



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

April 25, 2025

Validity Date:

n/a

Model code/Part number:

559D / 7N0242-7020B

Customer: TRJ

Car Model: TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1251

Purpose:

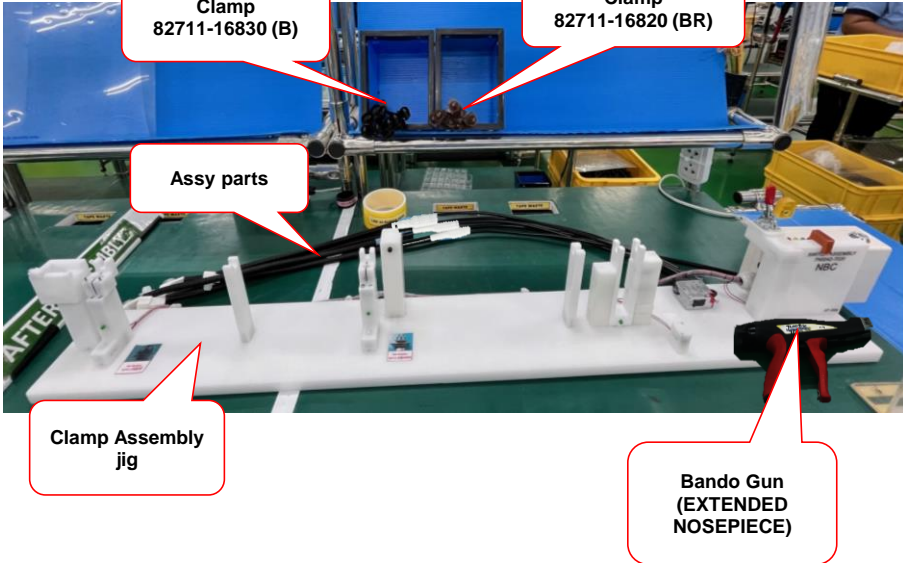
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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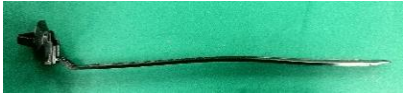

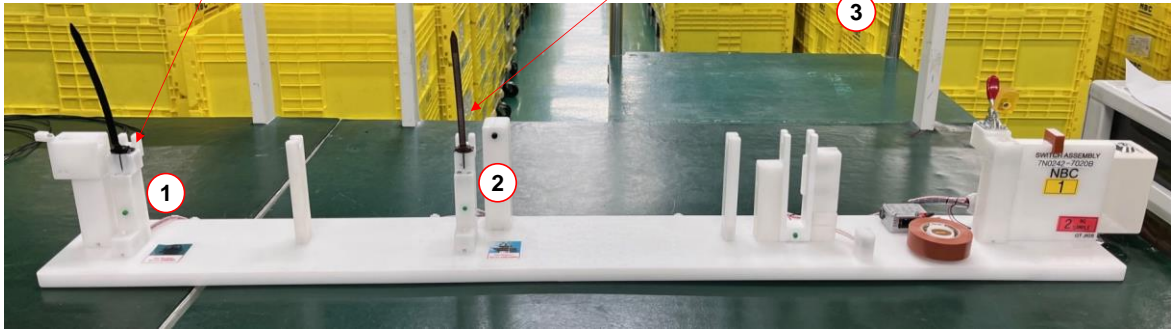
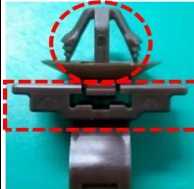
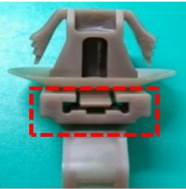
PARTS:		1. Assy parts 2. Clamp 82711-16830 (B) 3. Clamp 82711-16820 (BR) 4. Brown tape				JIG:		1. Clamp assembly jig 2. Bando gun		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
1	P1	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction Be sure to wear required personal 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>Document reference/s: 1. Refer to WI-ENG-PDE-1250A-B for Taping assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>		
Revision History										
						Prepared by	Checked by	Reviewed by	Approved by	
04/25/25	0	Initial issue.				D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Checked	Reviewed	Approved	
						Est. Date:	April 25, 2025			

