



WORK INSTRUCTION

Process Name/Title: CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 02, 2024

Model code/Part number: 311D / 7L0154-7023 Customer: TRQSS Car Model: TOYOTA-RAV4

Validity Date:

n/a

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

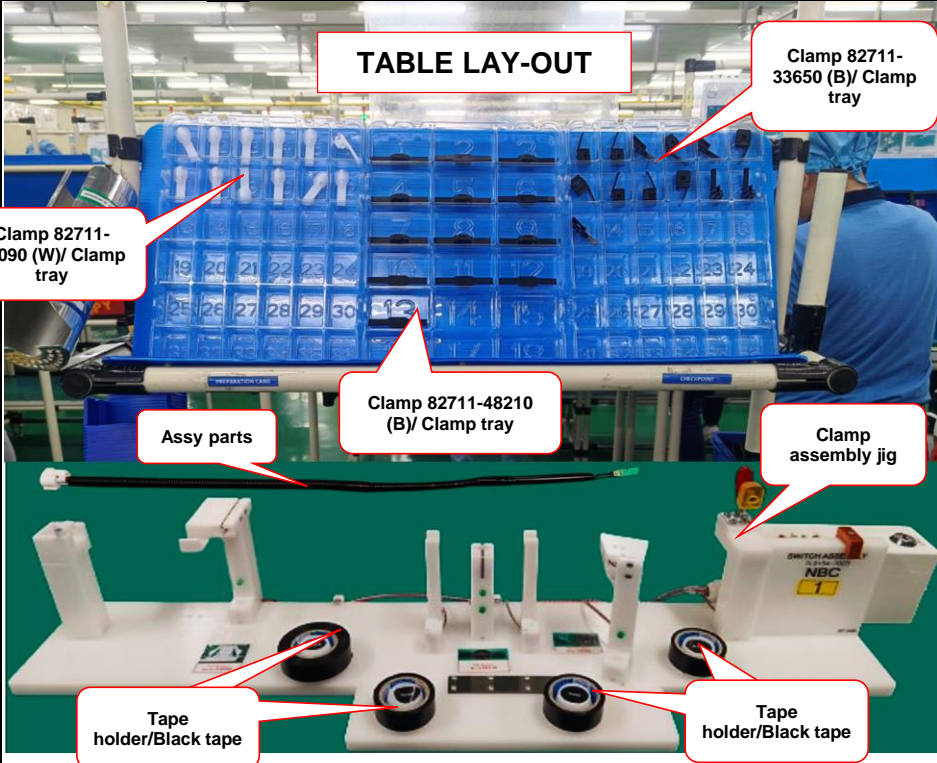



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PARTS:		1. Assy parts; Clamp 82711-33650 (B) Clamp 82711-48210 (B); Black tape [5pcs]				JIG:		1. Clamp assembly jig					
NO.		PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS					
1		Clamp assy		Table lay-out				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Important reminders/Notes 1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</div> <div>1. No missing part/tools. 2. No excess parts/tools</div>			
Revision History													
								Prepared by	Reviewed by	Approved by	Noted by		
10/02/24	1	Change purpose from Pre-launch to Masspro. Update the Work Procedure/Illustrations pages 1 to 4.				M. Ariola	C. Villanueva	A. Arañes	n/a	 M. Ariola	 C. Villanueva	 A. Arañes	n/a
09/10/24	0	Initial issue. Change quantity of clamp 82711-48210 (B) from [2pcs] to [1pc]; Additional clamp 82711-52090 [1pc].				M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024		

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DCC Stamp

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2 of 6**PARTS:**

1. Clamp 82711-48210 (B)
2. Clamp 82711-33650 (B)

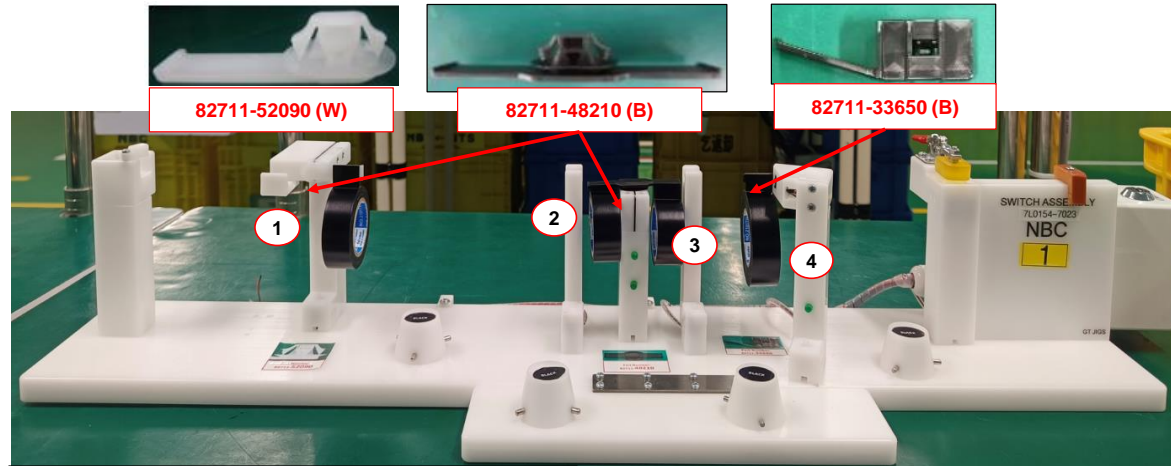
3. Clamp 82711-52090 (W)
4. Black tape [4pcs]

