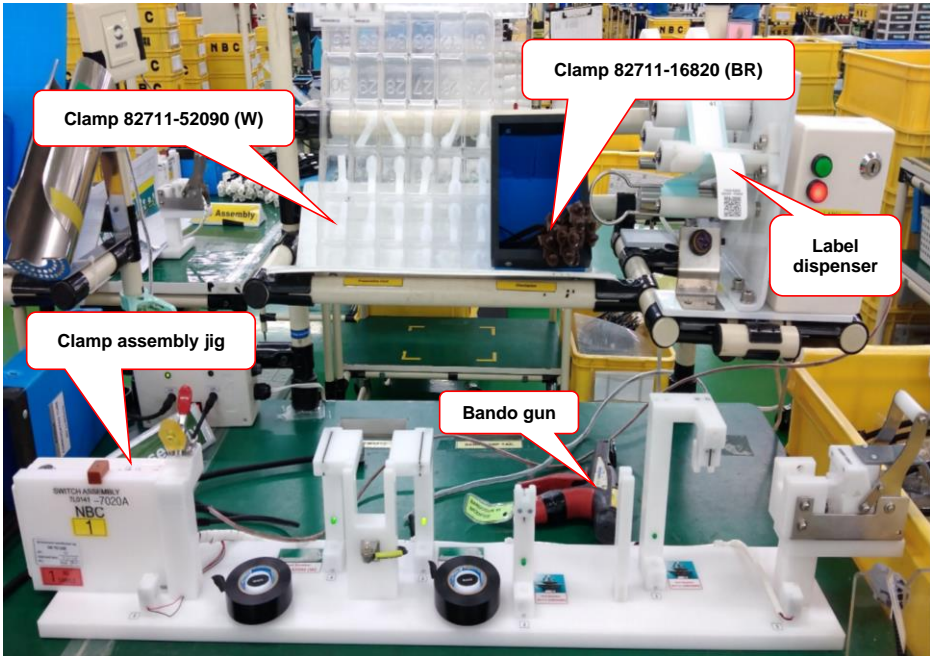


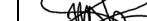
	<b>WORK INSTRUCTION</b>			Effectivity Date:	September 13, 2024		
	Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>380D / 7L0141-7020B</b>	Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.:	<b>WI-ENG-PDE-1053</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 7

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-16820 (B); Label 7V8120-0020; Black tape		JIG:	1. Clamp assembly jig 2. Label dispenser
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to <b>WI-ENG-PDE-610</b> for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History							Prepared by	Reviewed by	Approved by	Noted by	
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a	
09/13/24	1	Change from Pre-launch to Masspro.		A. Hernandez	C. Villanueva	A. Arañes					n/a
09/11/24	0	Initial issue		A. Hernandez	C. Villanueva	A. Arañes					n/a
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 11, 2024	

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# WORK INSTRUCTION

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### PARTS:

1. Clamp 82711-52090 (W) [2pcs.]
2. Clamp 82711-16820 (BR) [2pcs.]

3. Black tape [2pcs.]

JIG:

