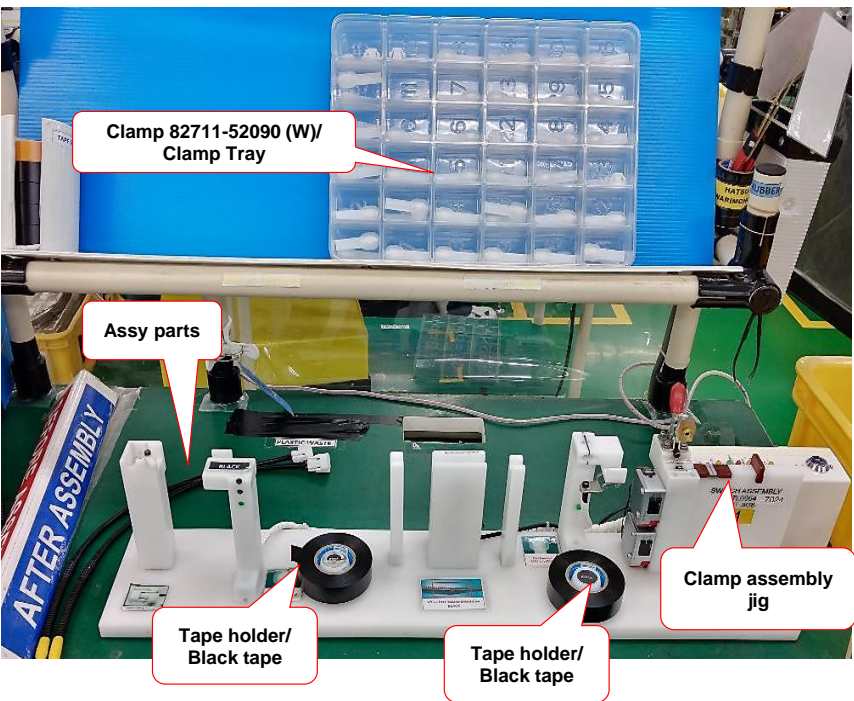
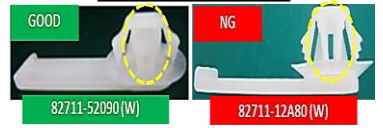
	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0054-7025A		Customer: TRQSS		Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1039	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 5

PARTS: 1. Assy parts; Clamp 82711-52090 (W); Black tape [2pcs.]		JIG: 1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	Clamp Assy Table lay-out	<div style="text-align: center;"> TABLE LAY-OUT </div> 	<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		Document reference/s: 1. Refer to WI-ENG-PDE-1038A-B for Taping assembly process Important reminders/Note/s: 1. Check the Clamp first before start of assembly to avoid wrong use of clamp.	
		<div> 1. No missing parts/tools 2. No excess parts/tools. 3. No wrong positions of parts/tools </div> <div> CLAMP ILLUSTRATION  </div>	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
09/12/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a	
09/09/24	0	Initial issue. Improvement of measurement and visual inspection/quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: September 09, 2024

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DCC Stamp

**WORK INSTRUCTION**

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

320B / 7L0054-7025A

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2 of 5**PARTS:**

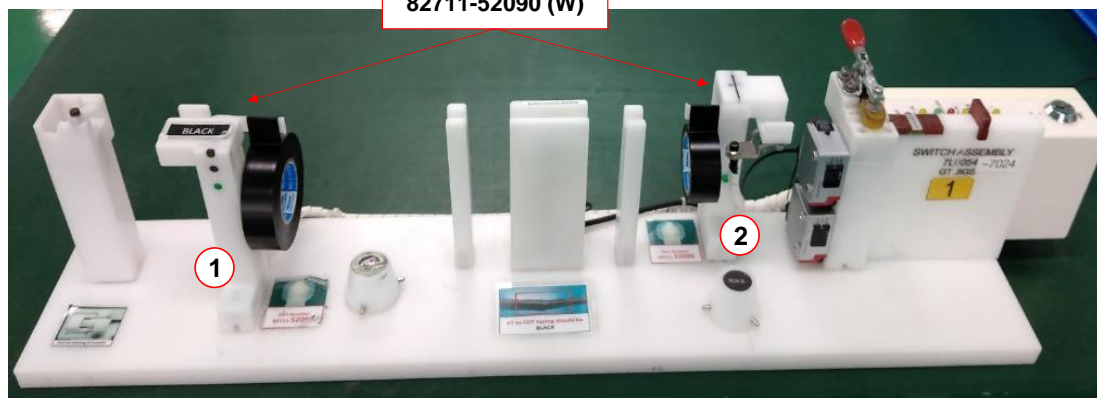
1. Clamp 82711-52090 (W) [2pcs.]
2. Black tape 2pcs.]

