



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

January 23, 2024

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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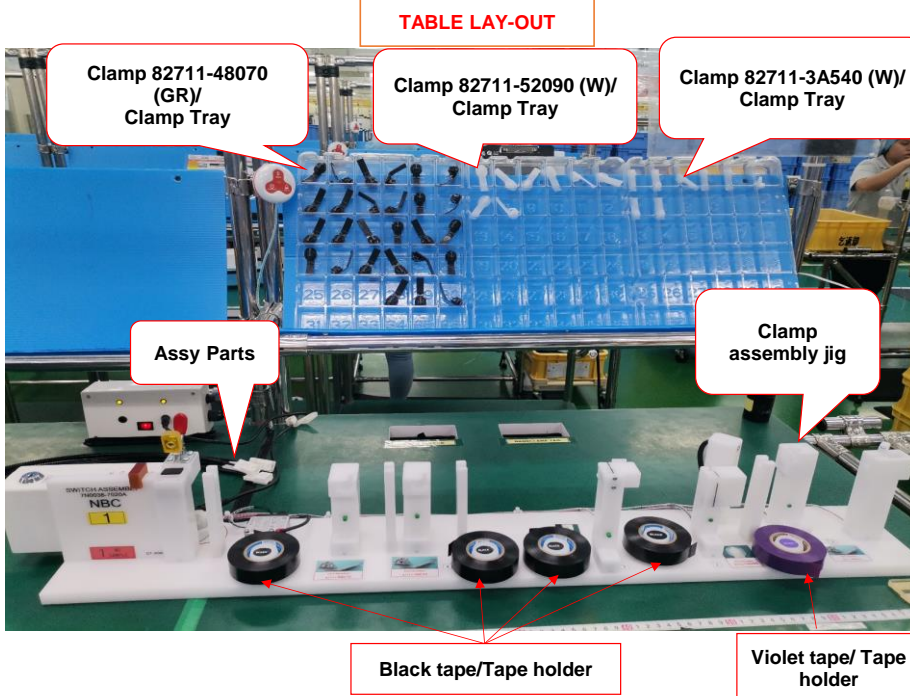
## PARTS:

1. Assy Parts
2. Clamp 82711-52090 (W)
3. Clamp 82711-48070 (GR) [3pcs]

4. Clamp 82711-3A540 (W)
5. Black tape [4pcs]
6. Violet tape [1pc]

JIG:

1. Clamp Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/23/24	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a
							Est. Date:	January 23, 2024		

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<b>PARTS:</b>	1.Clamp 82711-48070 (GR) [3pcs] 2.Clamp 82711-52090 (W) 3.Clamp 82711-3A540 (W)	4. Violet Tape 5. Black tape [4 pcs.]	JIG:	1. Clamp Assembly jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	n/a  Clamp setting	<div data-bbox="862 379 1059 451"></div> <div data-bbox="1088 379 1285 451"></div> <div data-bbox="1314 379 1512 451"></div> <div data-bbox="1518 379 1715 451"></div> <div data-bbox="555 523 1720 887"></div> <div data-bbox="568 935 1077 1011">1. Get 3pcs. of clamp <b>82711-48070 (GR)</b> using right hand and set to clamp location <b>1, 4</b> and <b>5</b> using both hands.</div> <div data-bbox="568 1046 1077 1123">2. Get 2pcs. of clamp <b>82711-52090 (W)</b> using right hand and set to clamp location <b>2</b> using both hands.</div> <div data-bbox="568 1158 1077 1235">3. Get 1pcs. of clamp <b>82711-3A540 (W)</b> using right hand and set to clamp location <b>3</b> using both hands.</div> <div data-bbox="1133 983 1688 1059">4. Initially attach <b>Violet tape</b> to clamp location <b>1</b> using both hands.</div> <div data-bbox="1133 1110 1688 1187">5. Initially attach <b>Black tape</b> to clamp location <b>2, 3, 4, and 5</b> using both hands.</div>		<div data-bbox="1733 411 2125 510">1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div data-bbox="1778 568 2080 593"><b>Important reminders/Note/s:</b></div> <div data-bbox="1756 612 2103 683">1. <b>Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div> <div data-bbox="1800 718 2058 743">One side tape under clamp</div> <div data-bbox="1778 754 2080 943"></div> <div data-bbox="1733 1023 2085 1161"><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div>