1. Clamp assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

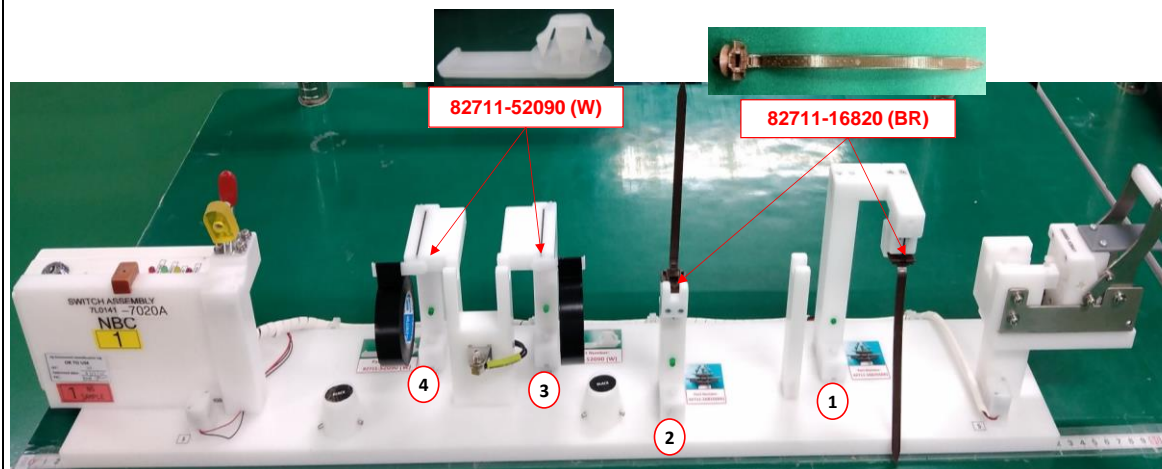
### TOOLS/PPE

### QUALITY POINTERS

2

Clamp Assy

Clamp setting



1. Get 2pcs. of clamp **82711-52090 (W)** using both hands then set to clamp location **4 and 3** using both hands.

2. Get 2pcs. of clamp **82711-16820 (BR)** using both hands then set to clamp location **2 and 1** using both hands.

3. Initially attach **Black tape** on clamp location **4 and 3** using both hands.

### STANDARD TAPING FOR CLAMP

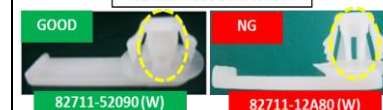
One wind for under tape

### Important reminders/Note/s:

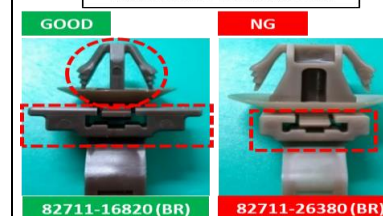
1. Please check the **Clamp** first before start of assembly to avoid wrong use of clamp.

1. No wrong use of clamp
2. No damaged clamp
3. No missing clamp
4. No wrong use of tape
5. No missing tape

### CLAMP ILLUSTRATION



### BAND CLAMP ILLUSTRATION



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## PARTS:

1. Assy parts
2. Black tape

JIG:

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

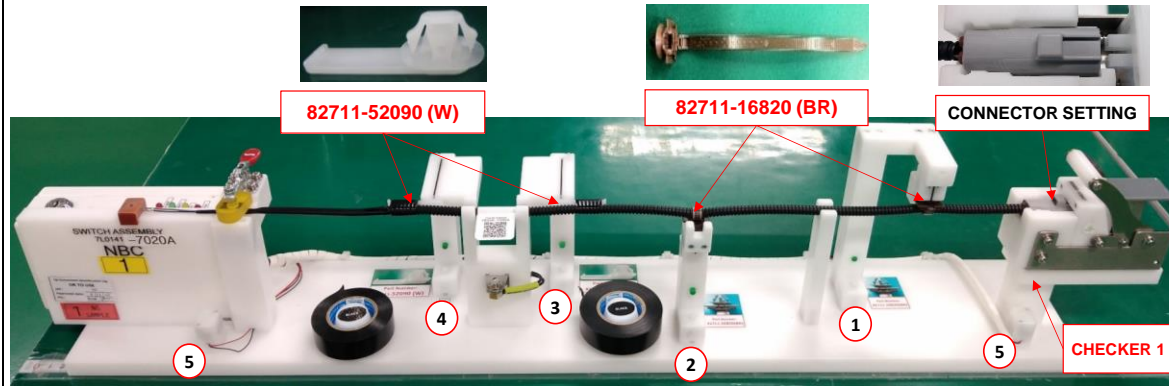
## TOOLS/PPE

## QUALITY POINTERS

3

Clamp  
Assy

Clamp assembly



1. Get the assy parts and set into jig. (See above picture for correct **setting of harness**). First, set the connector **6188-0066 (GR)** to **Checker 1** then push the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the terminal end together within the stopper then press by **Toggle clamp**.

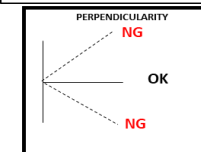
2. Check if all LED light for **Power On, Clamp ON**, was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

3. Initially tighten the band clamp on location **1 and 2** using both hands.

4. Get the bando gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cut. Continue if the sequence light on clamp location **2** was **ON**.

BANDO GUN POSITION ON CLAMP  
LOCATION 1

BANDO GUN ALIGNMENT



Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For: ø5 - 1~2, ø7 - 3~4



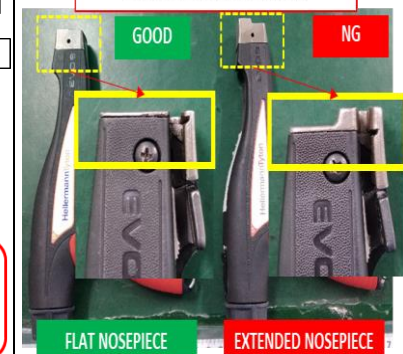
1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position



## Important reminders/Note/s:

1. Make sure no gap in stopper and terminals.

## BANDO GUN ILLUSTRATION



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## PARTS:

1. Assy parts
2. Black tape

JIG:

1. Clamp assembly jig

NO.