JIG:

1. Clamp assembly jig

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

Clamp setting

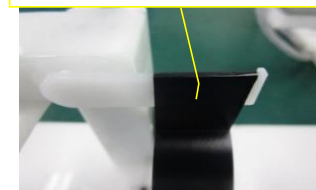
**82711-52090 (W)**

1. Get 2pcs. of clamp **82711-52090 (W)** using both hands then set to location **1 and 2** using both hands.

2. Initially attach **Black tape** on clamp location **1 and 2** using both hands.

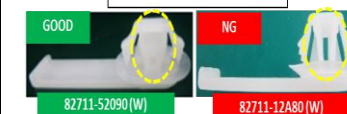
STANDARD TAPING FOR CLAMP

One wind for under tape

**Important reminders/Note/s:**

1. Check the Clamp first before start of 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

CLAMP ILLUSTRATION

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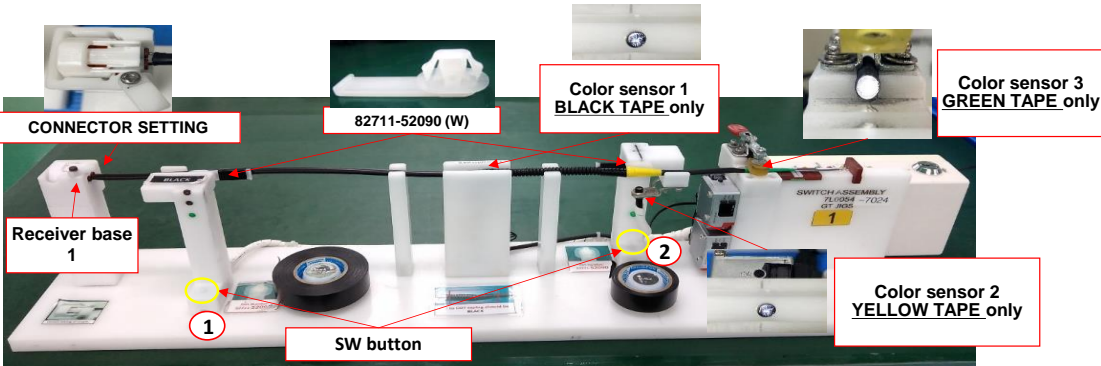

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly		
			<p>1. Get the assy part and set to jig. <i>(See above picture for correct setting)</i>. First, set the connector to 6189-0451 (W) to Receive base 1. Continue setting of harness in jig. Color sensor 1 will beep/buzz if sensor detects BLACK tape. Color sensor 2 will beep/buzz if sensor detects YELLOW tape. Color sensor 3 will beep/buzz if sensor detects GREEN tape. Last, set the G-B/W wires with terminal end together within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p>	
			<p>2. Check if all LED light for POWER ON, CLAMP ON, COLOR SENSOR 1, COLOR SENSOR 2, COLOR SENSOR 3 was ON. Check also if clamp location 1 sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p>	
			<p>3. Hold the tape on clamp location 1 using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue if sequence light on clamp location 2 was ON.</p>	
			<p>4. Hold the tape on clamp location 2 using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Go sound will be heard.</p>	
			<p>5. After taping, conduct POINT CHECKING before removing of harness from jig.</p>	
<p>6. After point checking. Remove the harness start from toggle clamp up to connector receiver base..</p>				

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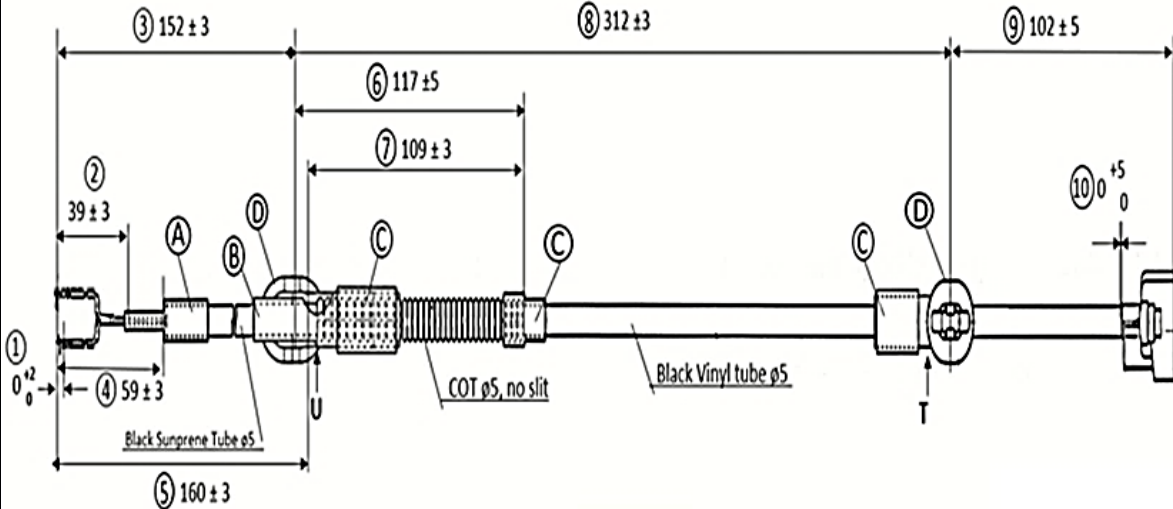
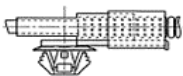

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PARTS:		1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement	<div><div>MEASURING TAPE</div></div>  <div> U T</div> <div>NOTE: A - Taping (G) B - Taping (Y) C - Taping (B) D - Clamp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

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP ASSY****7L0054-7025A****1****No Wrong Facing of Clamp**

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