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DCC Stamp

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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 6

PARTS:	1. Clamp 82711-16830 (B) 2. Clamp 82711-16820 (BR)			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Clamp Setting	<div> 82711-16830 (B)</div> <div> 82711-16820 (BR)</div> <div></div> <div>1. Get 1pc of band clamp 82711-16830 (B) then attach to clamp location 1.</div> <div>2. Get 1pc of band clamp 82711-16820 (BR) then attach to clamp location 2.</div>			Important reminders/Notes/: 1. Please check the clamp first before start of assembly to avoid wrong use of clamp. 1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp <div>BAND CLAMP ILLUSTRATION</div> <div><div>GOOD  82711-16820 (BR)</div><div>NG  82711-26380 (BR)</div></div>

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PROTOTYPE



PRE-LAUNCH



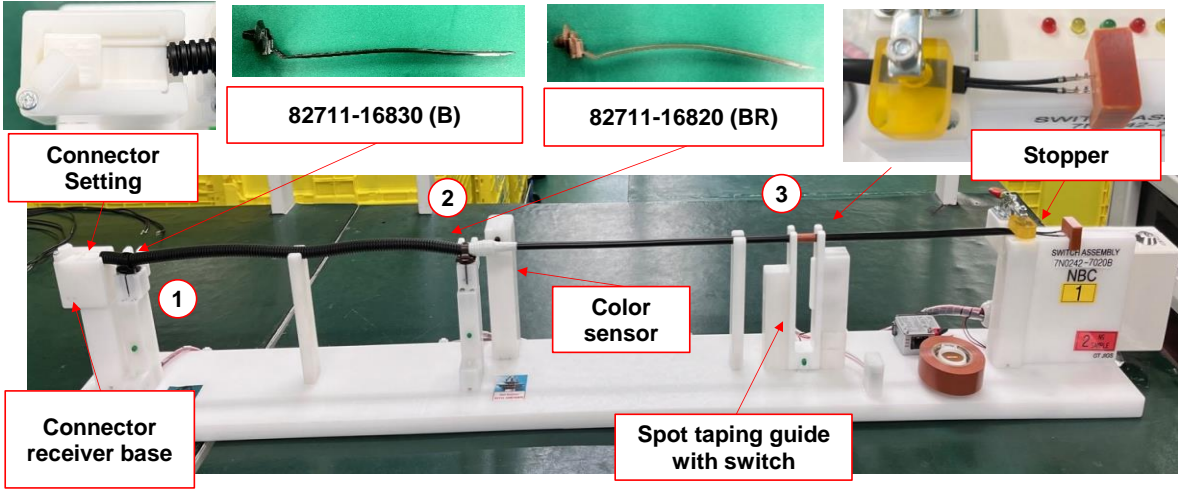
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PARTS:		1. Assy parts 2. Brown tape		JIG:	1. Clamp assembly jig 2. Bando gun
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Clamp Assembly	 <p>1. Put the assy into jig. <i>(See above picture for the correct setting)</i>. First, set the connector 6098-3802 (W) with Clip to Receiver base 1 then lock. Last, set the terminals together within stopper then press by toggle clamp. Continue if the sequence light of location 1 was on.</p> <p>2. Checked if all LED light for POWER ON, COLOR SENSOR and CLAMP ON was ON. IF encountered problem, STOP and immediately CALL the attention of leader. WAIT for further instruction nad continue the process.</p> <p>3. Initially tighten the band clamp 1 and band clamp 2 using both hands</p> <p>4. Get the Bando Gun using right hand and cut the band clamp on location 1 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 2 was on.</p> <p>5. Cut the band clamp on clamp location 2 using both hands. Press the SW button after cutting of band clamp. Continue the process if clamp location 3 was on.</p> <p>BAND CLAMP CUT POSITION FOR LOCATION 1 & 2</p> <p>BANDO GUN ALIGNMENT</p> <p>PERPENDICULARITY</p> <p>GOOD NG OK NG</p> <p>BANDO GUN ILLUSTRATION</p> <p>GOOD NG</p> <p>EXTENDED NOSEPIECE (.8mm) FLAT NOSEPIECE</p>		Important reminders/Note/s:	
				1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm). 2. Make sure no gap between the terminal and stopper jig. 3. Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4	
				1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No missing Spot tape 6. No wrong color of tape	

