




Revision History								Prepared by	Reviewed by	Approved by	Noted by
								 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
08/07/24	1	Change from Pre-launch to Masspro		A. Hernandez	C. Villanueva	A. Arañes	n/a				
08/06/24	0	Initial Issue.		A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	August 06, 2024	

DCC Stamp



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

August 29, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

310D

/ 7N0197-7020B

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-999

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

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PARTS:

1. Clamp 82711-48210(B) [2pcs]
2. Clamp 82711-52090 (W)

3. Clamp 82711-33650 (B)
4. Black tape 20mm [5pcs]

5. Green tape 20mm

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

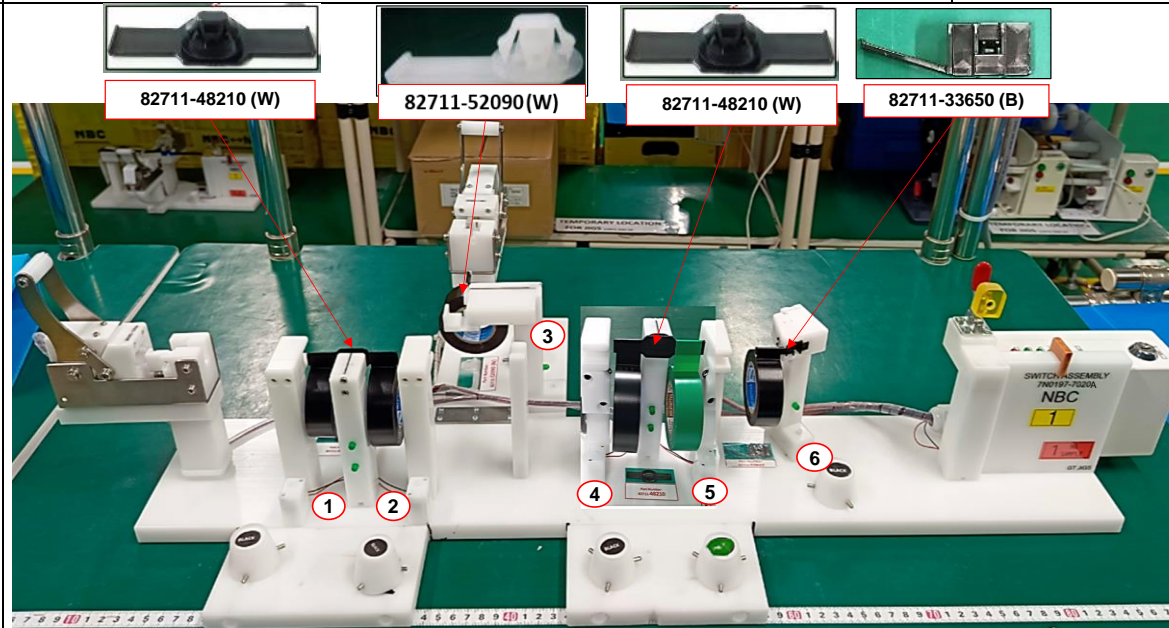
TOOLS/PPE

QUALITY POINTERS

2

Clamp
Assy

Clamp setting



1. Get 1pc. of clamp **82711-48210 (B)** then set to clamp location **1** and **2** using both hands.

2. Get 1pc. of clamp **82711-48210 (B)** then set to clamp location **4** and **5** using both hands.

3. Get 1pc. of clamp **82711-52090 (W)** then set to clamp location **3** using both hands.

4. Get 1pc. of clamp **82711-33650 (B)** then set to clamp location **6** using both hands.

5. Get the **Black tape** then initially attach to clamp location **1,2,3,4 and 6** using both hands.

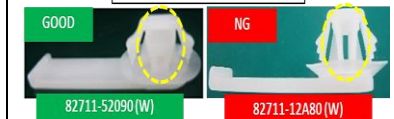
6. Get the **Green tape** then initially attach to clamp location **5** using both hands.

