



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

310D / 7N0199-7020B

Customer: TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1062

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

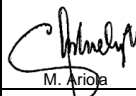
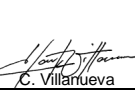
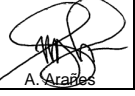
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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-48210 (B) 3. Clamp 82711-34490 (B)	4. Clamp 82711-3A540 (W) 5. Clamp 82711-33650 (B) 6. Black tape [4 pcs.]	7. Pink tape 8. Assy part	JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME		⚠ WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	Table Lay-out			<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>	<div>1. No missing parts/tools. 2. No missing parts/tools</div> <div> CLAMP ILLUSTRATION BAND CLAMP ILLUSTRATION</div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/24/24	1	Change purpose from Pre-launch to Masspro. Update the Work Procedure/Illustrations.	M. Ariola	C. Villanueva	A. Arañes	n/a				
09/24/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2024		

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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-48210 (B) 3. Clamp 82711-34490 (B)			4. Clamp 82711-3A540 (W) 5. Clamp 82711-33650 (B) 6. Black tape [4 pcs.]		7. Pink tape		JIG:		1. Clamp Assembly Jig				
NO.		PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS			
2		Clamp Assy		Clamp setting		<div><div> 82711-34490 (B)</div><div> 82711-52090 (W)</div><div> 82711-3A540 (W)</div><div> 82711-48210 (B)</div><div> 82711-33650 (B)</div><div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div><div>6</div></div></div> <div><div>1. Get 1pc. of clamp 82711-34490 (B) using right hand and set to clamp location 1 using both hands.</div><div>2. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 2 using both hands.</div><div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</div><div>4. Get 1pc. of clamp 82711-48210 (B) using right hand and set to clamp location 4 and 5 using both hands.</div><div>5. Get 1pc. of clamp 82711-33650 (B) using right hand and set to clamp location 6 using both hands.</div><div>6. Initially attach White tape to clamp location 5 using both hands.</div><div>6. Initially attach Black tape to clamp location 2, 3, 4, and 6 using both hands.</div></div>								1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No missing clamp	
				<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><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under clamp</div><div></div><div>CLAMP ILLUSTRATION</div><div><div>GOOD 82711-52090 (W)</div><div>NG 82711-12A80 (W)</div></div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD 82711-34490 (B)</div><div>NG 82711-16R30 (B)</div></div></div>											

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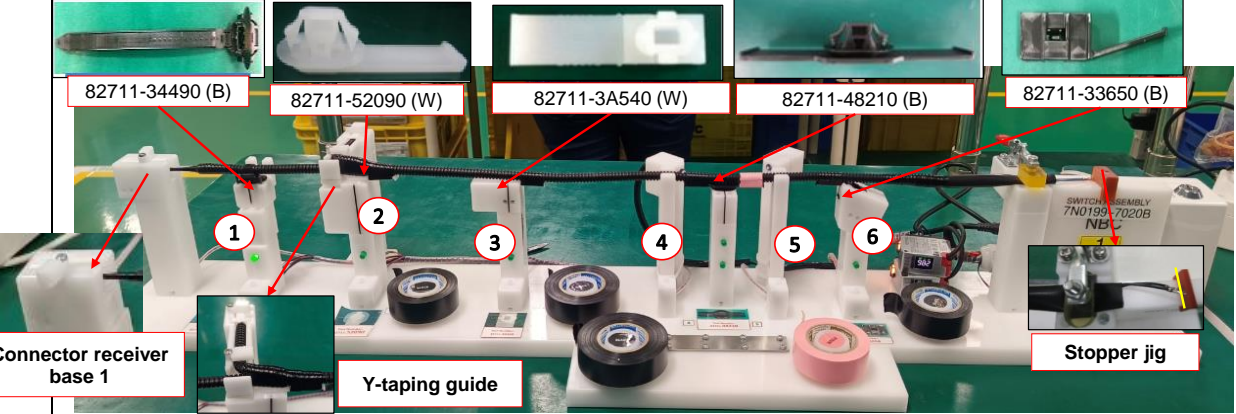


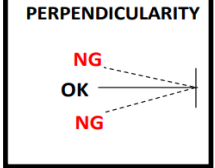

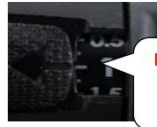


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PARTS:		1. Assy parts 2. Black tape [4pcs]	3. Pink tape	JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div></div> <div><p>1. Get the assy parts and put into jig. <i>(See above picture for the correct setting)</i>. First, set the connector 6098-3802 (W) to Receiver base 1 then Lock. Second, set the Connector 6098-3810 (W) to Receiver base 2 then loc. Last, set the B-B wires together within stopper then press by toggle clamp.</p><p>2. Initially tighten the band clamp on location 1 using both hands. Get the bando gun using right hand then cut the band clamp using both hands. Continue the process if the sequence light on location 2 was ON.</p></div> <div><div><p>PROPER CUTTING POSITION OF BANDO GUN</p></div><div><p>IMPROPER CUTTING POSITION OF BANDO GUN</p></div></div> <div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p></div> <div><p>BANDO GUN ILLUSTRATION</p></div> <div><p>Fixed setting of band clamp cutter: 1~ 2</p></div>			<div><p>1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp 4. No missing clamp</p></div> <p>Important reminders/Note/s:</p> <p>1. Must be no gap between terminal and stopper jig.</p> <p>2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p> <p>3. Setting of band clamp cutter depends on the size of the COT/SV tube (Vinyl) ø5- 1~2, ø7- 3~4</p> 