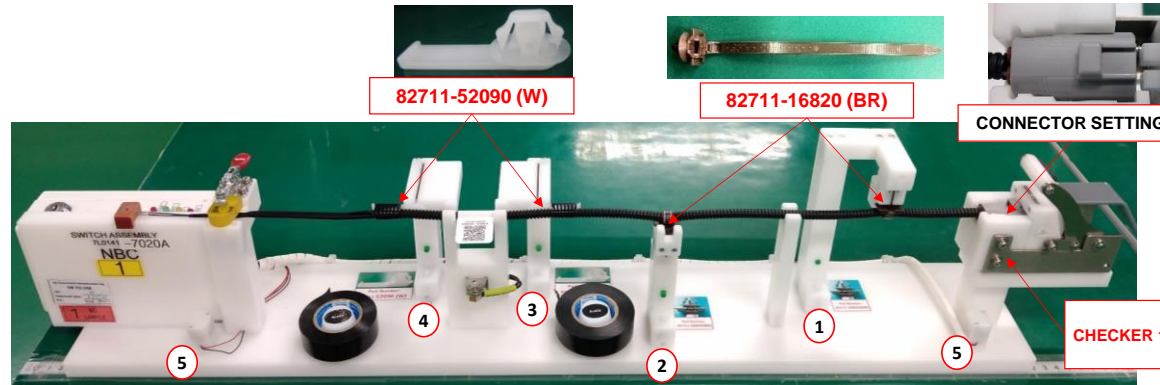
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Clamp  
AssyClamp assembly  
(Continuation)

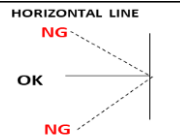
5. Cut the band clamp on location **2** using both hands. Press the **SW button** after cut. Continue if the sequence light on clamp location **3** was **ON**.

6. Hold the tape on clamp location **3**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue if the sequence light on clamp location **4** was **ON**.

## BANDO GUN POSITION ON CLAMP LOCATION 2



Fixed setting of  
band clamp  
cutter: 3 ~ 4

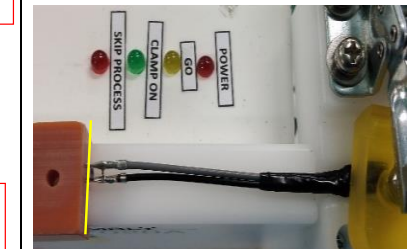


7. Hold the tape on clamp location **4**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process on label attachment

8. For label attachment, get the QR code label then attach using both hands. Press both **SW button** after attachment. **Go** sound will be heard. (Refer to the next page for label attachment).

9. Conduct **POINT CHECKING** before removing the harness from jig.

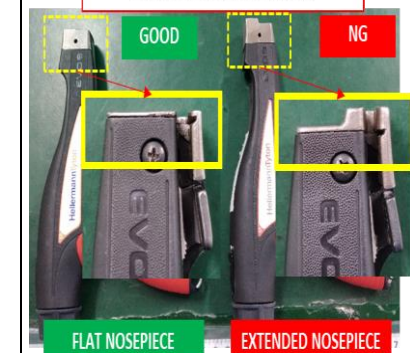
1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position



## Important reminders/Note/s:

1. Make sure no gap in stopper and terminals.
2. Make 2-3 windings for clamp taping

## BANDO GUN ILLUSTRATION



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### PARTS:

1. Assy parts

2. Label 7V8120-0020

JIG:

1. Label dispenser

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Clamp  
Assy

Label attachment

SWITCH ASSY P/N	SWITCH ASSY PART NUMBER REFERENCE	PART NO.	TOYOTA PART NO.	SEAT POSITION	SEAT TYPE
7L0141-702	41	7V8120-0020	73230-AQ020	DRIVER	POWER
7L0140-702	40	7V8110-0020	73230-AQ010	DRIVER	PWR + MEM
7L0139-702	39	7V8130-0020	73230-AQ040	DRIVER	MANUAL



2. Align the end part of  
label in the jig.



3. Fold the center part  
of the label



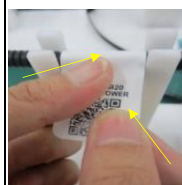
Model  
code

Item no. &  
name

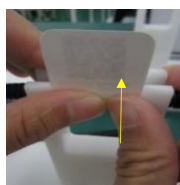
1. Get the label.  
**Note: Check the  
model code, item no.  
& name**



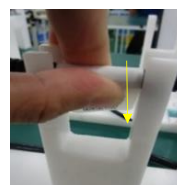
4. Align both end part of label .



