



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number:

700B

/ 7N0039-7020B

Customer:

TRJ

Car Model:

TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-884

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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## PARTS:

1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-3A540 (W)

JIG:

1. Clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

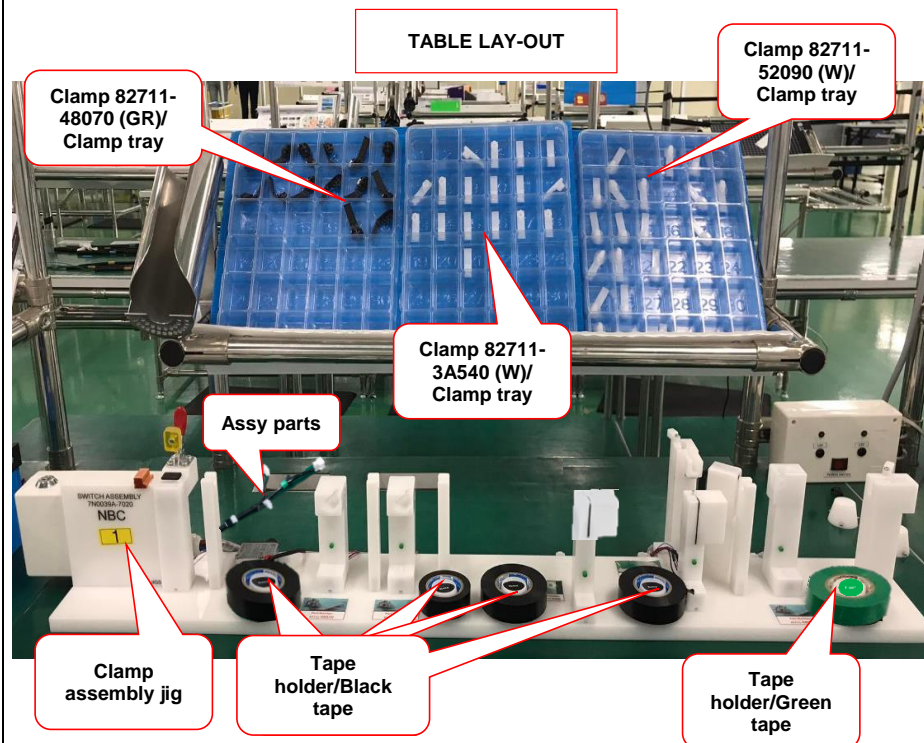
## TOOLS/PPE

## QUALITY POINTERS

1

n/a

Table lay-out

**Safety Instruction**

Be sure to wear 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

## CLAMP ILLUSTRATION

**Important reminders/Note/s:**

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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

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

05/09/24 0 Initial issue

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

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Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

May 09, 2024

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PARTS:	1. Clamp 82711-52090 (W) 2. Clamp 82711-48070 (GR) [3pcs] 3. Clamp 82711-3A540 (W)	4. Black tape 5. Green tape	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a  Clamp setting	<div data-bbox="846 384 1055 496"> 82711-48070 (GR)</div> <div data-bbox="1070 384 1272 496"> 82711-3A540 (W)</div> <div data-bbox="1288 384 1496 496"> 82711-52090 (W)</div> <div data-bbox="1512 384 1713 496"> 82711-48070 (GR)</div> <div data-bbox="564 507 1666 804"></div> <div data-bbox="555 820 1202 890">1. Get [2pcs] of clamp 82711-48070 (GR) using right hand and set to Clamp location 4 and 5 using both hands.</div> <div data-bbox="555 938 1202 1008">2. Get [1 pc.] of clamp 82711-48070 (GR) using right hand and set to Clamp location 2 using both hands.</div> <div data-bbox="555 1072 1202 1142">3. Get [1 pc.] of clamp 82711-3A540 (W) using right hand and set to Clamp location 3 using both hands.</div> <div data-bbox="555 1206 1202 1276">4. Get [1 pc.] of clamp 82711-52090 (W) using right hand and set to Clamp location 1 using both hands.</div> <div data-bbox="1238 890 1686 997">5. Get the Black tape using right hand then initially attached to clamp location 5, 4, 3 and 1 using both hands.</div> <div data-bbox="1238 1061 1686 1168">6. Initially attached Green tape on location no. 2 using both hands.</div>		<p><b>Important reminders/Note/s:</b></p> <p>1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</p> <p>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</p> <div data-bbox="1742 927 2123 1082"><p>CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div>

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## PARTS:

1. Assy parts
2. Black tape [4pcs]

3. Green tape

JIG:

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

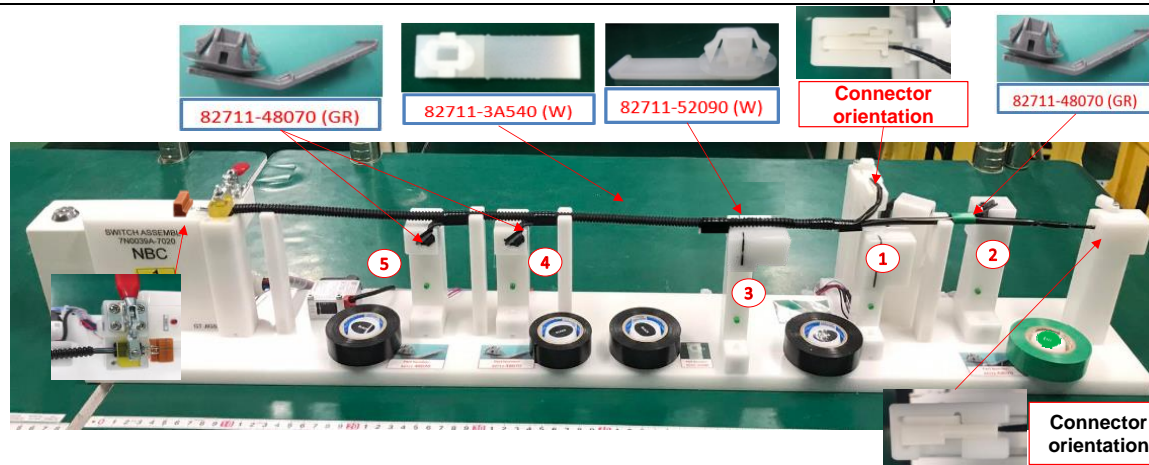
## TOOLS/PPE

## QUALITY POINTERS

3

n/a

Clamp assembly



1. Get the assy parts and set into jig using both hands. (See above picture illustration for correct setting of harness). First, set the connector 6098-3802 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Set the connector 6098-3810 (W) to Receiver base 2 then lock. Continue to set the harness in jig then set the terminal end within the stopper then press by toggle clamp.

2. Hold the Black tape on clamp location 1 then start taping using both hands. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 2 was ON.

3. On clamp location 2 hold the tape then start taping using both hands. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 3 was ON.

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

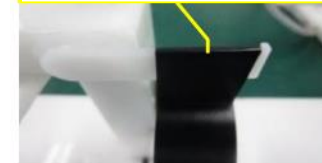
5. Hold the Black tape on clamp location 4. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if the sequence light on Location 5 was ON.

6. Hold the Black tape on clamp location 5. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping.

7. After taping, Check the taping. Conduct POINT CHECKING before removing of harness from jig.

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

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.
2. Must be no gap between terminal and stopper jig.
3. Make 2-3 windings for clamp taping.

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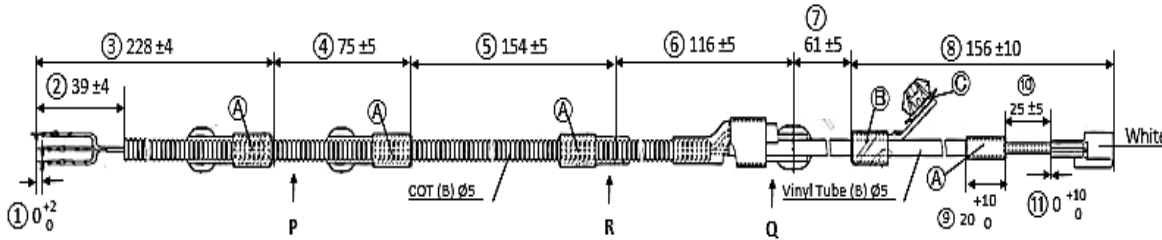
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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> 	<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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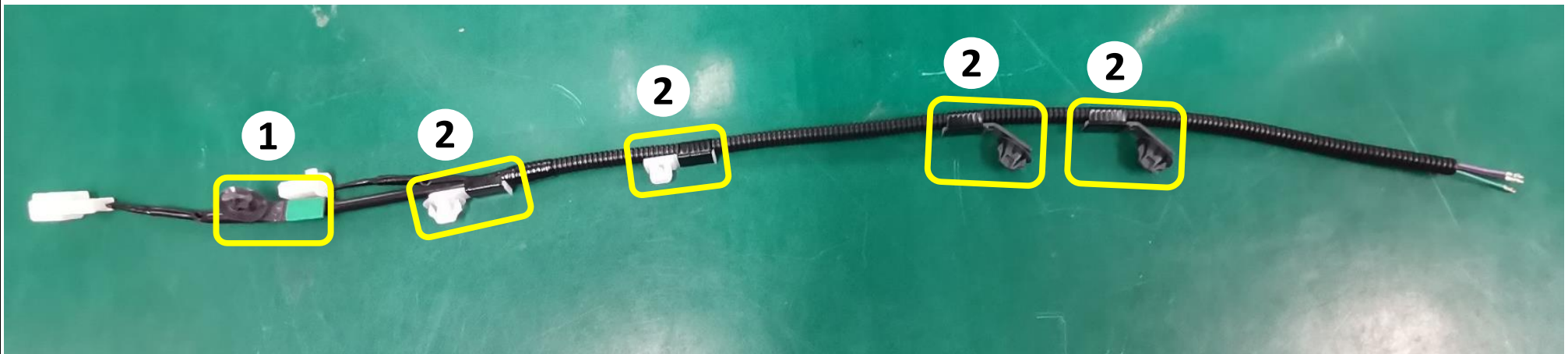
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****CLAMP****7N0039-7020B****1****No Wrong use of tape (Clamp taping)****2****No Missing Clamp****3****Check the Clamp appearance****4****Check the Alignment of Clamp**

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