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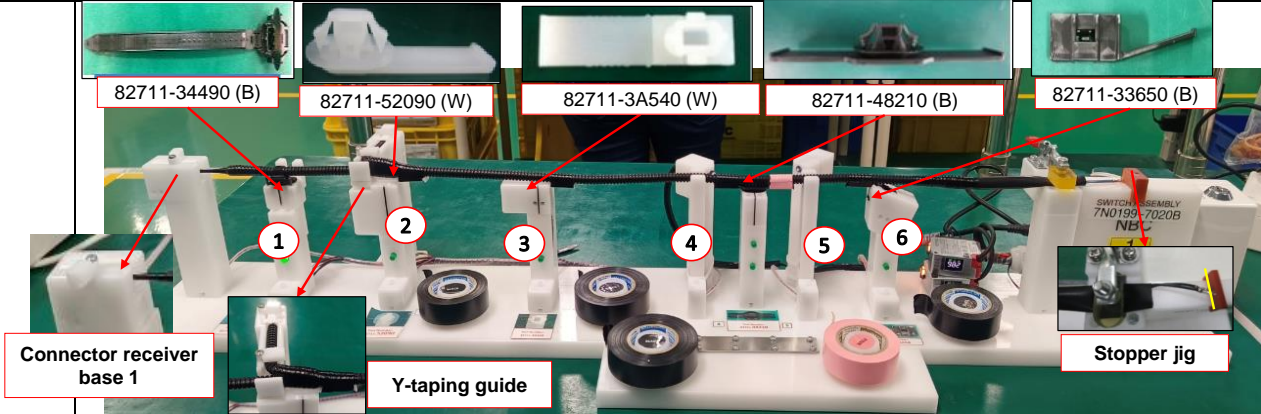



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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div></div><div><div><div><div><p>3. On clamp location 2, hold the tape then make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if the sequence light on location 3 was ON.</p></div><div><div><p>4. On clamp location 3, hold the tape then make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if the sequence light on location 4 was ON.</p></div><div><div><p>5. On clamp location 4, hold the tape then make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if the sequence light on location 5 was ON.</p></div></div><div><div><div><p>6. On clamp location 5, hold the tape then make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if the sequence light on location 6 was ON.</p></div><div><div><p>7. On clamp location 6, hold the tape then make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. GO sound will be heard.</p></div><div><div><p>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div></div></div></div></div></div></div></div></div></div>		<div></div> <div><p>Important reminders/Note/s:</p><p>1. <i>Must be no gap between terminal and stopper jig.</i></p><p>2. <i>Make 2-3 windings for clamp taping</i></p><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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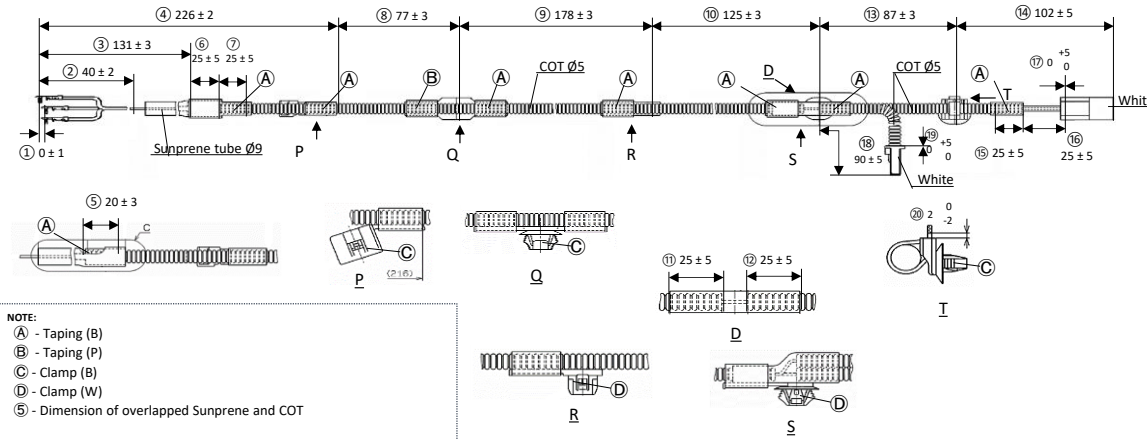
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PARTS:		n/a	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement		<p>1. No wrong dimension.</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting 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-Assey Hatsumono, Nakamono and Owarimono Inspection.</p>



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PARTS:

n/a

JIG:

n/a

1 VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0199-7020B****1 No Wrong Facing of Clamp****2 3 No Missing Tape (Black Tape)**

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