



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 3, 2024

Model code/Part number:

311D / 7L0155-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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0

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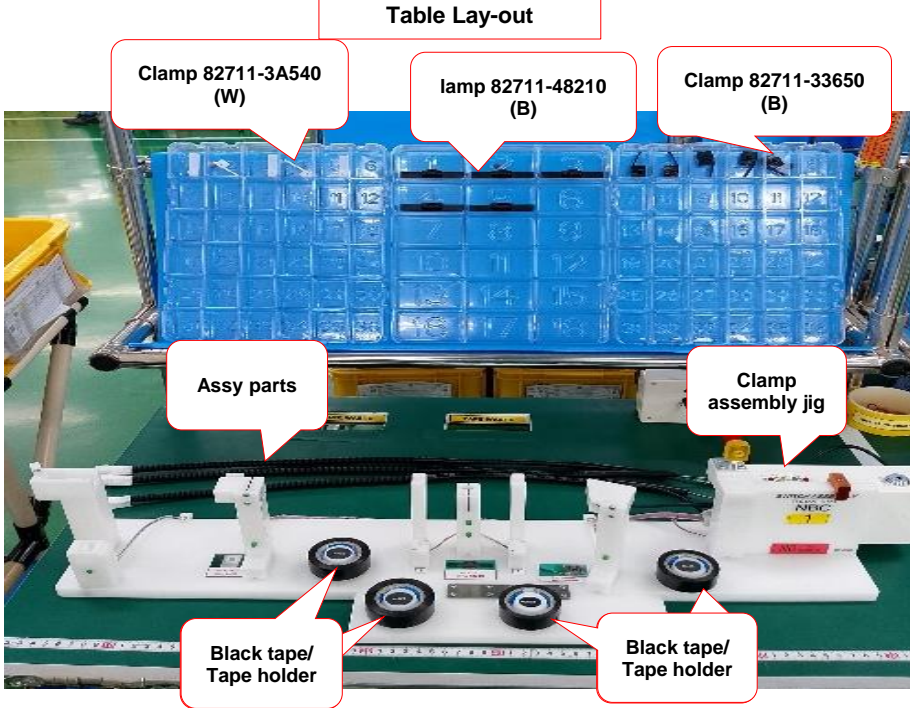
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PARTS:

1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-33650 (B); Clamp 82711-3A540 (W); Black tape [4pcs]

JIG:

1. Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy Table Lay-out		<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>	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
10/03/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C.Villanueva	A. Arañes	n/a

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PARTS:

1. Clamp 82711-48210 (B)
2. Clamp 82711-33650 (B)

3. Clamp 82711-3A540 (W)
4. Black tape [4pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

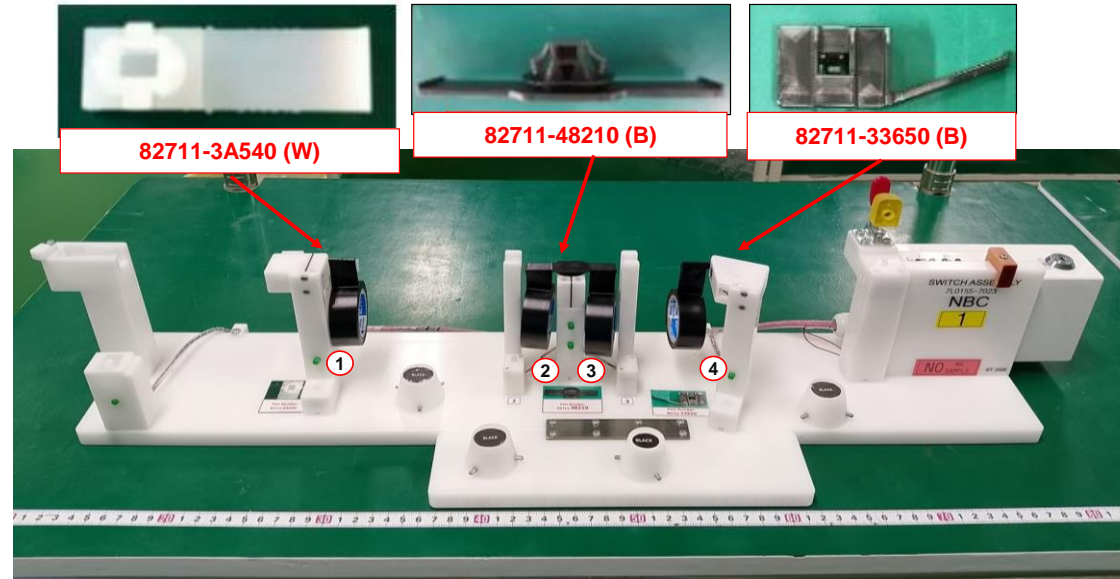
TOOLS/PPE

QUALITY POINTERS

2

Clamp Assy

Clamp setting



1. Get **1pc** of clamp **82711-3A540 (W)** using right hand then set to Clamp location no. **1** both hands.

2. Get **1pc** of clamp **82711-48210 (B)** using right hand then set to Clamp location no. **2 and 3** using both hands.

