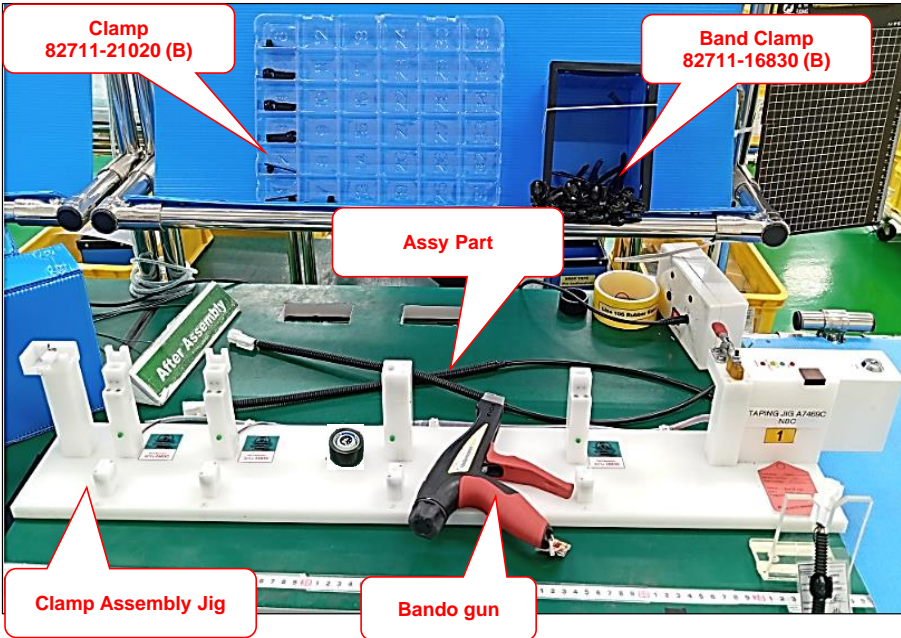



	WORK INSTRUCTION				Effectivity Date:		May 20, 2024	
	CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 881A / A7469D		Customer: TRQSS	Car Model: TOYOTA-CAMRY	Document No.: WI-ENG-PDE-893	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 1 of 4

PARTS:	1. Assy Part 2. Clamp 82711-21020 (B) 3. Band Clamp 82711-16830 (B) 4. Black tape (19mm)			JIG:	1. Clamp Assembly Jig 2. Bando gun	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	Clamp	<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>	1.No missing parts/tools 2.No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by		
						 A. Hernandez	 C. Villanueva	 A. Arañes	n/a		
5/20/2024	0	Initial issue.									
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	May 16, 2024

