



WORK INSTRUCTION  
CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 240B / 7M0487-7020C

Customer: TRJ

Car Model: LEXUS-ES

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 24, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-822

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. Assy parts; Clamp 82711-52090 (W); Black tape; Violet tape

JIG:

1.Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

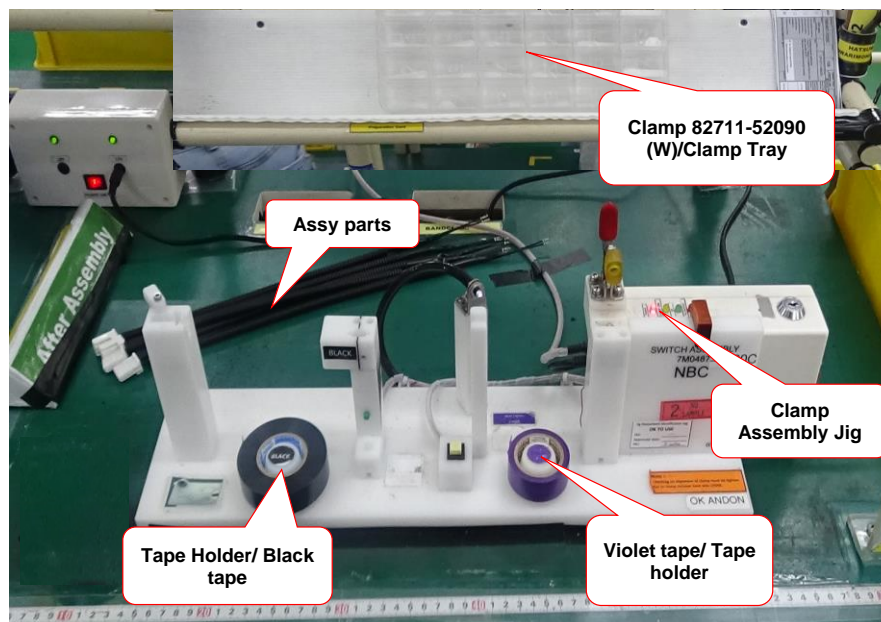
TOOLS/PPE

QUALITY POINTERS

1

CLAMP  
ASSY

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**

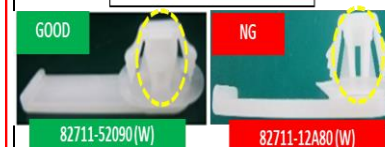
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

**Document reference/s:**

1. Refer to WI-ENG-PDE-071 for Taping assembly process

CLAMP ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/24/24	0	Initial issue.	D.Castillo	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a

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DCC Stamp

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**240B / 7M0487-7020C**Customer: **TRJ**

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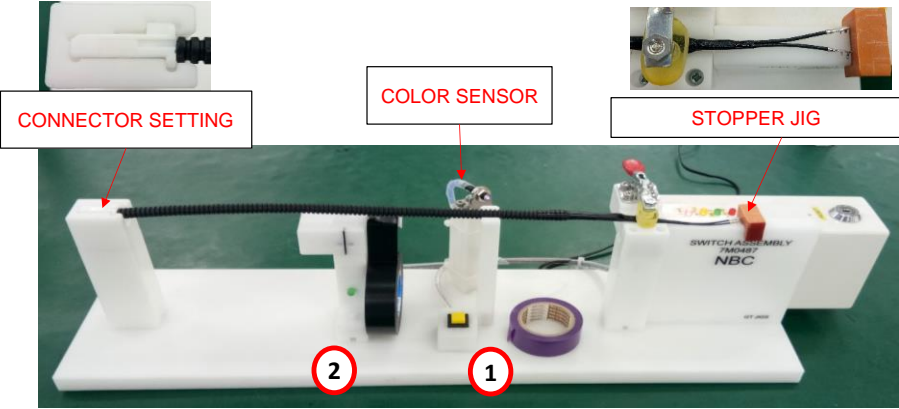
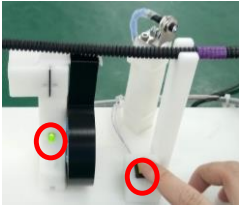


PARTS:		1. Clamp 82711-52090 (W) 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	<div><div><div><div><div><div></div><div>82711-52090</div></div><div><div></div><div>2</div></div><div><div></div><div>1</div></div></div><div></div></div></div><div>1. Get the clamp <b>82711-52090 (W)</b> using right hand and set to clamp assembly jig using both hands.</div><div>2. Initially attach <b>Black tape</b> on clamp location <b>2</b> using both hands.</div></div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>1. No wrong use of parts. 2. No wrong use of tape</div> <div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div><div>82711-52090 (W)</div></div></div><div><div>NG</div><div><div>82711-12A80 (W)</div></div></div></div></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 5


<b>PARTS:</b>	1. Assy parts 2. Violet tape			JIG:	1. Clamp Assembly jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
3	CLAMP ASSY	<div><div>1. Get the harness using both hands and set to jig. First put the connector into receiver base. Second, put the terminal to stopper jig and pull down the toggle clamp.</div><div>2. Check the LED light for <b>POWER, CLAMP</b> and <b>SEQUENCE LIGHT</b> is <b>ON</b>. If encountered abnormality, <b>STOP</b> the process, <b>CALL</b> the immediate superior and <b>WAIT</b> for instructions.</div><div>3. Get the <b>Violet tape</b> and conduct spot taping on <b>location 1</b> using both hands. Make 2-3 winds. <b>GO buzzer will be heard if the Violet tape is detected.</b> Press the yellow button after taping. Continue the process if sequence light in location <b>2</b> was <b>on</b>.</div><div><div>4. Conduct taping on location <b>2</b> using both hands and cut the tape. Press the button after taping. <b>GO</b> sound will be heard.</div><div>5. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div></div></div> <div>n/a</div> <div><div><div>1. No wrong use of tape 2.No loose tape 3. No flip-out tape 4. No peel-off tape</div></div><div><div><b>Important reminders/Note/s:</b> <b>1. Must be no gap between terminal and stopper jig</b> <b>2. Make 2-3 windings for clamp taping</b></div></div></div>						

