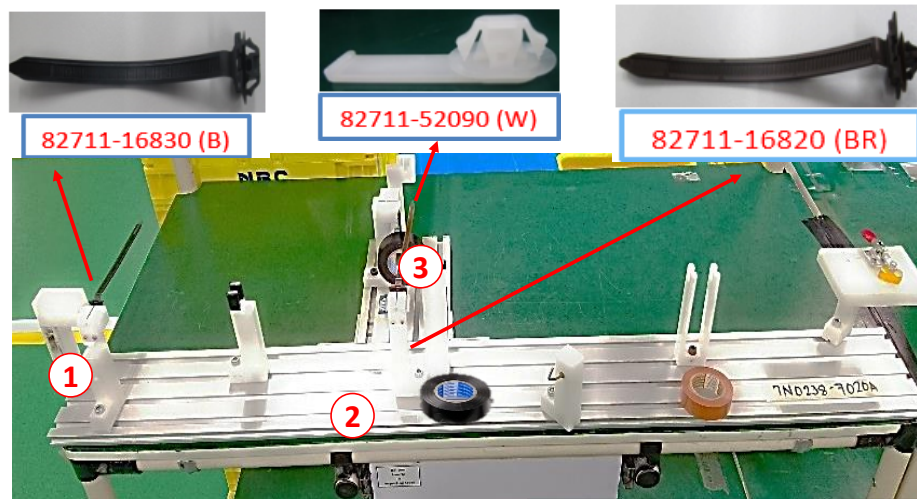
TOOLS/PPE

QUALITY POINTERS

1

P1

Clamp Settings



1. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **1** using both hands.

2. Get 1pc. of clamp **82711-52090 (W)** using right hand and set to clamp location **3** using both hands.

3. Get 1pc. of clamp **82711-16820 (BR)** using right hand and set to clamp location **2** using both hands.

4. Initially attach **Black tape** to clamp location **3** using both hands.

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

**Important reminders/Note/s:**

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

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	Prepared by	Checked by	Reviewed by	Approved by
04/23/25	0	Initial issue	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes		A.Hernandez	J.Loterte	C.Villanueva	A.Arañes

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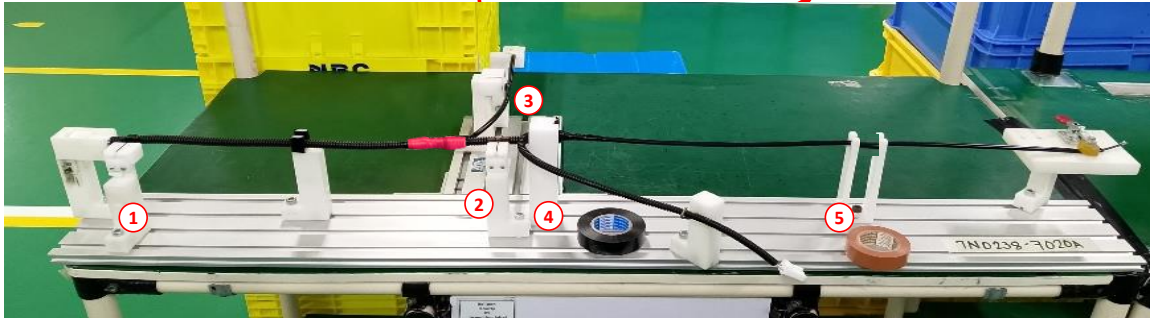


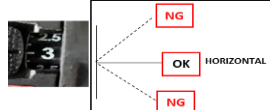
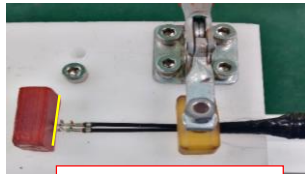

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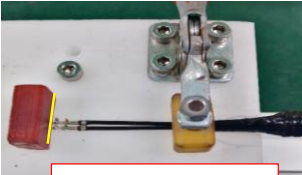
2 of 5