1. No wrong use of clamp
2. No damaged clamp
3. No wrong use of tape

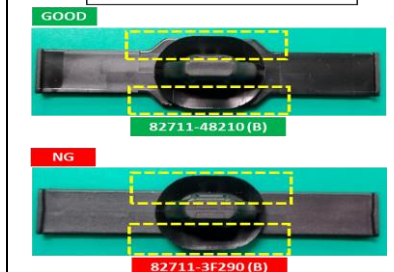
Important reminders/Note/s:

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

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



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PARTS:

1. Assy parts
2. Black tape 20mm

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

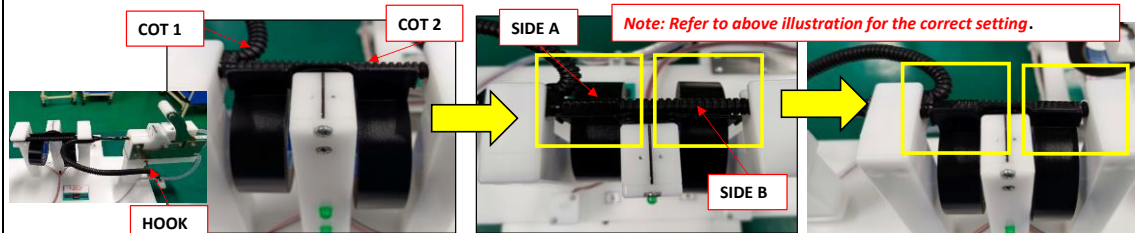
Clamp
Assy

Clamp assembly



1. Put the assy parts into jig (*See above picture for the correct setting*). First, set the **connector 6098-3802 (W)** to **checker 1**. Second, set the **(VM tube (Sunprene) with B-B wires** together with the stopper then press by toggle clamp. Last, initially put the COT (with **Connector 6098-2220(W)**) in hook.

2. Check if **LED** light for **POWER, CLAMP, WIRE 1** and **WIRE 2**, and sequence light was **ON**. If encountered abnormality, **STOP** immediately and **CALL** the attention of the leader. **WAIT** for the further instructions. Continue it the sequence light on **location 1** was **ON**.

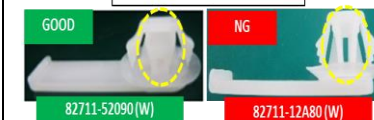


3. Wrap the **COT 2 (SIDE A)** of clamp 2 windings of tape using both hands. Press the **SW button** after taping (**Do not cut the tape**).

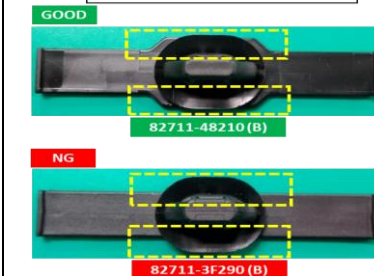
4. Wrap the **COT 1 (SIDE B)** of clamp 2 windings of tape using both hands. Press the **SW button** after taping (**Do not cut the tape**).

1. No loose/tight clamp attachment.
2. No damaged clamp.
3. No missing tape.
4. No missing spot tape.
5. No missing parts
6. Make sure there is no clearance between the PCB and the stopper jig