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Document No.:

WI-ENG-PDE-812

Purpose:

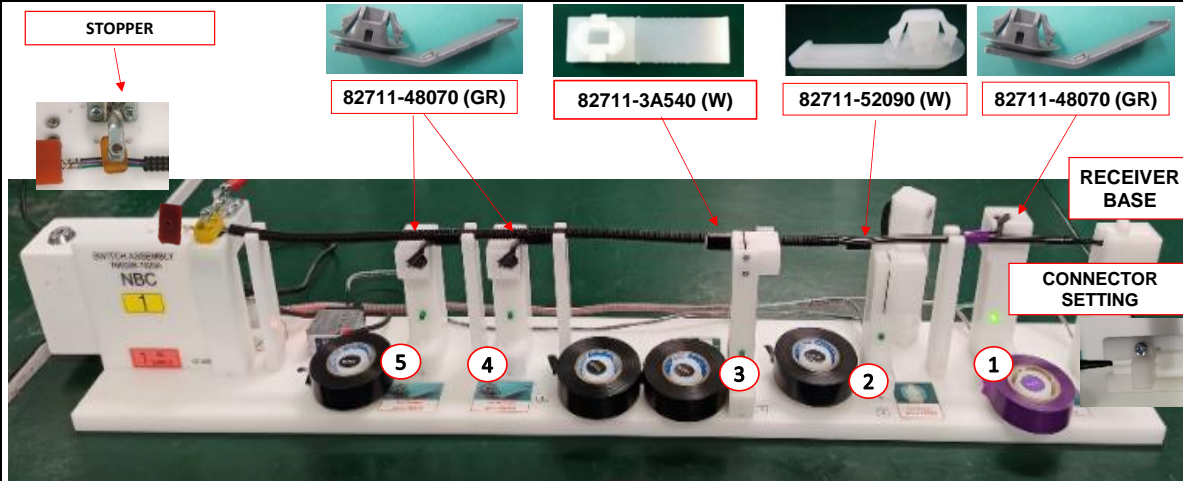
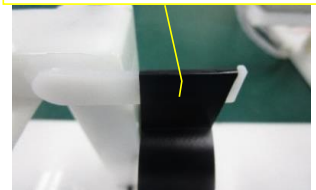


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PARTS:		1. Assy parts		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Clamp Assembly			
		<div><div><div>STOPPER</div><div></div></div><div><div>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector <b>6098-3802 (W)</b> to <b>Receiver base 1</b>, continue to set the harness in jig. Last, set <b>G-B-V wires</b> together within stopper then press by toggle clamp.</div><div>2. Check if all <b>LED Light for POWER ON, CLAMP ON</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 and continue the process.</div><div>3. Hold the tape on clamp location <b>1</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location <b>2</b>.</div><div>4. Hold the tape on clamp location <b>2</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location <b>3</b>.</div><div>5. Hold the tape on clamp location <b>3</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location <b>4</b>.</div><div>6. Hold the tape on clamp location <b>4</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location <b>5</b>.</div><div>7. Hold the tape on clamp location <b>5</b>, make <b>3 windings</b> of tape then cut the tape using both hands. Press the Switch button after taping.</div><div>8. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div></div><div><div><div>Important reminders/Note/s: <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div><div>Important reminders/Note/s: <b>1. Make sure no gap between stopper and terminals</b></div><div>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</div><div><div>One side tape under clamp</div><div></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div></div></div></div></div>			

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

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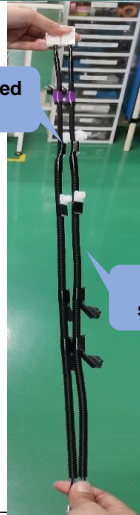
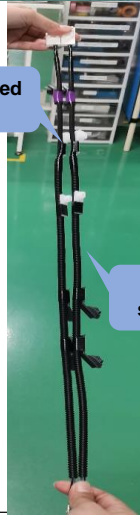



