Table Lay-out  Clamp 82711-52090 (W) Clamp tray  Clamp 82711-48070 (GR) Clamp 12711-52090  Clamp 82711-48070 (GR) Clamp 12711-52090  Clamp 82711-48070 (GR) Clamp 12711-52090  Clamp 82711-52090  Clamp 82711-52090  Clamp 82711-52090  Cots, etc.)  Pocument references:  1. No missing parts/tools 2. No excess parts/tools 2. No excess parts/tools 2. No excess parts/tools 3. No excess parts/tools 4. No excess parts/tools 4. No excess parts/tools 5. On excess parts/tools 5. On excess parts/tools 6000  Alert level For any trouble, inform the Assembly Assistant 5. Supervisor or unle Leader for immediate corrective action.  82711-52090(W)  8				Effectivity Date:	June 11, 2024								
Parts: 1. All parts: Assy parts; Clamp 82711-52990 (W); Clamp 82711-48070 (GR); Black tape [3pcs.]  NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION  Table Lay-out  Clamp 82711-52990 (W)/ Clamp tray  Clamp 82711-52990 (W)/ Clamp t			Process Name/Title:		Validity Date:		n/a						
PARTS: 1. All parts: Assy parts; Clamp B2711-52090 (W); Clamp B2711-48070 (GR); Black tape (Spos.)  NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION  Table Lay-out  Clamp B2711-48070 (GR) Clamp tray  Table Lay-out  Table Lay-out  Table Lay-out  Assy parts  Clamp B2711-48070 (GR) Clamp tray  Document references:  I. No missing partshools  2. No excess partshools  Assy parts  CLAMP ILUSTRATION  Assembly Jig  CLAMP ILUSTRATION  COMP ILUSTRATION  STOLE  GOOD  ACTION  EQUIT S009(W)  1. No missing partshools  2. No excess partshools  2. No excess partshools  Assy parts  CLAMP ILUSTRATION  STOLE  STOLE  GOOD  ACTION  EQUIT S009(W)  1. No missing partshools  2. No excess partshools  2. No excess partshools  2. No excess partshools  Assy parts  CLAMP ILUSTRATION  STOLE  GOOD  ACTION  EQUIT S009(W)  1. No missing partshools  2. No excess partshools  2. No excess partshools  2. No excess partshools  3. No excess partshools  4. No missing partshools  2. No excess partshools  3. No excess partshools  4. No excess partshools  4. No excess partshools  5. Assy parts  CLAMP ILUSTRATION  Assy parts  CLAMP ILUSTRATION  STOLE  4. No excess partshools  4. No excess partshools  4. No excess partshools  5. Assy parts  CLAMP ILUSTRATION  CLAMP ILUSTRATION  Assy parts  C			Model code/Part number:	102D / 7L0121-7024	Customer: TRQSS	Car Model: TOYOTA-RAV4		Document No.:		WI-ENG-PDE-797			
Table Lay-out  Clamp 82711-52090 (Wy Clamp tray)  Clamp 82711-62070 (GR) Clamp tray  Assembly Process  Locking lig  Black tape/Tape holder  Table Lay-out  Table Lay-out  Safety Instruction Be sure to wear required personal protective personal drings on the varieties 5's.  1. No missing parts/tools 2. No excess parts/tools 2. No excess parts/tools 2. No excess parts/tools 2. No excess parts/tools 3. No excess part			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	RO	Revision No.:	0	Page No.:	1 of 6		