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



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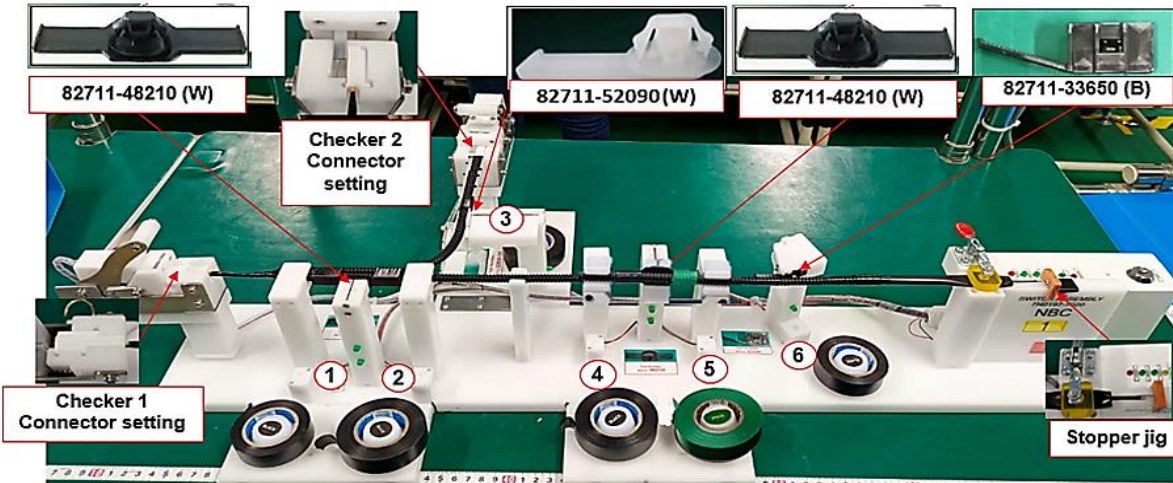
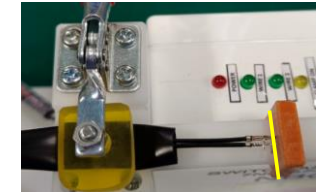
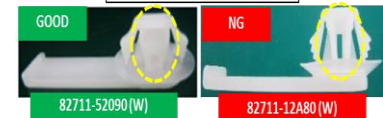
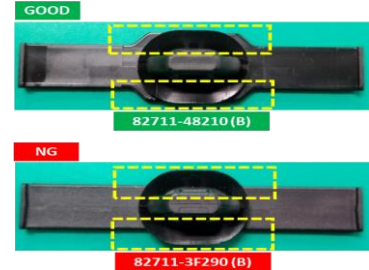
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PARTS:		1. Assy parts 2. Black tape 20mm	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<p>Clamp assembly (Continuation)</p>  <p>5. Remove the COT 1 from the hook and set the connector 6098-2220 (W) to Checker 2 using both hands then lock. <i>(Refer to above illustration for the correct setting)</i>. Continue the process if the sequence light was ON.</p> <p>6. Combine the COT 1 and COT 2. Hold the black tape on clamp location 1 (SIDE A) then start taping using both hand. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on location 2 was ON.</p> <p>7. On Clamp location 2 (SIDE B). Hold the Black tape using right hand. Make 3 winding of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on location 3 was ON.</p>		<p>1. No loose/tight clamp attachment. 2. No damaged clamp. 3. No missing tape. 4. No missing spot tape. 5. No missing parts 6. Make sure there is no clearance between the PCB and the stopper jig</p>  <p>CLAMP ILLUSTRATION</p>  <p>CLAMP ILLUSTRATION</p> 

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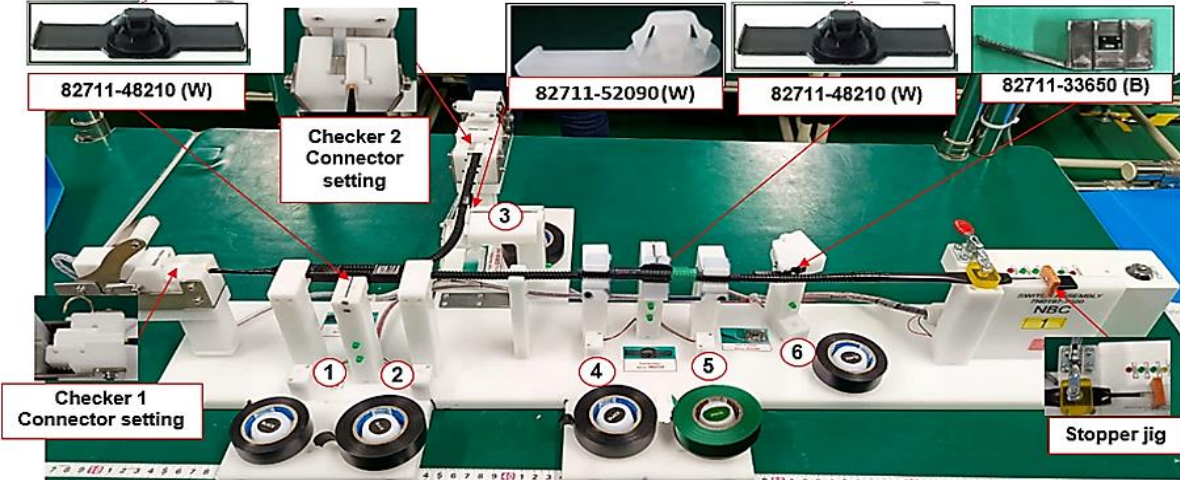


