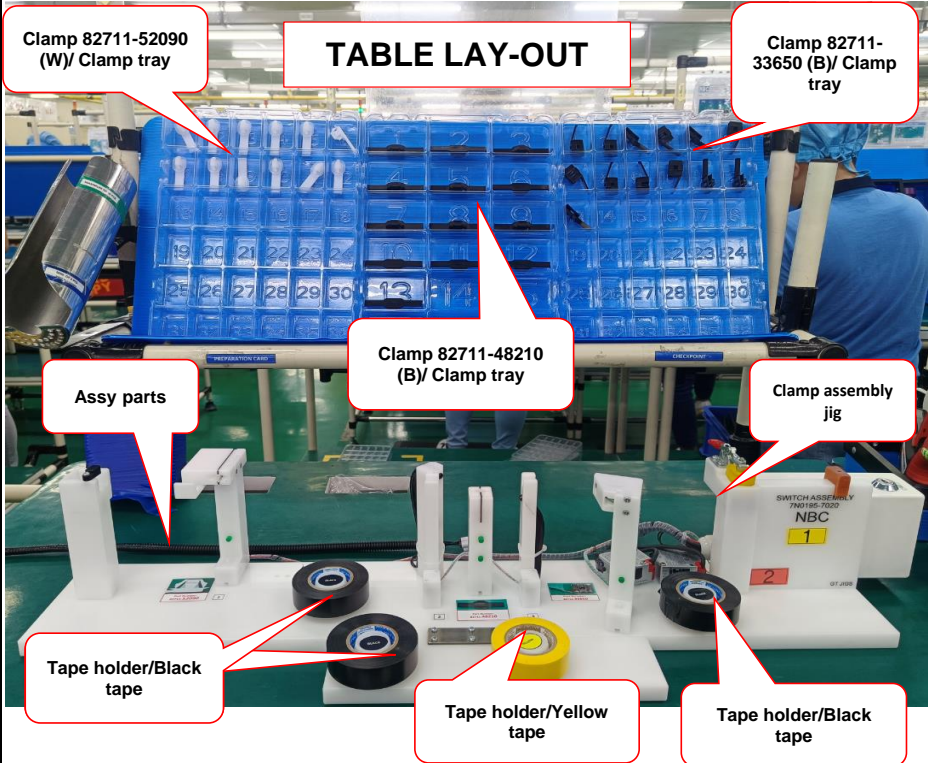
	WORK INSTRUCTION				Effectivity Date:	June 27, 2024	
	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a	
	Process Name/Title:		Model code/Part number: 310D / 7N0195-7020Ea		Customer: TRJ	Car Model: TOYOTA-RAV4	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-941		Revision No.: 0		Page No.: 1 of 5

PARTS:		1. Assy parts; Clamp 82711-33650 (B); Clamp 82711-52090 (W); Clamp 82711-48210 (B); Black tape [3pcs]; Yellow 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>	1. No missing part/tools. 2. No excess parts/tools

Revision History				Prepared by	Reviewed by	Approved by	Noted by
6/27/24	0	Initial issue. Excluded process from WI-ENG-PDE-919 to WI-ENG-PDE-941 ; Change Process name/Title from TAPING ASSEMBLY PROCESS to CLAMP ASSEMBLY PROCESS due to split process. Additional Table lay-out; Improve work procedure/illustration and Visual Inspection/Quality Checkpoints.		M. Ariola	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted
				Est. Date:	June 27, 2024		

**WORK INSTRUCTION**Process Name/Title: **CLAMP ASSEMBLY PROCESS**

Effectivity Date:

June 27, 2024

Validity Date:

n/aModel code/Part number: **310D / 7N0195-7020Ea** Customer: **TRJ** Car Model: **TOYOTA-RAV4**

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PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B) 3. Clamp 82711-52090 (W) 4. Black tape [3pcs] 5. Yellow tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy Clamp setting	<div></div> <div><div><div>1. Get 1pc of clamp 82711-52090 (W) using right hand then set to Clamp location no. 1 using both hands.</div><div>2. Get 1pc of clamp 82711-48210 (B) using right hand then set to Clamp location no. 2 and 3 using both hands.</div><div>3. Get 1pc of clamp 82711-33650 (B) using right hand then set to Clamp location no. 4 using both hands.</div><div>4. Initially attach YELLOW TAPE to location 3 using both hands.</div><div>5. Initially attach BLACK TAPE to location 1, 2, and 4 using both hands.</div></div></div> <td></td> <td>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</td>			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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DCC Stamp



WORK INSTRUCTION

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CLAMP ASSEMBLY PROCESS

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/

7N0195-7020Ea

Customer: TRJ

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TOYOTA-RAV4

Document No.:

WI-ENG-PDE-941

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

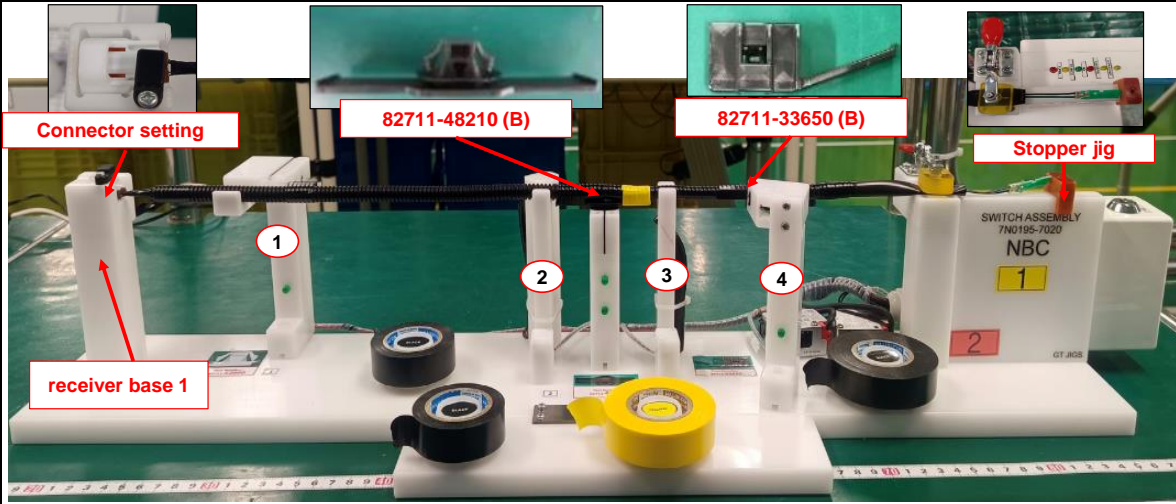
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [3pcs] 3. Yellow tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy Clamp assembly	<div></div> <div>1. Get the assy parts using right hand then set into jig using both hands. <i>(See above picture for the correct setting)</i>. First put the connector 6189-0451 (W) into receiver base 1. Continue setting the harness in jig. Last, set the hotmelted wires (B/W-G) within the stopper jig then press by the toggle clamp.</div> <div>2. Hold the tape on the clamp location no. 1 using right hand. Make 3 windings of tape using both hands then cut the tape. Proceed to clamp location 2.</div> <div>3. Hold the tape on the clamp location no. 2 using right hand. Make 3 windings of tape using both hands then cut the tape. Proceed to clamp location 3.</div> <div>4. Hold the tape on the clamp location no. 3 using right hand. Make 3 windings of tape using both hands then cut the tape. Proceed to clamp location 4.</div> <div>5. Hold the tape on the clamp location no. 4 using right hand. Make 3 windings of tape using both hands then cut the tape.</div> <div>6. After taping, conduct POINT CHECKING before removing the harness from jig</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>

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WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D

/

7N0195-7020Ea

Customer:

TRJ

Car Model:

TOYOTA-RAV4

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

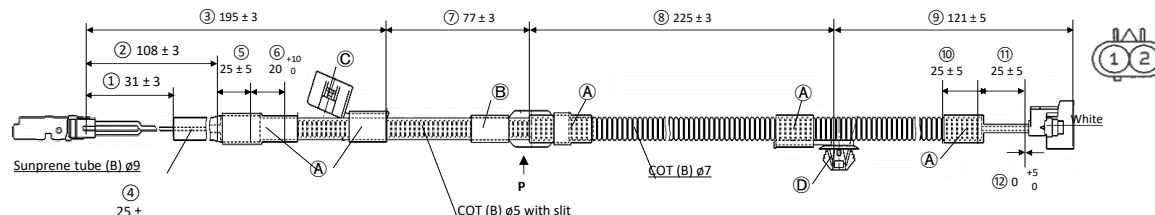
TOOLS/PPE

QUALITY POINTERS

4

Clamp
assy

Measurement



NOTE:

- (A) - Taping (B)
- (B) - Taping (Y)
- (C) - Clamp (B)
- (D) - Clamp (W)
- (4) - dimension of overlapped Sunprene and COT

WIRE TYPE TABLE

No.	Color	Wire Type
1	G	TVSS 0.3 f
2	BW	TVSS 0.3 f

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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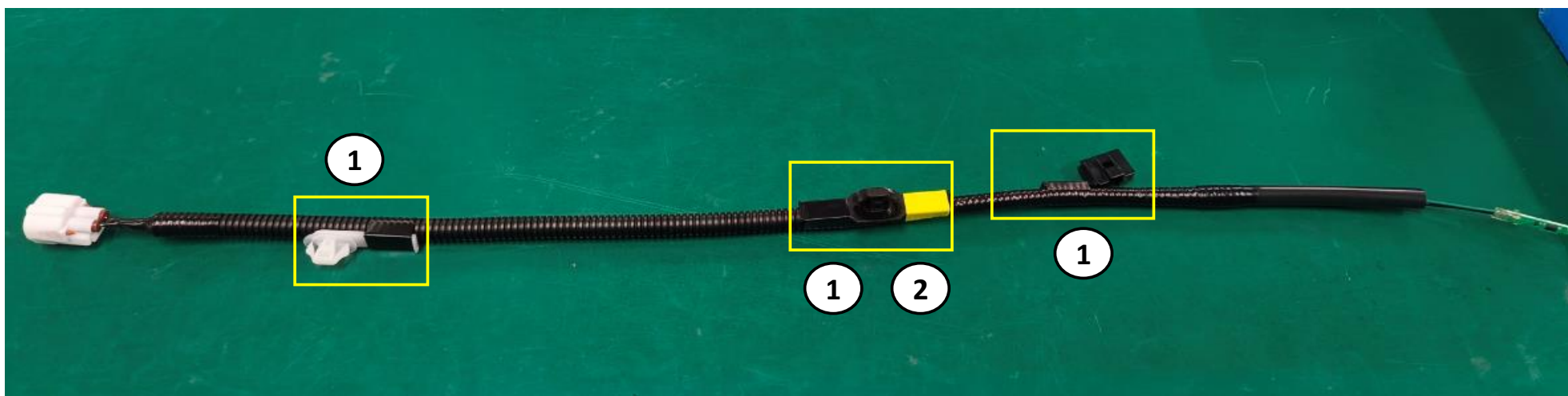
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**CLAMP
ASSY****7N0195-7020Ea****1 No MISSING TAPE (B)****2 No MISSING TAPE (Y)****3 Check the alignment of clamp**

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