



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 18, 2024

Model code/Part number:

310D

/

7N0195-7020E

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1029

1

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PARTS:

1. Assy parts; Clamp 82711-33650 (B); Clamp 82711-52090 (W); Clamp 82711-48210 (B); Black tape [3pcs]; Yellow tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

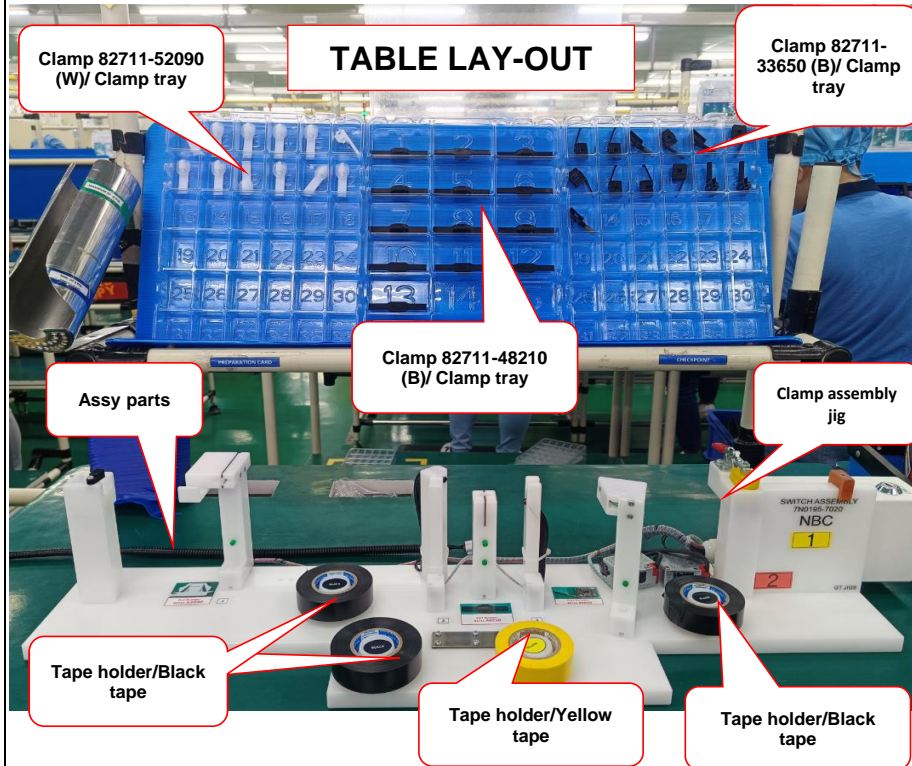
TOOLS/PPE

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 part/tools.
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/18/24	1	Change Purpose from Pre-launch to Masspro. Update the Visual Inspections/Quality Checkpoints	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
09/10/24	0	Initial Issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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DCC Stamp

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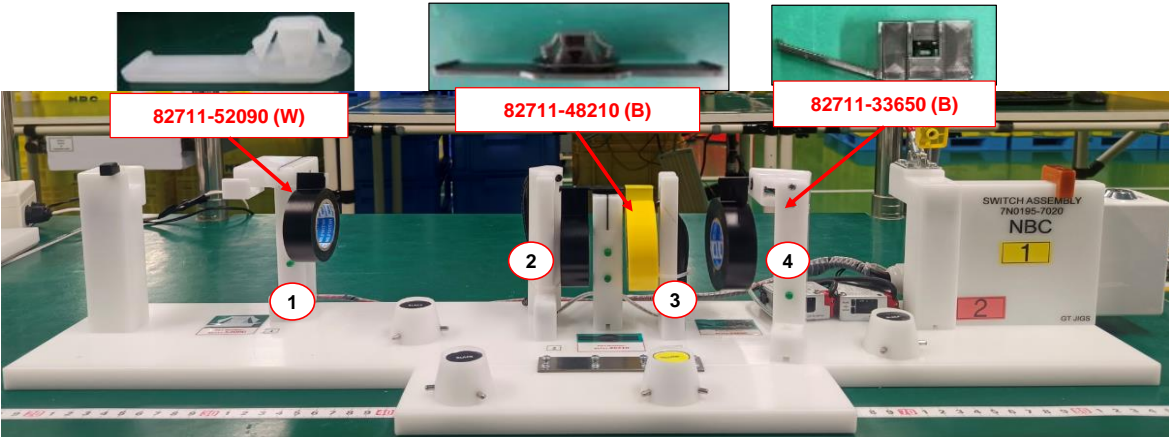
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B) 3. Clamp 82711-52090 (W)	4. Black tape [3pcs] 5. Yellow tape	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp assy Clamp setting	<div></div> <div>1. Get 1pc of clamp 82711-52090 (W) using right hand then set to Clamp location no. 1 using both hands.</div> <div>2. Get 1pc of clamp 82711-48210 (B) using right hand then set to Clamp location no. 2 and 3 using both hands.</div> <div>3. Get 1pc of clamp 82711-33650 (B) using right hand then set to Clamp location no. 4 using both hands.</div> <div>4. Initially attach YELLOW TAPE to location 3 using both hands.</div> <div>5. Initially attach BLACK TAPE to location 1, 2, and 4 using both hands.</div>		Important reminders/Notes 1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp. 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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PARTS:

