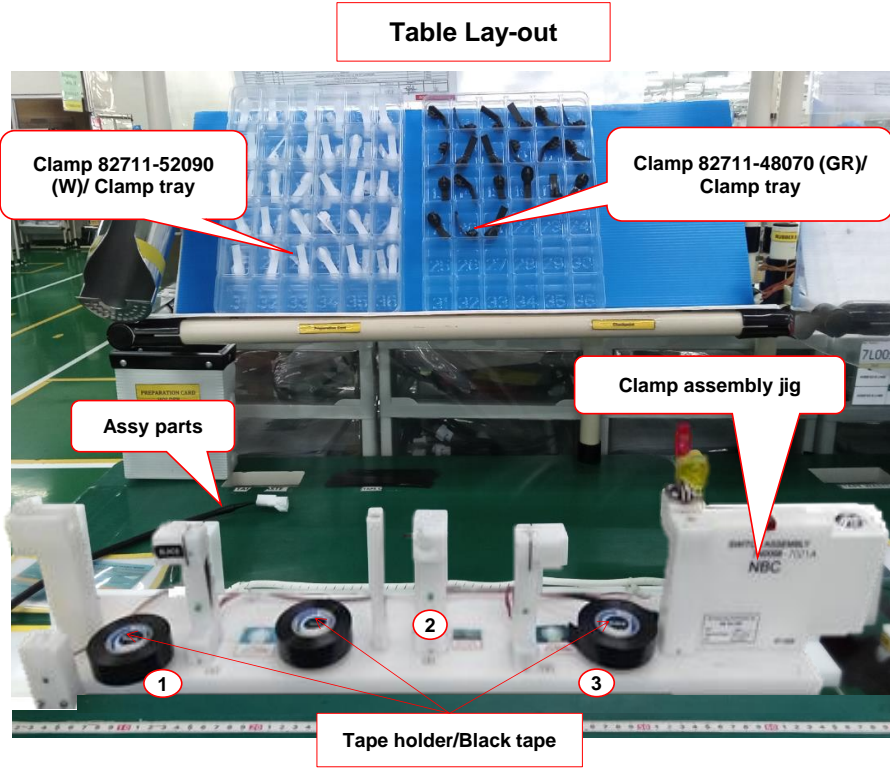

	WORK INSTRUCTION				Effectivity Date:	August 2, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 086D / 7N0098-7021A		Customer: TRQSS	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-980		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 6

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			<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				Prepared by	Reviewed by	Approved by	Noted by
08/02/24	0	Initial issue. Seperate clamp assy process from Taping assembly process.	D.Castillo	C.Villanueva	A. Arañes	N/A	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 17, 2024

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WI-ENG-PDE-980

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


2 of 6

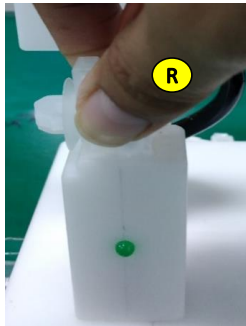
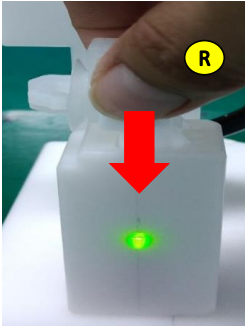
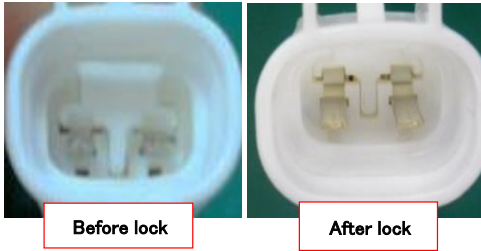
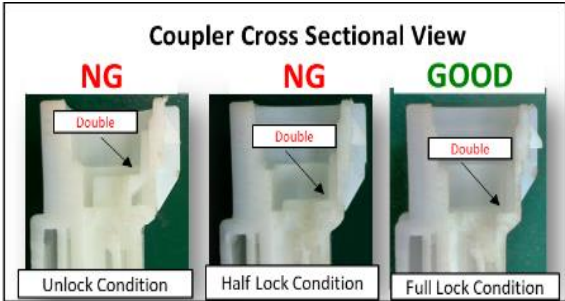

