



WORK INSTRUCTION

Process Name/Title: CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 13, 2023

Model code/Part number: 320B / 7L0054-7025 Customer: TRQSS Car Model: TOYOTA-RAV4

Validity Date:

n/a

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

WI-ENG-PDE-701

Revision No.:

0

Page No.:

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PARTS:

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

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

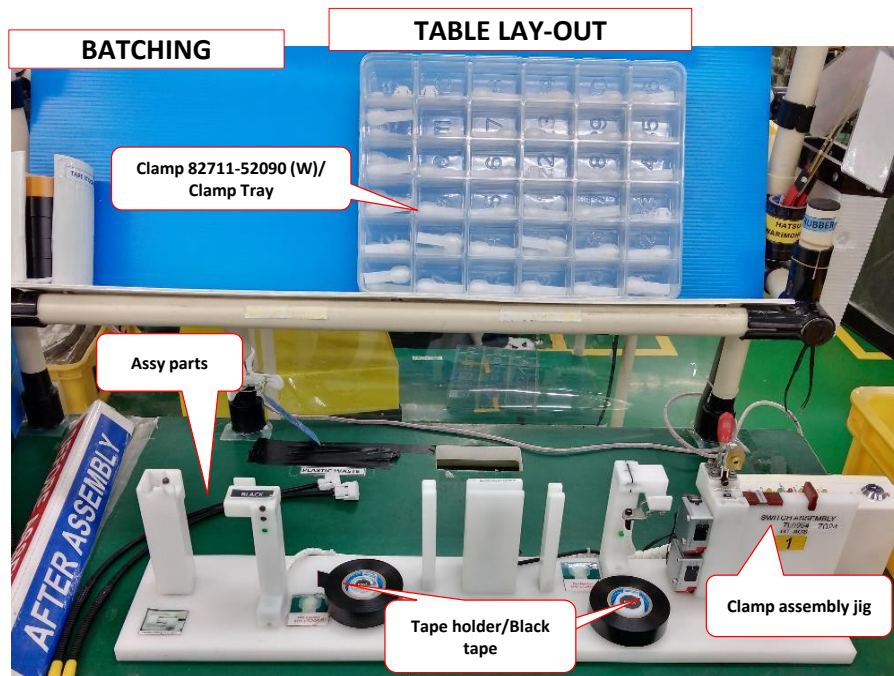
TOOLS/PPE

QUALITY POINTERS

1

n/a

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

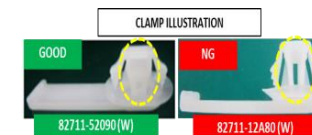
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited.
Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools.
3. No wrong positions of parts/tools

Important reminders/Note/s:
1. Check the Clamp first before start of assembly to avoid wrong use of clamp.



Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/13/23

0

Initial issue.
Excluded process from P2; Change Part name from **TAPING ASSEMBLY PROCESS** to **CLAMP ASSEMBLY PROCESS**;
Change Document control number from **WI-ENG-PDE-141B** to **WI-ENG-PDE-701** due to separation of process; Update template; Inclusion of **CAR MODEL** "TOYOTA-RAV4". Refer to ENGDRR-125 for Document revision request.

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Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 13, 2023

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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

n/a

Clamp setting



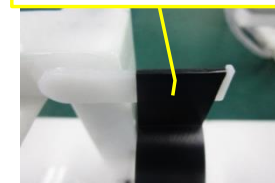
1. Get 2pcs. of clamp **82711-52090 (W)** using both hands then set to location **1 and 2** using both hands.

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

n/a

STANDARD TAPING FOR CLAMP

One side tape under clamp

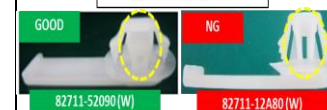


Important reminders/Note/s:

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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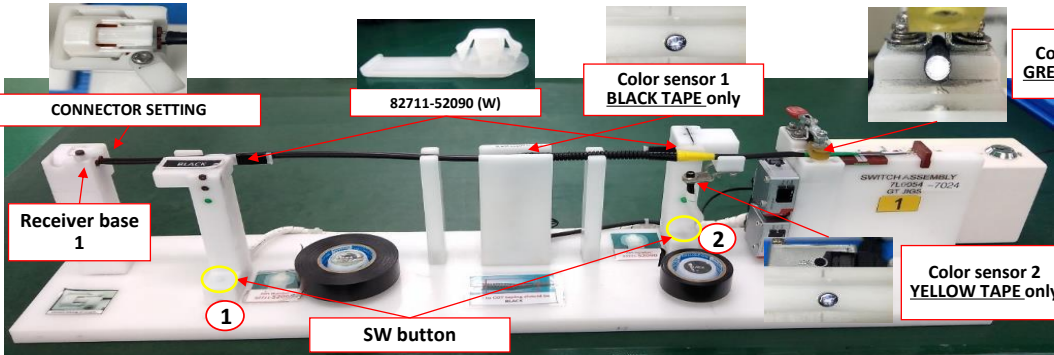
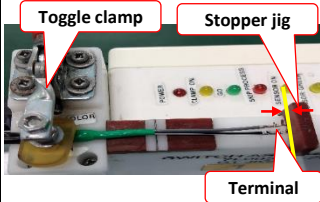
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black ta		JIG	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	n/a	Clamp Assembly	<div></div>			<div></div>	<p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper jig and Terminal</p> <p>1. No loose attachment of clamp 2. No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape</p>
			<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 Receiver 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</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>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>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>				