1. Assy parts
2. Black tape [3pcs]
3. Yellow tape

JIG:

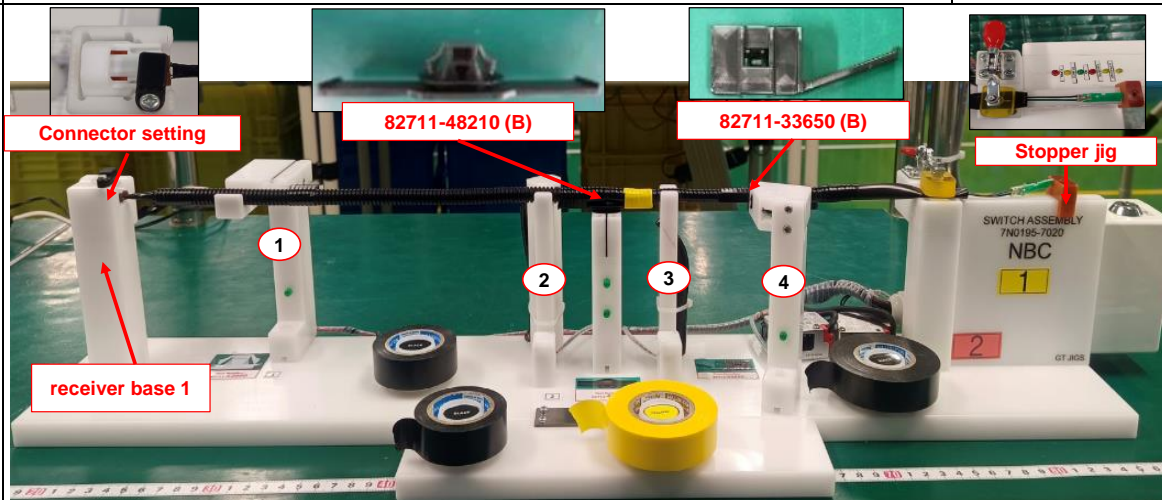
1. Clamp assembly jig

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

3

Clamp
assy

Clamp assembly



1. Get the assy parts using right hand then set into jig using both hands. **(See above picture for the correct setting)**. First put the connector **6189-0451 (W)** into **receiver base 1**. Continue setting the harness in jig. Last, set the hotmelted wires **(B/W-G)** within the stopper jig then press by the toggle clamp.

2. Hold the tape on the clamp location no. **1** using right hand. Make **3 windings** of tape using both hands then cut the tape. Proceed to clamp location **2**.

3. Hold the tape on the clamp location no. **2** using right hand. Make **3 windings** of tape using both hands then cut the tape. Proceed to clamp location **3**.

4. Hold the tape on the clamp location no. **3** using right hand. Make **3 windings** of tape using both hands then cut the tape. Proceed to clamp location **4**.

5. Hold the tape on the clamp location no. **4** using right hand. Make **3 windings** of tape using both hands then cut the tape.

6. After taping, conduct **POINT CHECKING** before removing the harness from jig

Important reminders/Notes

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

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

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

n/a

JIG:

n/a

NO.

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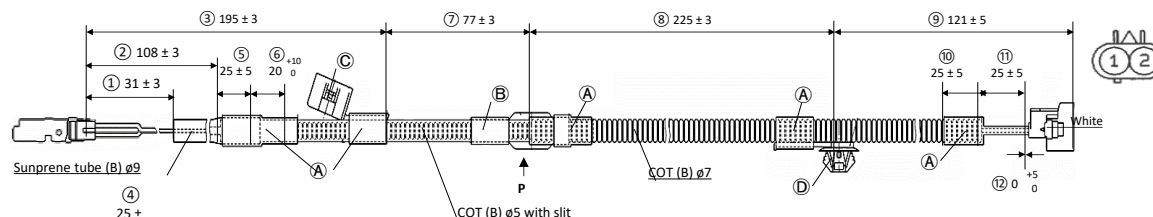
TOOLS/PPE

QUALITY POINTERS

4

Clamp
assy

Measurement



NOTE:

- (A) - Taping (B)
- (B) - Taping (Y)
- (C) - Clamp (B)
- (D) - Clamp (W)
- (4) - dimension of overlapped Sunprene and COT

WIRE TYPE TABLE

No.	Color	Wire Type
1	G	TVSS 0.3 f
2	BW	TVSS 0.3 f

MEASURING TAPE



1. No wrong dimension

Important reminders/Notes

1. Please use calibrated/verified measuring tape when fetting the measurement.
2. For Hatsumono, Nakamono and Owarimono

Document reference/s:

I-PRO-ASY-056

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JIG:

n/a

**VISUAL INSPECTIONS/ QUALITY CHECKPOINTS****CLAMP ASSY****7N0195-7020E****1** No **MISSING TAPE (B)****2** Check the **ALIGNMENT OF CLAMP**

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