PARTS:		1. Clamp 82711-52090 (W) [2pcs.] 2. Clamp 82711-48070 (GR)		3. Black tape (3pcs)	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	<div><div> 82711-52090 (W)</div><div> 82711-48070 (GR)</div><div></div></div>			<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</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>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>

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	Model code/Part number: 086D / 7N0098-7021A		Customer: TRQSS	Car Model: TOYOTA-RAV 4	Document No.:		WI-ENG-PDE-980	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:


PARTS:		1. Assy parts		JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	Clamp Assy	<div><div>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.</div></div> <div><p>Coupler Cross Sectional View</p></div>		<div>LOCKING JIG</div> 	<div>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div>	

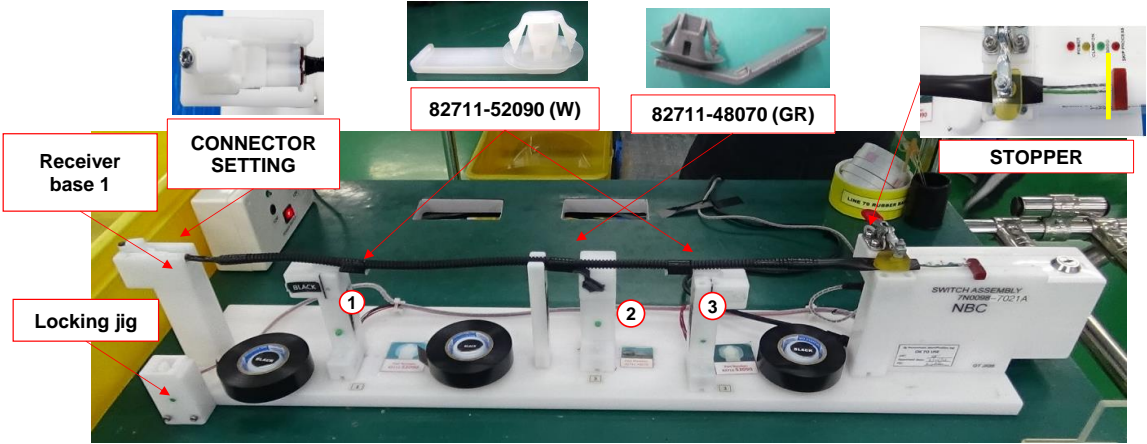
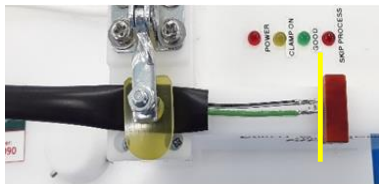
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 4 of 6

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><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>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>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>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>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>6. Conduct POINT CHECKING before removing the harness from jig.</p></div>		<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> <p>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape</p>			