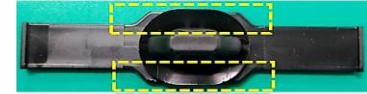

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp assembly (Continuation)			
		<div></div> <div>8. On Clamp location 3 hold the Black tape using right hand. Make 3 winding of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on location 4 was ON.</div> <div>9. On Clamp location 4 hold the Black tape using right hand. Make 3 winding of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on location 5 was ON.</div> <div>10. On Clamp location 5 hold the Green tape using right hand. Make 3 winding of tape then cut the tape. Press the SW button after taping. Continue the process if the sequence light on location 6 was ON.</div> <div>11. On Clamp location 6 hold the Black tape using right hand. Make 3 winding of tape then cut the tape. Press the SW button after taping. GO buzzer will be heard.</div> <div>12. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div>			<div>1. No loose/tight clamp attachment.</div> <div>2. No damaged clamp.</div> <div>3. No missing tape.</div> <div>4. No missing spot tape.</div> <div>5. No missing parts</div> <div>6. Make sure there is no clearance between the PCB and the stopper jig</div> <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> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-48210 (B)</div></div><div><div>NG</div><div></div><div>82711-3F290 (B)</div></div></div>

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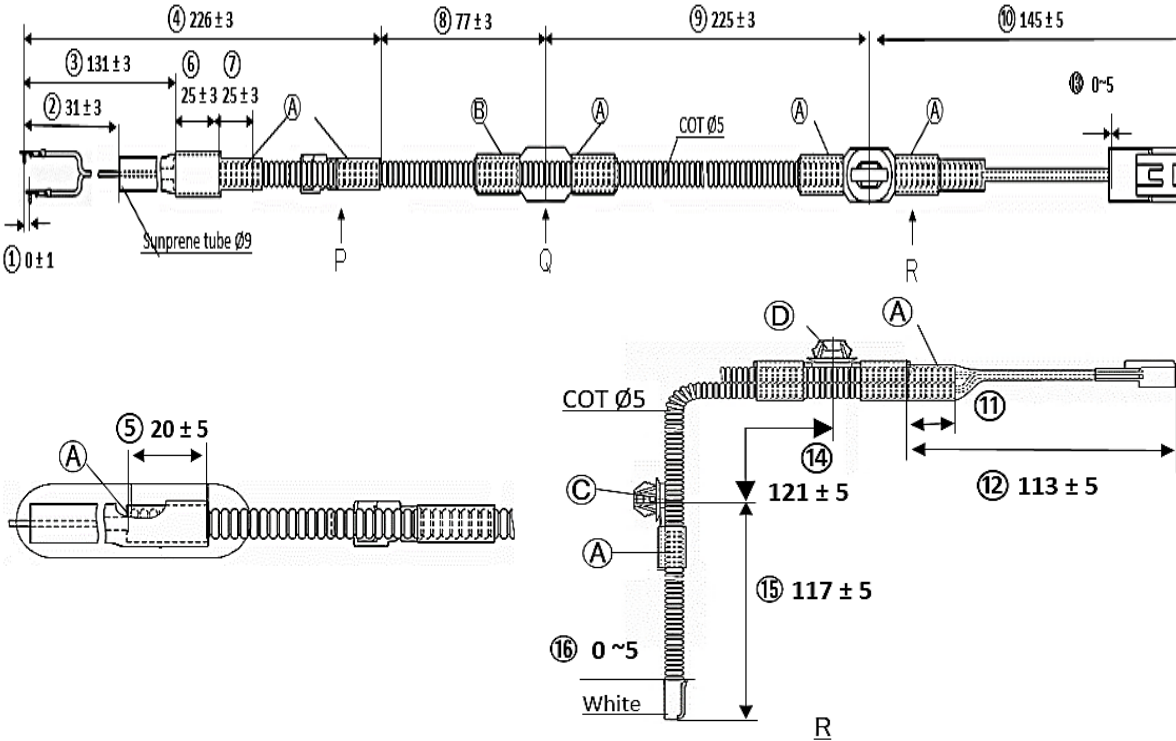

