



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 26, 2024

Process Name/Title:

Model code/Part number:

491D/564D / 7R0150-7020

Customer:

TRMX

Car Model:

TOYOTA-SEQUOIA

Validity Date:

n/a

Document No.:

WI-ENG-PDE-988

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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PARTS:

1. Assy parts; Clamp 82711-34490 (B)

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

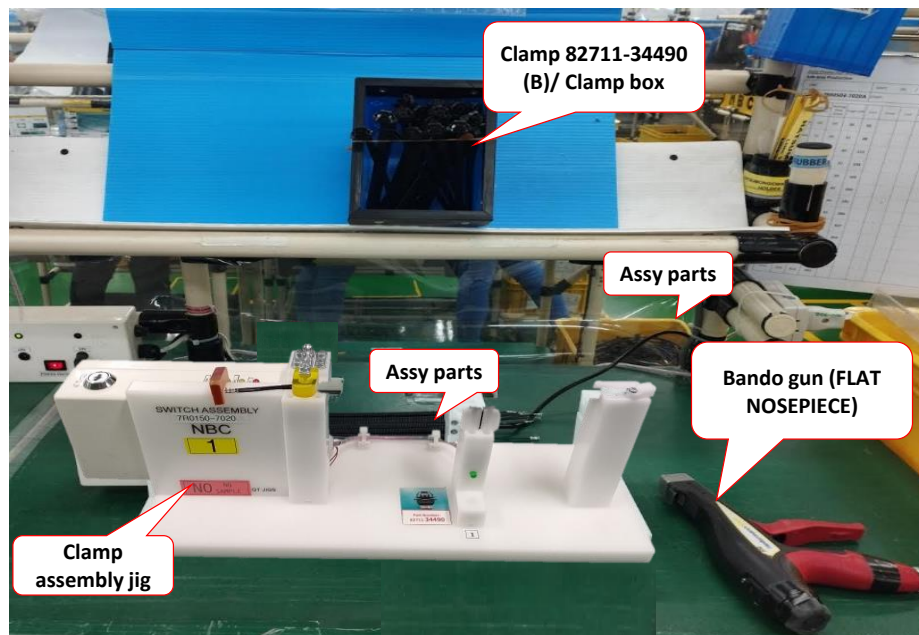
QUALITY POINTERS

1

n/a

Table lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required 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 references:

1. Refer to WI-ENG-PDE-576 Taping assembly process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/26/24 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:

July 26, 2024

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|--|--------------|---|--|--|---|
| PARTS: | | 1. Assy parts 2. Clamp 82711-34490 (B) | | JIG: | 1. Clamp Assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | Clamp Assy | Clamp Setting | | <div></div> | <p>Important reminders/Note/s:</p> <p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p> |
| <div>1. Get 1 pc of band clamp 82711-34490 (B) using right hand and set to clamp location ① using both hands.</div> | | | | | |

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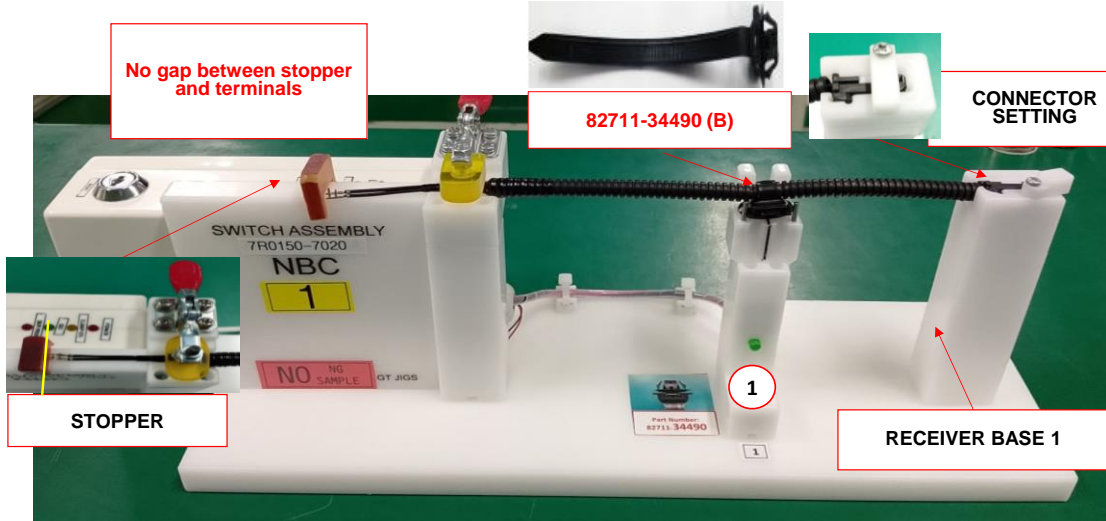

