



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 10, 2024

Model code/Part number:

500B / 7L0085-7024

Customer:

TRQSS

Car Model:

TOYOTA-SIENNA

Document No.:

WI-ENG-PDE-918

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Clamp 82711-52090 (W); Blue tape (10mm); Black tape ; Assy Parts

JIG:

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

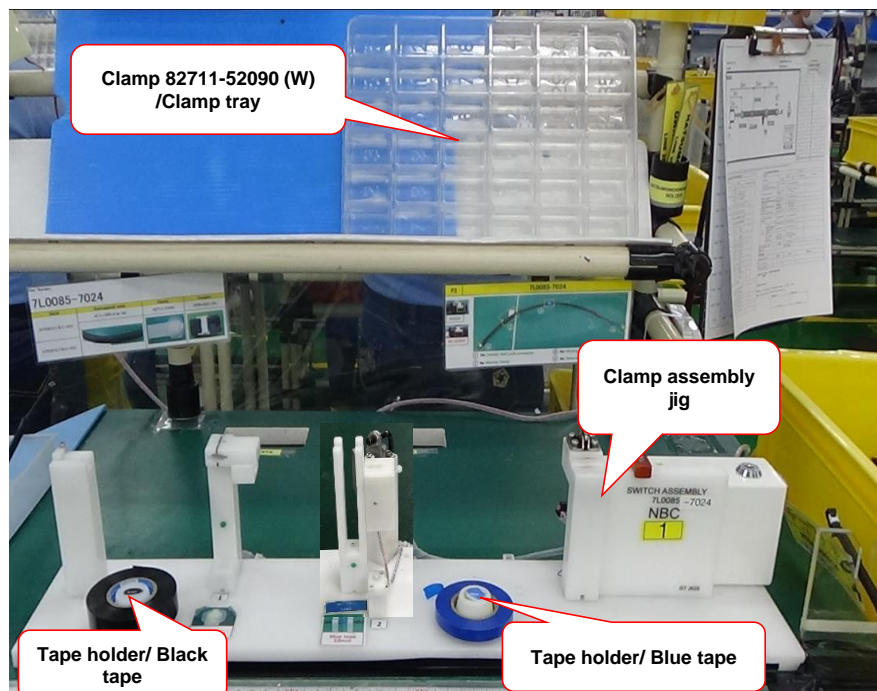
QUALITY POINTERS

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.

Document reference/s:

1. Refer to **WI-ENG-PDE-050** for Taping assembly process

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

CLAMP ILLUSTRATION



Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/10/24

0

Initial issue.
Separate Clamp setting and clamp assembly to Clamp assembly process. Improved assembly jig

D.Castillo

C.Villanueva

A. Arañes

N/A

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted


Est. Date:

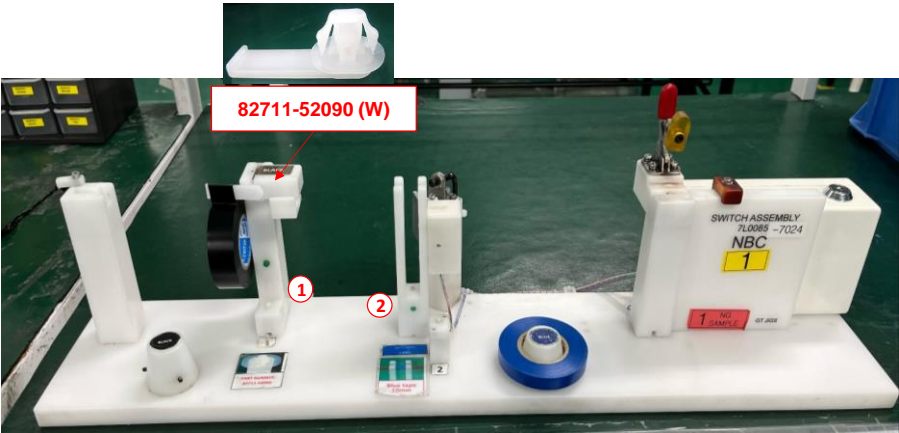



July 10, 2024

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DCC Stamp


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	8	Page No.:	2 of 7

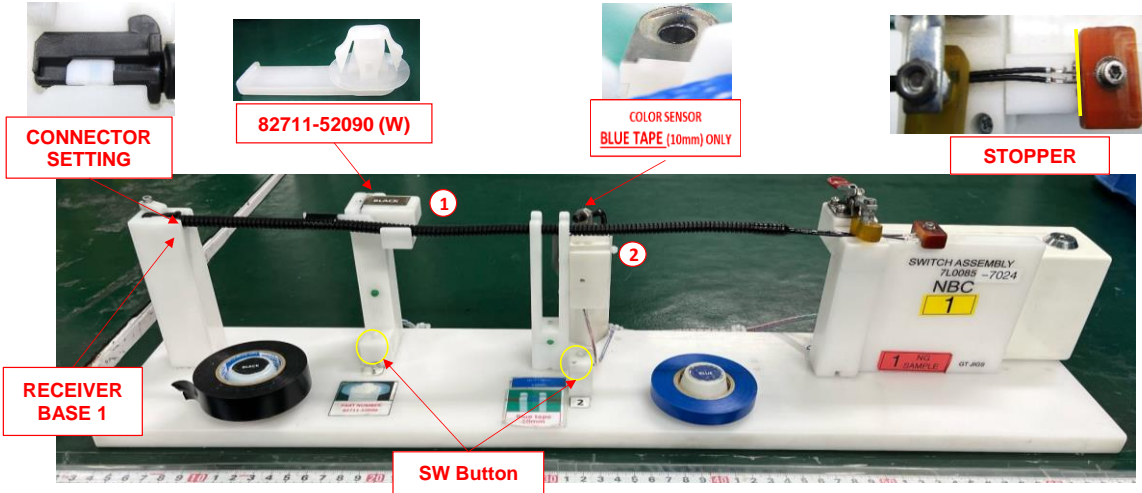



PARTS:	1. Black tape 2. Clamp 82711-52090(W)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting <div><div>1. Get 1pc. of clamp 82711-52090 (W) using right hand then set to clamp location 1 using both hands.</div><div>2. Initially attach Black tape to clamp location 1 using both hands.</div></div>		n/a	<div>1. No wrong use of clamp 2. No missing clamp 3. No wrong use of tape 4. No missing tape</div> <div>STANDARD TAPING FOR CLAMP One wind for under tape </div> <div>Important reminders/Note/s: 1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</div> <div>CLAMP ILLUSTRATION <div><div>GOOD 82711-52090 (W)</div><div>NG 82711-12A80 (W)</div></div></div>

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PARTS:	1. Blue tape 10mm 2. Assy parts			JIG:	1.Clamp Assembly Jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
3	CLAMP ASSY	Clamp Assembly		<div>1. No missing parts</div> <div>2. No missed tape</div> <div>3. No wrong used of tape</div> <div>4. No damaged clamp</div> <div>5. No lacking/excess tape winding</div> <div> STOPPER</div> <div>Important reminders/Note/s:</div> <div>1. Make sure that no Gap between terminal and stopper jig.</div> <div>2. Make 2-3 windings for clamp taping</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-52090 (W)</div><div>NG</div><div> 82711-12A80 (W)</div></div></div> <div><div>1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6098-6663 (B) to Receiver base 1 then lock. Continue to set the harness in jig. Last, set the end of B-B wire together within the stopper then press by Toggle clamp. Continue if the clamp in location 1 was ON.</div><div>2. Check if all LED light for Power and Clamp was ON. Check if clamp location 1 sequence is ON. If encountered abnormality, STOP the process, CALL the immediate superior and WAIT for instructions.</div><div>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the next process.</div></div>			


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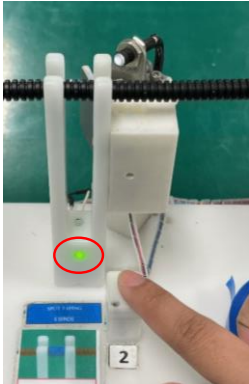
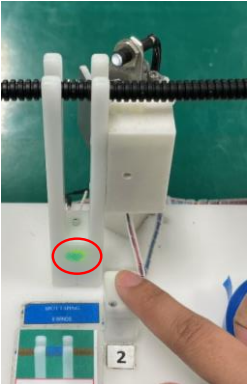
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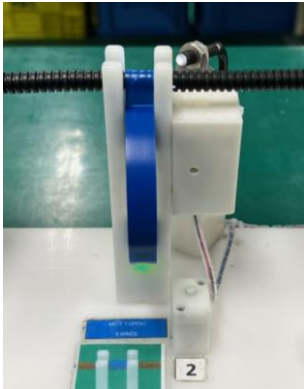
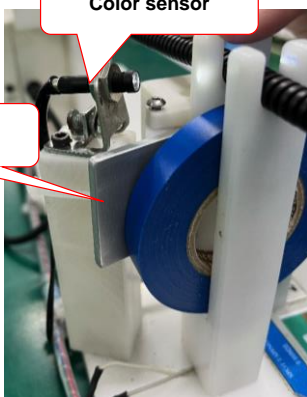
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PARTS:		1. Blue tape (10mm) 2. Assy parts		JIG:	1.Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)		n/a	<div> 1. No missing parts 2. No missed tape 3. No wrong used of tape 4. No damaged clamp 5. No lacking/excess tape winding </div> <div>  <div> STOPPER </div> </div> <div> Important reminders/Note/s: 1. <i>Make sure that no gap between terminal and stopper jig.</i> </div>

