



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model code/Part number:

310B / 7M0522-7021B

Customer: TRJ

Car Model: TOYOTA-RAV 4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1131

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-48070 (GR) ; Clamp 82711-52090 (W); Black Tape

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

CLAMP
ASSY

Table lay-out

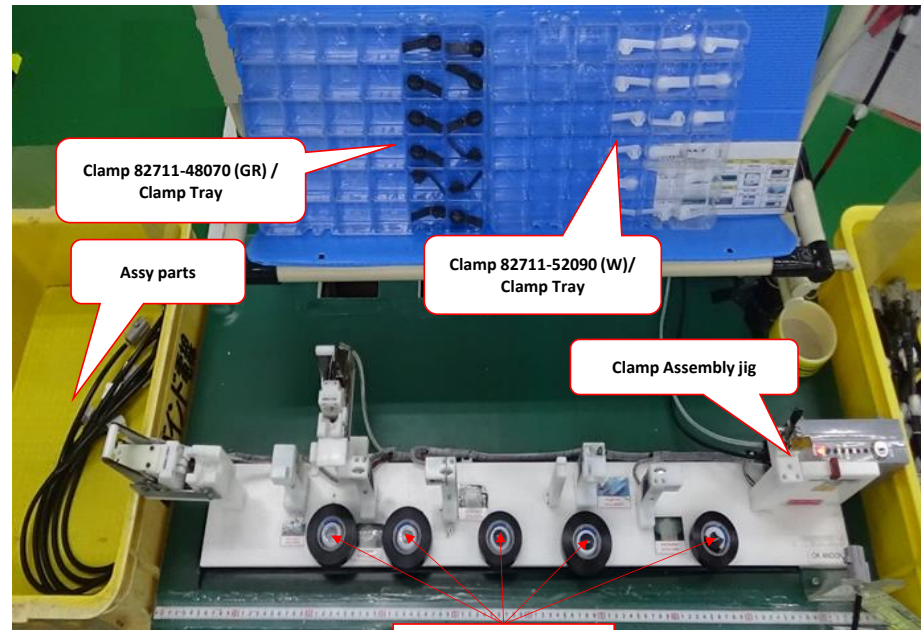


Table Lay-out

Clamp 82711-48070 (GR) /
Clamp Tray

Assy parts

Clamp 82711-52090 (W)/
Clamp Tray

Clamp Assembly jig

Black Tape/ Tape Holder

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-403A-B** for Taping assembly process

1. No missing parts/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
10/22/24	1	Change from Pre-launch to Masspro,	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a
10/17/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				

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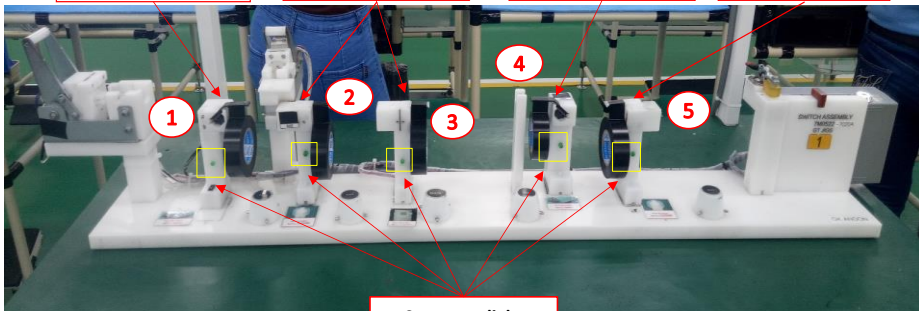



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PARTS:		1. Clamp 82711-48070 2. Clamp 82711-52090		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp setting	<div><div></div><div>82711-48070 (GR)</div><div></div><div>82711-52090 (W)</div><div></div><div>82711-48070 (GR)</div><div></div><div>82711-52090 (W)</div></div> <div></div> <div>Sequence light</div> <div>1. Get 2pcs. of clamp 82711-48070 (GR) using right hand then set to location 1 & 4 using both hands.</div> <div>2. Get 3pcs. of clamp 82711-52090 (W) using right hand then set to location 2, 3 & 5 using both hands.</div> <div>3. Get Black tape using right hand and conduct pre-taping from location 1,2,3,4,5 using both hands.</div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under clamp</div> <div></div> <div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong use of clamp 6. No missing clamp</div> <div>CLAMP ILLUSTRATION</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>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div>