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Measurement			<p>1. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsumono, Nakamono, and Owarimono Inspection.</p> <div data-bbox="1769 1040 2083 1270"><p>MEASURING TAPE</p></div>

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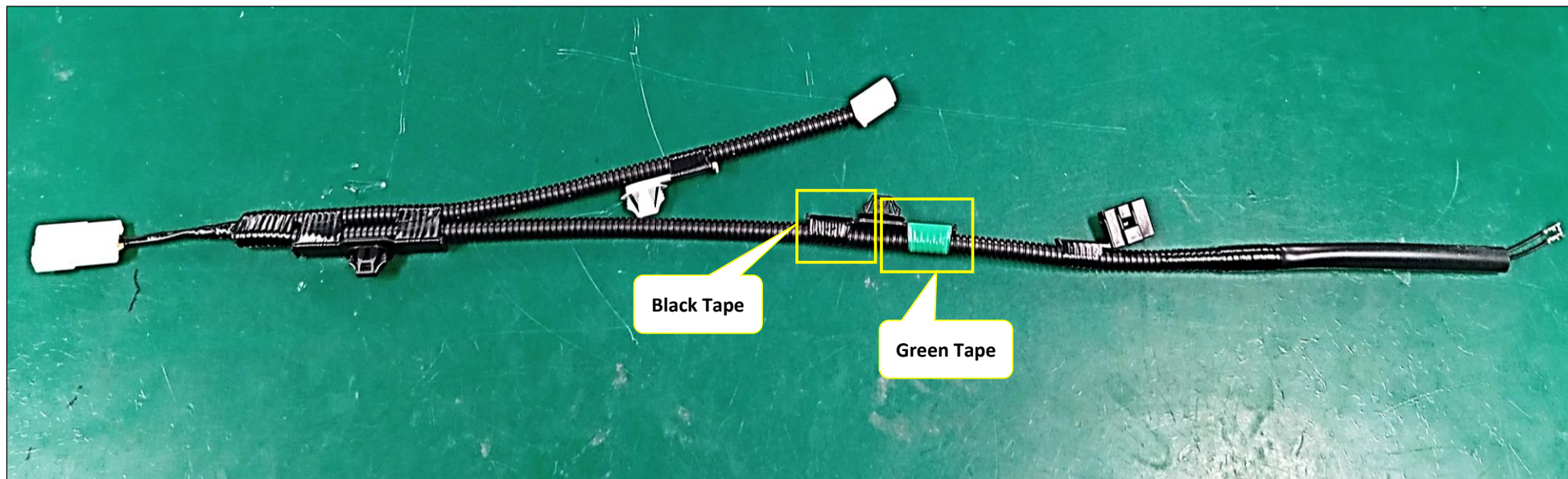
PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS



1 No Wrong Use of tape

3 No Missing Clamp

2 Check the Clamp Appearance

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