



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

310B / 7M0523-7020B

Customer: TRJ

Car Model:

TOYOTA RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-853

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. Assy parts; Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Clamp 82711-34490 (B); Black tape [1pc]; Pink tape [1pc]

JIG:

1. Clamp Assembly Jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

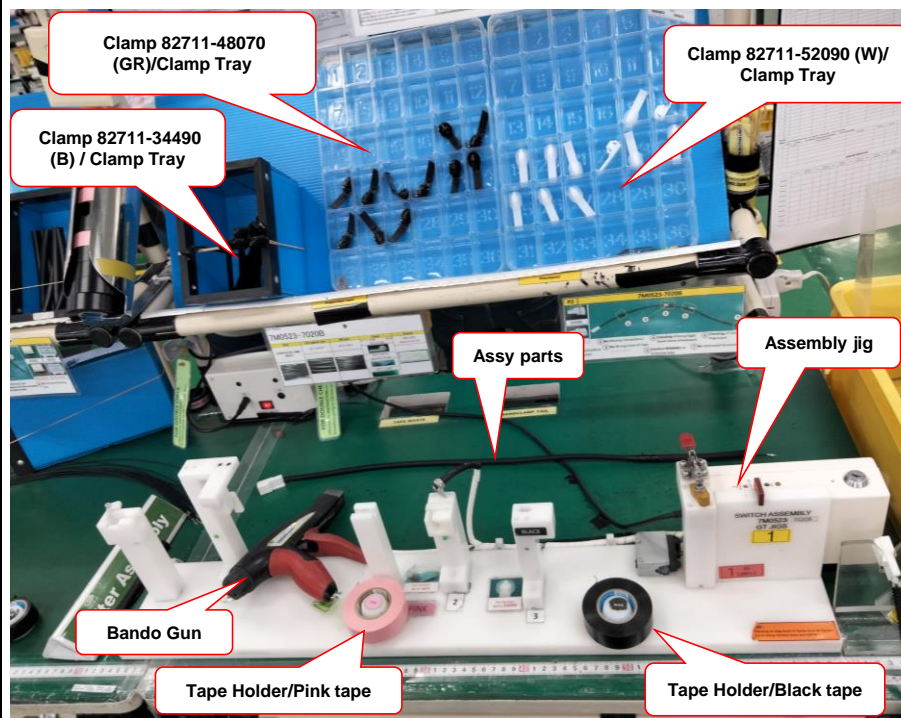
QUALITY POINTERS

1

Clamp Assy

Table Lay-out

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.

Document references:

1. Refer to WI-ENG-PDE-064 Taping Assembly Process

- 1.No missing parts/tools
- 2.No excess parts/tools

Revision History

								Prepared by	Reviewed by	Approved by	Noted by
06/06/24	0	Initial issue.						D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 6, 2024			

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Model code/Part number:

310B / 7M0523-7020B

Customer:

TRJ

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-853

Purpose:

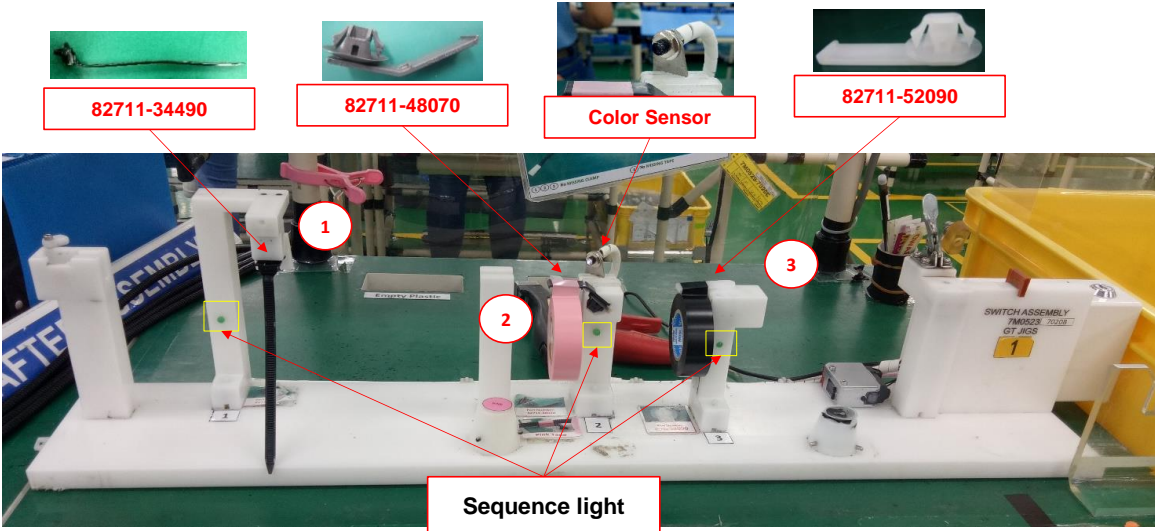

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:	1. Clamp 82711-34490 (B) 2. Clamp 82711-48070 (GR) 3. Clamp 82711-52090 (W)	4. Black tape 5. Pink tape	JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Clamp Setting	<div></div> <div>1. Get the clamp 82711-34490 using right hand and set to clamp location ① using both hands.</div> <div>2. Get the clamp 82711-48070 using right hand set to clamp location ② using both hands.</div> <div>3. Get the clamp 82711-52090 using right hand and set to clamp location ③ using both hands.</div> <div>4. Get the Pink tape and initially attach tape to location ② using both hands.</div> <div>5. Get the Black tape and initially attach tape to location ③ using both hands.</div>		<div>STANDARD TAPING FOR CLAMP</div> <div></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>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

