
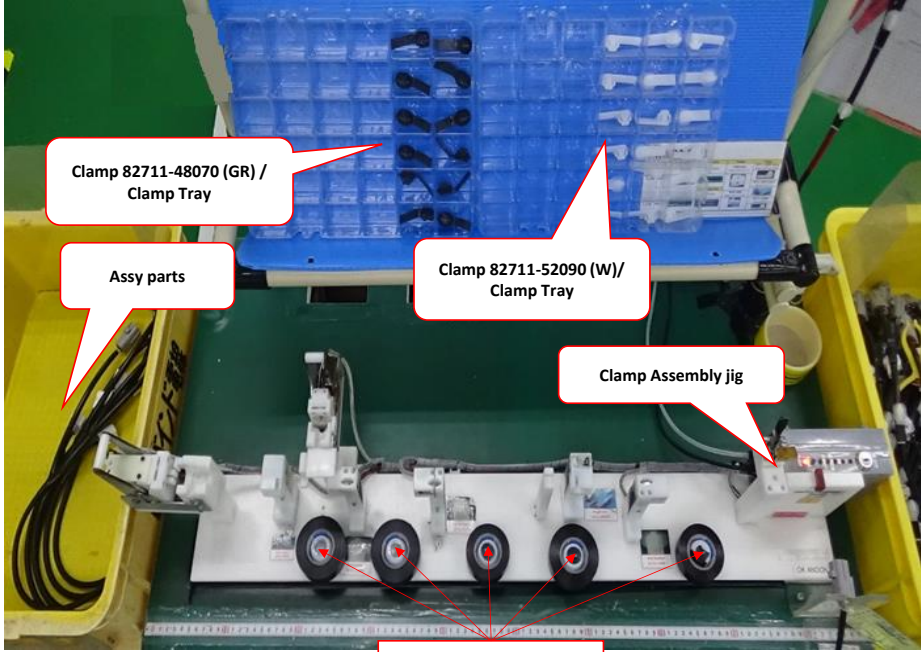


|   |   |  |                      |                                |                   |                        |           |        |
|---|---|--|----------------------|--------------------------------|-------------------|------------------------|-----------|--------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                                | Effectivity Date: | <b>August 08, 2024</b> |           |        |
|   | Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>   |  |                      |                                | Validity Date:    | n/a                    |           |        |
|   | Model code/Part number: <b>310B / 7M0522-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>TOYOTA-RAV 4</b> | Document No.:     | <b>WI-ENG-PDE-1000</b> |           |        |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                                | Revision No.:     | 0                      | Page No.: | 1 of 5 |

|               |   |  |  |   |  |
|---------------|---|--|--|---|--|
| <b>PARTS:</b> | 1. Assy parts; Clamp 82711-48070 (GR) ; Clamp 82711-52090 (W); Black Tape |  |  | JIG:  | 1. Clamp assembly jig  |
| <b>NO.</b>    | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>  |  | <b>TOOLS/PPE</b>  | <b>QUALITY POINTERS</b>  |
| 1             | CLAMP ASSY  | <p style="text-align: center;">Table Lay-out</p>  |  | <p><b>Safety Instruction</b><br/>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b><br/>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b><br/>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> | <p><b>Document reference/s:</b><br/>1. Refer to <b>WI-ENG-PDE-403A-B</b> for Taping assembly process</p> <p>1. No missing parts/tools<br/>2. No excess parts/tools</p> |

|                  |         |  |  |             |                |             |          |
|------------------|---------|--|--|-------------|----------------|-------------|----------|
| Revision History |         |  |  | Prepared by | Reviewed by    | Approved by | Noted by |
|                  |         |  |  |             |                |             |          |
| 08/08/24         | 0       | Initial issue. Separate clamp assy from Taping assembly process. |  | D.Castillo  | C.Villanueva   | A. Arañes   | N/A      |
| Eff. Date        | Rev. No | Details of Change  |  | Revised     | Reviewed       | Approved    | Noted    |
|                  |         |  |  | Est. Date:  | August 8, 2024 |             |          |

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Effectivity Date:

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|--------|--------------|--|--|----------------------|--|-----------|--|
| PARTS: |              | 1. Clamp 82711-48070<br>2. Clamp 82711-52090 |  | 3. Black tape [5pcs] |  | JIG:      | 1. Clamp assembly jig  |
| NO.    | PROCESS NAME |  | WORK PROCEDURE/ ILLUSTRATION   |                      |  | TOOLS/PPE | QUALITY POINTERS   |
| 2      | CLAMP ASSY   | Clamp setting                                | <div><div></div><div>82711-48070 (GR)</div><div></div><div>82711-52090 (W)</div><div></div><div>82711-48070 (GR)</div><div></div><div>82711-52090 (W)</div></div> <div></div> <div>Sequence light</div> <div>1. Get 2pcs. of clamp 82711-48070 (GR) using right hand then set to location 1 &amp; 4 using both hands.</div> <div>2. Get 3pcs. of clamp 82711-52090 (W) using right hand then set to location 2, 3 &amp; 5 using both hands.</div> <div>3. Get Black tape using right hand and conduct pre-taping from location 1,2,3,4,5 using both hands.</div> |                      |  | n/a       | <div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under clamp</div> <div></div> <div>1. No loose tape<br/>2. No flip-out tape<br/>3. No peel-off tape<br/>4. No wrong use of tape<br/>5. No wrong use of clamp<br/>6. No missing clamp</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>Important reminders/Note/s:<br/>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> |

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DCC Stamp

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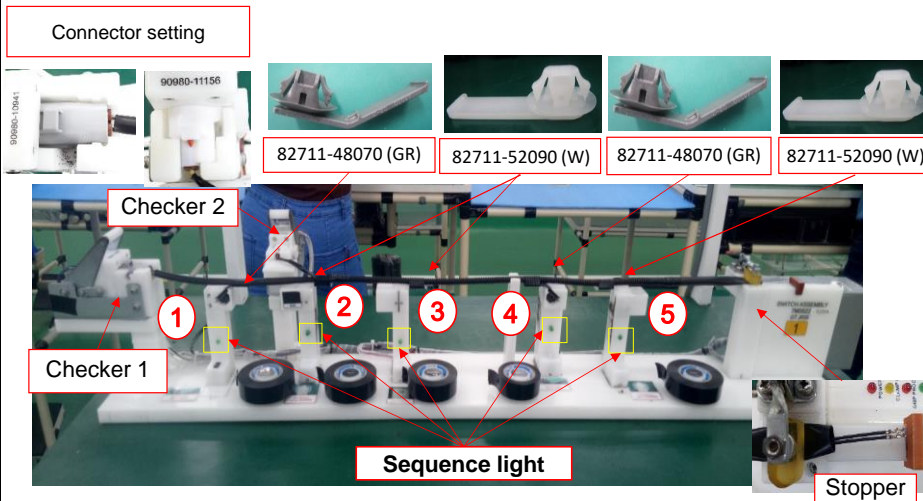

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|               |                     |   |  |                  |  |
|---------------|---------------------|---|--|------------------|--|
| <b>PARTS:</b> | 1. Assy parts       |   |  | JIG:             | 1. Clamp assembly jig  |
| <b>NO.</b>    | <b>PROCESS NAME</b> | <b>WORK PROCEDURE/ ILLUSTRATION</b>   |  | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |
| 3             | CLAMP ASSY          | <div>Connector setting</div> <div></div> <div>1. Get the assy parts and set to jig using both hands. First, put the Gray connector to <b>Checker 1</b> then pull the checker fixture. Second, put the White connector to <b>Checker 2</b> then pull the checker fixture. Last, set the terminal to stopper jig then pull down the toggle clamp. <b>Refer to the above illustration for the correct setting.</b></div> <div>2. Check if all LED light for <b>POWER ON</b>, <b>WIRE1</b> and <b>WIRE2</b> and <b>CLAMP ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction then continue the process. Continue if the sequence light of <b>Location 1</b> is <b>ON</b>.</div> <div>3. Start the taping process (3 windings) on clamp <b>location 1</b> using both hands. Press the switch button after taping. Sequence light will <b>ON</b> to the next process.</div> <div>4. Continue the taping process until you finished the <b>location 2,3,4 &amp; 5</b>. Press the SW button after taping. Go sound will be heard.</div> <div>5. Conduct <b>Point Checking</b> using right hand and slowly remove the harness from jig.</div> |  | n/a              | <div></div> <div><b>Important reminders/Note/s:</b><br/>1. Must be no gap between terminal and stopper jig.<br/>2. Make 2-3 windings for clamp taping</div> <div>1. No loose attachment of clamp<br/>2. No damage clamp<br/>3. No missed tape<br/>4. No missing parts<br/>5. No wrong use of tape</div> |