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WORK INSTRUCTION

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

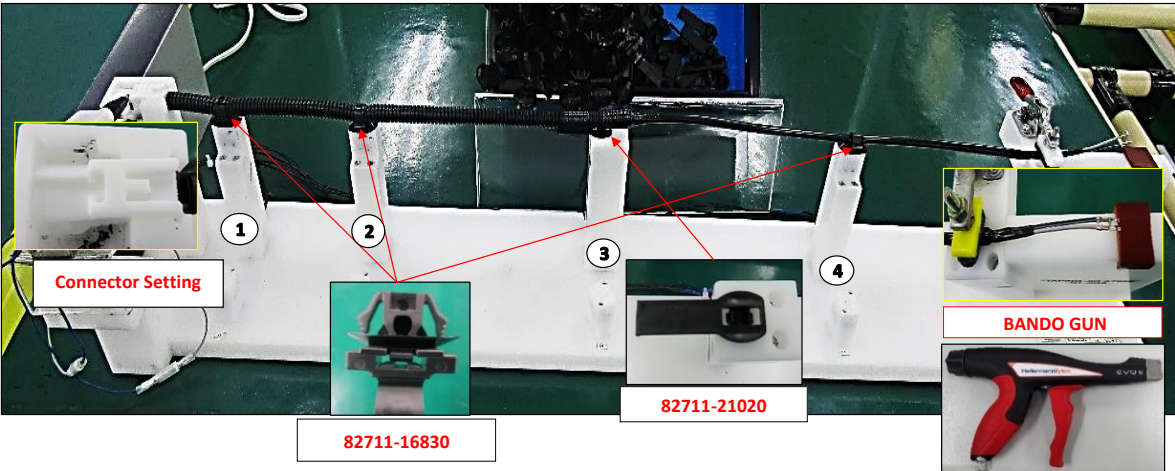
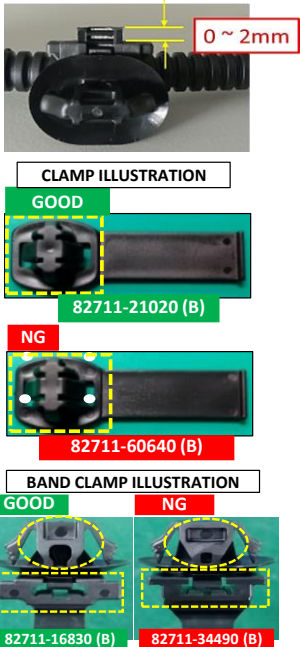
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PARTS:		1. Assy part 2. Clamp 82711-16830 (B)		3. Black tape (19mm) 4. Clamp 82711-21020		JIG:		1. Clamp Assembly Jig 2. Bando Gun	
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
2		Clamp		Clamp Assembly		<div><p>1. Get 2pcs of Band Clamp 82711-16830 using left and right hand then attached to jig. Location ①→②</p><p>2. Get 1pc of Clamp 82711-21020 using left hand then attached to jig Location ③ and using right hand get 1pc of Clamp 82711-16830 then attached to jig. Location ④</p><p>3. Put the assy part into jig. Make sure no clearance between terminal and stopper jig.</p><p>4. Initially tighten the 1st, 2nd and 4th Clamp 82711-16830 using right hand. Location ①→②→④</p><p>5. Get the Bando gun using right hand and cut all the band clamps Location ① ② ④. Press the Switch Button after band clamp cutting.</p><p>Fixed setting of band clamp cutter: 1~2</p><p>GOOD NG</p><p>Bando Gun Alignment</p><p>PERPENDICULARITY NG OK NG</p><p>STANDARD TAPING FOR CLAMP</p><p>One side tape under clamp</p></div>		<div><p>CLAMP ILLUSTRATION</p><p>GOOD 82711-21020 (B)</p><p>NG 82711-60640 (B)</p><p>BAND CLAMP ILLUSTRATION</p><p>GOOD NG</p><p>82711-16830 (B) 82711-34490 (B)</p><p>Important reminders/Note/s:</p><p>1. Make sure no gap between the terminal and stopper jig. use of tape and missing tape.</p><p>2. Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div>	

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PARTS:

1. Assy part

JIG:

