



## WORK INSTRUCTION

Process Name/Title: **CLAMP ASSEMBLY PROCESS**Model code/Part number: **311D / 7L0154-7022** Customer: **TRJ** Car Model: **TOYOTA-RAV4**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

September 25, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1008

Revision No.:

0

Page No.:

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## PARTS:

1. Assy parts; Clamp 82711-33650 (B) Clamp 82711-48210 (B); Black tape [5pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

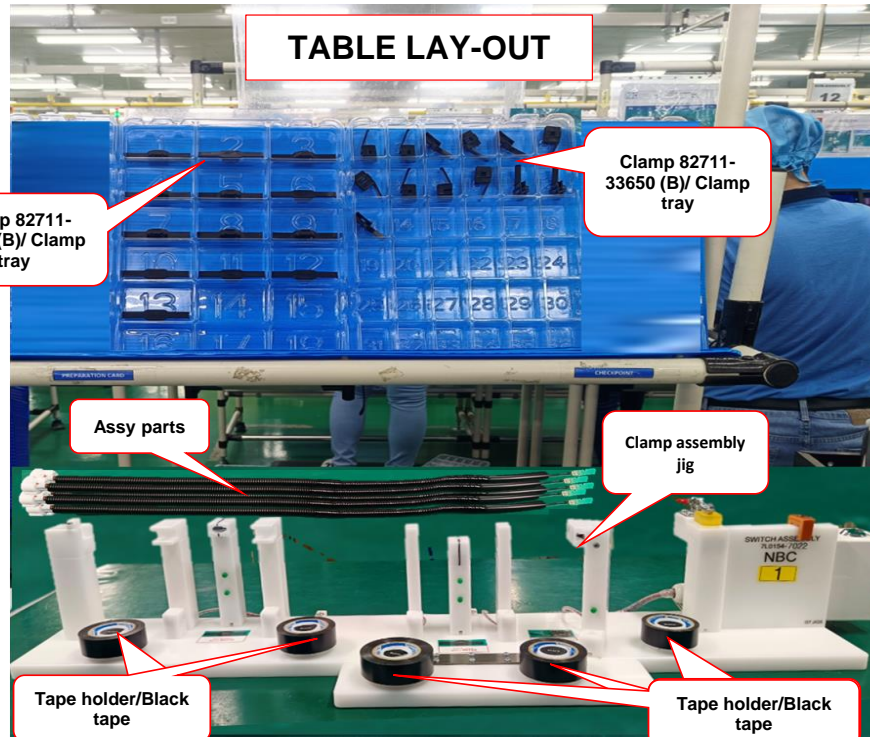
TOOLS/PPE

QUALITY POINTERS

1

Clamp  
assy

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.

**Important reminders/Notes**

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

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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/25/24

0

Initial issue.  
Excluded process from **WI-ENG-PDE-942 to WI-ENG-PDE-1008**; Change Process name/Title from **TAPING ASSEMBLY PROCESS to CLAMP ASSEMBLY PROCESS** due to split process. Additional Table lay-out; Improve work procedure/Illustration (Provided permanent jig) and Visual Inspection/Quality Checkpoints.

