



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

101D / 7N0098-7021C

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

November 04, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1119

Revision No.:

1

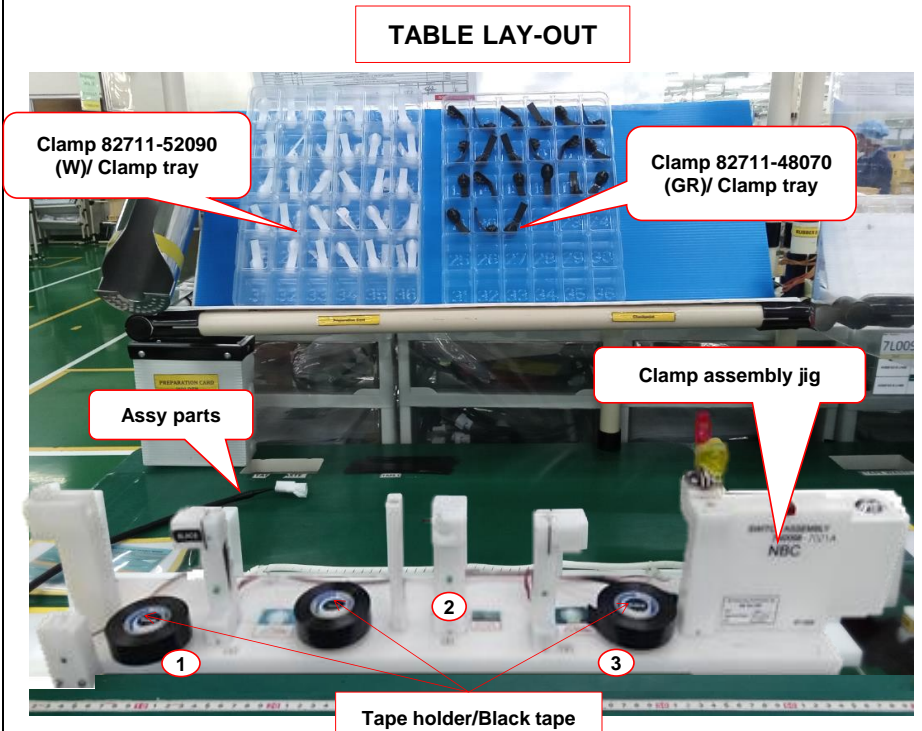

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PARTS: 1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape (3pcs)

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy Table Lay-out	<p>TABLE LAY-OUT</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>Bando Gun</p> 	<p>Document reference/s: 1. Refer to WI-ENG-PDE-527A-B for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/04/24	1	Change document purpose from pre-launch to Masspro.	M. Ariola	C.Villanueva	A. Arañes	n/a	M. Ariola	C.Villanueva	A. Arañes	n/a
10/16/24	0	Initial issue. Update the Illustration of Visual Inspections/Quality checkpoints	M. Ariola	C.Villanueva	A. Arañes	n/a	M. Ariola	C.Villanueva	A. Arañes	n/a

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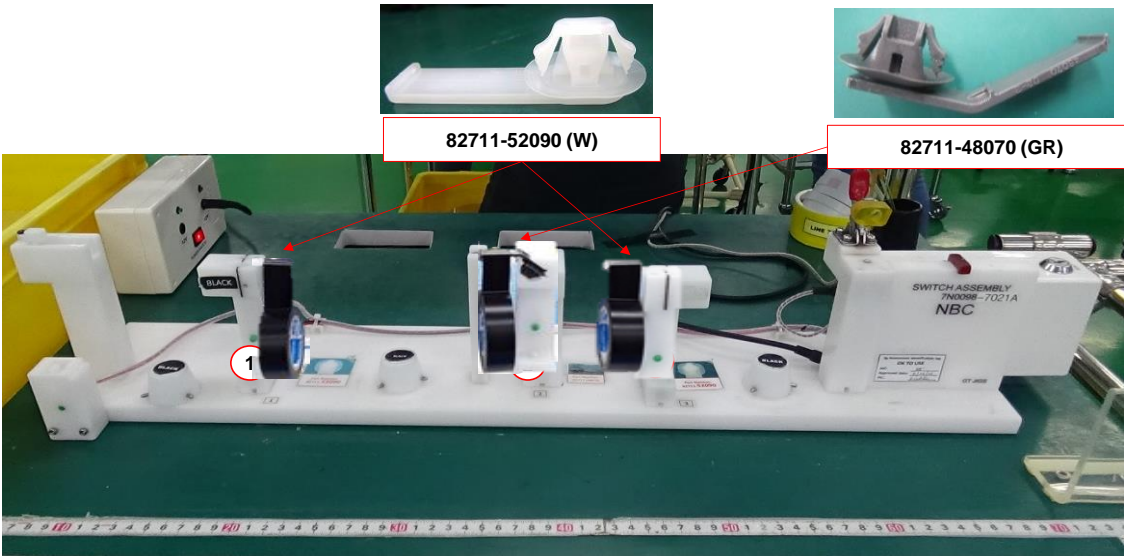



