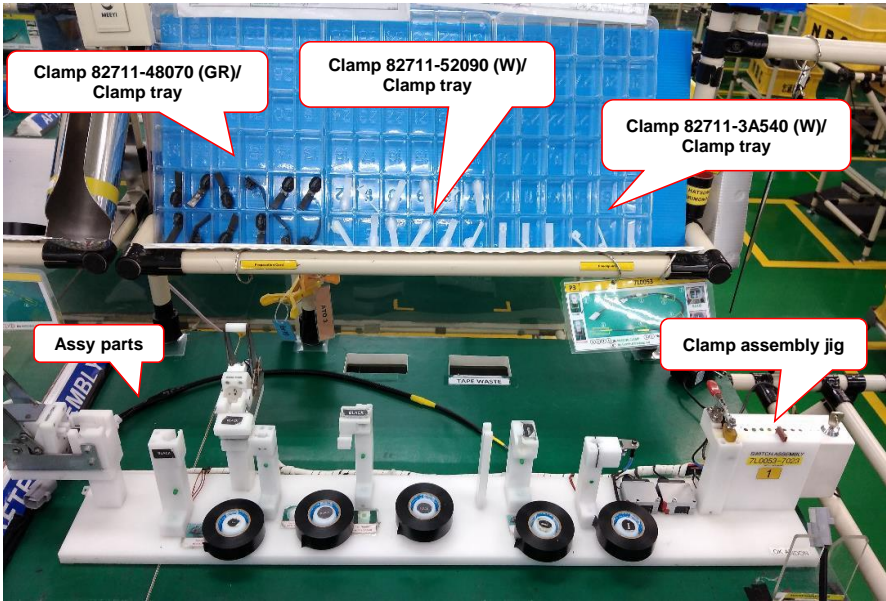




	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0053-7025A		Customer: TRQSS	Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1036		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	1 of 6	

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Clamp 82711-3A540 (W); Black tape [5pcs]		JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <ol style="list-style-type: none"> Maintain and always practice 5's. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>Document reference/s:</div> <ol style="list-style-type: none"> Refer to WI-ENG-PDE-1035A-C for Taping assembly process <ol style="list-style-type: none"> No missing parts/tools No excess parts/tools 	

Revision History								Prepared by		Reviewed by		Approved by		Noted by		
								 D. Castillo	 C. Villanueva	 A. Arañes	n/a					
09/12/24	1	Change from Pre-launch to Masspro.				D. Castillo	C. Villanueva								A. Arañes	n/a
09/11/24	0	Initial issue.				D. Castillo	C. Villanueva								A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		September 11, 2024				

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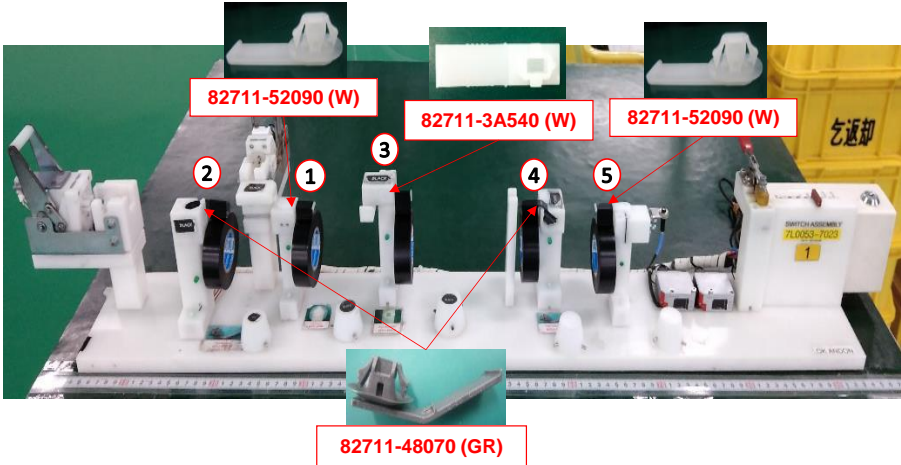



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Clamp 82711-3A540 (W) 2. Clamp 82711-52090 (W) [2pcs]		3. Clamp 82711-48070 (GR) [2pcs] 4. Black tape [5pcs]		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 2pcs. of clamp 82711-48070 (GR) using both hands then set to location 2 & 4 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-52090 (W) using both hands then set to location 1 & 5 using both hands.</div> <div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand then set to clamp location 3 using both hands.</div> <div>4. Initially attach Black tape to clamp location 1, 2, 3, 4 and 5 using both hands.</div>			n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</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>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div></div><div>82711-52090 (W)</div><div>NG</div><div></div><div>82711-12A80 (W)</div></div>

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DCC Stamp



WORK INSTRUCTION

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Model code/Part number:

320B / 7L0053-7025A

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PARTS:

1. Assy parts

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

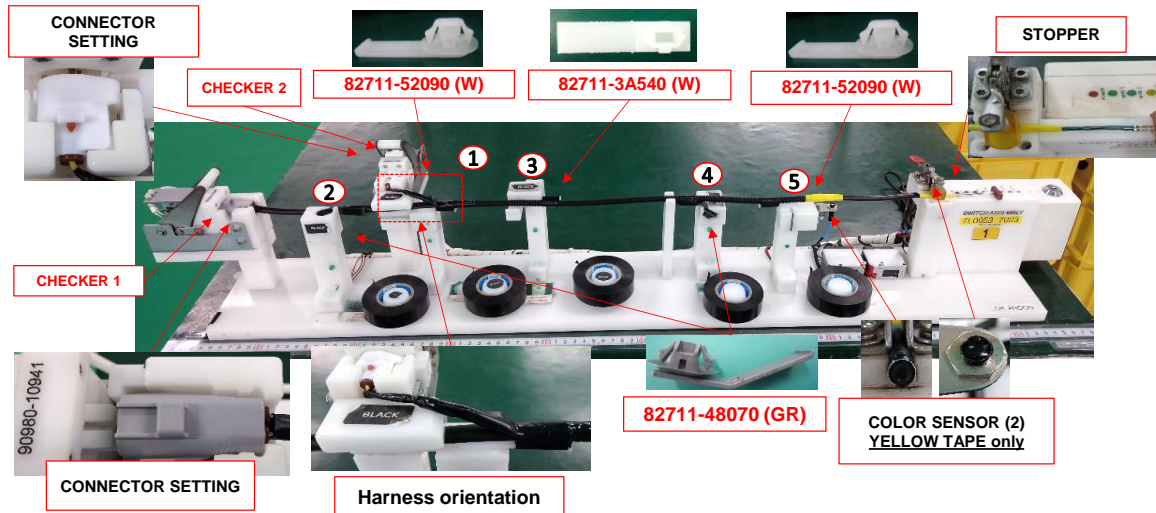
TOOLS/PPE

QUALITY POINTERS

3

CLAMP
ASSY

Clamp Assembly



1. Get the assy parts and set into jig. **(See above picture for correct setting of harness).** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Continue to set the harness in jig. **Color sensor 1** will beep/buzz if sensor detects **Yellow tape**. **Color sensor 2** will beep/buzz if sensor detects **Yellow tape**. Last, set the hotmelted wires and terminal end together within the stopper then press by **Toggle clamp**. Check if the sequence light of location **1** was **ON**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

3. Hold the tape on clamp location **1**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **2** was **ON**.

4. Hold the tape on clamp location **2**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **3** was **ON**.



Important reminders/Note/s:

1. Make sue no gap between stopper jig and terminal.
2. Make 2-3 windings for clamp taping.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position
5. No gap between terminal and stopper jig

CLAMP ILLUSTRATION



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PARTS:		1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly			
		<div><div><div>CONNECTOR SETTING</div><div>CHECKER 2</div><div>82711-52090 (W)</div><div>82711-3A540 (W)</div><div>82711-52090 (W)</div><div>STOPPER</div><div>CHECKER 1</div><div>90980-10941</div><div>CONNECTOR SETTING</div><div>Harness orientation</div><div>82711-48070 (GR)</div><div>COLOR SENSOR (2) YELLOW TAPE only</div></div><div><div>5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</div><div>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 5 was ON.</div><div>7. Hold the tape on clamp location 5. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</div><div>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div><div>9. After point checking, remove the harness from toggle clamp up to checker checker 1 and checker 2.</div></div></div>			<div><p>Important reminders/Note/s:</p><p>1. Make sue no gap between stopper jig and terminal.</p><p>2. Make 2-3 windings for clamp taping.</p><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position 5. No gap between terminal and stopper jig</p><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div><div>NG</div><div>82711-12A80 (W)</div></div></div></div>

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PARTS:

1. Assy parts

JIG:

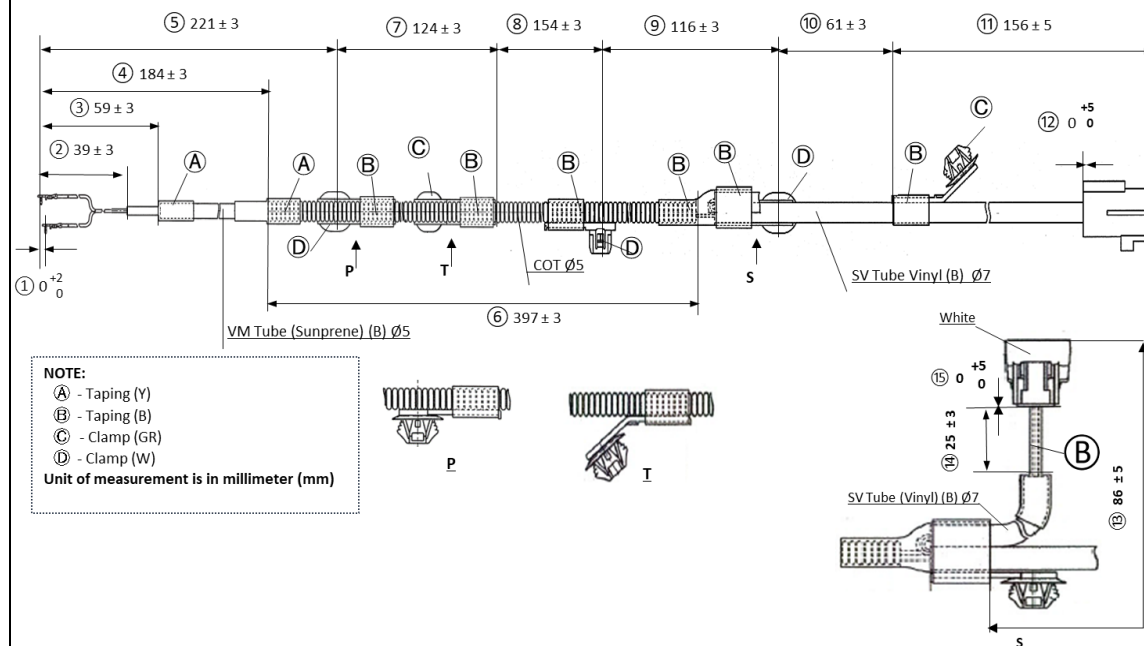
1. Clamp assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

CLAMP
ASSY

Measurement

**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

1. No wrong dimension

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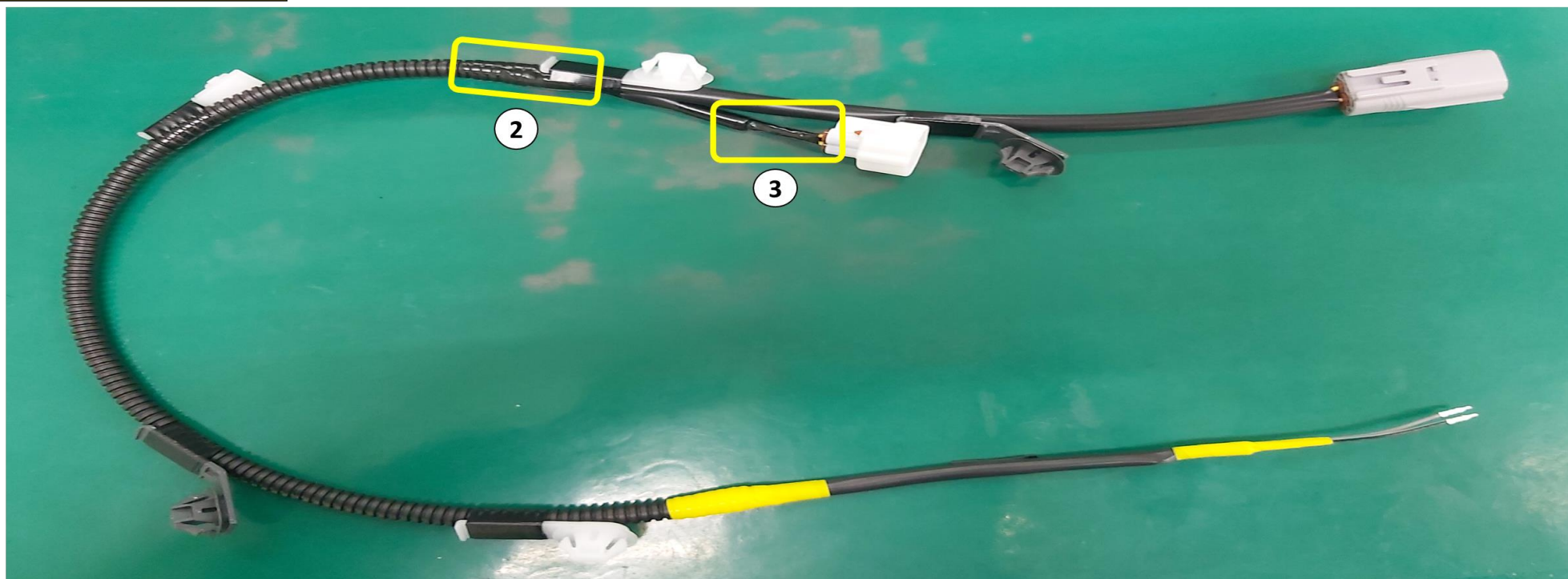
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0053-7025A****① No Wrong facing of clamp****② ③ No Missing Tape (Black tape)**

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