3. Get **1pc** of clamp **82711-33650 (B)** using right hand then set to Clamp location no. **4** using both hands.

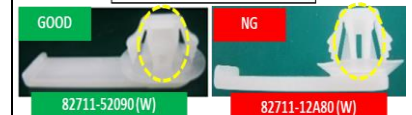
4. Initially attach **BLACK TAPE** to location **1, 2, 3 and 4** using both hands.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

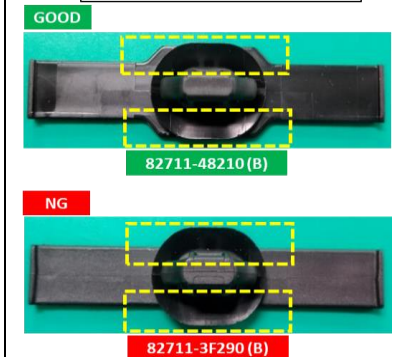
Important reminders/Notes

1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



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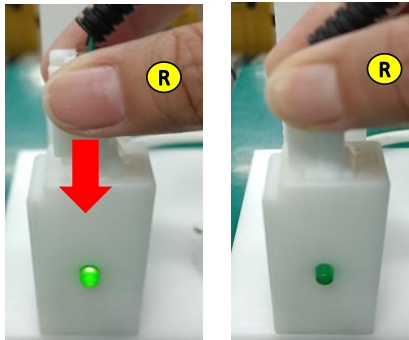
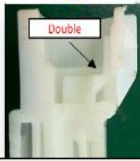
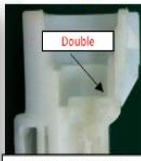
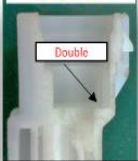
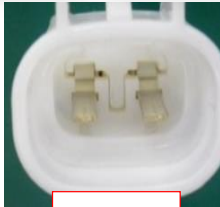

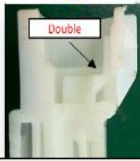
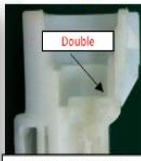
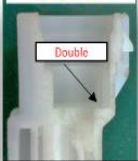

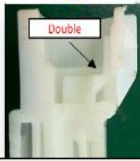
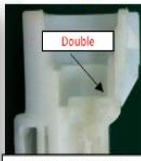
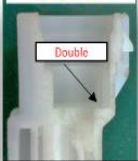
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PARTS:	1. Assy parts 2. Black tape [4pcs]		JIG:	1. Clamp assembly jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS									
3	Clamp Assy Connector Lock	<div></div> <div>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</div> <div><p>Coupler Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock Condition</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table><div></div><div>Before lockAfter lock</div></div>	NG	NG	GOOD				Unlock Condition	Half Lock Condition	Full Lock Condition	<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</p>
NG	NG	GOOD											
													
Unlock Condition	Half Lock Condition	Full Lock Condition											

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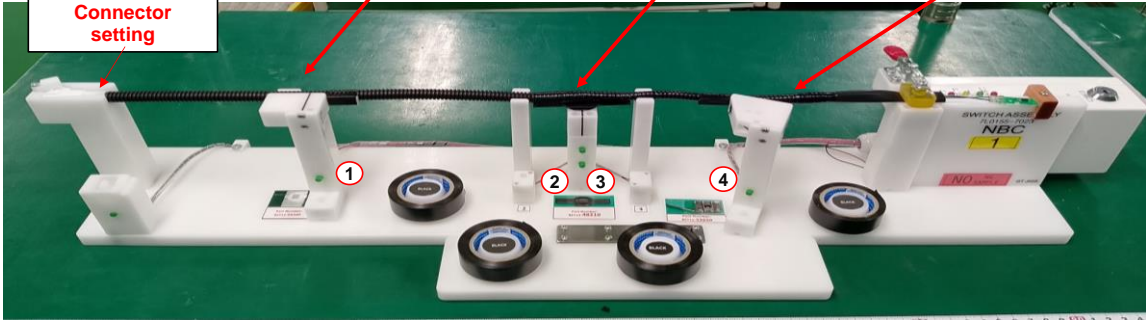




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PARTS:		1. Assy parts 2. Black tape [4pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Clamp assembly		<div><div><div></div><div></div><div></div><div></div></div><div></div></div> <div><div><p>1. Get the assy parts using right hand then set into jig using both hands. (See above picture for the correct setting). First put the connector 6189-0451 (W) into receiver base 1 then lock. Continue setting the harness into jig. Last, set the hotmelted wires (B/W-G) within the stopper jig then press by the toggle clamp.</p></div><div><p>2. Check the LED light for POWER 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 on location 1 is ON.</p></div></div> <div><div><p>3. Hold the tape on the clamp location no. 1 using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue to location 2 if light was ON.</p></div><div><p>4. Hold the tape on the clamp location no. 2 using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue to location 3 if light was ON.</p></div></div> <div><div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><p>Important reminders/Notes 1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</p><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-48210 (B)</div></div><div><div>NG</div><div>82711-3F290 (B)</div></div></div></div></div></div>	

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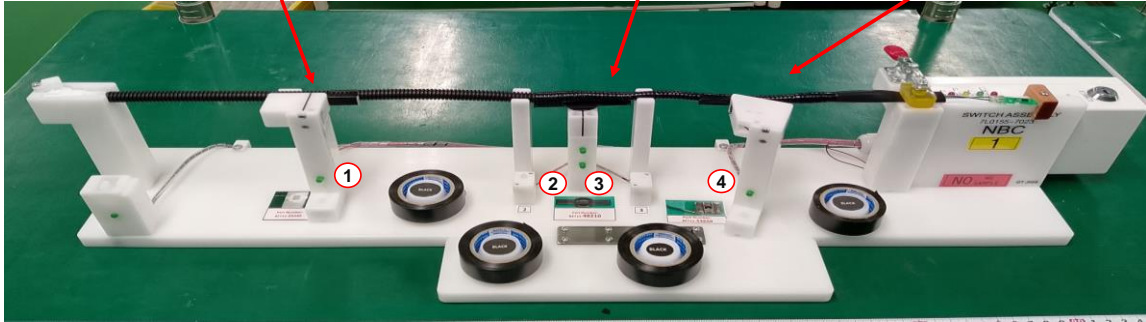
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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	<div><div><div>82711-3A540 (W)</div></div><div><div>82711-48210 (B)</div></div><div><div>82711-33650 (B)</div></div><div></div></div>		<p>Important reminders/Notes</p> <p>1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p>
		<p>5. Hold the tape on the clamp location no. 3 using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue to location 4 if light was ON.</p>	<p>6. Hold the tape on the clamp location no. 4 using right hand. Make 3 windings of tape using both hands then cut the tape. Press the SW button after taping. Continue to location 5 if light was ON.</p>	
		<p>7. Hold the tape on the clamp location no. 5 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>8. After taping, conduct POINT CHECKING before removing the harness from jig</p>	

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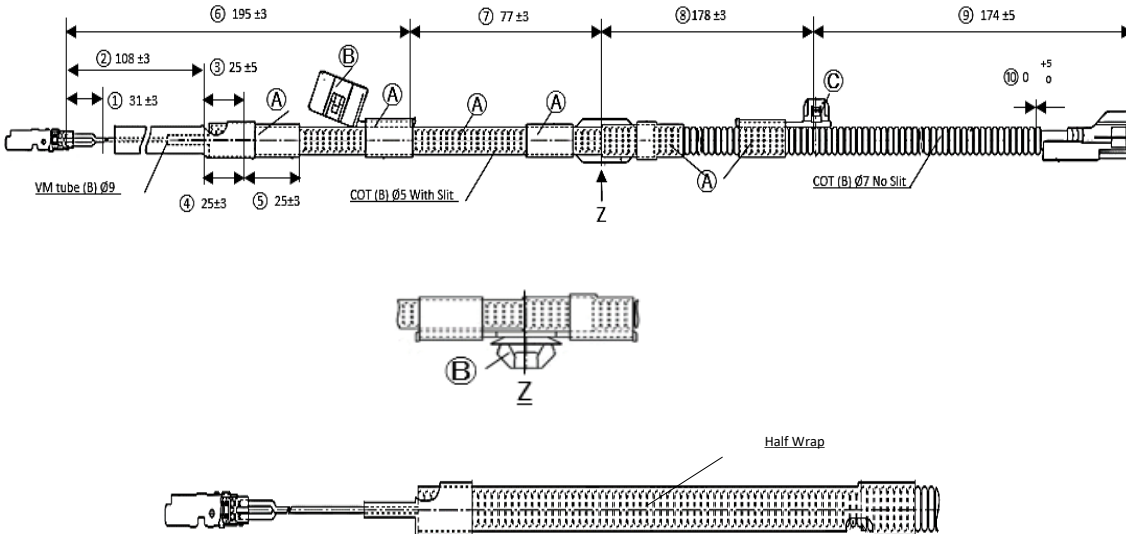

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Measurement	<div></div> <div><p>NOTE:</p><ul style="list-style-type: none">(A) - Taping (B)(B) - Clamp (B)(C) - Clamp (W)(3) - Dimension overlapped COT & sunprene tube</div> <div><p>MEASURING TAPE</p></div>		<p>1. No wrong dimension</p> <p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.</p>

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0155-7023**

- ① **No Half locked/Unlocked Connector**
- ② **Check the Clamp Alignment**
- ③ **No Missing Clamp**

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