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PARTS:		1. Clamp 82711-52090 (W) [2pcs.] 2. Clamp 82711-48070 (GR)		3. Black tape (3pcs)	JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	Clamp Assy	Clamp Setting	<div><div></div><div><div>1. Get 2pcs. of band clamp 82711-52090 (W) then set to clamp location 1 and 3 using both hands.</div><div>2. Get 1pc. of clamp 82711-48070 (GR) then set to clamp location 2 using both hands.</div><div>3. Initially attach Black tape on clamp location 1, 2 and 3 using both hands.</div></div></div>				<div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</div><div></div><div><div>1. No wrong use of parts</div><div>2. No wrong use of tape</div><div>3. No damaged clamp</div><div>4. No wrong clamp position</div></div><div><div>Important reminders/Note/s:</div><div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div></div></div></div>

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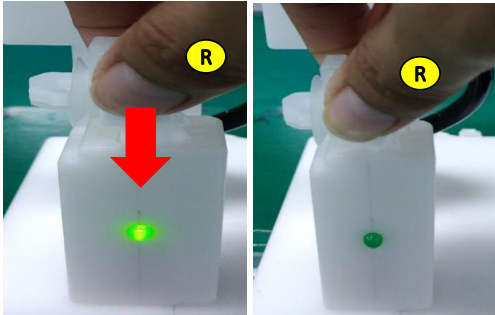
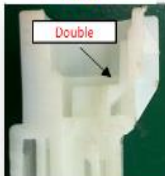
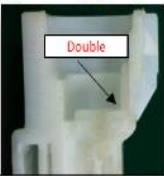
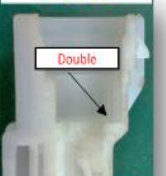
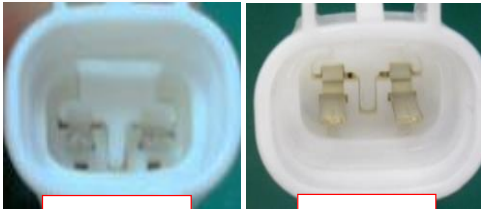

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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Connector lock		
		<div><div></div><div><p>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Sequence light will OFF. Check the lock if properly locked.</p></div><div><p>Coupler Cross Sectional View</p><div><div>NG</div><div>Unlock Condition</div></div><div><div>NG</div><div>Half Lock Condition</div></div><div><div>GOOD</div><div>Full Lock Condition</div></div></div><div><div></div><div><div>Before lock</div><div>After lock</div></div></div></div>	<div>LOCKING JIG</div> <div></div>	<div>1. Use the provided locking jig per model</div> <div>2. No unlock/half-locked connector</div> <div>3. No skip of locking process</div> <div><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div></div>

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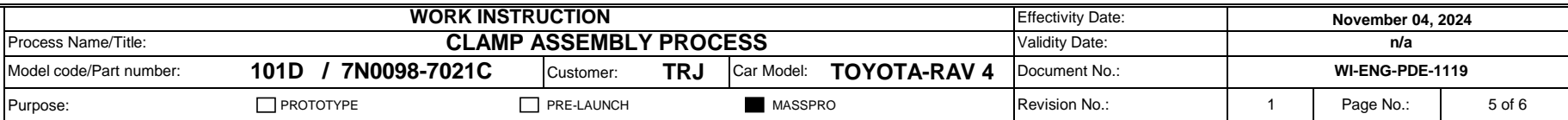
PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Clamp assembly	<div><p>Receiver base 1</p><p>CONNECTOR SETTING</p><p>82711-52090 (W)</p><p>82711-48070 (GR)</p><p>STOPPER</p><p>Locking jig</p><p>1</p><p>2</p><p>3</p><p>SWITCH ASSEMBLY TYPING - 7037A NBC</p></div>	<div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals.</p><p>2. Make 2-3 windings for clamp taping</p></div>	
			<p>1. Get the assy parts and set into jig. (See above picture for correct setting). First, set the connector 6188-0407 (W) to Receiver base 1 then lock. Continue to set the harness then last, set the G-B/W wires together within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p>		<p>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if sequence light in location 3 was ON.</p>
			<p>2. Check if all LED light for POWER ON, and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p>		<p>5. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape. Press the SW button after taping. Go sound will be heard.</p>
			<p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if sequence light in location 2 was ON.</p>		<p>6. Conduct POINT CHECKING before removing the harness from jig.</p>

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0098-7021C****① No Wrong Facing of Clamp****② ③ No Missing Tape (Black Tape)**

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