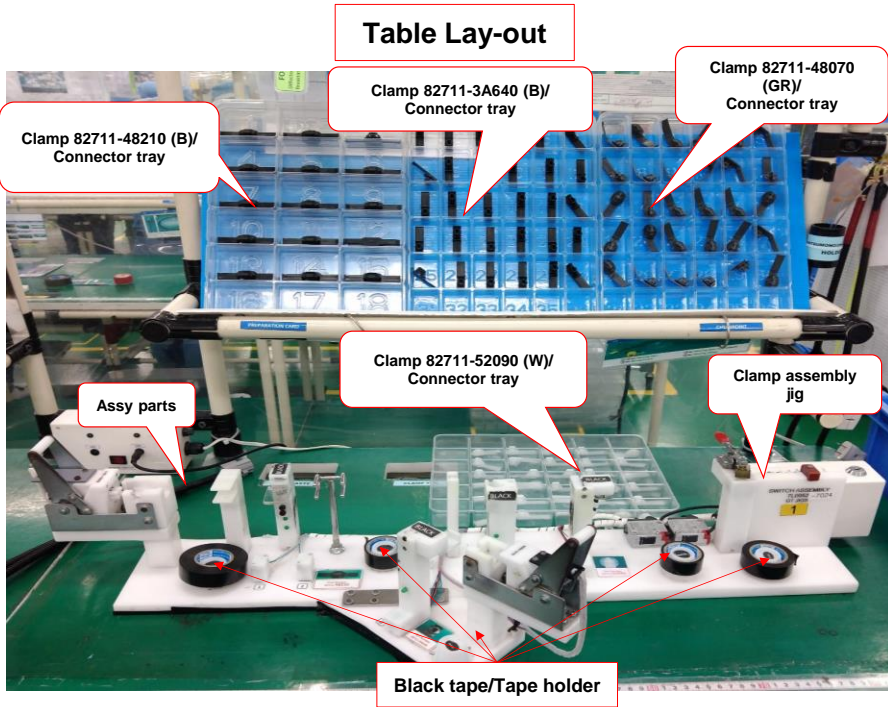

	WORK INSTRUCTION				Effectivity Date:		July 10, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0052-7024		Customer: TRQSS		Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-939	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 0	
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PARTS:		1. Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-48070 (GR); Clamp 82711-52090 (W); Black tape [5pcs.]				JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	<div style="text-align: center;">  </div>				<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		<div> Document reference/s: 1. Refer to WI-ENG-PDE-409A-B for Taping assembly process </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div> <div style="text-align: center;">  </div>	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
07/10/24	0	Initial issue. Separate clamp assy from Taping assembly process.				D.Castillo	C. Villanueva	A. Arañes	n/a		n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		July 10, 2024	

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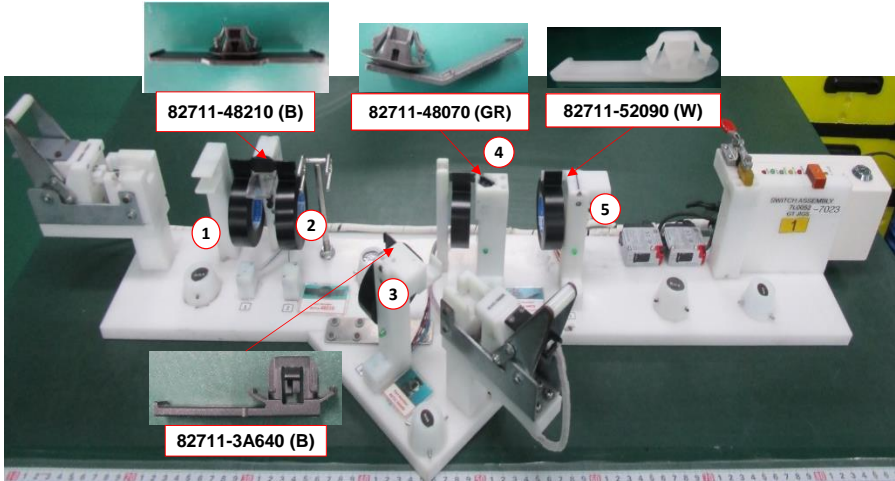