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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

n/a

Visual/By Two's Inspection



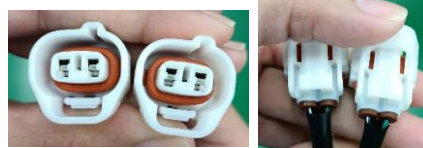
ACTUAL PRODUCT

Assembled parts

Master sample



1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **Connector lock, terminal and insertion.**



4. Check the **SV tube to COT, COT to VM tube and VM tube to wire near terminal taping condition.** Conduct slightly pulling of VT during bending to avoid missing tape. Check the **color of tape.**



3. Check the **presence of all clamp attachment, taping condition and color of tape.**



5. Check the **terminal appearance.** Must be **no deformed terminal.**

MASTER SAMPLE



1. No Skip checking during inspection

CLAMP ILLUSTRATION



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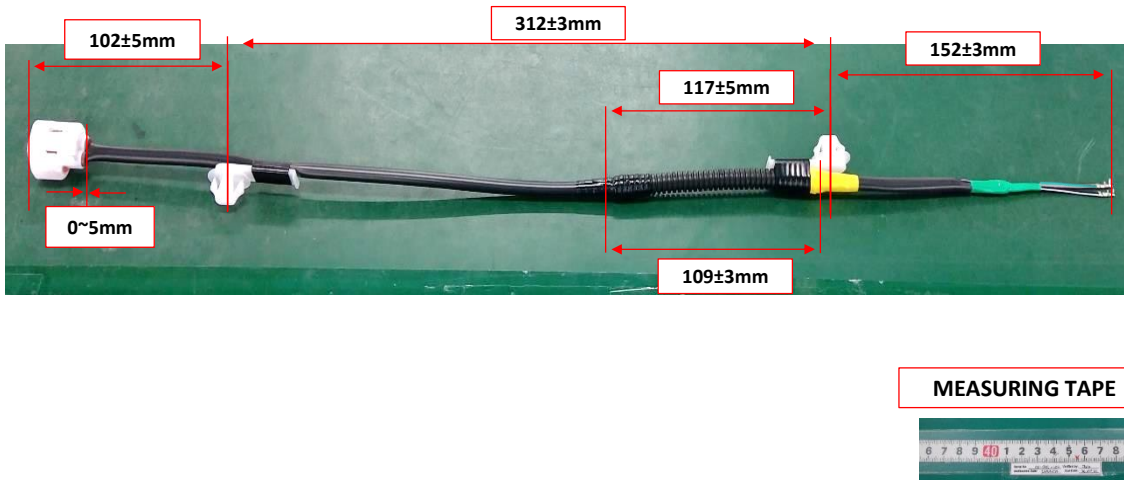
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	Measurements			1. No wrong dimension Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono

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PARTS:

n/a

JIG

n/a

QUALITY CHECKPOINTS

CLAMP
ASSEMBLY

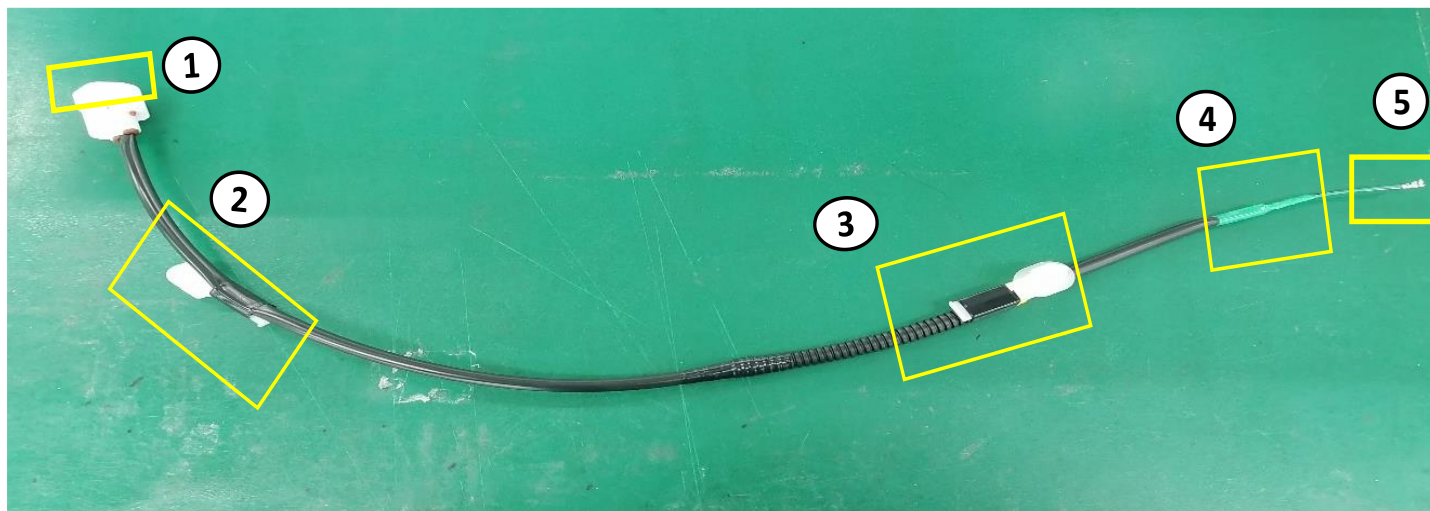
7L0054-7025



GOOD



NO GOOD



① No Unlock/ Half Lock Connector

⑤ No Deformed Terminal

② ③ No Missing Clamp

④ No Missing Tape

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