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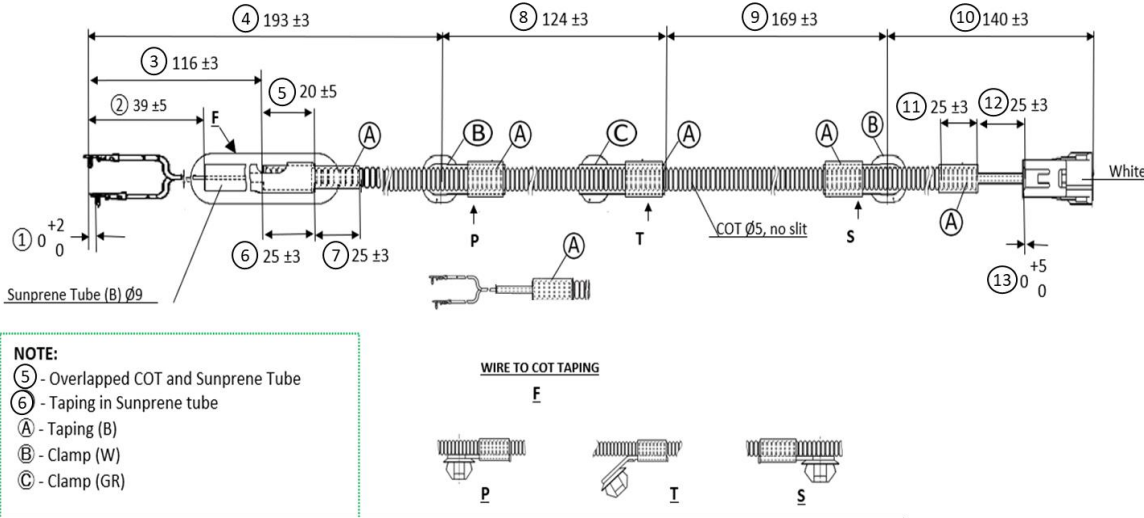
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 6

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Clamp Assy	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: ⑤ - Overlapped COT and Sunprene Tube ⑥ - Taping in Sunprene tube A - Taping (B) B - Clamp (W) C - Clamp (GR)</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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Purpose:

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Revision No.:

0

Page No.:

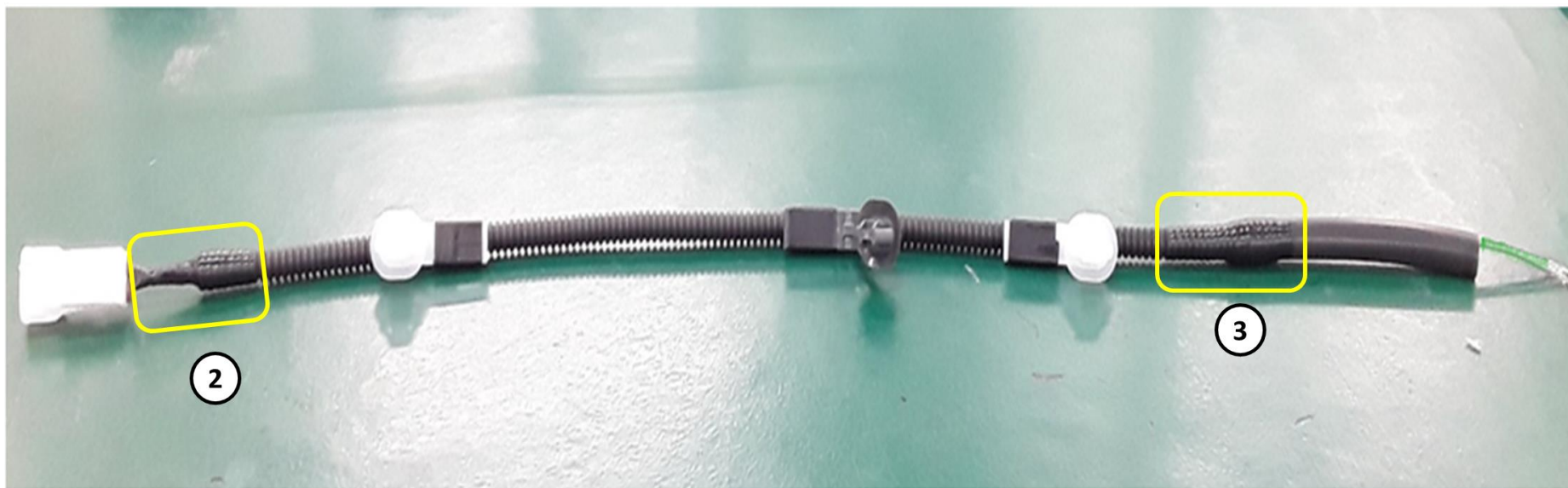
6 of 6

PARTS:

1. Assy parts

JIG:

n/a

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

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