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PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-48070 (GR) 3. Clamp 82711-3A640 (B) 4. Clamp 82711-52090 (W) 5. Black tape [5pcs.]		JIG:	1.Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp setting	<div></div> <div>1. Get 1 pc. of clamp 82711-48210 (B) using right hand then insert to clamp location 1 and 2 using both hands.</div> <div>2. Get 1 pc. of clamp 82711-3A640 (B) using right hand then insert to clamp location 3 using both hands.</div> <div>3. Get 1 pc. of clamp 82711-48070 (GR) using right hand then insert to clamp location 4 using both hands.</div> <div>4. Get 1 pc of clamp 82711-52090 (W) using right hand then insert to clamp location 5 using both hands.</div> <div>5. Get the Black tape then initially attach to clamp location 1, 2, 3, 4 and 5 using both hands.</div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</div> <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>

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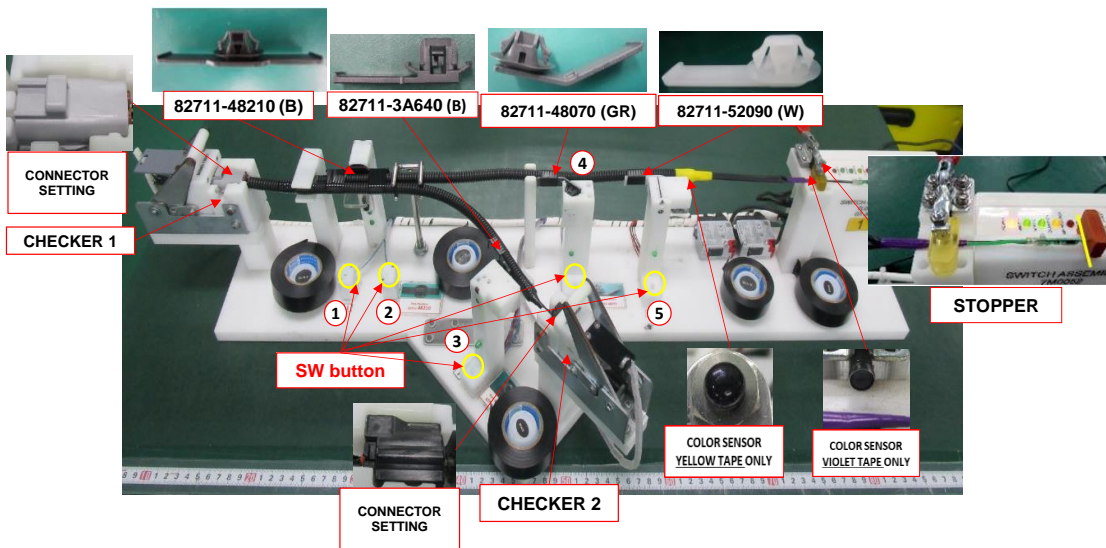


