



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number: 707B / 7L0094-7020

Customer: TRQSS

Car Model: LEXUS ES HIGHBRID

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1011

Revision No.:

0

Page No.:

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PARTS: 1. Assy parts; Clamp 82711-52090 (W); Black Tape [2 pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

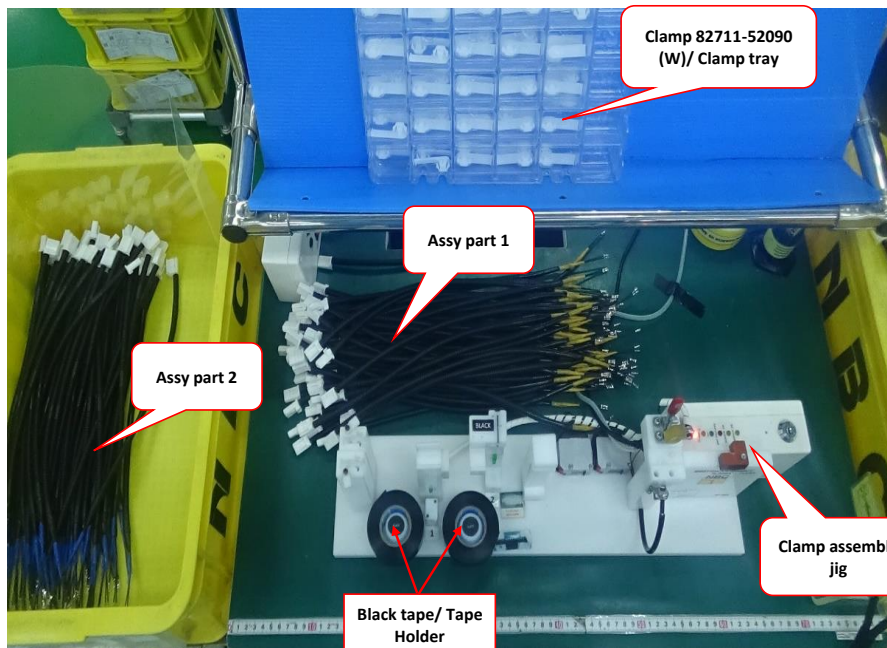
QUALITY POINTERS

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. Please refer to WI-PRO-CNC-017 for the Wire and Strip Length tolerance.

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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/12/24 0 Initial issue.

A.Hernandez C.Villanueva A.Arañes n/a

A.Hernandez

C.Villanueva

A.Arañes

n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

September 12, 2024

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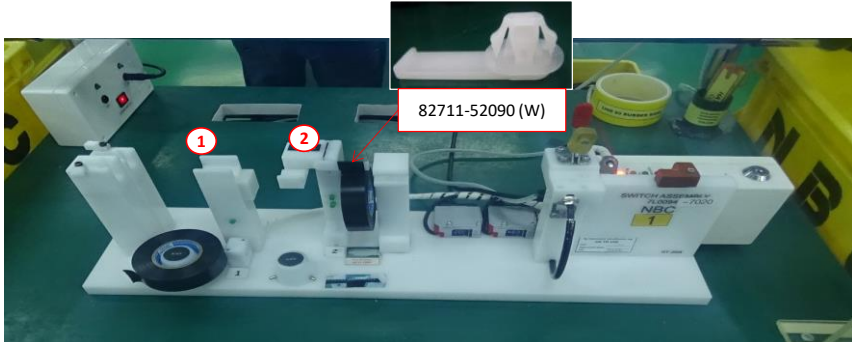
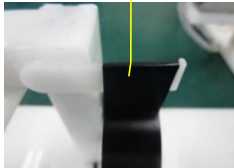


