



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 19, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0122-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-722

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

1 of 5

PARTS:

1. Assy parts: Clamp 82711-52070 (W)

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

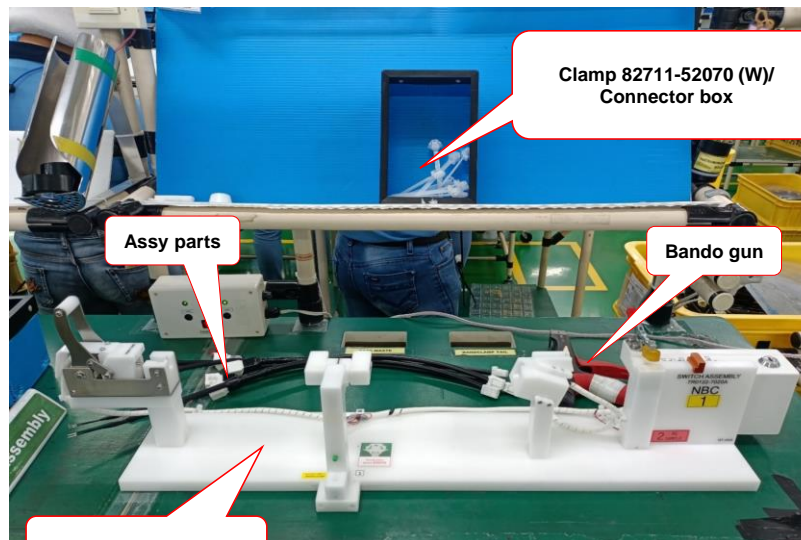
QUALITY POINTERS

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. Refer to **WI-ENG-PDE-722A-C** for Taping assembly process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/19/24 2 Improved Measurement and Visual inspection/Quality checkpoint.

D.Castillo

C.
Villanueva

A. Arañes

n/a

09/06/23 1 Change purpose from pre-launch to mass pro.

M. Manalac

J. Lotere

C.
Villanueva

A. Arañes

09/01/23 0 Initial issue.

M. Manalac

J. Lotere

C.
Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted


Est. Date:


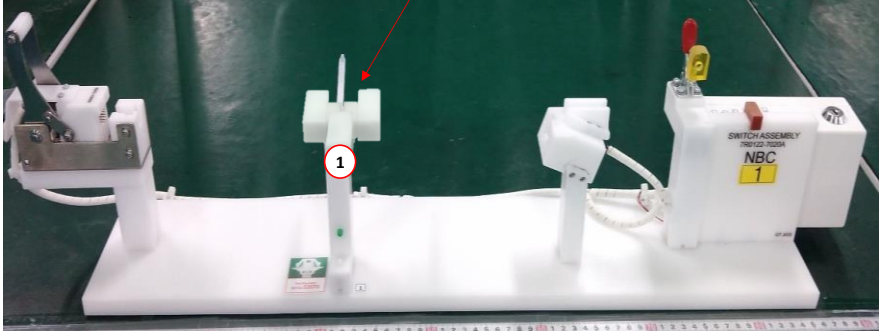
September 01, 2023

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DCC Stamp

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	Model code/Part number: 920B / 7R0122-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-722	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	2 of 5


PARTS:		1. Clamp 82711-52070 (W)		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<div><p>82711-52070 (W)</p><p>1</p><p>1. Get 1pc. of clamp 82711-52070 (W) using right hand then set to clamp location 1 using both hands.</p></div>		n/a	<div>1. No missing clamp 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp positionng parts/tools 5. No excess parts/tools</div>


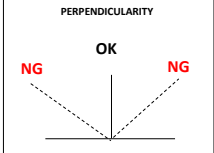

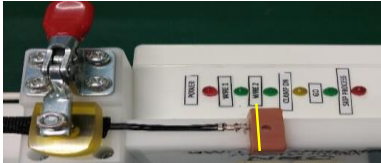

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 5

PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
3	Clamp assy	<div><div>CONNECTOR SETTING</div><div>82711-52070 (W)</div><div>CHECKER 1</div><div>Clip checker 2</div><div>1</div></div> <div><div>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-3909 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 7188-0996 (W) to Clip Checker 2 for continuity checking then set the tube to tube guide. Last, set the terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1 was ON.</div><div>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div><div>3. Initially tighten the band clamp from location 1 using both hands.</div><div>4. Get the bando gun and cut the band clamp on location 1 using both hands. Press the SW button after cut. GO sound will be heard.</div><div>5. Conduct POINT CHECKING before removing from clamp assembly jig.</div><div>6. After point checking, remove the harness from toggle clamp up to checker 1 to tube guide. Last remove to clip checker 2.</div></div> <div><div>BANDO GUN</div><div></div><div>BANDO GUN ALIGNMENT</div><div></div><div></div></div>		<div></div> <div><div>Important reminders/Note/s:</div><div>1. Make sure no gap between stopper and terminals</div></div> <div><div>1. No damaged clamp</div><div>2. No wrong use of clamp</div><div>3. No missing clamp</div><div>4. No wrong use of bando gun</div></div> <div><div>BANDO GUN ILLUSTRATION</div><div></div></div>			