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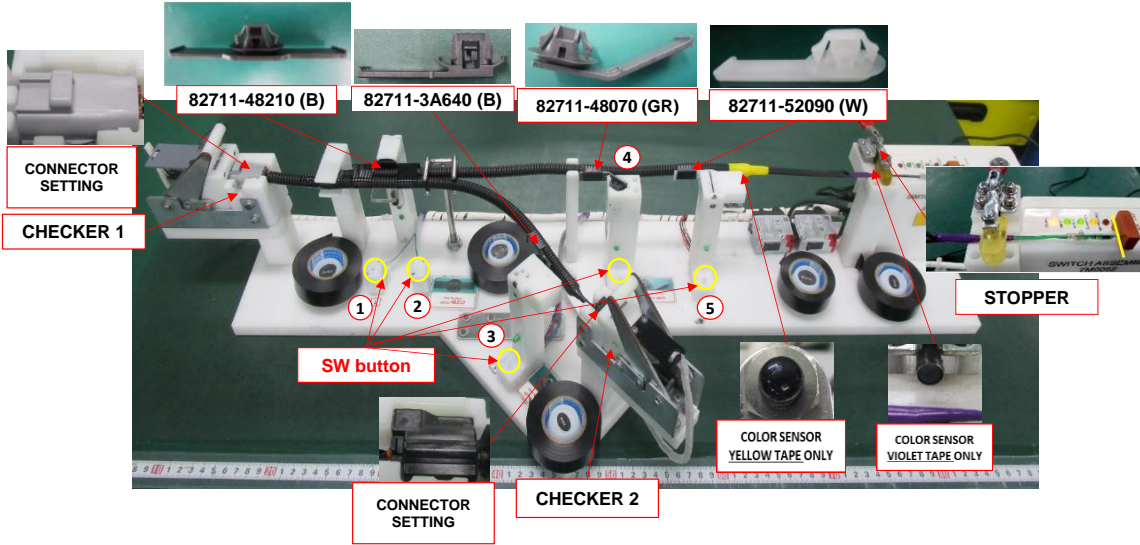
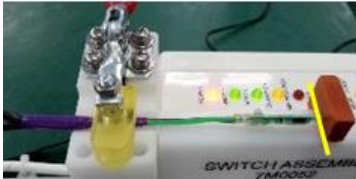
PARTS:		1. Assy parts 2. Black tape		JIG:	1.Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly		<div><p>CONNECTOR SETTING</p><p>CHECKER 1</p><p>82711-48210 (B)</p><p>82711-3A640 (B)</p><p>82711-48070 (GR)</p><p>82711-52090 (W)</p><p>1</p><p>2</p><p>3</p><p>4</p><p>5</p><p>SW button</p><p>COLOR SENSOR YELLOW TAPE ONLY</p><p>COLOR SENSOR VIOLET TAPE ONLY</p><p>CONNECTOR SETTING</p><p>CHECKER 2</p><p>STOPPER</p></div> <div><p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-1161 (B) to Checker 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the PCB within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</p><p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 2 was ON.</p></div>	<div><p>STOPPER</p><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper and terminals</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No wrong use of parts</p><p>2. No wrong use of tape</p><p>3. No damaged clamp</p><p>4. No wrong clamp position</p></div> <div><p>CLAMP ILLUSTRATION</p></div>

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	Model code/Part number: 320B / 7L0052-7024		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-939		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 6

PARTS:	1. Assy parts 2. Black tape			JIG:	1.Clamp Assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	CLAMP ASSY	<div></div> <div><div>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 3 was ON.</div><div>5. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 4 was ON.</div><div>6. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light on clamp location 5 was ON.</div><div>7. Hold the tape on clamp location 5, make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.</div><div>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div></div>				<div>STOPPER</div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals 2. Make 2-3 windings for clamp taping</div> <div><div>1. No wrong use of parts</div><div>2. No wrong use of tape</div><div>3. No damaged clamp</div><div>4. No wrong clamp position</div></div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD 82711-52090 (W)</div><div>NG 82711-12A80 (W)</div></div></div>	