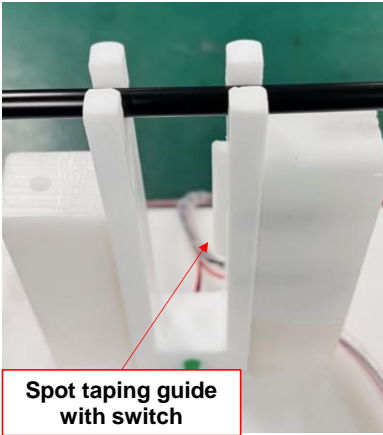

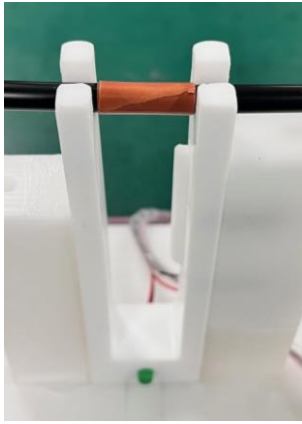
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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 6

PARTS: 1. Assy parts 2. Brown tape	JIG: 1. Clamp assembly jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Clamp Assembly (Continuation)	<div>    </div> <div> <p>6. Get the Brown tape and start taping to Location 3. Make 3 windings only of tape. Press the SW button after taping. Go sound will be heard. Note: Jig will alarm if lacking and excess winding.</p> <p>7. Conduct POINT CHECKING, before removing of harness from jig.</p> <p>8. Remove the harness from jig. Start from toggle clamp up to clamp up to connector receiver base.</p> </div>		<p>Important reminders/Note/s:</p> <p>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm). 2. Make sure no gap between the terminal and stopper jig.</p> <p>1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No missing Spot tape 6. No wrong color of tape</p>

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

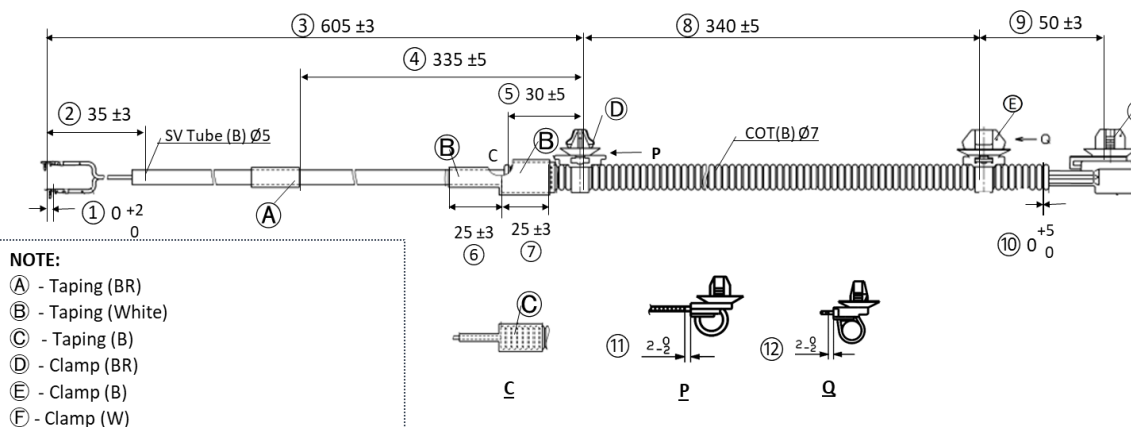
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement