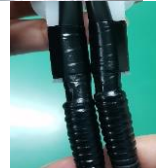






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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	Visual/By Two's Inspection			1. No skip checking during inspection.
		<div><p>ACTUAL PRODUCT</p></div> <div><p>Assembled parts</p></div> <div><p>Master sample</p></div> <div><p>2. Check the <b>connector lock condition, insertion.</b></p></div> <div><p>3. Check the <b>Taping condition.</b> Conduct slightly bending to <b>avoid overlook of missing tape.</b></p></div> <div><p></p></div> <div><p></p></div> <div><p>4. Check the <b>presence of clamp attachment, taping condition</b> and <b>color of tape.</b></p></div> <div><p></p></div> <div><p></p></div> <div><p></p></div> <div><p>5. Check the <b>terminal.</b> Must <b>no deformed terminal.</b></p></div>		<div>MASTER SAMPLE</div> 	

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PARTS:

n/a

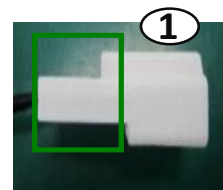
JIG:

n/a

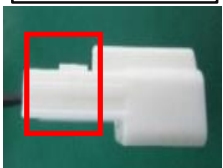
### QUALITY CHECKPOINTS

# CLAMP

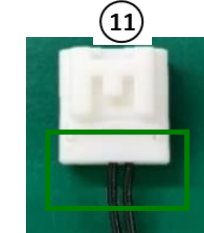
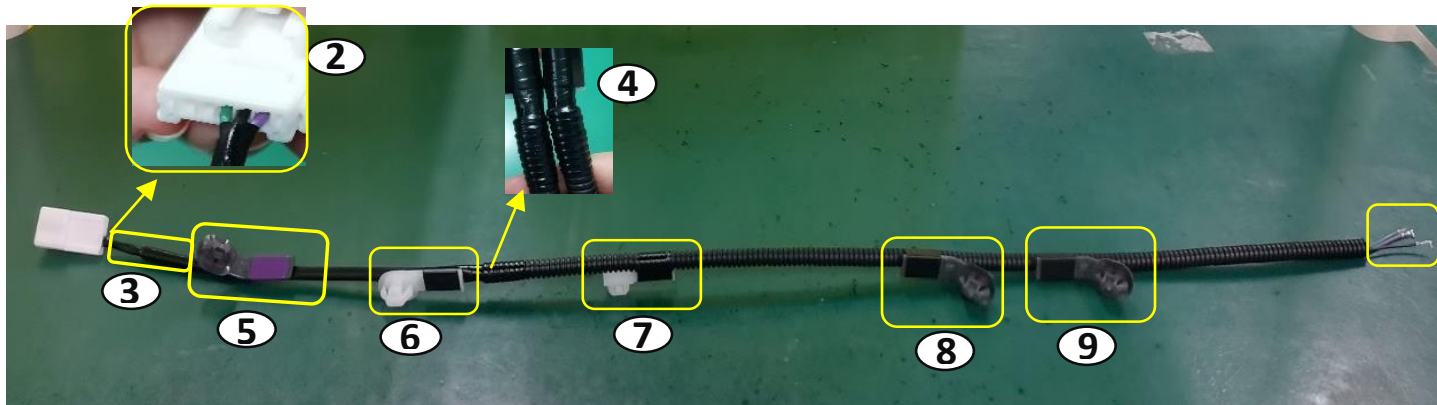
# 7N0038-7020A



GOOD



NO GOOD



GOOD



NO GOOD

- 1 No **Unlock/ Halflocked Connector** (on connector)
- 2 No **Wrong Insert** (on connector)
- 3 4 No **Wrong use of tape**
- 5 6 7 8 9 No **missing Clamp/No wrong color of tape**
- 10 **Checking of Clamp alignment/ orientation**
- 11 No **Deformed terminal**

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