Table Lay-out  Clamp 82711-52090 (IW) Clamp tray  Clamp 82711-48070 (GR) Clamp 12711-52090 (IW) Clamp tray  Clamp 82711-48070 (GR) Clamp 82711-48070 (GR) Clamp 82711-48070 (GR) Clamp 82711-48070 (GR) Clamp 82711-52090  Locking jig  Black tape/Tape holder  Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)  L. Refer to Wi-ENG-PDE-424A Assembly Process  L. No missing parts/tools 2. No excess parts/tools (Rep it in your locker.  Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)  L. Refer to Wi-ENG-PDE-424A Assembly Process  L. No missing parts/tools 2. No excess parts/tools Supervisor or lune Leader for immediate corrective action.  Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)  L. Refer to Wi-ENG-PDE-424A Assembly Process  L. No missing parts/tools 2. No excess parts/tools CLAMP ILLUSTRATION  Supervisor or lune Leader for immediate corrective action.  Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)  L. Refer to Wi-ENG-PDE-424A Assembly Process  L. No missing parts/tools 2. No excess parts/tools 2. No excess parts/tools 3. No e	PARTS:	1. All pa	arts: Assy parts; Clamp 82711	-52090 (W); Clamp 82711-48070 (GR); Bla	ack tape [3pcs.]			JIG:	1. Clamp A	ssembly Jig			
CLAM P ASSY Table Lay-out  Assy parts  Clamp 82711-52090 (WY Clamp tray)  Clamp 82711-48070 (GR) Clamp tray  Clamp 82711-48070 (GR) Clamp tray  Clamp 82711-48070 (GR) Clamp tray  Document references:  1. Refer to WI-ENG-PDE-424A Assembly Process  1. No missing parts/tools 2. No excess parts/tools 2. No excess parts/tools 2. No excess parts/tools 2. No excess parts/tools 3. No excess parts/tools 4. No excess parts/tools 5. No excess parts/tools 6000  CLAMP ILLUSTRATION  Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.  82711-52090 (W)  82711-52	NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(	QUALITY POINTERS			
Revision nistory Prepared by Reviewed by Approved by	1	Р	Table Lay-out	Clamp  Assy parts  Locking jig	assembly jig	(GR)	9 82711-48070 / Clamp tray	Be sure to wear required 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 Leade for immediate corrective action.	Docume 1. Refer Assemble 1. No miss 2. No exce	to WI-ENG-PDE-4. by Process  sing parts/tools ess parts/tools  CLAMP ILLUSTRATI	711-12A80 (W)		
	1			Revision History		T T	<u> </u>	Prepared by	Reviewed by	Approved by	Noted by		
D6/11/24 0 Initial issue.  D. Castillo C. Villanueva A. Arañes n/a C. Villariueva Details of Change  D. Castillo C. Villanueva A. Arañes n/a C. Villariueva A. Arañes  Revised Reviewed Approved Noted Est. Date: June 11, 2024			ue.	Details of Change			<u> </u>	D. Castillo	•	A. Arades	n/a		