☒ MASSPRO

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PARTS:		1. Clamp 82711-52090 (W) 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<div>Clamp Setting</div> <div></div> <div><div>1. Get 1pc of clamp <b>82711-52090 (W)</b> using right hand and set it to clamp <b>location 2</b> using both hands.</div><div>2. Initially attach <b>Black tape</b> on clamp <b>location 2</b> using both hands.</div></div> <div><div>STANDARD TAPING FOR</div><div>One side tape under clamp</div><div></div></div>		n/a	<div>1. No damaged clamp 2. No missing clamp 3. No wrong use of tape</div> <div><b>Important reminders/Note/s:</b>  <i>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</i></div> <div><div>CLAMP ILLUSTRATION</div><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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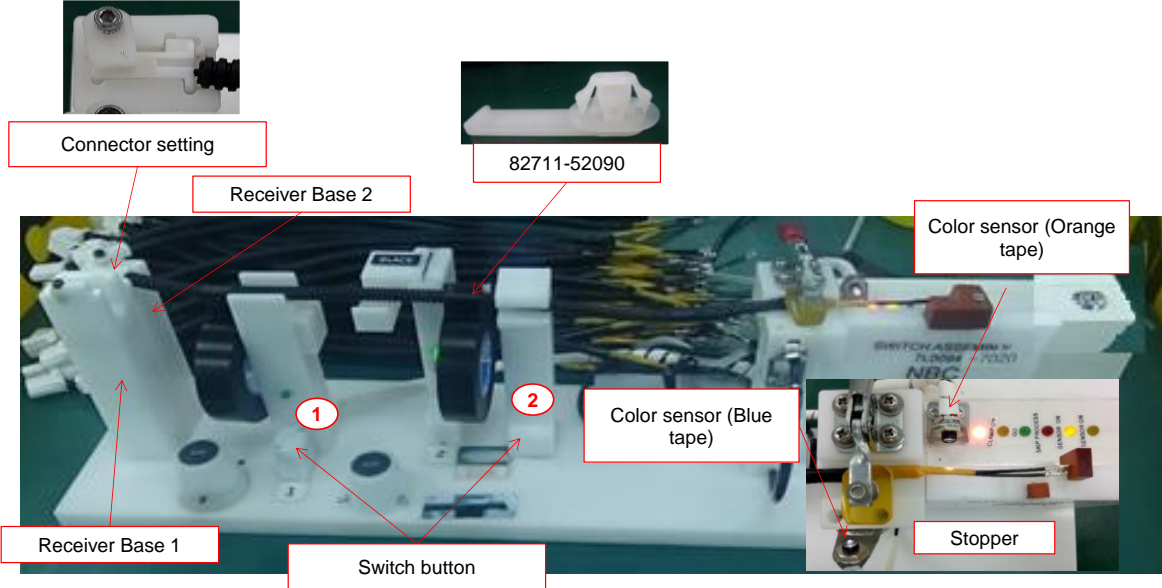
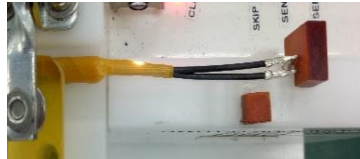
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts (with Orange tape) 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly	<div></div> <div>1. Get the assy parts (with <b>Orange tape</b>) and set to jig using both hands. First, set the connector 6098-3810 (W) to <b>receiver base 2</b> then lock and set the B-B wires with terminal end together within the stopper then press by Toggle clamp. <i>See above picture for correct setting.</i> <i>Note: Beep sound will be heard if the color sensor detect the Orange tape.</i></div> <div>2. Get Black tape using right hand, conduct pre-taping of COT on <b>location 1</b> using both hands. Make 2 windings. <i>Note: Do not cut the tape.</i></div> <div>3. Tape the clamp to COT on <b>location 2</b> using both hands. Make 2 windings. <i>Note: Do not cut the tape.</i></div>		<div>1. No loose attachment of clamp 2. No lacking/excess tape windings 3. No missing tape 4. No wrong use of tape</div> <div><b>Important reminders/Note/s:</b>  <i>1. Please check the clamp before start of assembly to avoid wrong use of tape.</i> <i>2. Make sure no gap between the terminals and stopper jig.</i></div> <div></div>