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 **82711-52090 (W)** using right hand then set to Clamp location no. **1** both hands.

2. Get **1pc** of clamp **82711-48210 (B)** using right hand then set to Clamp location no. **2 and 3** using both hands.

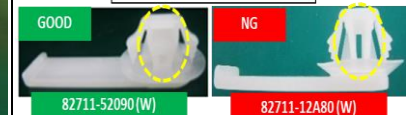
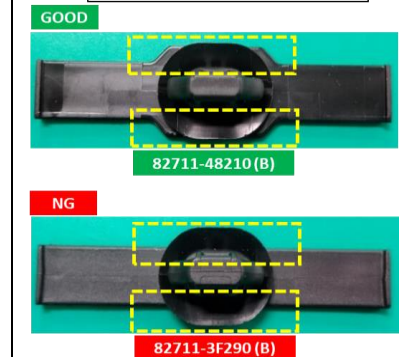
3. Get **1pc** of clamp **82711-33650 (B)** using right hand then set to Clamp location no. **4** using both hands.

4. Initially attach **BLACK TAPE** to location **1, 2, 3 and 4** using both hands.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Important reminders/Notes

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

CLAMP ILLUSTRATION**CLAMP ILLUSTRATION**

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PARTS:

1. Assy parts
2. Black tape [4pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

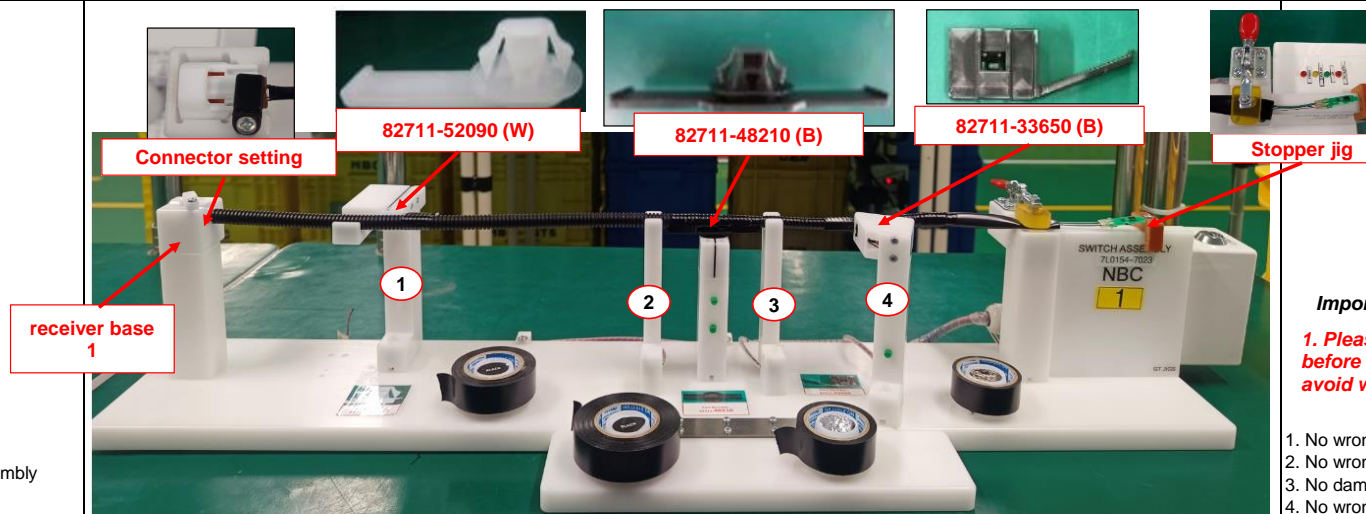
TOOLS/PPE

QUALITY POINTERS

3

Clamp
assy

Clamp assembly



1. Get the assy parts using right hand then set into jig using both hands. *(See above picture for the correct setting)*. First put the connector **6189-0451 (W)** into **receiver base 1** then lock. Continue setting the harness into jig. Last, set the hotmelted wires **(B/W-G)** within the stopper jig then press by the toggle clamp.

2. Check the **LED** light for **POWER** and **CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Continue if the sequence light on location **1** is **ON**.