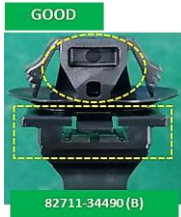
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| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | Clamp Assy | Clamp Assembly | <div><div><div>No gap between stopper and terminals</div><div>82711-34490 (B)</div><div>CONNECTOR SETTING</div><div>STOPPER</div><div>RECEIVER BASE 1</div></div><div></div><div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6098-6663 (B) in Receiver base 1 then lock using right hand. Continue to set the harness then last, set the B-B wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was ON. the CLAMP ON.</p><p>2. Check if LED light for POWER, CLAMP, and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the Leader and WAIT for instruction.</p></div></div> <div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div><div>82711-34490 (B)</div><div>82711-16830 (B)</div></div></div><div><p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p></div></div> | | |

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| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | Clamp Assy | <div><div>No gap between stopper and terminals</div><div>STOPPER</div><div>82711-34490 (B)</div><div>CONNECTOR SETTING</div><div>RECEIVER BASE 1</div><div>1</div><div>SWITCH ASSEMBLY 7R0150-7020 NBC 1 NO NG SAMPLE GT JIGS</div><div>3. Initially tighten the band clamp 82711-34490 on clamp location 1 using right hand.</div><div>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. GO sound will be heard.</div></div> | | <div><div>BAND CLAMP ILLUSTRATION</div><div>GOOD</div><div>NG</div><div>FLAT NOSEPIECE</div><div>EXTENDED NOSEPIECE</div><div>1. No damaged clamp</div><div>2. No wrong use of clamp</div><div>3. No wrong use of tape</div><div>4. No missing clamp</div><div>5. No wrong use of bando gun.</div></div> | |
| | | <div><div>IMPROPER CUTTING POSITION OF BANDO GUN</div><div>NG</div><div>PROPER CUTTING POSITION OF BANDO GUN</div><div>GOOD</div><div>BANDO GUN ALIGNMENT</div><div>NG</div><div>OK HORIZONTAL</div><div>NG</div><div>5. Conduct POINT CHECKING before removing the harness from jig.</div></div> | <div><div>BANDO GUN</div><div>FLAT NOSEPIECE</div></div> | | |

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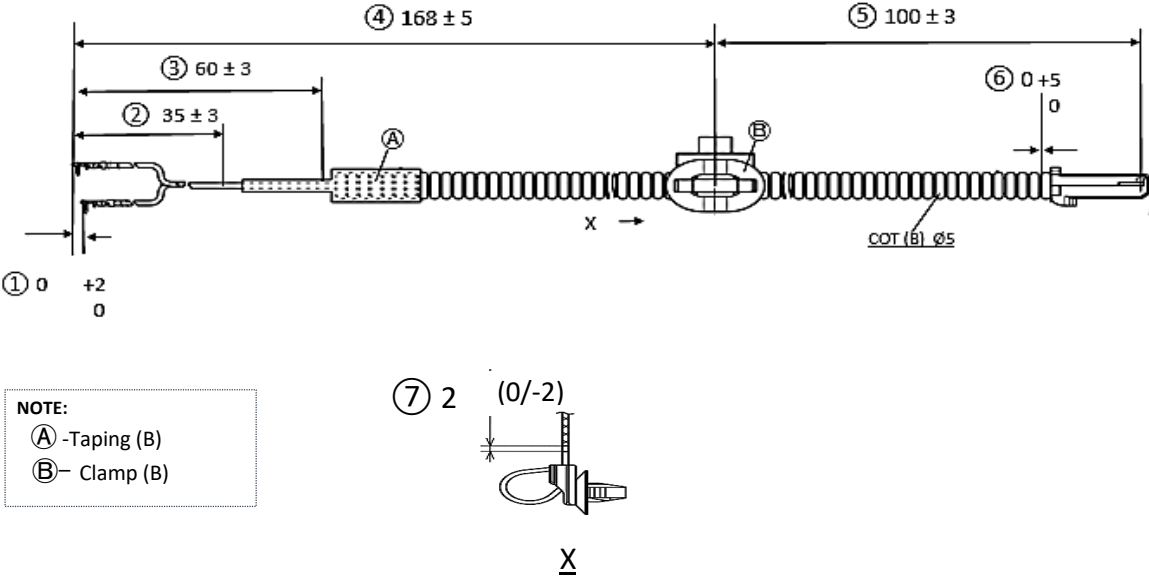
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| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 4 | Clamp Assy Measurement | <div><div>MEASURING TAPE</div></div>  <p>NOTE: ① -Taping (B) ② - Clamp (B)</p> | | <p>1. No wrong dimension.</p> <p>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> |

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP ASSY****7R0150-7020****GOOD****NO GOOD****1 No Unlock/Halflock Connector****2 No Missing tape (Black Tape)**

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