PARTS:		1. Assy parts 2.Clamp 82711-16830 (B) 3.Clamp 82711-52090 (W)	4.Clamp 82711-16820 (BR) 5. Black tape [2 pcs.] 6. Brown tape	JIG:	1. Temporary Assembly jig 2. Bando Gun
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Clamp Assembly	<div><div> 82711-16830 (B)</div><div> 82711-52090 (W)</div><div> 82711-16820 (BR)</div><div><p>1. Put the assy into jig. <i>(See above picture for the correct setting).</i> First, set the connector <b>7286-4097 (W)</b> to <b>Receiver base 1</b>. Second, connector <b>7283-1027 (W)</b> to <b>Receiver base 2</b>. Third, set the <b>B-B wires</b> together within stopper then press by toggle clamp. Fourth, Put the connector <b>6098-5677 (W)</b> to <b>hook</b>.</p><p>2. Initially tighten the band clamp on location <b>1</b> using both hands. Continue to clamp location <b>2</b>.</p><p>3. Initially tighten the band clamp on location <b>2</b> using both hands. Continue to clamp location <b>3</b>.</p><p>4. Hold the tape on clamp location <b>3</b>, make <b>3 windings</b> of tape then cut the tape using both hands.</p></div><div><p>BANDO GUN POSITION ON CLAMP LOCATION 1 and 2</p><div><p>PROPER CUTTING POSITION OF BANDO GUN</p> GOOD</div><div><p>IMPROPER CUTTING POSITION OF BANDO GUN</p> NG</div></div><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></div><div><p>BANDO GUN ALIGNMENT</p></div></div>			<div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><p><b>Important reminders/Note/s:</b></p><p><b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></p><p>No gap between stopper and terminals</p><p>BANDO GUN</p></div>


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



No gap between stopper and terminals



BANDO GUN

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**PARTS:**

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4. Clamp 82711-16820 (BR)

5. Black tape [2 pcs.]

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JIG:

1. Temporary Assembly jig

2. Bando Gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Clamp Assembly  
(Continuation)

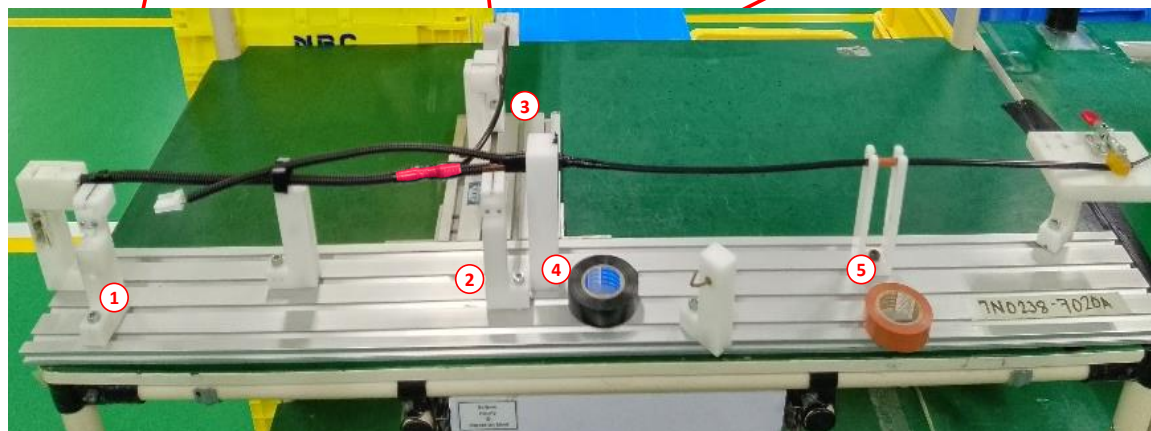
82711-16830 (B)



82711-52090 (W)



82711-16820 (BR)



5. Remove the connector 6098-5677 (W) to hook. Get the **Black Tape (20mm)** using right hand then conduct spot taping using both hands on location 4. Make **2~3 windings** then cut the tape.

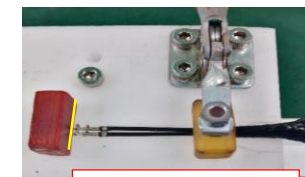
6. Get the **Brown Tape (20mm)** using right hand then conduct spot taping using both hands on location 5. Make **2~3 windings** then cut the tape.

