



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 25, 2024

Validity Date:

n/a

Model code/Part number:

491D/564D / 7R0151-7020A

Customer: TRMX

Car Model: TOYOTA-SEQUOIA

Document No.:

WI-ENG-PDE-990

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. Clamp 82711-35730 (B); White tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

CLAMP
ASSY

Table lay-out

TABLE LAY-OUT

Clamp 82711-35730 /
Clamp tray

Assy parts

Clamp assembly jig

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.

Document reference/s:

1. Refer to **WI-ENG-PDE-843** for Taping
assembly process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/25/24 0 Initial issue. Separate clamp assembly from Taping assembly process.

D. Castillo C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted


Est. Date:

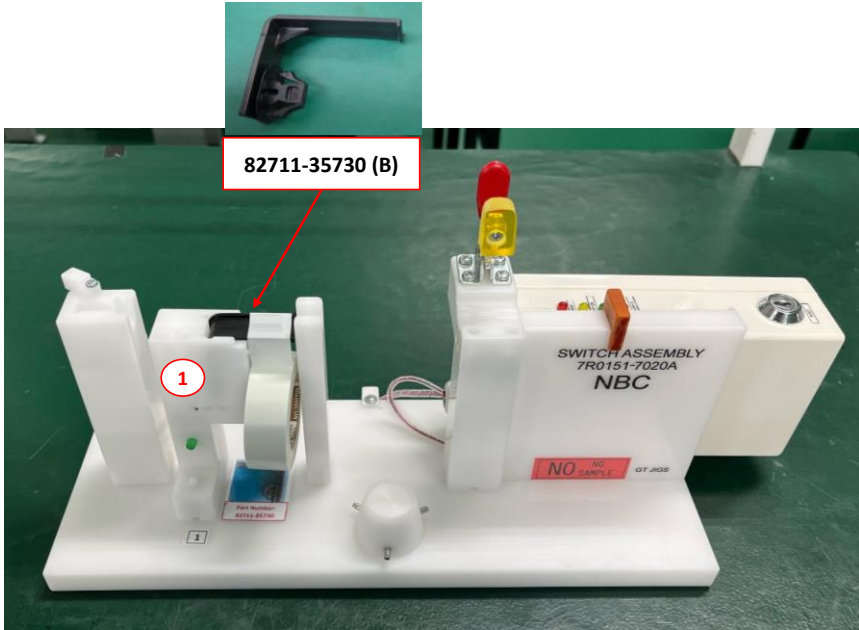
July 25, 2024

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

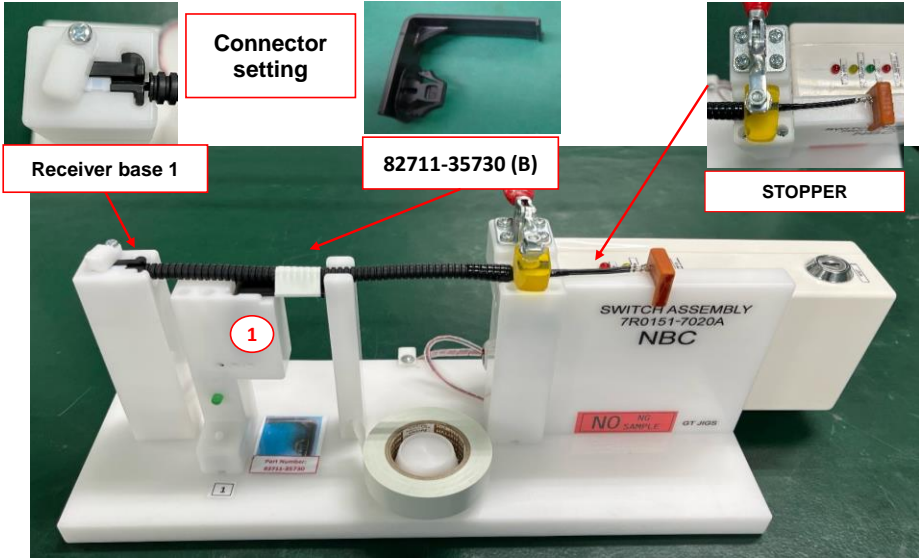

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|---------------|---------------------|--|--|------------------|---|
| PARTS: | | 1. Clamp 82711-35730 (B) 2. White tape | | JIG: | 1. Clamp assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | CLAMP ASSY | Clamp Setting <div><div>82711-35730 (B)</div><div>1</div></div> <div>1. Get 1 pc.of band clamp 82711-35730 (B) then set to clamp location 1 using both hands.</div> <div>2.Initially attach WhiteTape on clamp location 1 using both hands</div> | | | Important reminders/Note/s: 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 wrong use of tape 4. No missing clamp |

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|---------------|---------------------|-------------------------------------|---|------|-----------------------|-------------------------|---|--|--|
| PARTS: | 1. Assy parts | | | JIG: | 1. Clamp assembly jig | | | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS | | | |
| 3 | CLAMP ASSY | Clamp Assembly | <div></div> <div>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). . First, set the connector 6098-6663 (B) in Receiver base 1 . Continue to set the harness in jig. Last, set the B-B wires together within the stopper then press by Toggle clamp.</div> <div>2. Hold the tape on clamp location 1 then start taping using both hands. Make 3 windings of tape then cut the tape.</div> <div>3. Conduct POINT CHECKING before removing the harness from jig.</div> | | | n/a | <div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals 2. Make 2-3 windings for clamp taping</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> | | |

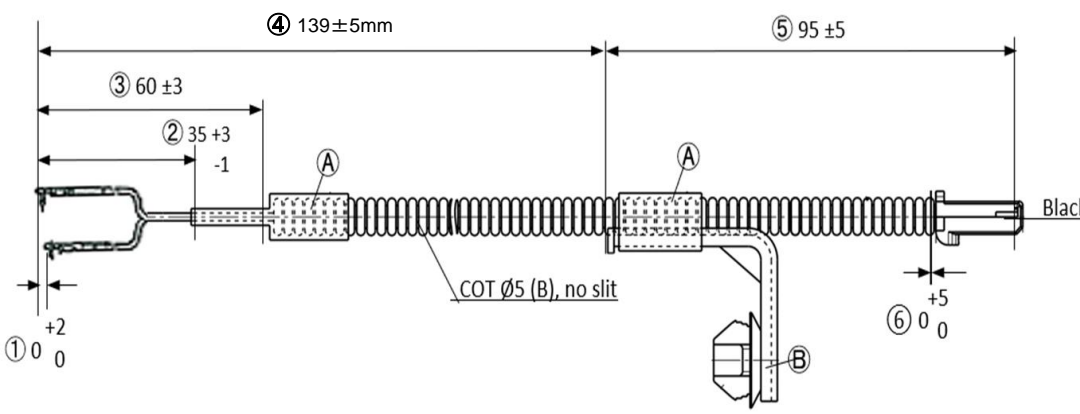

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|---------------|---------------------|--|--|--|-----|
| PARTS: | 1. Assy parts | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS | |
| 4 | CLAMP ASSY | <div>Measurement</div> <div><div>NOTE: Ⓐ -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

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7R0151-7020A****GOOD****NO GOOD****1 No Unlocked /Half-locked Connector****2 No Missing tape (Black tape)**

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