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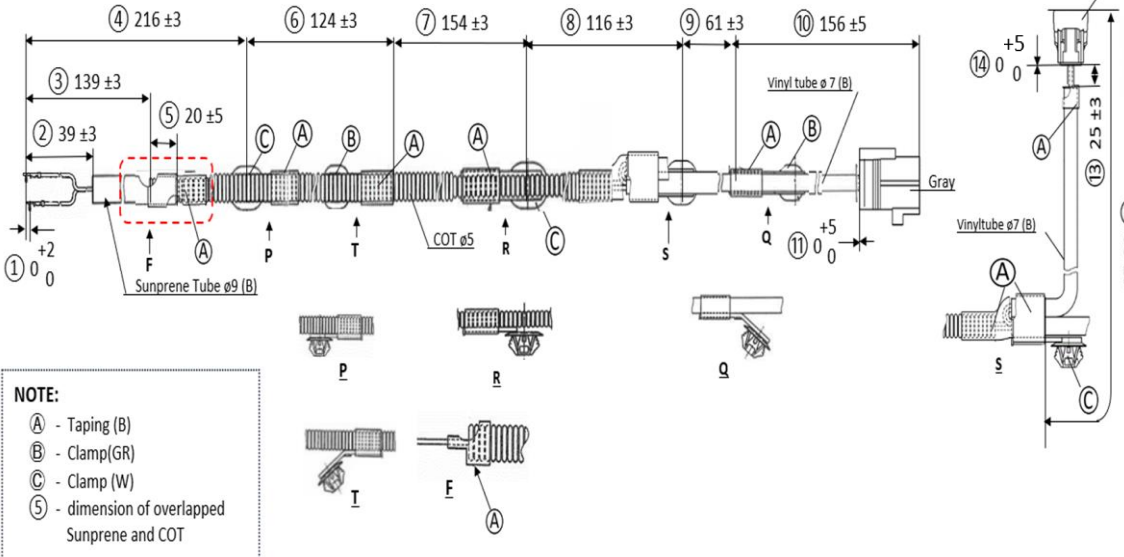

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|        |              |   |  |  |  |
|--------|--------------|---|--|--|--|
| PARTS: |              | 1. Assy parts   |  | JIG:   | n/a  |
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE  | QUALITY POINTERS   |
| 4      | CLAMP ASSY   | <div>Measurement</div> <div><p><b>NOTE:</b><br/>A - Taping (B)<br/>B - Clamp (GR)<br/>C - Clamp (W)<br/>⑤ - dimension of overlapped Sunprene and COT</p></div> |  | <div>MEASURING TAPE</div> <div></div> | <div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div> |

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# WORK INSTRUCTION

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## CLAMP ASSEMBLY PROCESS

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n/a

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PARTS:

1. Assy part

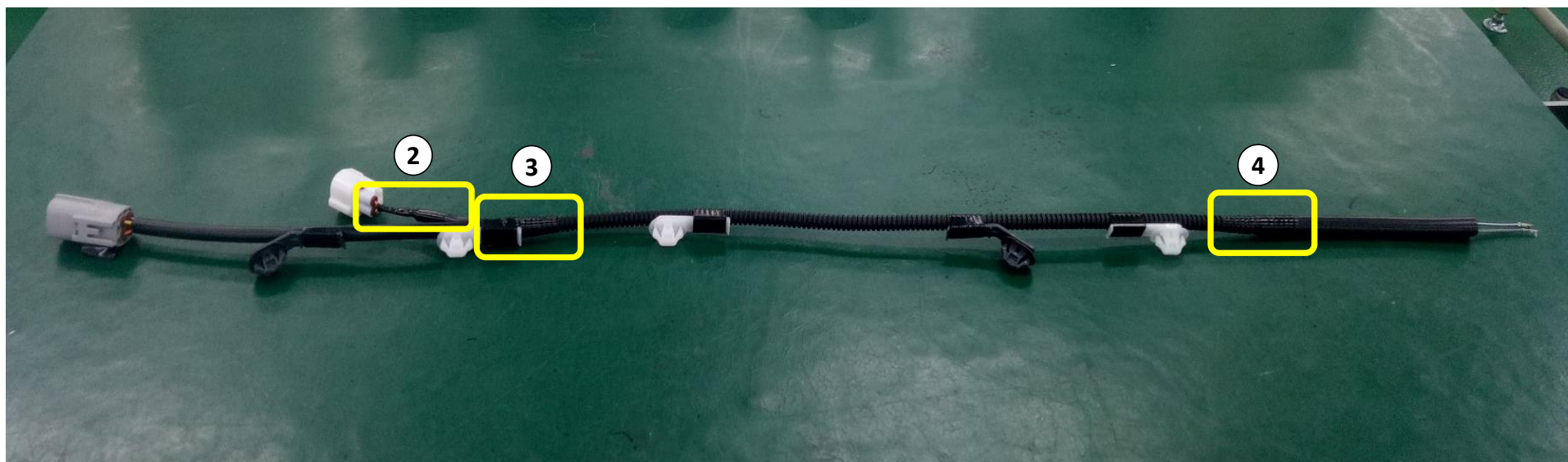
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7M0522-7021



① No Wrong facing of clamp

② ③ ④ No Missing Tape (Black tape)

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