M. Ariola

C. Villanueva

A. Arañes

n/a

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 25, 2024

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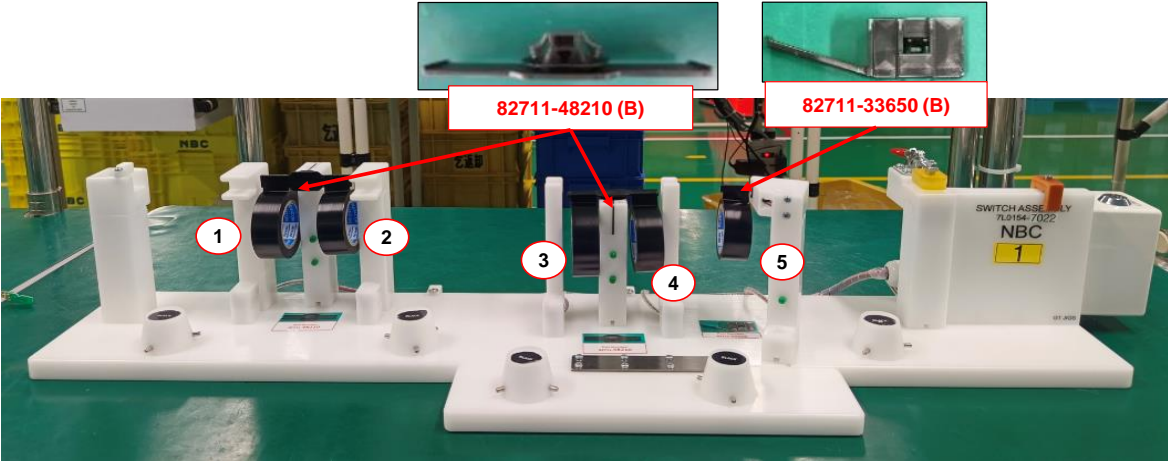
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Clamp 82711-48210 (B) [2pcs] 2. Clamp 82711-33650 (B)		3. Black tape [5pcs]		JIG:		1. Clamp assembly jig	
NO.		PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
2		Clamp assy		Clamp setting		<div><div></div><div>1. Get <b>1pc</b> of clamp <b>82711-48210 (B)</b> using right hand then set to Clamp location no. <b>1 and 2</b> using both hands.</div><div>2. Get <b>1pc</b> of clamp <b>82711-48210 (B)</b> using right hand then set to Clamp location no. <b>3 and 4</b> using both hands.</div><div>3. Get <b>1pc</b> of clamp <b>82711-33650 (B)</b> using right hand then set to Clamp location no. <b>5</b> using both hands.</div><div>4. Initially attach <b>BLACK TAPE</b> to location <b>1, 2, 3, 4 and 5</b> using both hands.</div></div>		<div><b>Important reminders/Notes</b> <b>1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</b></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>	

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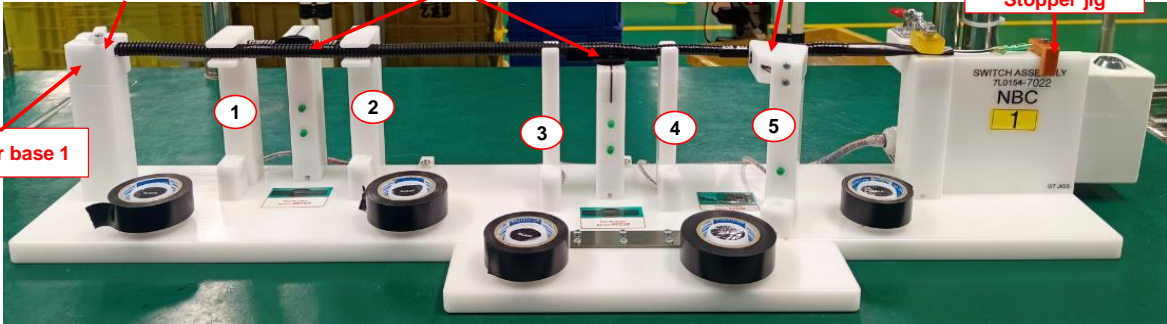
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PARTS:		1. Assy parts 2. Black tape [5pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly		<div><div><div><div><div></div><div>Connector setting</div></div><div><div></div><div>82711-48210 (B)</div></div><div><div></div><div>82711-33650 (B)</div></div><div><div></div><div>Stopper jig</div></div></div><div></div></div></div>	<div><div><div><b>Important reminders/Notes</b> <b>1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</b></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></div>
		<div><div><div>1. Get the assy parts using right hand then set into jig using both hands. <b>(See above picture for the correct setting)</b>. First put the connector <b>6189-0451 (W)</b> into <b>receiver base 1</b> then lock. Continue setting the harness into jig. Last, set the hotmelted wires <b>(B/W-G)</b> within the stopper jig then press by the toggle clamp.</div><div>2. Check the <b>LED</b> light for <b>POWER</b> and <b>CLAMP ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process. Continue if the sequence light on location <b>1</b> is <b>ON</b>.</div></div><div><div><div>3. Hold the tape on the clamp location no. <b>1</b> using right hand. Make <b>3 windings</b> of tape using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue to location <b>2</b> if light was <b>ON</b>.</div><div>4. Hold the tape on the clamp location no. <b>2</b> using right hand. Make <b>3 windings</b> of tape using both hands then cut the tape. Press the <b>SW button</b> after taping. Continue to location <b>3</b> if light was <b>ON</b>.</div></div></div></div>			