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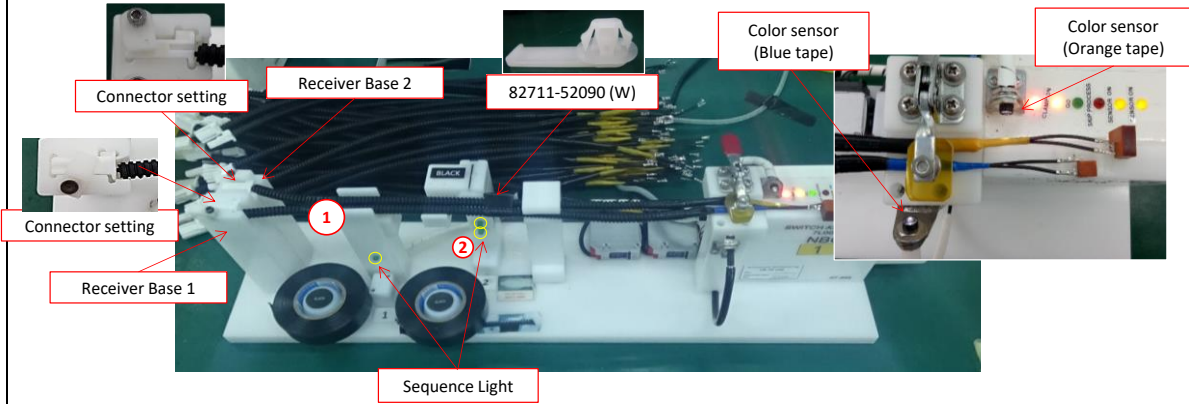
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly (Continuation)	<div></div>		<div>1. No loose attachment of clamp 2. No lacking/excess tape windings 3. No missing tape 4. No wrong use of tape</div> <div>Important reminders/Note/s:</div> <div>1. Please check the clamp before start of assembly to avoid wrong use of tape. 2. Make sure no gap between the terminals and stopper jig.</div>
			<div>4. Get the assy parts (with <b>Blue tape</b>) and set to jig using both hands. First, set the connector <b>6098-5677 (W)</b> to <b>receiver base 1</b> then lock and set the <b>B-B wires</b> with terminal end together within the stopper then press by Toggle clamp. <i>See above picture for correct setting.</i> <i>Note: Beep sound will be heard if the color sensor detect the Blue tape.</i></div> <div>5. Check if all LED light for <b>POWER ON, CLAMP, COLOR SENSOR (Orange) &amp; COLOR SENSOR (Blue)</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process.</div>	<div>6. Combine the COT of assy parts (with <b>orange tape</b>) and assy parts (with <b>Blue tape</b>) and start taping using both hands on <b>location 1</b>. Make 3 windings and cut the tape. Press the <b>SW</b> button after taping.</div> <div>7. Continue taping of COT to clamp on <b>location 2</b> using both hands. Make 3 windings and cut the tape. Press the <b>SW</b> button after taping. <b>GO</b> sound will be heard.</div> <div>8. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div>	

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PARTS: 1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

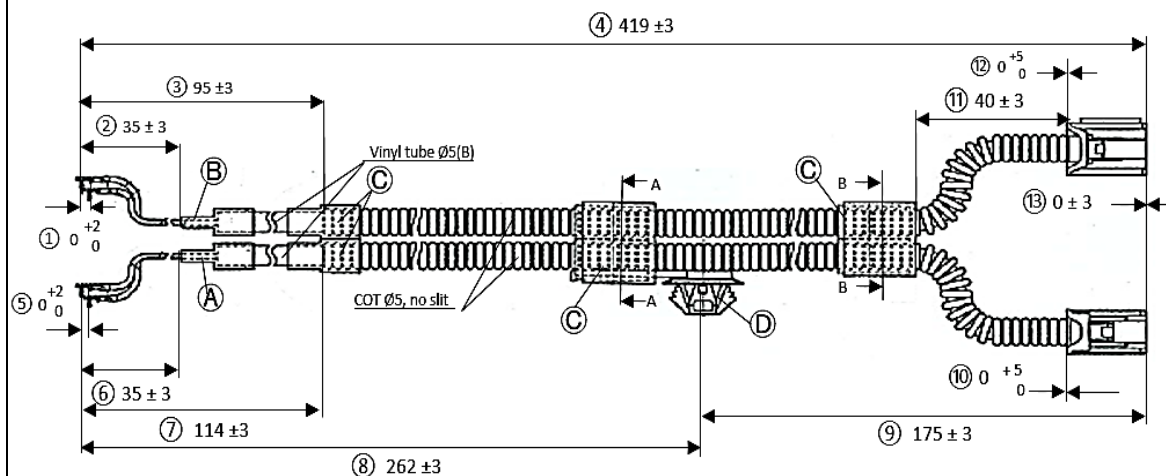
TOOLS/PPE

QUALITY POINTERS

4

Clamp  
assy

Measurement



MEASURING TAPE



Important reminders and note/s:

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

2. For Hatsumono, Nakamono 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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PARTS: 1. Assy parts

JIG:

n/a

## VISUAL INSPECTION/QUALITY CHECKPOINTS

### CLAMP ASSY

# 7L0094-7020

**1** **2** No **UNLOCKED/Half locked Connector**

**3** **4** No **WRONG INSERT**

**5** **6** No **MISSING SPOT TAPE**

**7** No **MISSING CLAMP**

**8** **9** No **MISSING TAPE**

**10** **11** No **Wrong use of TAPE (Blue & Orange)**

**12** **13** No **Deformed Terminal**

**14** No **Terminal Backing Out**

**NO GOOD**

**GOOD**

**GOOD**

**NO GOOD**

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