3. Hold the tape on the clamp location no. **1** using right hand. Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue to location **2** if light was **ON**.

4. Hold the tape on the clamp location no. **2** using right hand. Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue to location **3** if light was **ON**.

Important reminders/Notes

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

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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PARTS:

1. Assy parts
2. Black tape [4pcs]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

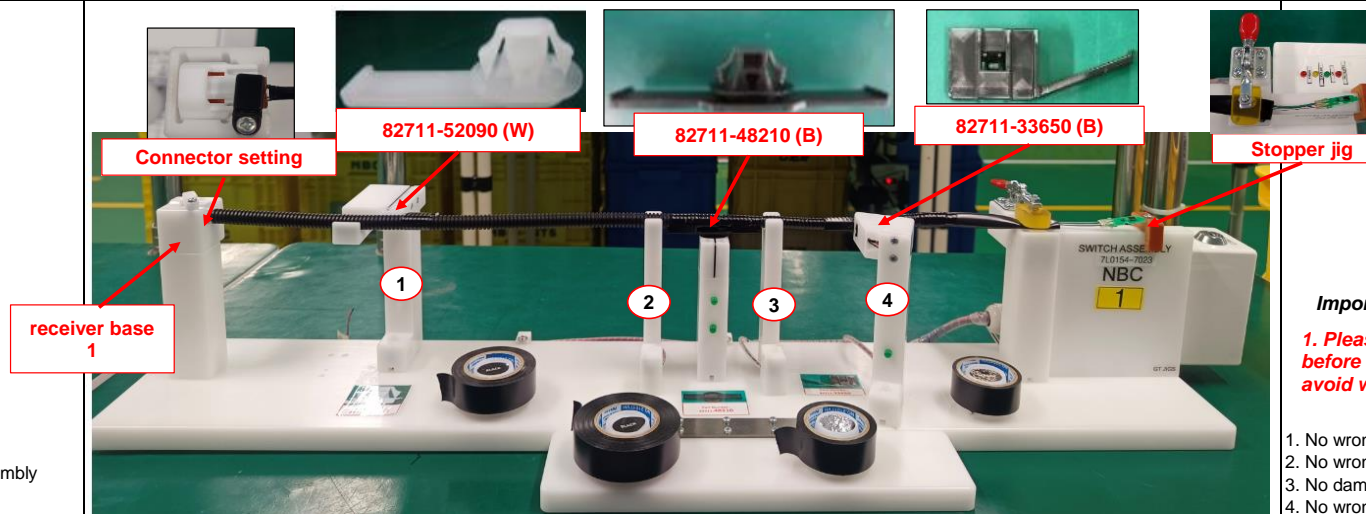
TOOLS/PPE

QUALITY POINTERS

3

Clamp
assy

Clamp assembly



5. Hold the tape on the clamp location no. **3** using right hand. Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue to location **4** if light was **ON**.

6. Hold the tape on the clamp location no. **4** using right hand. Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Continue to location **5** if light was **ON**.

7. Hold the tape on the clamp location no. **5** using right hand. Make **3 windings** of tape using both hands then cut the tape. Press the **SW button** after taping. Go sound will be heard.

8. After taping, conduct **POINT CHECKING** before removing the harness from jig

Important reminders/Notes

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

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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PROTOTYPE



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PARTS:

n/a

JIG:

n/a

NO.

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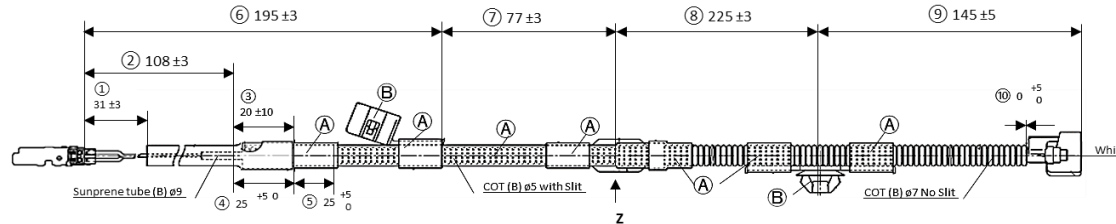
TOOLS/PPE

QUALITY POINTERS

4

Clamp
assy

Measurement



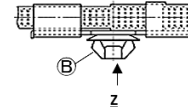
Half Wrap Roll

NOTE:

① - Taping (B)

② - Clamp (B)

③ - Dimension overlapped sunprene and COT



MEASURING TAPE



1. No wrong dimension

Important reminders/Notes

1. Please use calibrated/verified measuring tape when fetting the measurement.
2. For Hatsumono, Nakamono and Owarimono

Document reference/s:

1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0154-7023****1** No **MISSING TAPE (B)****2** Check the **ALIGNMENT OF CLAMP**

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