7. Conduct **POINT CHECKING** before removing the harness from 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:**

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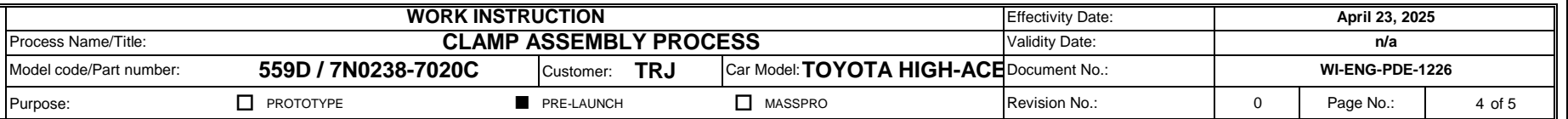


**No gap between stopper and terminals**

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### PARTS:

1. Assy parts

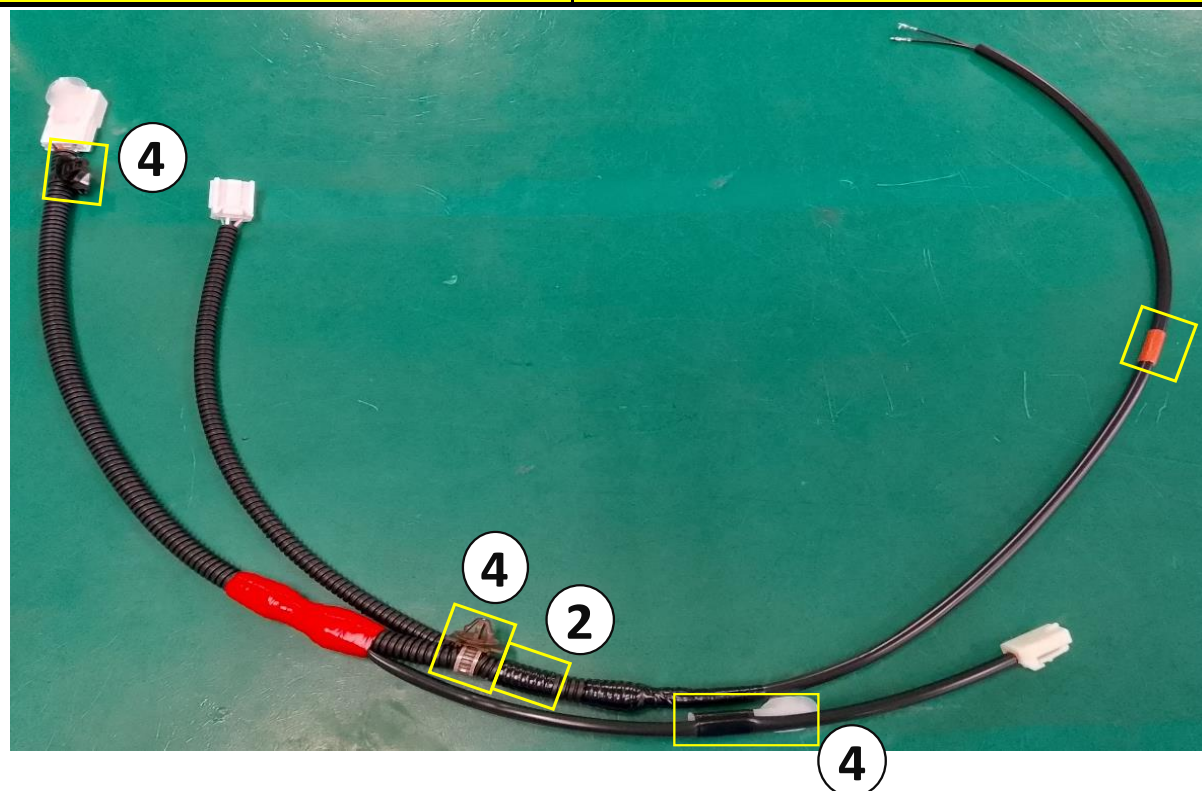
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## CLAMP ASSY

## 7N0238-7020C



- ① Check the **Clamp Alignment**
- ② No **Missing Tape/Spot Tape (Black/Brown)**
- ③ No **Wrong Used of Tape**
- ④ No **Missing Clamp**

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