4. On clamp location **2**, press the **SW button** first.
Sequence light will be OFF.


Color sensor

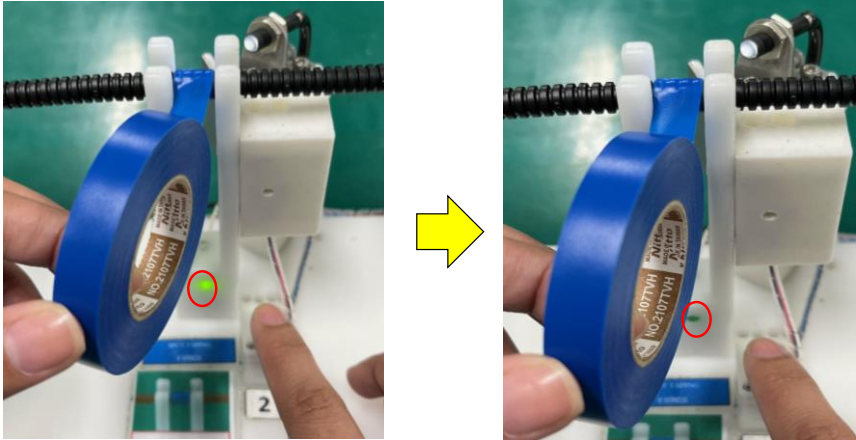

Trigger switch

5. Get the **Blue tape 10mm** using right hand, start taping process using both hands. Tape will touch the trigger switch while winding the tape.

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PARTS:	1. Blue tape (10mm) 2. Assy parts			JIG:	1.Clamp Assembly Jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	CLAMP ASSY	<div></div> <div>6. After first winding, press the SW button while holding the tape using both hands. Sequence light will be OFF. Repeat the process until reach the 9 winds of tape. <i>Note: Jig will alarm if detect discontinue of winding, insufficient and excess winding of tape.</i></div> <div>7. Go sound will be heard after taping and color sensor light will beep/buzz if sensor detects Blue tape.</div> <div>8. Conduct POINT CHECKING before removing from Jig.</div>			n/a	<div></div> <div>STOPPER</div> <div>Important reminders/Note/s: 1. Make sure that no gap between terminal and stopper jig.</div>		

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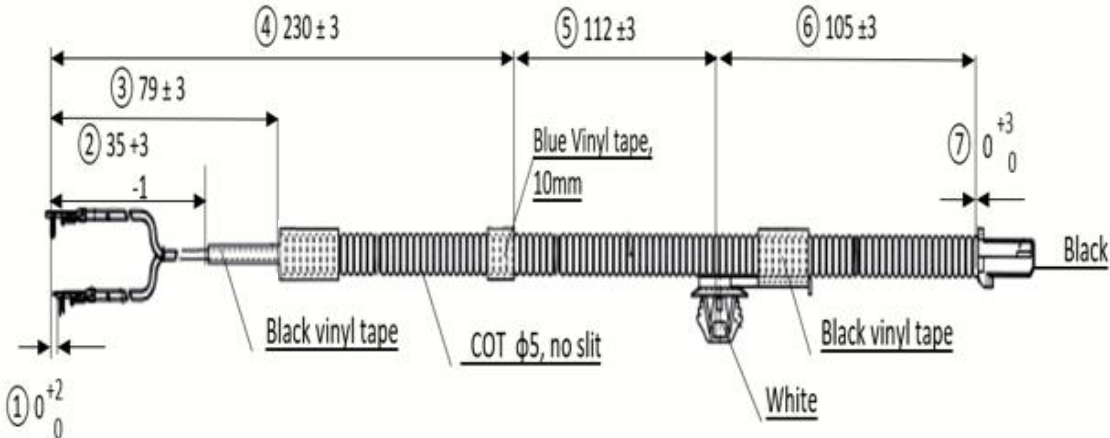
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Measurement		<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated /verified measuring tape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

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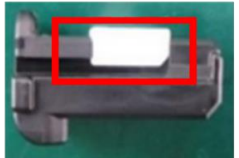
1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0085-7024**

①

**GOOD****NO GOOD**

① No Unlocked/ Halflock Connector

② No Missing Tape (Black Tape)

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