1. Measuring tape

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

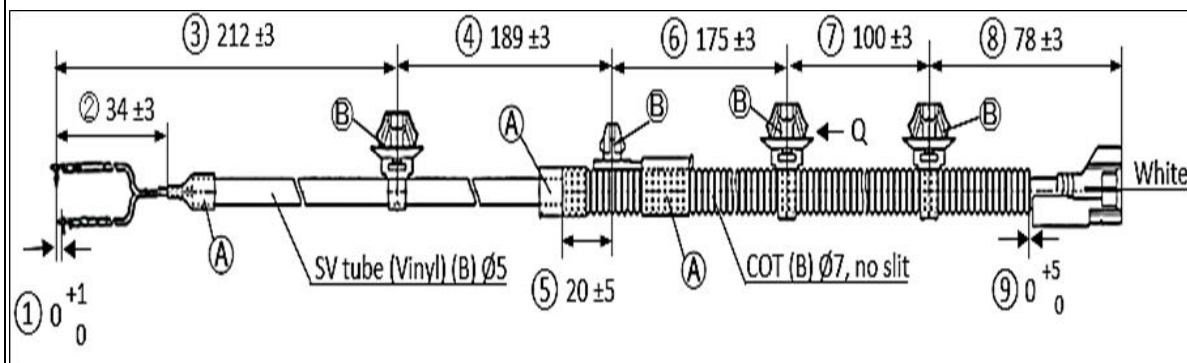
TOOLS/PPE

QUALITY POINTERS

3

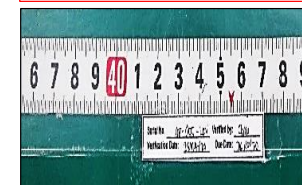
Clamp

Measurement



1. No wrong dimension

Measuring Tape



Wire alignment tolerance



0~2mm

Important reminders/note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINT

Clamp Assembly

A7469D

CLAMP ILLUSTRATION

GOOD



82711-21020 (B)

NG



82711-60640 (B)

BAND CLAMP ILLUSTRATION

GOOD

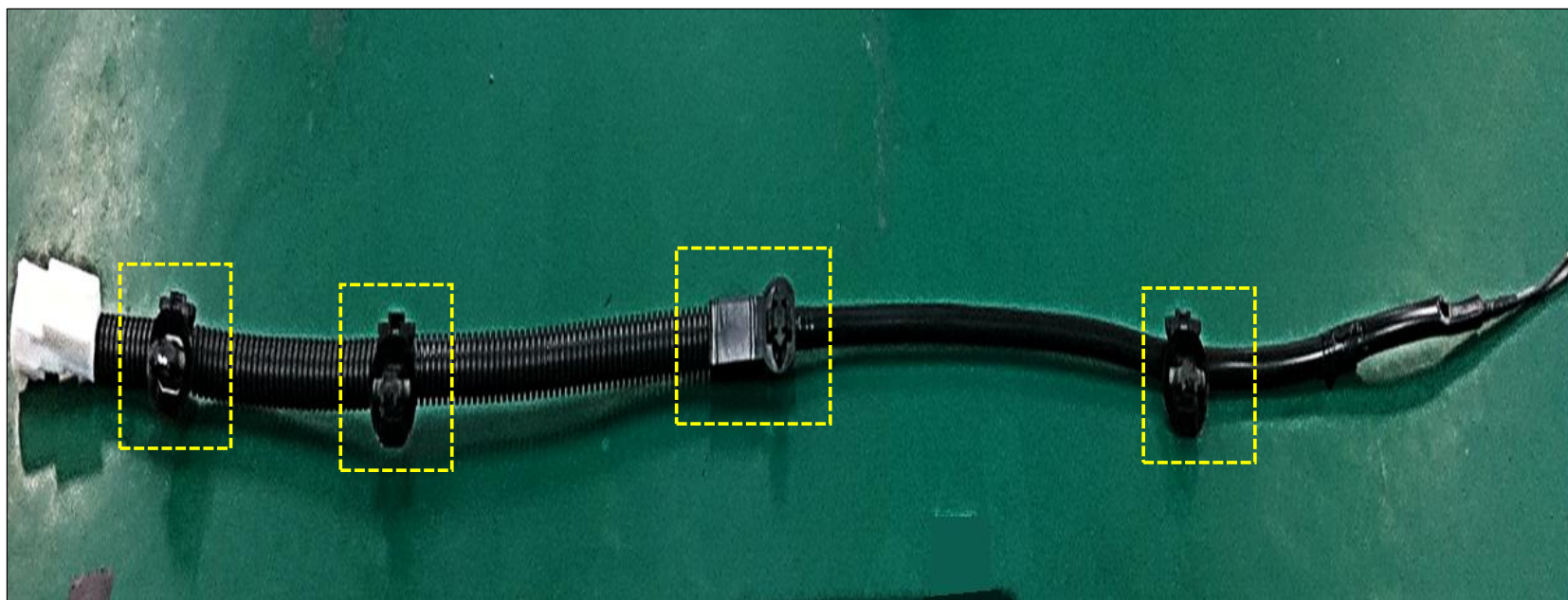


82711-16830 (B)

NG



82711-34490 (B)



① No Clamp Mis-alignment

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