310B / 7M0523-7020B

Customer:

TRJ

Car Model:

TOYOTA RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Document No.:

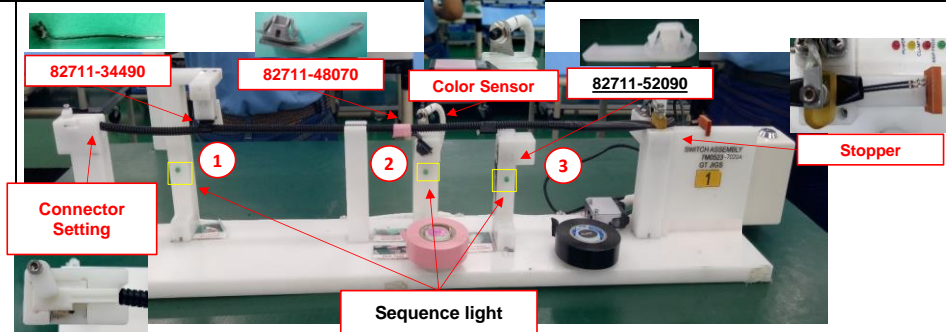


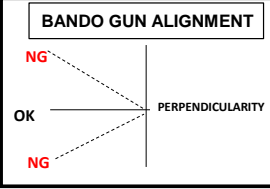


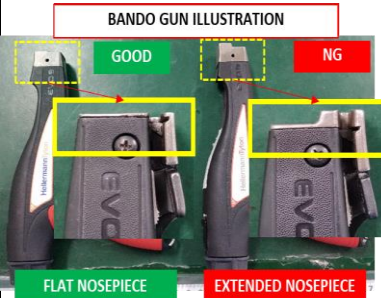
WI-ENG-PDE-853

Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Assy parts		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	<div><div></div><div><div><p>1. Get the assy part and set to jig. (See above picture for correct setting). First, set the connector to Receiver base. Last, set the B/B wires with terminal end 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, WIRE1 and WIRE2 and CLAMP 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>3. Initially tighten the band clamp on location ① using right hand.</p><p>4. Get the bando gun and cut the band clamp (82711-34490) using right hand. Press the sequence light button after cutting. Continue to location ② if light was on.</p><p>5. Hold the tape on clamp location ② and start taping (3 windings) using both hands. Press the sequence light button after taping. Continue to location ③ if light was on.</p><p>6. Hold the tape on clamp location ③ and start taping (3 windings) using both hands. Press the sequence light button after taping. GO buzzer will be heard.</p><p>7. CONDUCT POINT CHECKING before removing from jig.</p></div><div><div></div><div><p>Notes: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: $\phi 5$ - 1~2, $\phi 7$ - 3~4</p><div><div><p>BANDO GUN ALIGNMENT</p></div></div></div></div><div><div></div><div></div><div><p>Important reminders/Note/s:</p><p>1. Must be no gap between terminal and stopper jig.</p><p>2. Make 2-3 windings for clamp taping</p></div><div><div><p>BANDO GUN ILLUSTRATION</p></div></div></div></div></div>			

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

310B / 7M0523-7020BCustomer: **TRJ**Car Model: **TOYOTA RAV4**

Document No.:

WI-ENG-PDE-853

Purpose:


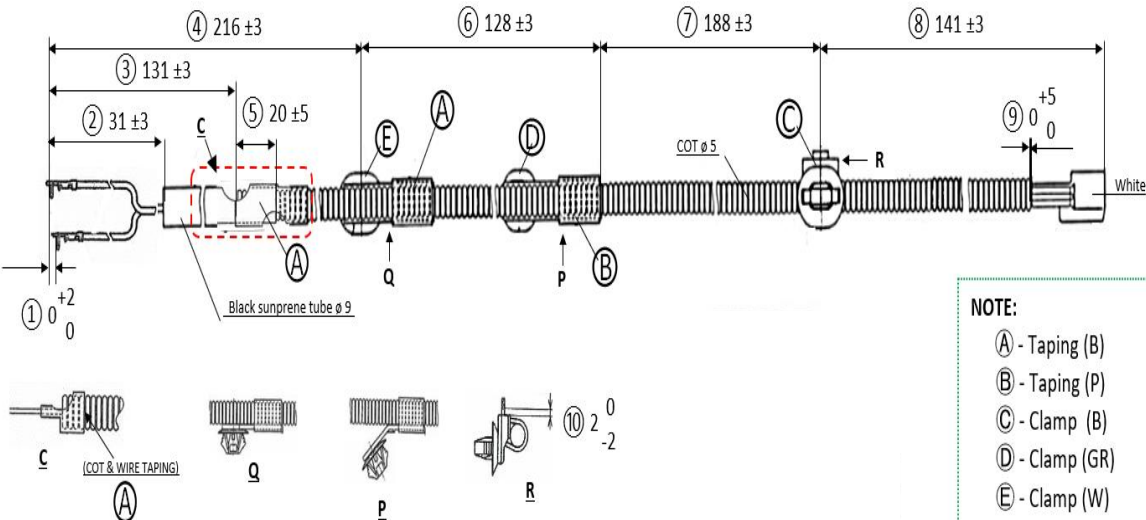
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

4 of 5

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement		<div>Measuring tape</div>   <div>NOTE: A - Taping (B) B - Taping (P) C - Clamp (B) D - Clamp (GR) E - Clamp (W)</div>	<p>Important reminders and 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-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Model code/Part number:

310B / 7M0523-7020BCustomer: **TRJ**

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-853

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7M0523-7020B**

1

No Wrong Facing of Clamp

2

No Missing Tape (Black Tape)

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp