



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

311D / 7L0152-7024

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 15, 2025

Validity Date:

n/a

Document No.:

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Revision No.:

1

Page No.:

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PARTS: 1. Assy parts; clamp 82711-48210 (B) [2 pcs.]; Clamp 82711-3A640 (B); Clamp 82711-33650 (B); Black Tape [6 pcs.]

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

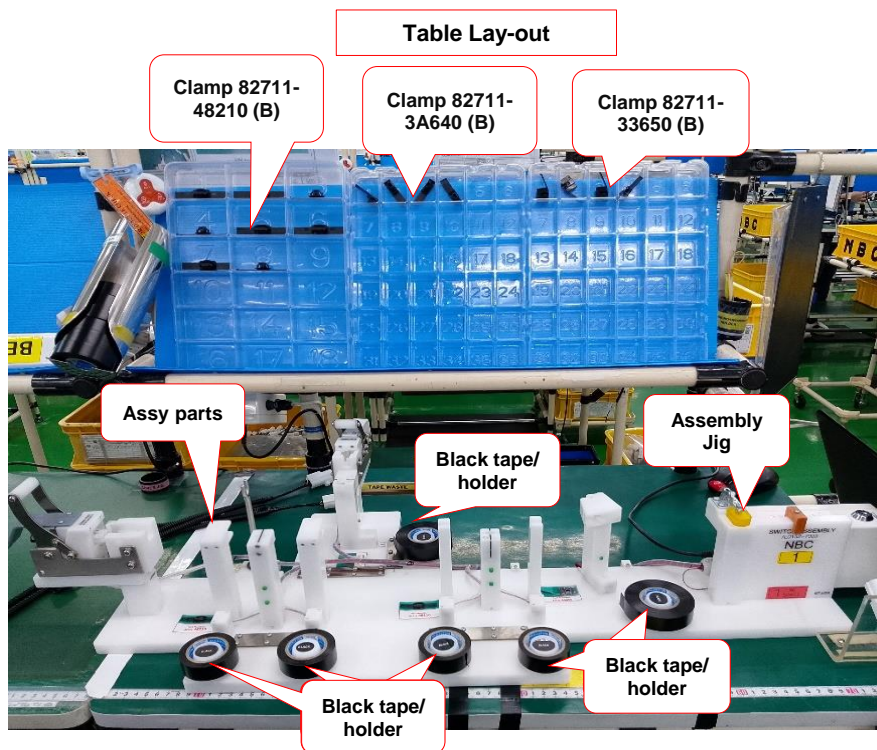
TOOLS/PPE

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/Note/s:

1. Refer to WI-ENG-PDE-675 for Offline assembly process
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
05/15/25	1	Change documents purpose from pre-launch to mass pro.	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes
04/28/25	0	Initial issue.	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes

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DCC Stamp

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PARTS:		1. Assy parts 2. Clamp 82711-48210 (B) [2 pcs.] 3. Clamp 82711-3A640 (B)		4. Clamp 82711-33650 (B) 5. Black Tape [6 pcs.]		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Setting	<div><div> 82711-48210 (B)</div><div> 82711-3A640 (B)</div><div> 82711-48210 (B)</div><div> 82711-33650 (B)</div></div> <div><p>1. Get 1pc. of clamp 82711-48210 (B) using right hand and set to clamp location 1,2,4 and 5 using both hands.</p><p>2. Get 1pc. of clamp 82711-3A640 (B) using right hand and set to clamp location 3 using both hands.</p><p>3. Get 1pc. of clamp 82711-33650 (B) using right hand and set to clamp location 6 using both hands.</p><p>4. Initially attach Black tape to clamp location 1, 2, 3,4,5 and 6 using both hands.</p></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>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div>

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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	<div><div><div><div><div>Connector Setting</div><div>82711-48210 (B)</div></div><div><div>82711-3A640 (B)</div><div>82711-48210 (B)</div></div><div><div>82711-33650 (B)</div></div></div><div></div></div><div><div><p>1. Put the assy parts into jig (<i>See above picture for the correct setting</i>). First, set the connector 6188-0093 (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 6189-1161(B)) in hook.</p></div><div><p>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.</p></div></div><div><div><div><div><div>COT 1</div><div>COT 2</div></div><div><div>HOOK</div><div>SIDE A</div></div></div><div></div></div><div><p>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).</p></div></div></div>			<p>Important reminders/Notes</p> <p>1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <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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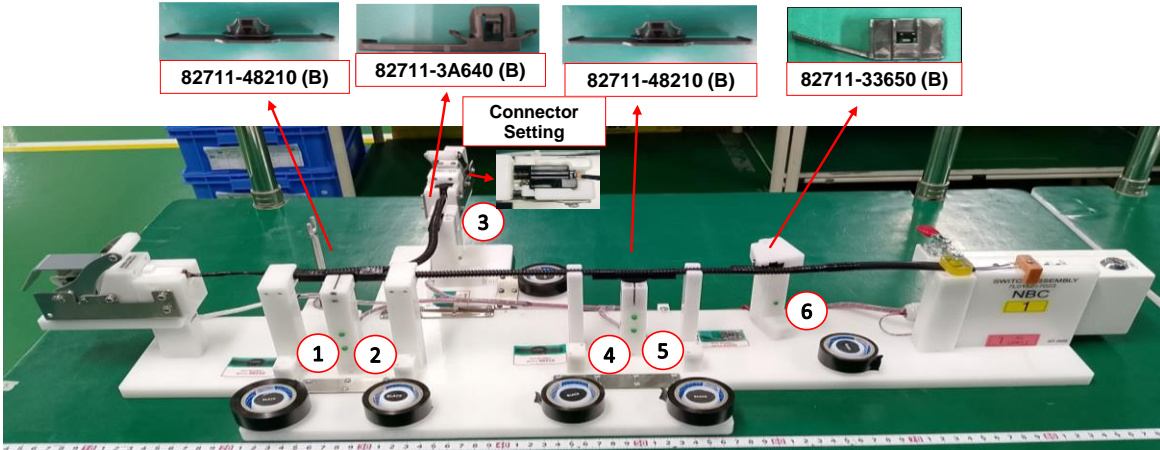

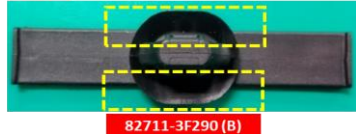
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy Clamp Assembly (Continuation)	<div></div> <div>4. Remove the COT 1 from the hook and set the connector 6189-1161 (B) 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.</div> <div>5. 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.</div> <div>6. 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.</div>			<p>Important reminders/Notes</p> <p>1. Please check the clamp first before start of clamp assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-48210 (B)</div></div><div><div>NG</div><div>82711-3F290 (B)</div></div></div>

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PARTS:
1. Assy parts
2. Black tape

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

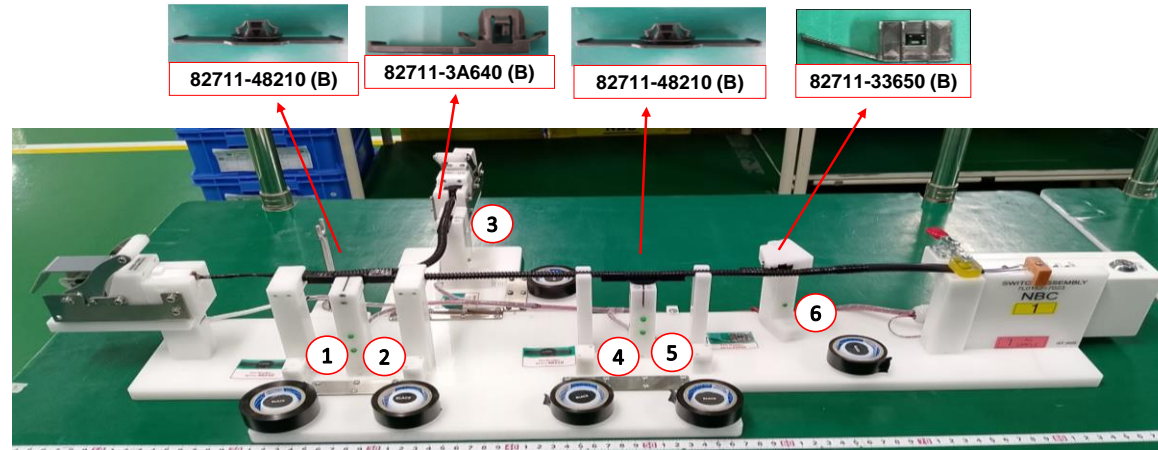
TOOLS/PPE

QUALITY POINTERS

5

Clamp Assy

Clamp Assembly (Continuation)



7. 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**.

8. 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**.

9. On Clamp **location 5** 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 6** was **ON**.

10. 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.

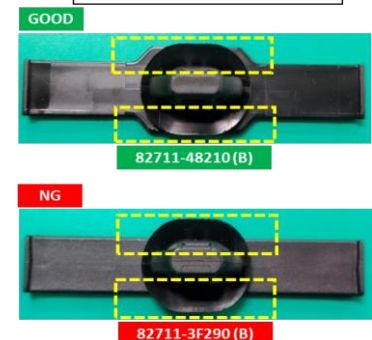
11. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

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

CLAMP ILLUSTRATION



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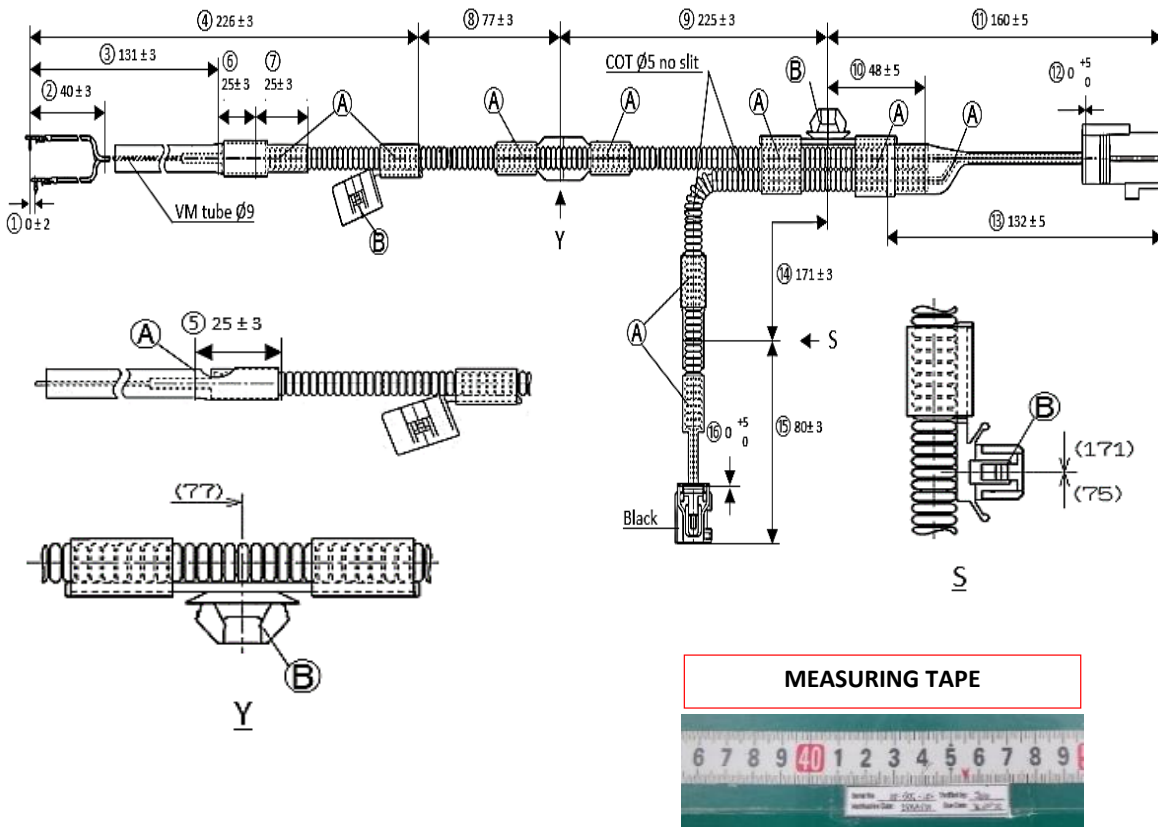
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PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Clamp Assy	Measurement			<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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>

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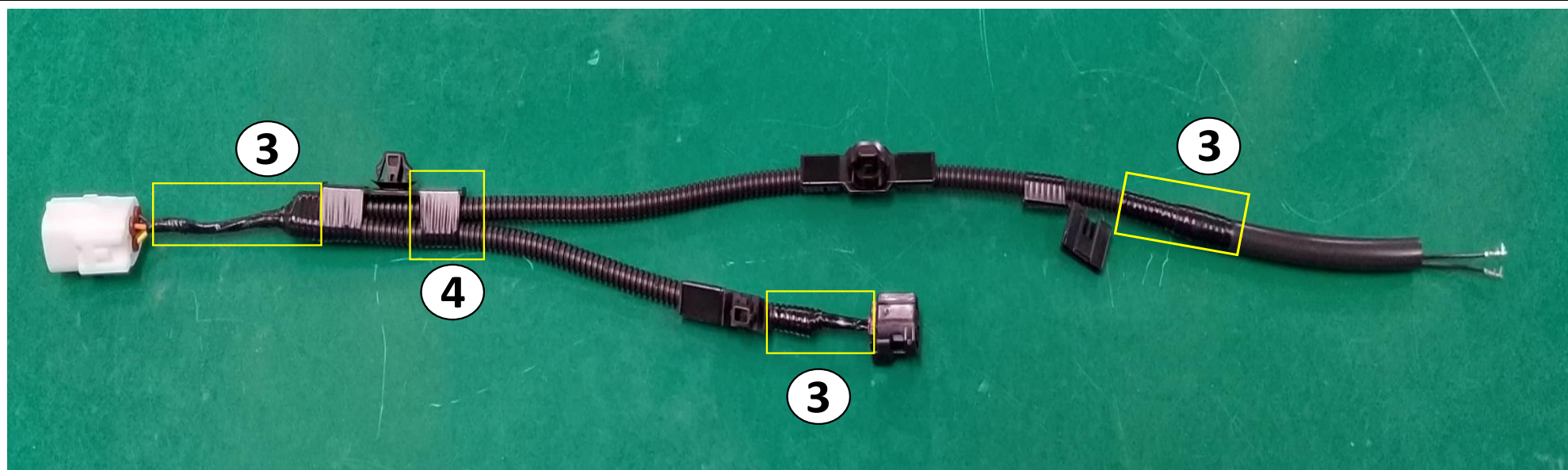
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**CLAMP ASSY****7L0152-7024**

- ① Check the Clamp Alignment ② No Missing Clamp ③ No Missing Tape (Blacktape) ④ No Missing Spot inside tape

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