WORK INSTRUCTION Effectivity Date: June 11, 2024										
		Process Name/Title:		IP ASSEMBLY PRO	CESS	Validity Date:	n/a			
		Model code/Part number:	102D / 7L0121-7024		S Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-7	97	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	2 of 6	
PARTS:	1. Clan 2. Clan	np 82711-52090 (W) [2pcs.] np 82711-48070 (GR)		3. Black tape [3pcs.]		JIG:	1. Clamp a	assembly jig		
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(	TERS		
2	CLAM P ASSY	Clamp setting	82711-52090 (W)  1. Get 2pcs. of clamp 82711-hands then set to clamp local hands.  2. Get 1pc. of clamp 82711-hand then set to clamp location.	82711-48070 (GR)  82711-48070 (GR)  -52090 (W) using both ation 1 and 3 using both	82711-52090 (W)  82711-52090 (W)  3. Initially attach Black tape on clamand 3 using both hands.	SWITCH ASSEMBLY PLOTE TO 23 NBC 1	1. No wron 2. No dama 3. No miss 4. No wron 5. No miss Importa 1. Please	ag use of tape ing tape  ant reminders/N  check the Clamp fisembly to avoid wi	or cLAMP er tape  Vote/s: irst before rong use of	

			WORK IN	Effectivity Date:	June 11, 2024 n/a					
		Process Name/Title:	Validity Date:							
		Model code/Part number:	102D / 7L0121-7024	Customer: TRQS	S Car Model:	TOYOTA-RAV4	Document No.:		WI-ENG-PDE-7	97
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	0	Page No.:	3 of 6
PARTS:	1. Assy						JIG:	1. Locking Jig		
NO.	P	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	QUALITY POINTERS		
3	CLAM P ASSY	Connector Lock	Cou NG Unlock Condition  Before lock	pler Cross Sections NG Double Half Lock Condition	lock using b	dition		1. MANU. DAMAGE  1. Use the 2. No unlo	ent reminders/N AL LOCKING MAY ED CONNECTOR. provided locking ji ck/half-locked cont of locking process	g per model

WORK INSTRUCTION Effectivity Date:  Process Name/Title: CLAMP ASSEMBLY PROCESS Validity Date:									June 11, 2024			
		Process Name/Title:	n/a									
		Model code/Part number:	102D / 7L0121-7024	Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-79	97			
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	4 of 6			
1. Assy parts												
PARTS:	2. Blac					JIG:	1. Clamp a	ssembly jig				
NO.	ı	PROCESS NAME	WORK	( PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(	QUALITY POINT	ERS			
4	CLAM P ASSY	Clamp assembly	CONNECTOR SETTING  1. Get the assy parts and set into setting of harness). First, set the Receiver base 1 then lock. Contisensor light will beep/buzz if dete will beep/buzz if sensor detects O wires together within stopper jig t if sequence light in location 1 was  2. Check if all LED light for Power Sensor ON was On. If encounter immediately CALL the attention of instruction then continue the process if sequence light in class the process if sequence light in class the process if sequence light in class the sequence light in cl	jig. (See above picture for concernation of the leader. WAIT for further ess.  1. Make 3 windings of tape the SW button after taping. C	4. Hold the tape on clamp I windings of tape then cut hands. Press the SW butto Continue the process if sec location 3 was ON.  5. Hold the tape on clamp I windings of tape then cut hands. Press the SW butto Sound will be heard.	the tape using both on after taping. quence light in clamp docation 3. Make 3 the tape using both on after taping. Go	1. Make stopper of 2. Make taping  1. No wron 2. No wron 3. No dama	nt reminders/Nasure no gap betwand terminals. 2-3 windings for company of the second parts go use of tape aged clamp golamp position	een			

		Effectivity Date:	June 11, 2024					
		Process Name/Title:	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS	Validity Date:	n/a			
		Model code/Part number:	102D / 7L0121-7024 Customer: TRQSS Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-797			
		Purpose:	□ PROTOTYPE □ PRE-LAUNCH ■ MASSPRO	Revision No.:	0 Page No.: 5 of 6			
PARTS:	1. Assy	parts		JIG:	n/a			
NO.	F	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
5	CLAM P ASSY	Measurement	(5) 197 ±3 (6) 124 ±3 (7) 154 ±3 (8) 39 ±3	MEASURING TAPE  7 8 9 10 1 2 3 4 5 6 7 8 9 9 1	Important reminders and note/s:  1. Please use calibrated/verified measuritape when getting the measurement.  2. For Hatsumono, Nakamono and Owarimono.  Document reference/s:  1. Refer to WI-PRO-ASY-056 for Subassembly Hatsumono Nakamono Owarimono Inspection  1. No wrong dimension			

			WORK INSTR	RUCTION			Effectivity Date:		June 11, 2024	4	
	Process Nam	Process Name/Title: CLAMP ASSEMBLY PROCESS							n/a		
	Model code/F	Part number: 102D / 7L	_0121-7024 Customer: TRQSS Car Model			TOYOTA-RAV4	Document No.:	WI-ENG-PDE-797			
	Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPI	RO	Revision No.:	0	Page No.:	6 of 6	
	·										
PARTS: 1.	. Assy parts						JIG:	n/a			
<b>'</b>			VISUA	AL INSPECTION	N/ QUALITY CHE	CKPOINTS					
CLA!			7L(	012	1-7	024					
Co	2 1 0 Unlock/Honnector	(3	(COT to wi	ire near co		4	(82711-52090)	(W)	5 No De Termi	5 eformed	
	Wrong In acking Out	sert/ Terminal		7	ibe near ter vire near tei	minal (Y)) rminal (OR))	(82711-48070)	(GR)			