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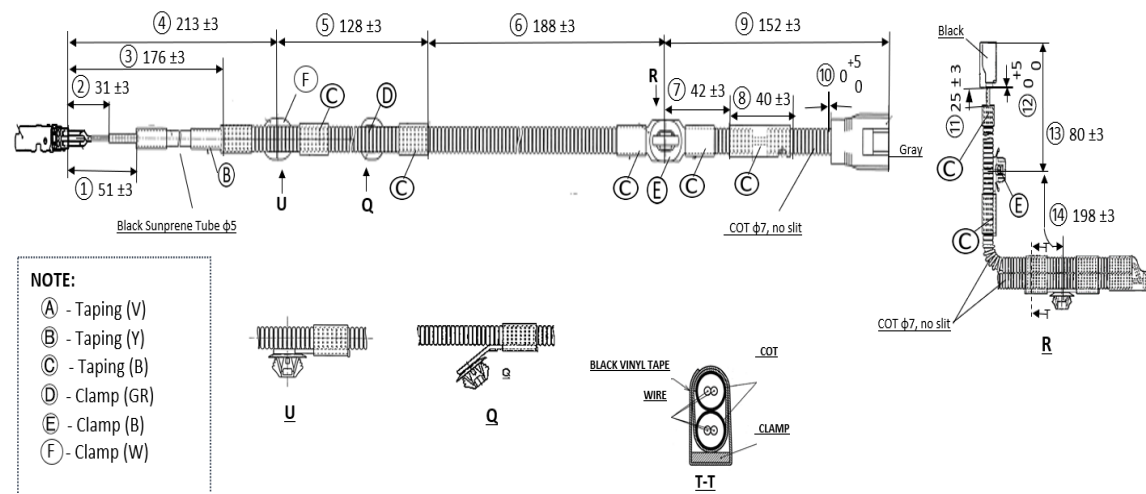
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div>Measurement</div> <div><div><div>MEASURING TAPE</div></div><div><div><div>NOTE:</div><div>A - Taping (V) B - Taping (Y) C - Taping (B) D - Clamp (GR) E - Clamp (B) F - Clamp (W)</div></div></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> <td>1. No wrong dimension</td>	1. No wrong dimension	

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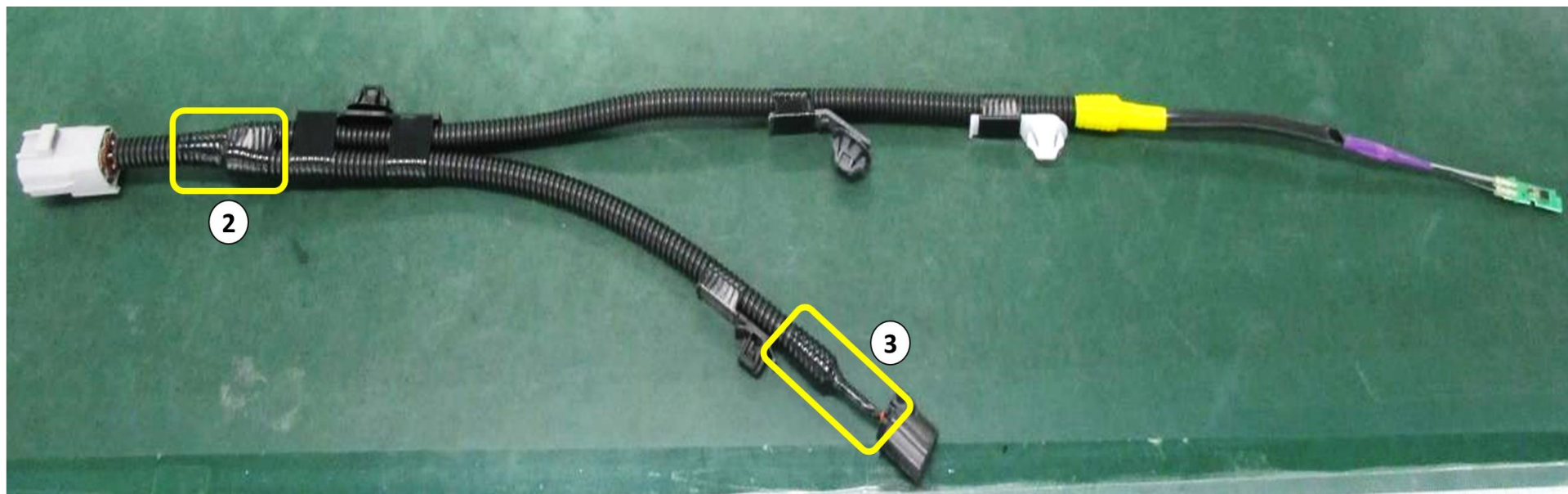
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0052-7024****1** No Wrong facing of clamp**2 3** No Missing Tape (Black tape)

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