5. After alignment ,  
Press the label with  
both fingers .



6. Press the label upside down using  
finger.



GOOD

Acceptable  
overlap  
0~1mm



NG

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of the label



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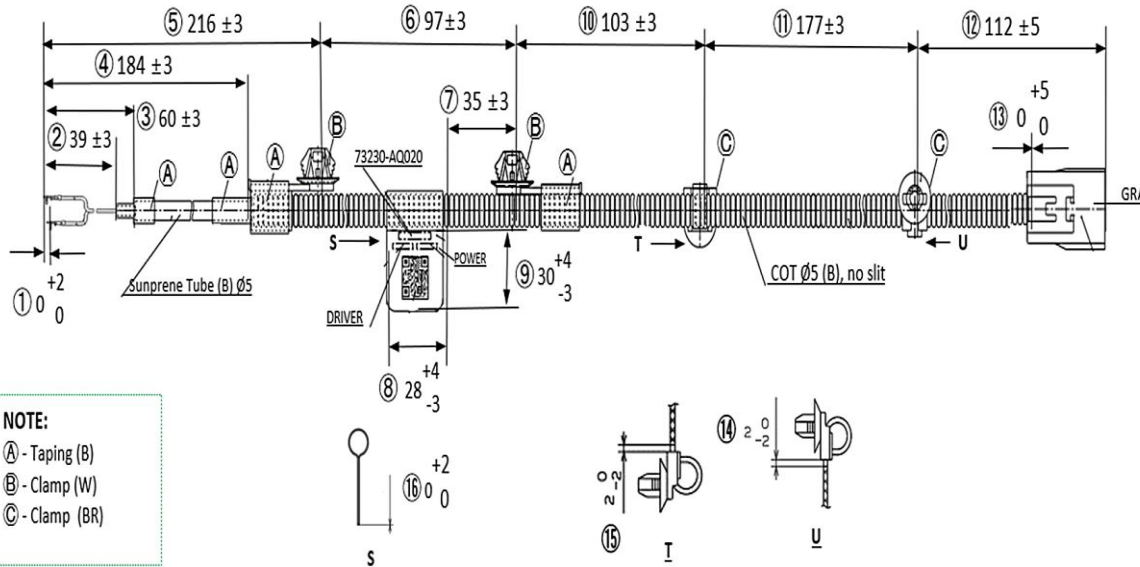

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PARTS:	1. Assy parts		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	<div>Measurement</div> <div><div><p><b>NOTE:</b></p><ul style="list-style-type: none"><li>A - Taping (B)</li><li>B - Clamp (W)</li><li>C - Clamp (BR)</li></ul></div></div>	<div><p><b>MEASURING TAPE</b></p></div> <div><p><b>Important reminders and note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. For Hatsumono, Nakamono and Owarimono.</p><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p></div>	<div>1. No wrong dimension</div>

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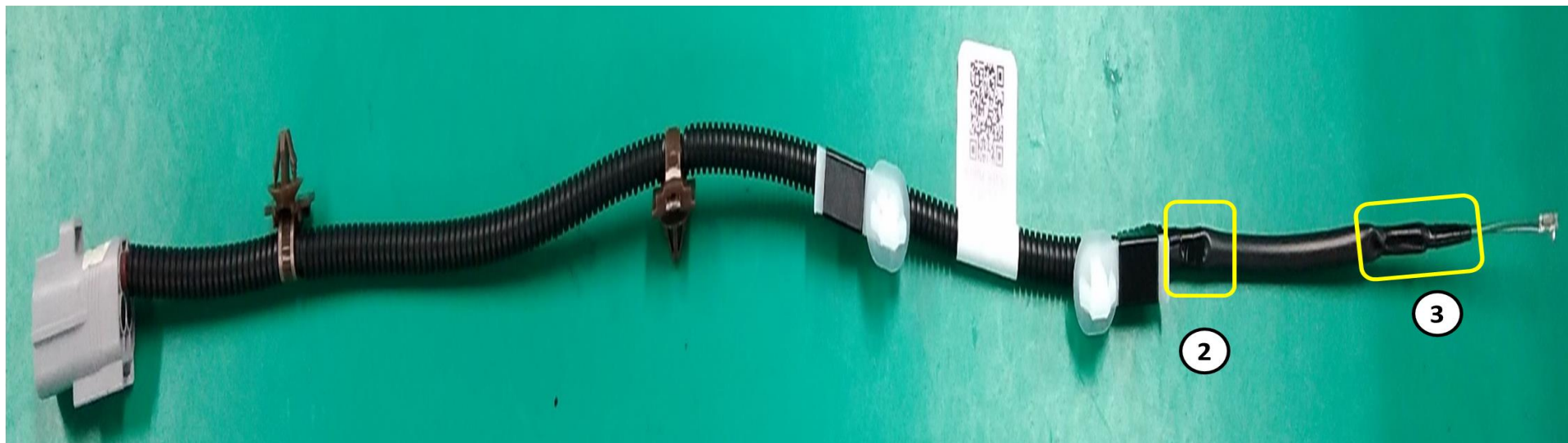
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP ASSY****7L0141-7020B****1** No Wrong Facing of Clamp**2** **3** No Missing Tape ( Black Tape )

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