Important reminders and note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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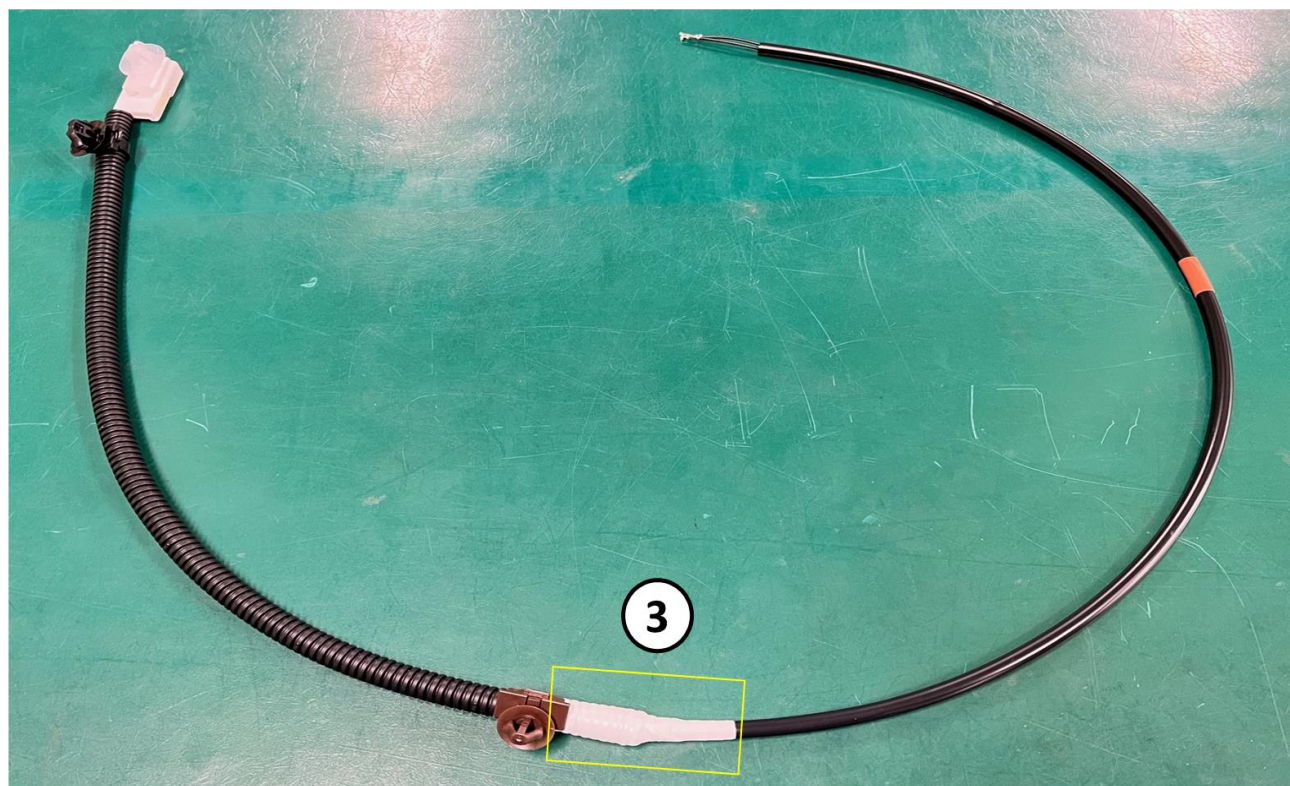
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0242-7020B**

① No Wrong Facing of Clamp

② No Mis-align Clamp

③ No Missing tape

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