



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Process Name/Title:

Model code/Part number:

700B / 7N0038-7020B

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-887

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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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

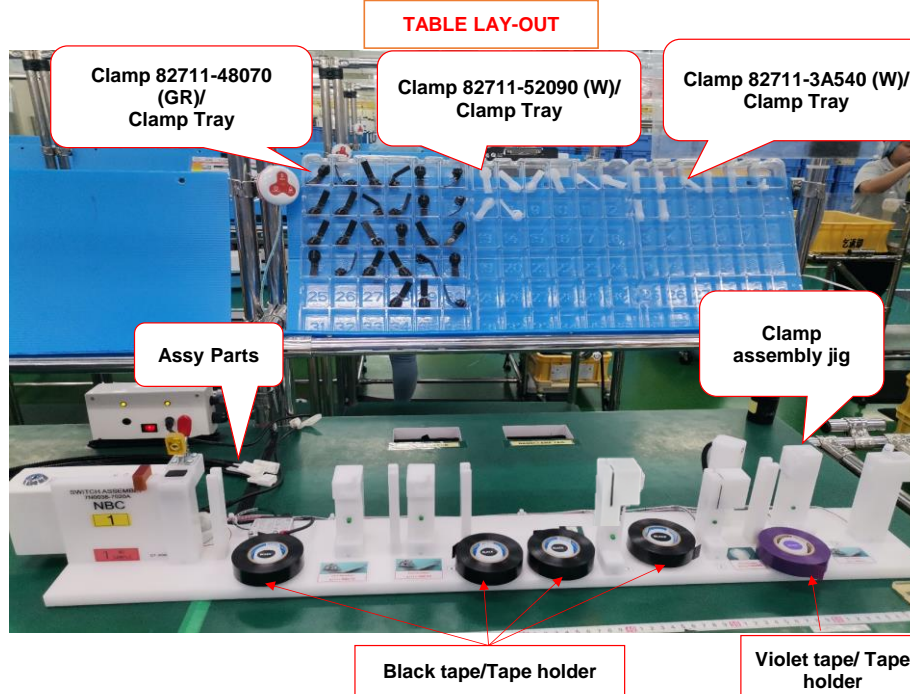
TOOLS/PPE

QUALITY POINTERS

1

n/a

Table Lay-out

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/03/24 1 Change pre-launch to mass pro.

A. Hernandez C. Villanueva A. Arañes n/a

05/09/24 0 Initial issue.

A. Hernandez C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date: May 09, 2024

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DCC Stamp



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PARTS:	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
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Clamp setting	<div data-bbox="862 383 1057 454"></div> <div data-bbox="1086 383 1281 454"></div> <div data-bbox="1310 383 1505 454"></div> <div data-bbox="1512 383 1706 454"></div> <div data-bbox="555 523 1720 885"></div> <div data-bbox="566 938 1077 1013"><p>1. Get 3pcs. of clamp 82711-48070 (GR) using right hand and set to clamp location 1, 4 and 5 using both hands.</p></div> <div data-bbox="566 1061 1077 1125"><p>2. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 2 using both hands.</p></div> <div data-bbox="566 1173 1077 1236"><p>3. Get 1pcs. of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</p></div> <div data-bbox="1131 1002 1686 1066"><p>4. Initially attach Violet tape to clamp location 1 using both hands.</p></div> <div data-bbox="1131 1114 1686 1193"><p>5. Initially attach Black tape to clamp location 2, 3, 4, and 5 using both hands.</p></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>Important reminders/Note/s:</p> <p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <div data-bbox="1776 710 2096 746"><p>One side tape under clamp</p></div> <div data-bbox="1776 754 2078 943"></div> <div data-bbox="1742 1026 2085 1201"><p>CLAMP ILLUSTRATION</p><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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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><p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6098-3802 (W) to Receiver base 1, continue to set the harness in jig. Last, set G-B-V wires together within stopper then press by toggle clamp.</p><p>2. Check if all LED Light for POWER ON, CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader, WAIT for further instruction and continue the process.</p><p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location 2.</p><p>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location 3.</p><p>5. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location 4.</p><p>6. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Press the Switch button after taping. Continue to clamp location 5.</p><p>7. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the Switch button after taping.</p><p>8. Conduct POINT CHECKING before removing the harness from jig.</p></div></div>			<div></div> <div><div>One wind for under tape</div><div></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div><div>NG</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	<div>MEASURING TAPE</div> <div>NOTE: A - Taping (B) B - Taping(V) C - Clamp (GR) D - Clamp (W)</div> <table><caption>WIRE TYPE TABLE</caption><tr><th>No.</th><th>Color</th><th>Wire Type</th></tr><tr><td>1</td><td>V</td><td>AVSS 0.3 f</td></tr><tr><td>2</td><td>B</td><td>AVSS 0.3 f</td></tr><tr><td>3</td><td>G</td><td>AVSS 0.3 f</td></tr></table>	No.	Color	Wire Type	1	V	AVSS 0.3 f	2	B	AVSS 0.3 f	3	G	AVSS 0.3 f	<div>1. No wrong dimension</div> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsomono, Nakamono, and Owarimono Inspection.</div>
No.	Color	Wire Type														
1	V	AVSS 0.3 f														
2	B	AVSS 0.3 f														
3	G	AVSS 0.3 f														

MEASURING TAPE

1. No wrong dimension

Important reminders/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, and Owarimono Inspection.

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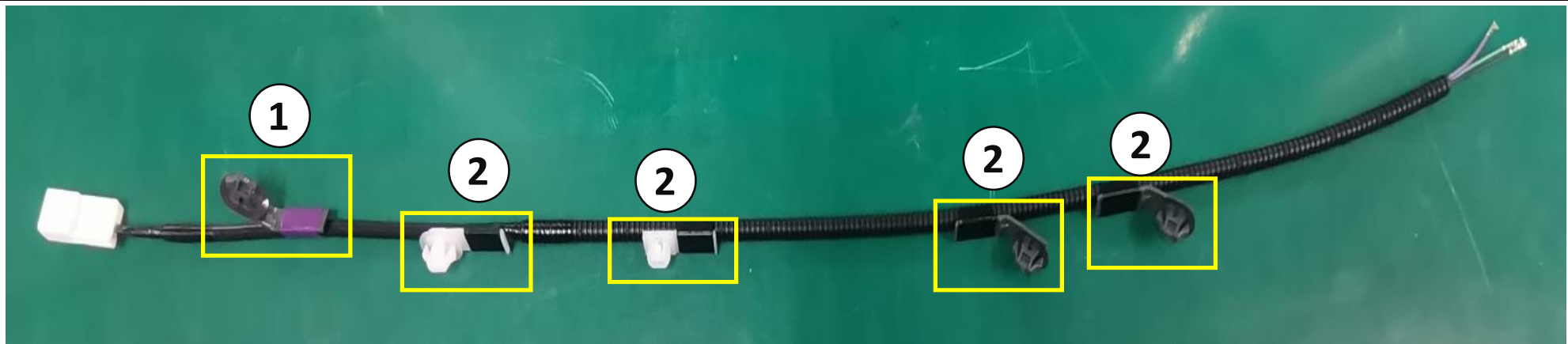
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP****7N0038-7020B**

① No **Wrong use of tape (Clamp taping)** ③ Check the **Clamp appearance**

② No **Missing Clamp** ④ Check the **Alignment of Clamp**

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