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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	<div><p>Connector setting</p><p>Checker 2</p><p>Checker 1</p><p>Sequence light</p><p>Stopper</p></div> <div><p>1. Get the assy parts and set to jig using both hands. First, put the Gray connector to Checker 1 then pull the checker fixture. Second, put the White connector to Checker 2 then pull the checker fixture. Last, set the terminal to stopper jig then pull down the toggle clamp. Refer to the above illustration for the correct setting.</p><p>2. Check if all LED light for POWER ON, WIRE1 and WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Continue if the sequence light of Location 1 is ON.</p><p>3. Start the taping process (3 windings) on clamp location 1 using both hands. Press the switch button after taping. Sequence light will ON to the next process.</p><p>4. Continue the taping process until you finished the location 2,3,4 & 5. Press the SW button after taping. Go sound will be heard.</p><p>5. Conduct Point Checking using right hand and slowly remove the harness from jig.</p></div>	n/a	<div><p>Stopper jig</p><p>Important reminders/Note/s:</p><p>1. Must be no gap between terminal and stopper jig.</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No loose attachment of clamp</p><p>2. No damage clamp</p><p>3. No missed tape</p><p>4. No missing parts</p><p>5. No wrong use of tape</p></div>

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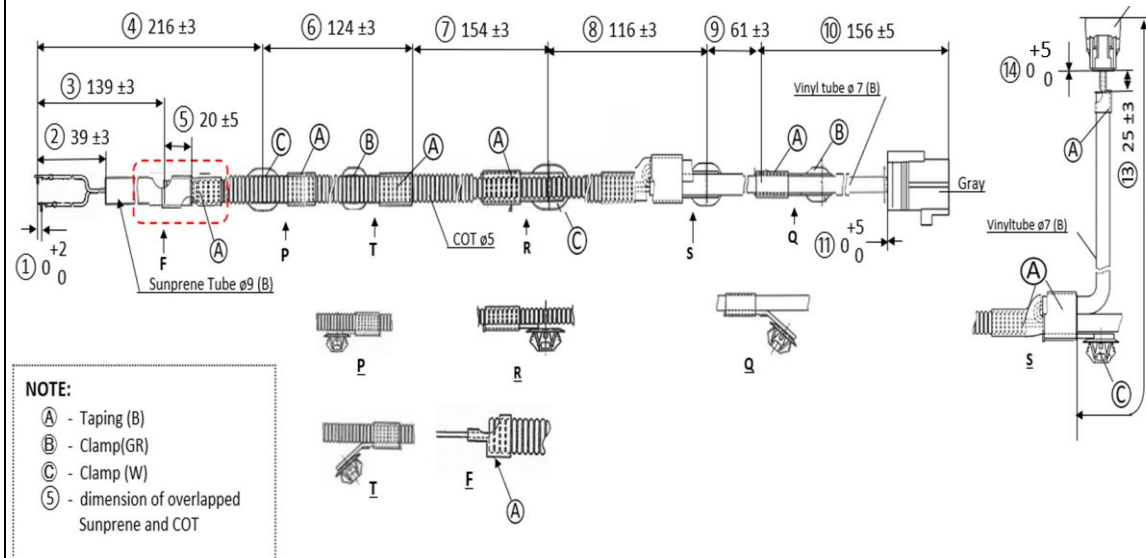

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div>Measurement</div> <div><p>NOTE:</p><ul style="list-style-type: none">(A) - Taping (B)(B) - Clamp (GR)(C) - Clamp (W)(S) - dimension of overlapped Sunprene and COT</div>		<div><div>MEASURING TAPE</div></div> <div><p>Important reminders and note/s:</p><ol style="list-style-type: none">Please use calibrated/verified measuring tape when getting the measurement.For Hatsumono, Nakamono and Owarimono.<p>Document reference/s:</p><ol style="list-style-type: none">Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <p>1. No wrong dimension</p>	

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1. Assy part

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0522-7021B****1** No **Wrong facing of clamp****2** **3** **4** No **Missing Tape (Black tape)**

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