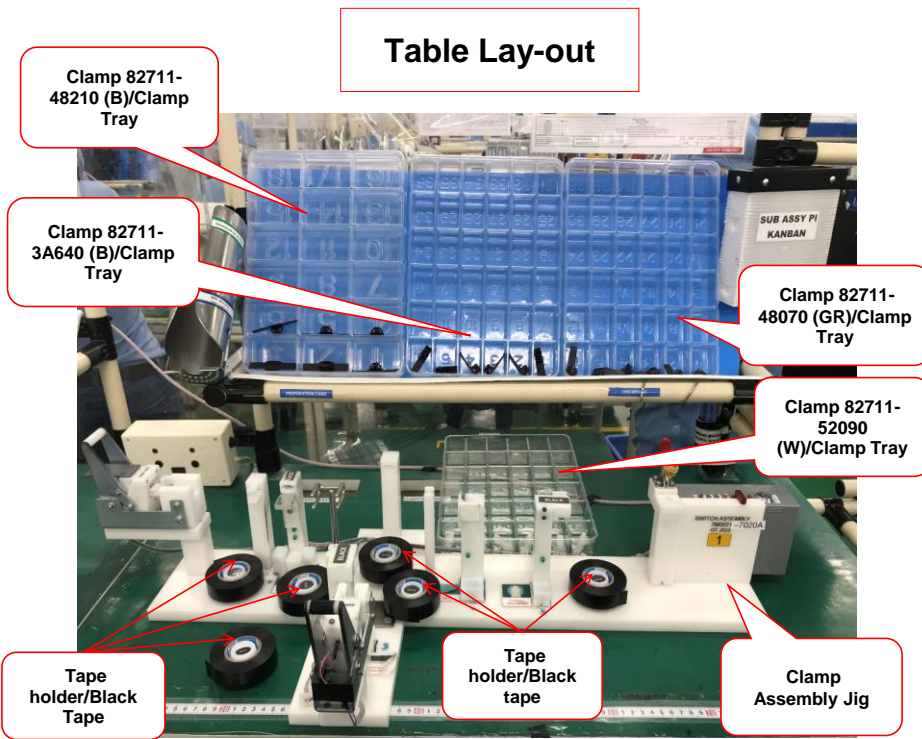

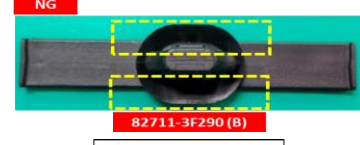


	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS				Effectivity Date:	June 11, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 310B / 7M0521-7021		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-901	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	1 of 7	

PARTS:	1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Black Tape			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy			<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-ENG-PDE-416A-B for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD  82711-48210 (B)</p> <p>NG  82711-3F290 (B)</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD  82711-52090 (W)</p> <p>NG  82711-12A80 (W)</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial Issue.	D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 11, 2024

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☐ PROTOTYPE

☐ PRE-LAUNCH

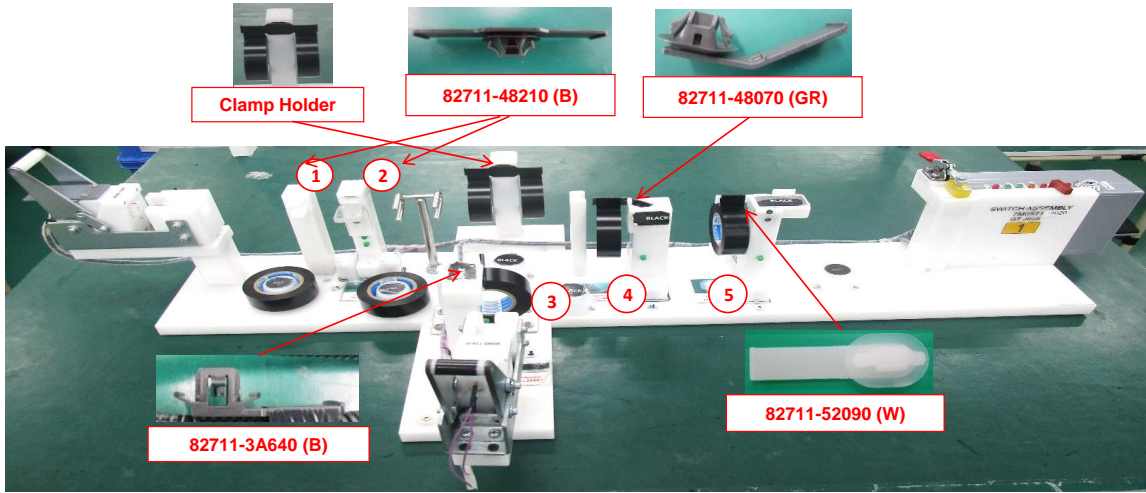

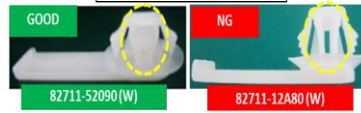
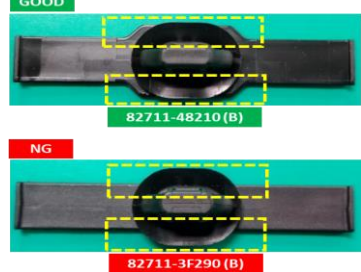
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PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-3A640 (B) 3. Clamp 82711-48070 (GR) 4. Clamp 82711-52090 (W) 5. Black tape [7pcs.]		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Clamp Setting	<div></div> <div>1. Get the clamp 82711-3A640 (B) using right hand and put to location 3 using both hands.</div> <div>2. Get the clamp 82711-48070 (GR) using right hand and put to location 4 using both hands.</div> <div>3. Get the clamp 82711-52090 (W) using right hand and put to location 5 using both hands.</div> <div>4. Initially attach black tape to location 3, 4 and 5 using both hands.</div> <div>5. Get the clamp 82711-48210 (B) using right hand then put to clamp holder and initially attach black tape using both hands.</div>			<div>1. No wrong use of tape 2. No wrong clamp position 3. No damaged clamp</div> <div>Important Reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>STANDARD TAPING FOR CLAMP One wind for under tape </div> <div>CLAMP ILLUSTRATION </div> <div>CLAMP ILLUSTRATION </div>

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☐ PROTOTYPE

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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 Clamp Assembly	<div></div> <div><p>1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Second, set the connector (6189-1161) to Checker 2 then push the lock for continuity checking. Last, set the end of G/BW hotmelted wire together within the stopper then press by Toggle clamp. Continue if the sequence light of location ① was ON.</p></div> <div><p>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></div>		n/a	<div><p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p></div> <div><p>Important reminders/note/s:</p><p>1. Make sure no gap between stopper jig and hotmelted terminals.</p><p>2. Make 2-3 windings for clamp tapping.</p><div><p>CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div><div><p>CLAMP ILLUSTRATION</p><div><div>GOOD</div><div>82711-48210 (B)</div></div><div><div>NG</div><div>82711-3F290 (B)</div></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

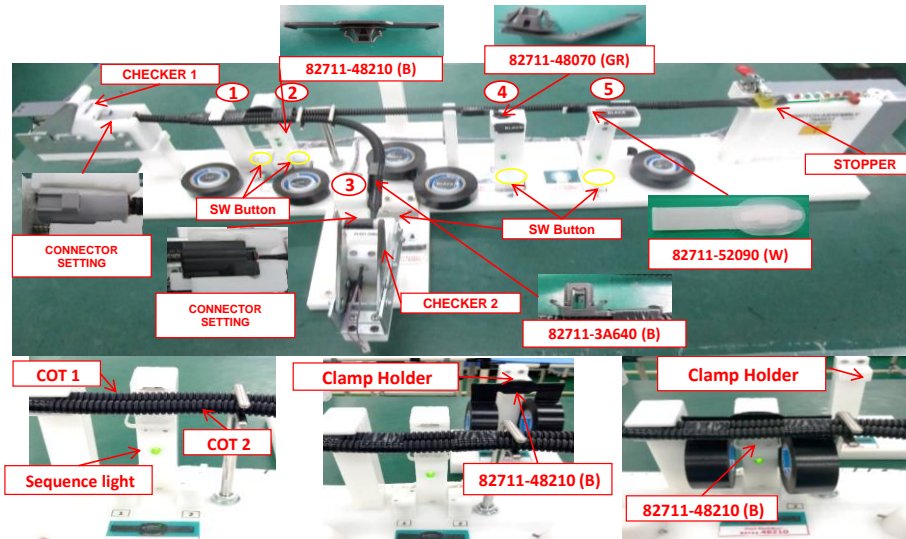
TOOLS/PPE

QUALITY POINTERS

3

Clamp
Assy

Clamp Assembly
(Continuation)



3. Fix the 2 corrugated tube and **2 windings** of tape on both sides (**tape width**) using both hands then cut the tape.

4. Get the clamp in clamp holder (**82711-48210**) and set to location **1 and 2**.

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

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

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

n/a

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape



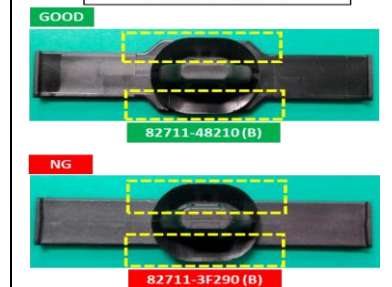
Important reminders/note/s:

1. Make sure no gap between stopper jig and hotmelted terminals.
2. Make 2-3 windings for clamp taping.

CLAMP ILLUSTRATION



CLAMP ILLUSTRATION



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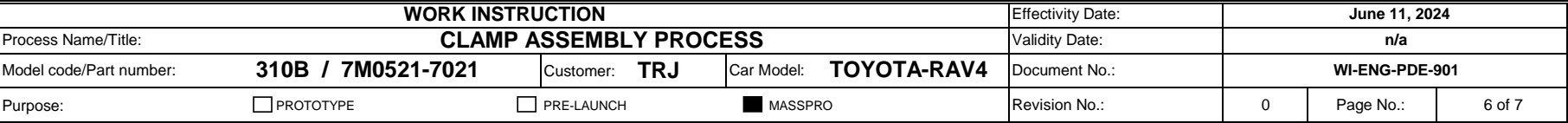
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp Assembly (Continuation)	<div></div> <div>8. Hold the tape on clamp location 4 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if sequence light on location 5 was ON.</div> <div>9. Hold the tape on clamp location 5 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Go sound will be heard.</div> <div>10. After taping, CONDUCT POINT CHECKING before removing of harness from jig.</div> <div>11. First, pull the 2 checker fixture (same timing) then remove the toggle clamp. Last, remove the harness from COT up to clamp.</div>		n/a	<div>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</div> <div></div> <div>Important reminders/note/s: 1. Make sure no gap between stopper jig and hotmelted terminals. 2. Make 2-3 windings for clamp taping.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div> <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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PARTS:

1. Assy parts

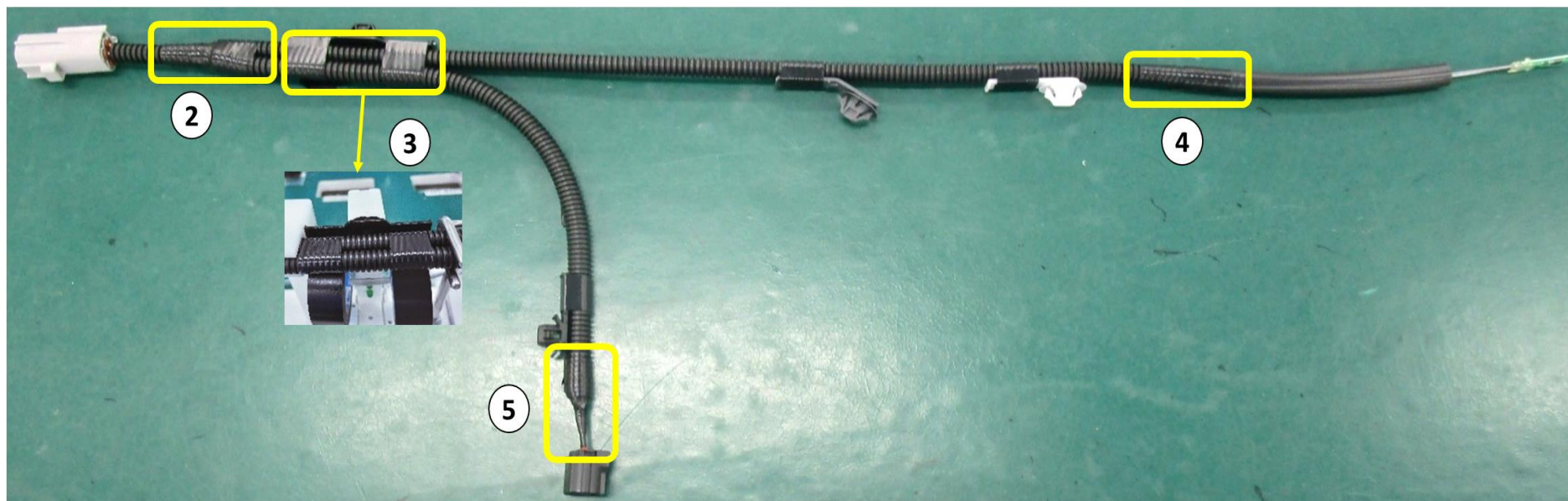
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7M0521-7021



① No Wrong facing of clamp

② ③ ④ ⑤ No Missing Tape and Spot tape (Black tape)

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