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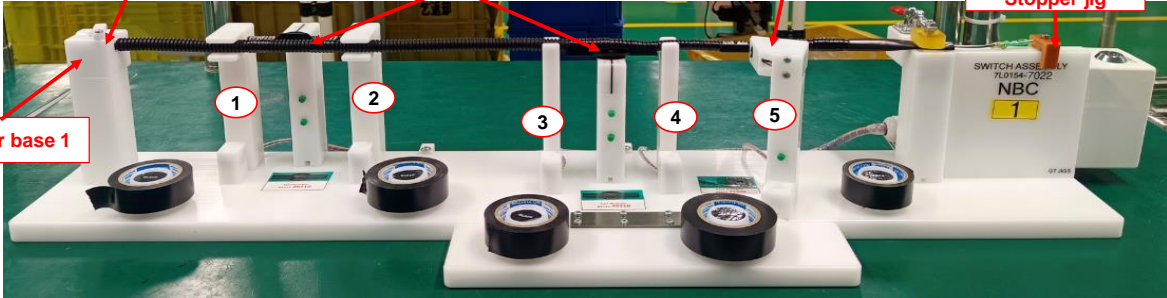
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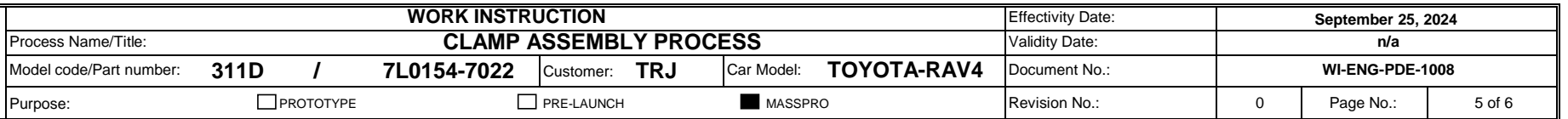
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PARTS:		1. Assy parts 2. Black tape [5pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly (Continuation)	<div><div> Connector setting</div><div> 82711-48210 (B)</div>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

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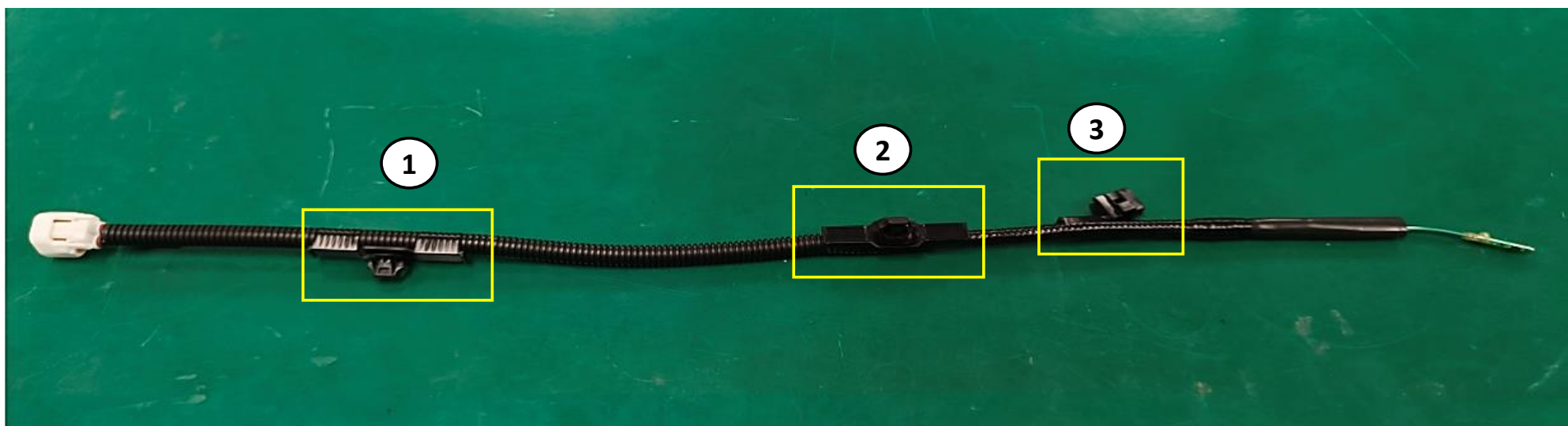
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP  
ASSY****7L0154-7022**

①

**No MISSING TAPE (B)**

②

③

**Check the alignment of clamp**

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