



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

373D / 7N0174-7020B

Customer: TRJ

Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 21, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-936

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts: White tape with Slit (10mm)

JIG:

1. Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

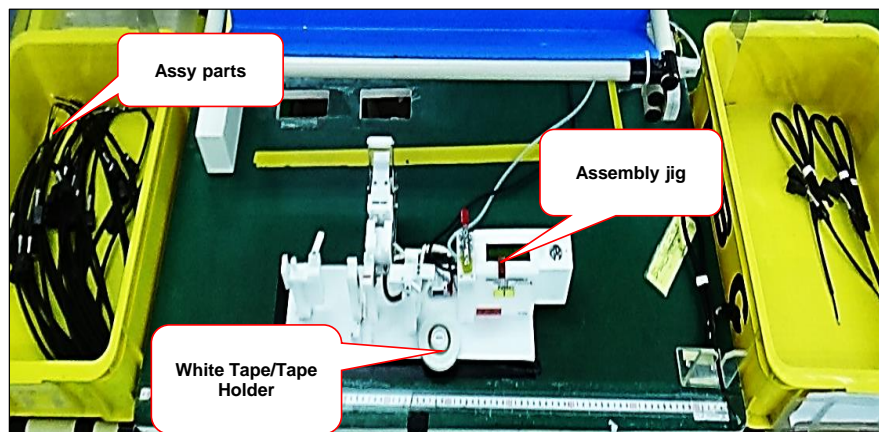
QUALITY POINTERS

1

Spot
taping

Table Lay-out

Table Lay-out

**Safety Instruction**

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 Leader for immediate corrective action.

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

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|-------------------|--------------|---------------|-----------|-------|--------------|---------------|-------------|----------|
| 06/21/24 | 0 | Initial issue | A. Hernandez | C. Villanueva | A. Arañes | n/a | A. Hernandez | C. Villanueva | A. Arañes | n/a |

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DCC Stamp



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PARTS:

1. Assy parts
2. White tape (10mm with Slit)

JIG:

1. Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

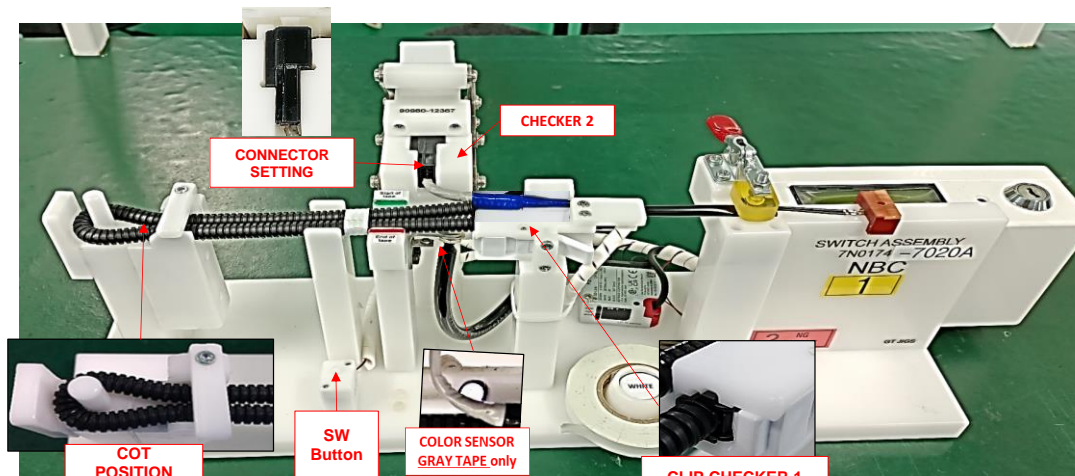
TOOLS/PPE

QUALITY POINTERS

3

Spot
taping

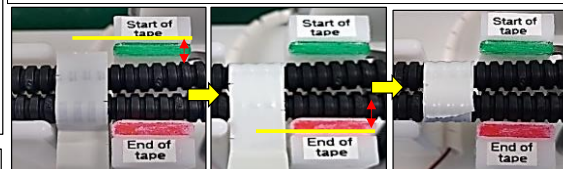
Assembly
(Spot taping)



1. Get the assy part and then put into jig. (See above illustration). First, set the connector 6098-6663 (B) to Clip Checker 1 then lock. Second, set the connector 6098-6663 (B) to Checker 2 then pull the checker fixture for continuity checking. Next, set the B-B wires together within the stopper jig and then press by toggle clamp. Color sensor light will be/buzz if sensor detects Gray tape. Last set the Y-taping in hook.

2. Check if all LED light for POWER ON, COLOR SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.

3. Get the WHITE NITTO TAPE 2107TVH (with slit) and begin taping using both hands. Make 1.5 windings of tape then cut using both hands. (Follow below instructions for taping procedure)



4. Start of tape must be within the GREEN MARK. Wind the tape 1.5 windings using both hands then cut within RED MARK.



Important reminders/Note/s:

1. Make sure no gap between stopper and terminals

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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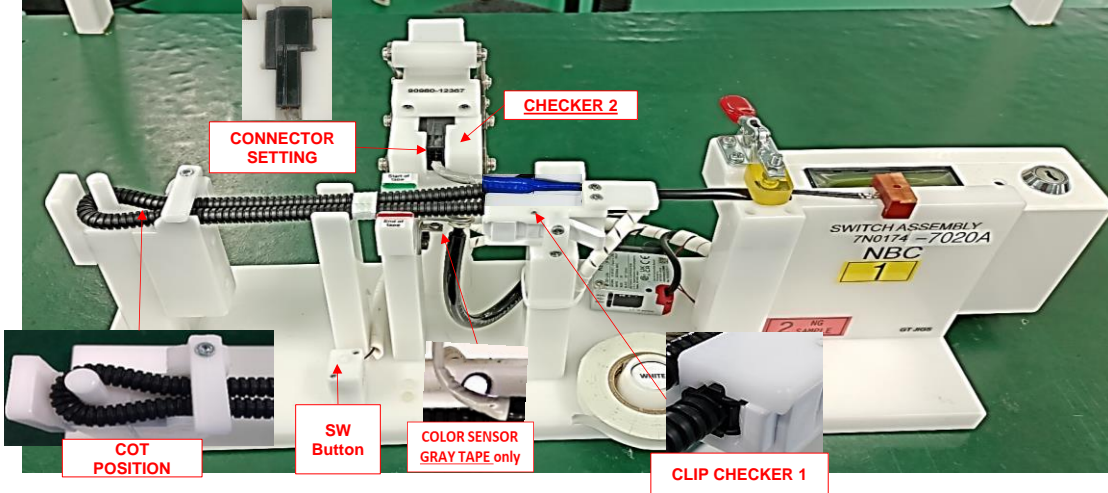
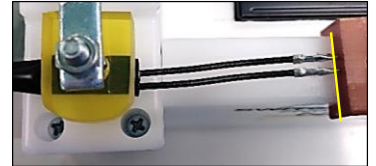

☒ MASSPRO

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| PARTS: | | 1. Assy parts | | JIG: | 1. Assembly jig |
|--------|---------------------------------------|--|--|-----------|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Spot taping Assembly (Spot taping) |  <p>5. Press the SW button, Go sound will be heard if the result is GOOD.</p> <p>6. Conduct POINT CHECKING before removing the harness from jig. First, unlock the COT then remove the assy. Second, remove the toggle clamp. Third, push the Checker fixture then remove the connector 6098-3870 (B). Last, press the clip then remove the connector 6098-6663 (B).</p> | | | <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals</p>  <p>REFERENCE AFTER TAPING USING NITTO TAPE 2107TVH</p>  |

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|--------|--------------|------------------------------|--|-----------|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | Spot taping | Measurement | | | <p>1. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. FOR HATSUMONO AND OWARIMONO</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>MEASURING TAPE</p> |

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

CLAMP ASSY

7N0174-7020B

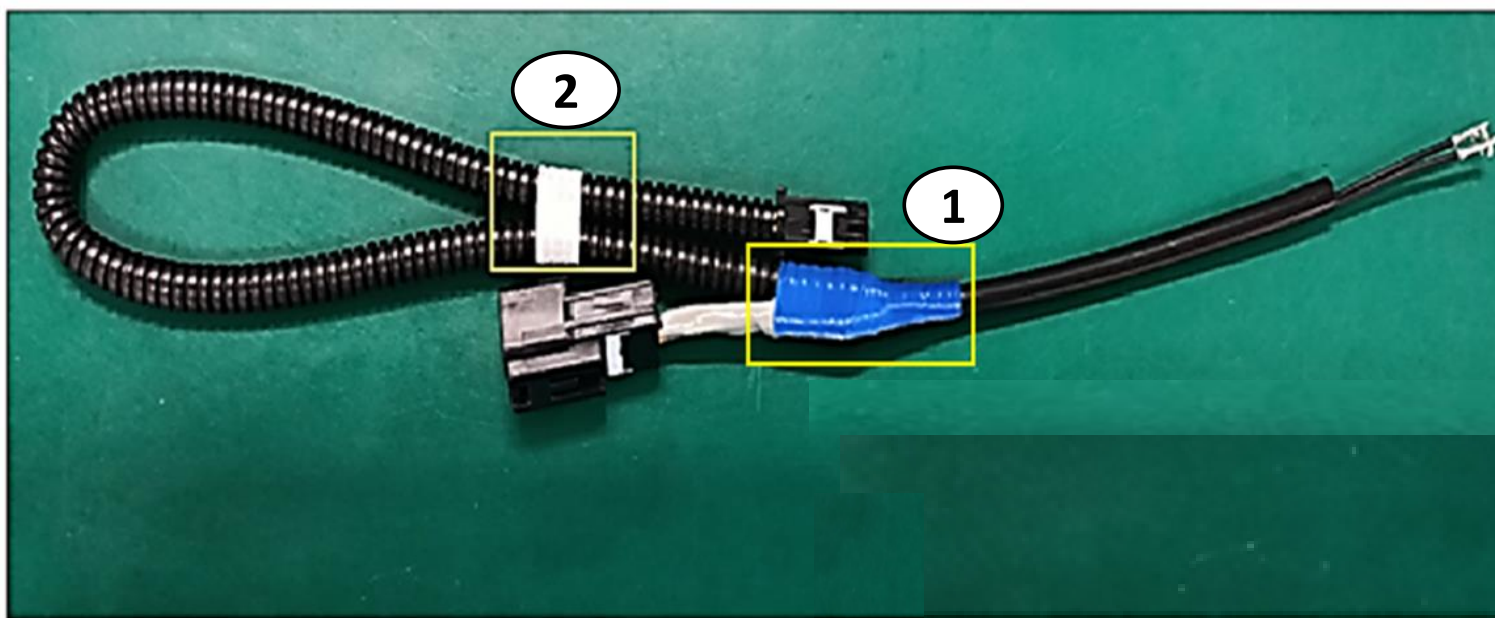
REFERENCE AFTER TAPING USING NITTO
TAPE 2107TVH



GOOD: 1.5 windings



NG: 1 winding



1 No Missing Y-Taping (BLUE Tape)

2 No Missing Spot tape (BLUE Tape)

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