



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310B / 7M0557-7021B

Customer: TRJ

Car Model: TOYOTA RAV4

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1133B

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts: Clamp 82711-52090 (W); Black tape [2pcs.]; Light Green tape

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

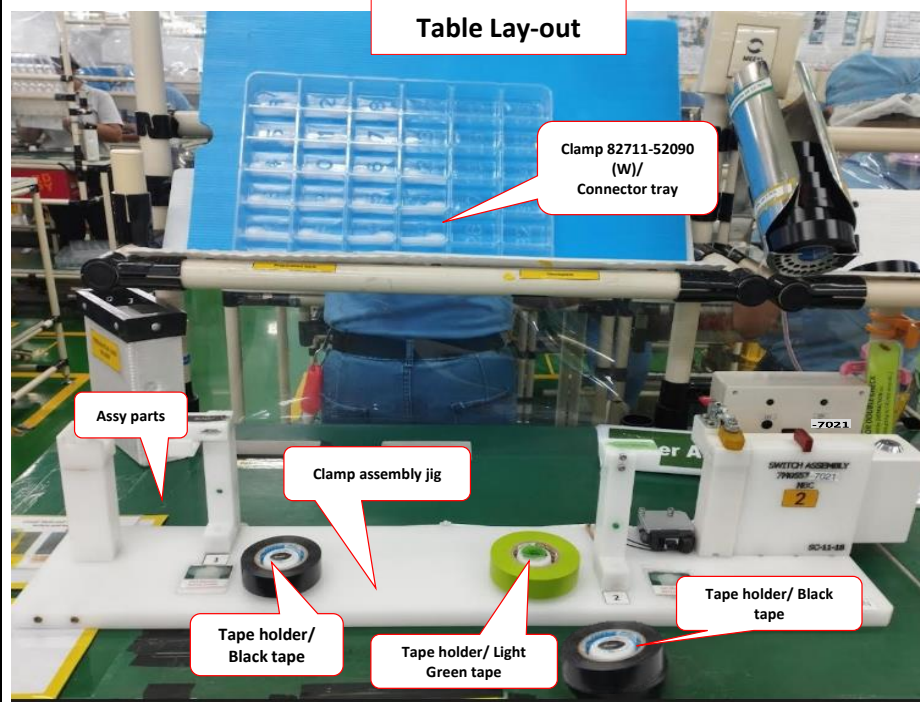
TOOLS/PPE

QUALITY POINTERS

1

P2

Table Lay-out



Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

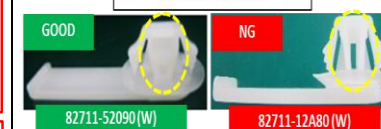
Housekeeping

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.

CLAMP ILLUSTRATION



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
10/22/24	0	Change Pre-launch to mass pro.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
10/17/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a

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PARTS:		1. Clamp 82711-52090 (W) [2pcs.] 2. Black tape 3. Light Green tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp Setting	<div></div> <div>1. Get 2pcs of clamp 82711-52090 (W) using right hand and insert to clamp location 1 and 2 using both hands.</div> <div>2. Get BLACK TAPE using right hand and conduct pre-taping on clamp location 1 using both hands.</div> <div>3. Get LIGHT GREEN TAPE using right hand and conduct pre-taping on clamp location 2 using both hands.</div>			<div>Important reminders/Note/s:</div> <div>1. Please check the clamp before start assembly to avoid wrong use of clamp.</div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div><div>STANDARD TAPING FOR CLAMP</div><div>One wind tape under tape</div><div></div></div>

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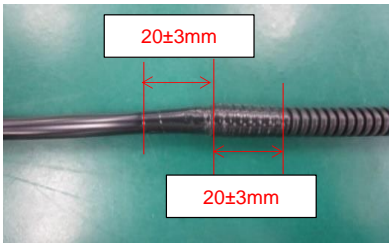

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 COT to Vinyl tube	<div>NO GAP between COT and Vinyl</div> <div></div> <div>1. Hold the corrugated tube using left hand then start taping process using both hands.</div> <div></div> <div>2. After taping, check the taping condition.</div>		MEASURING TAPE 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Make sure no gap between COT and vinyl tube. 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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PARTS:

1. Assy parts
2. Black tape
3. Light Green tape

JIG:

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

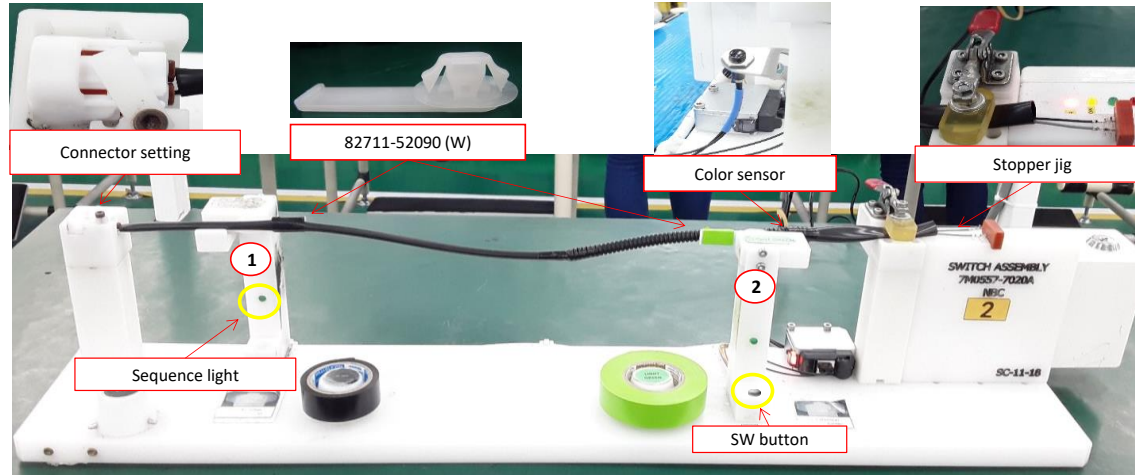
TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly



1. Get the assy parts and set to jig using both hands. First, put the connector 6189-0451 (W) into connector receiver base and lock. Second, put the terminal into stopper jig and pull down the toggle clamp.
Refer to above illustration for the correct setting.

2. Check if LED light for **POWER**, **CLAMP** and **SEQUENCE** light was **ON**. If encountered abnormality **STOP** the process, **CALL** the attention of the leaders and **WAIT** for instructions.

3. Hold the clamp on **location 1** and begin taping using right hand. Make **3 windings of tape** and cut the tape. Press the SW button after taping. Continue to clamp location **2**.
TAPE COLOR MUST BE BLACK.

4. Hold the clamp on **location 2** and begin taping using right hand. Make **3 windings of tape** and cut the tape. Press the SW button after taping.
Go sound will be heard.
TAPE COLOR MUST BE LIGHT GREEN.

5. Conduct **POINT CHECKING** before removing from jig.

Important reminders/Note/s:

1. Make sure no gap between terminal and stopper jig

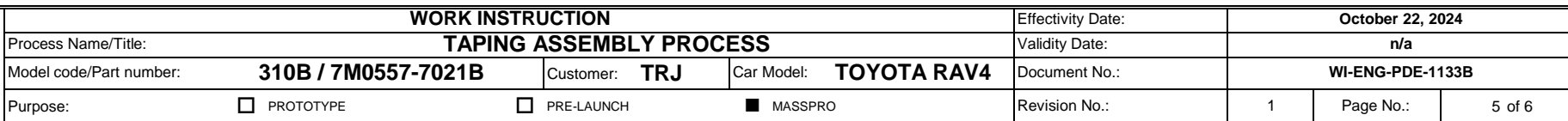


1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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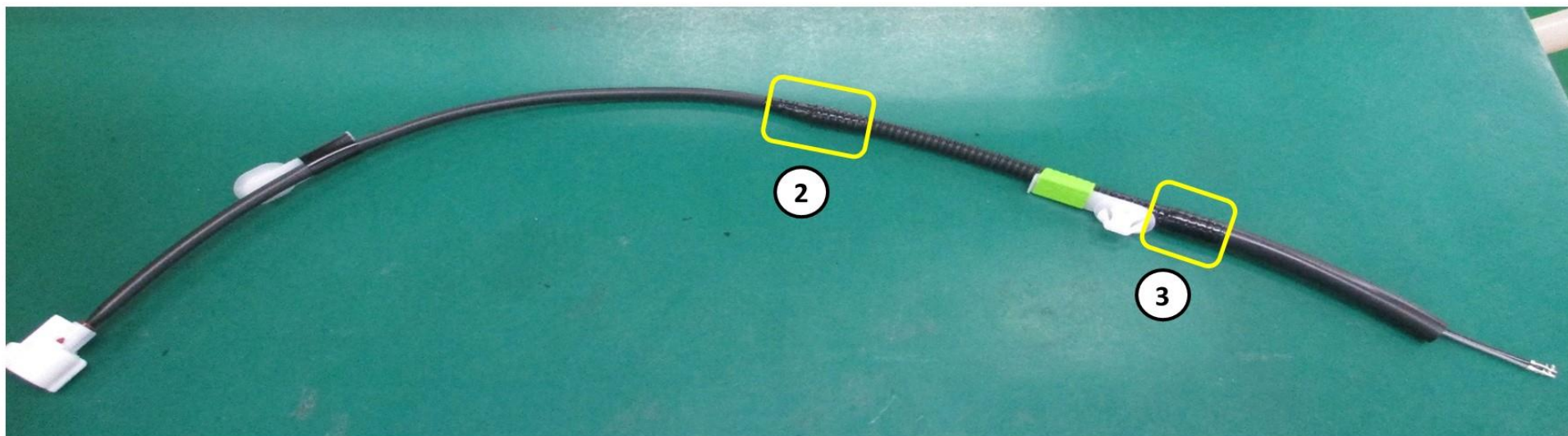
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7M0557-7021B****① No Wrong Facing of Clamp****② ③ No Missing Tape (Black Tape)**

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