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4 of 5**PARTS:**

1. Assy parts

JIG:

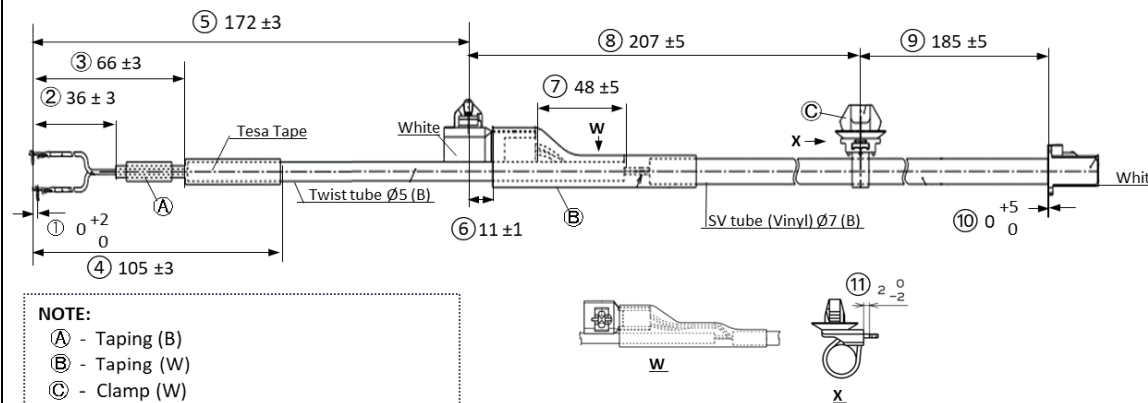
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NO.**PROCESS NAME****2****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

Clamp
assy

Clamp Assembly

**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**

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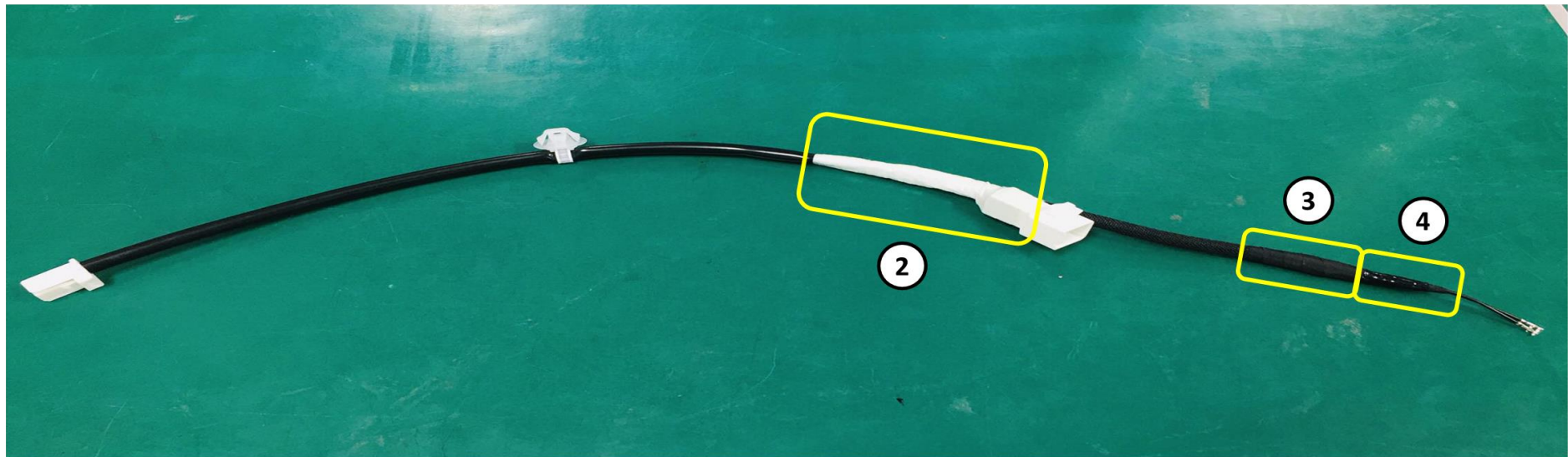
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7R0122-7022****1 No Wrong Facing of Clamp****2 No Missing Tape (White Tape)****3 No Missing Tape (Black Tesa Tape)****4 No Missing Spot tape (Black Nitto Tape)**

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