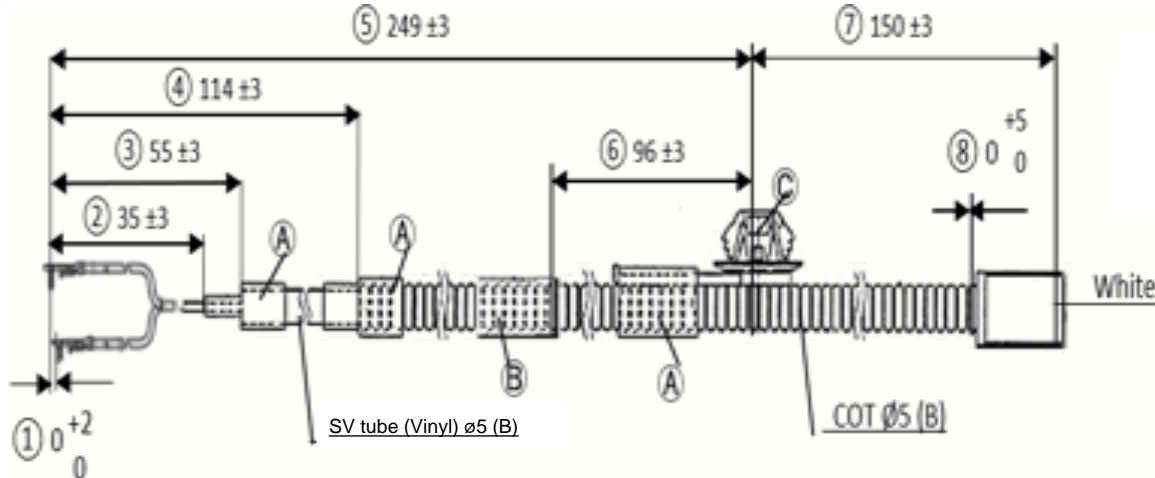

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 5

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Measurement	<div><div>MEASURING TAPE</div><div>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (V) Ⓒ - Clamp (W)</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> <p>1. No wrong dimension</p>

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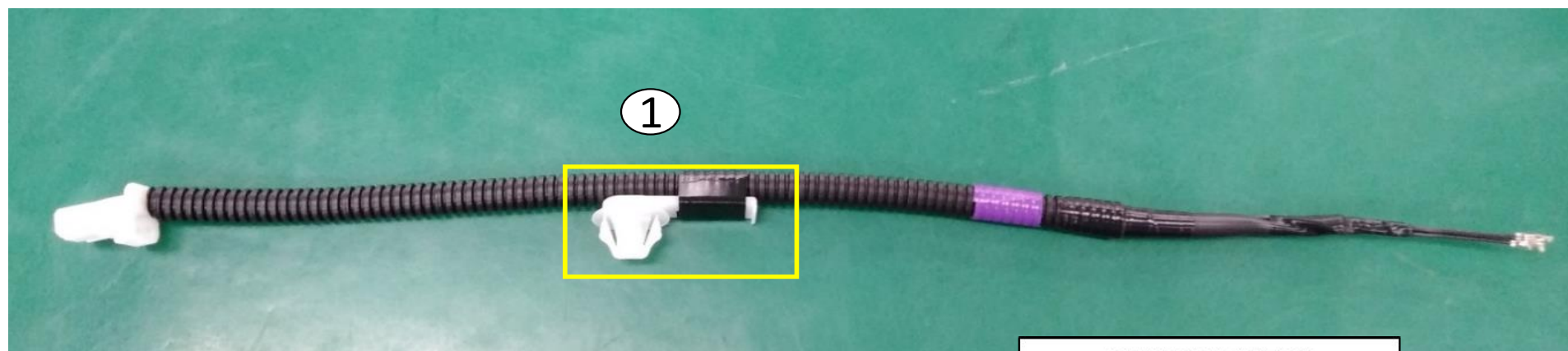
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**PARTS:**

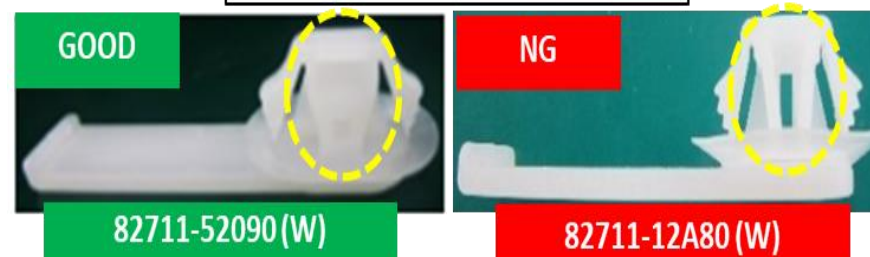
1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****CLAMP ASSY****7M0487-7020C****CLAMP ILLUSTRATION**

**1 Check the  
Clamp appearance**



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