



## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

February 07, 2025

Model code/Part number:

400D / 7L0160-7020A

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X (BEV)

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Document No.:

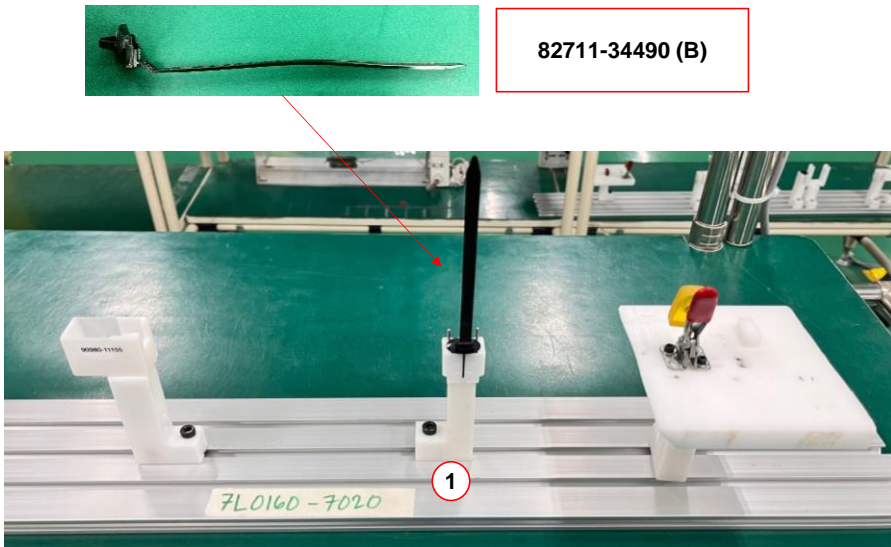
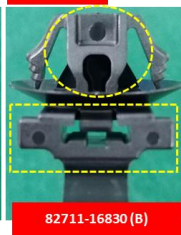
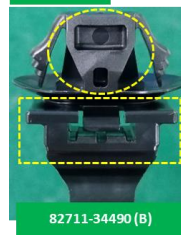



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PARTS:		1. Clamp 82711-34490 (B)				JIG:		1. Temporary Clamp assembly jig		
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	Clamp setting	<div><p>82711-34490 (B)</p><p>1</p><p>7L0160-7020</p><p>1. Get 1pc of Clamp 82711-34490 (B) then attach to clamp location 1.</p></div>				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Document reference/s:</b> 1. Refer to WI-ENG-PDE-1191 for Taping assembly process</div> <div><b>BAND CLAMP ILLUSTRATION</b></div> <div><div>GOOD</div><div>NG</div><div></div><div>82711-34490 (B)</div><div>82711-16830 (B)</div></div>	
Revision History										
							Prepared by	Reviewed by	Approved by	Noted by
02/07/25	0	Initial issue.					 D. Castillo	 C. Villanueva	 A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:
										February 4, 2025

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DCC Stamp

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PROTOTYPE



PRE-LAUNCH





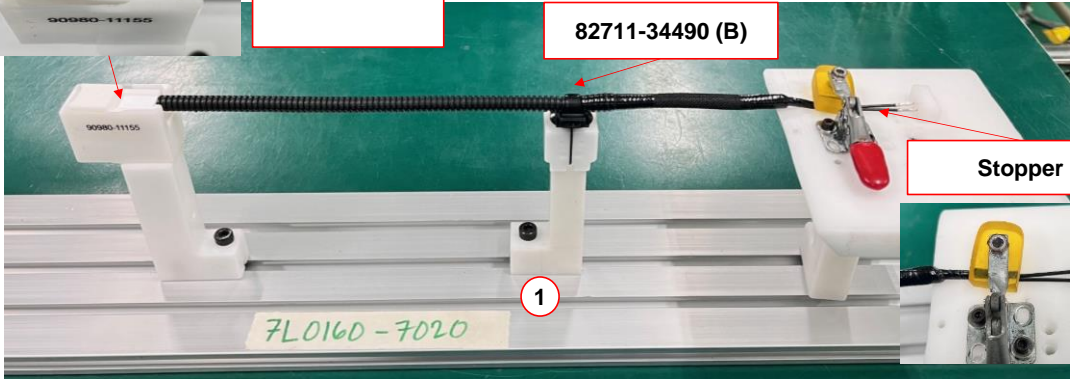

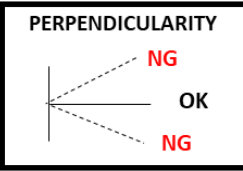
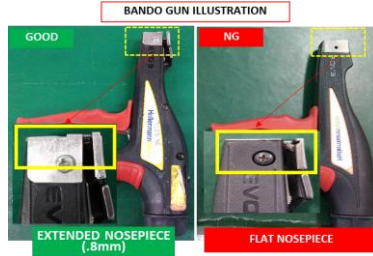
MASSPRO

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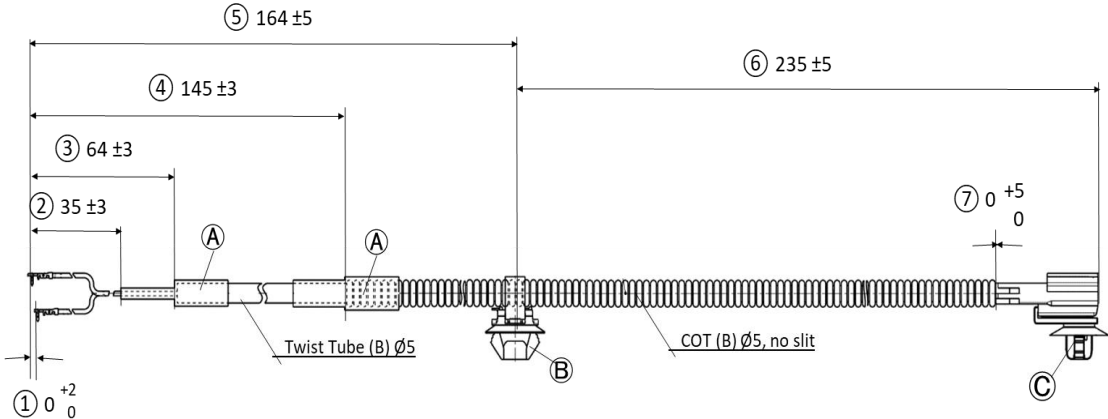

PARTS:		1. Assy parts		JIG:	1. Temporary Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp assembly	<div><div></div><div><div>Connector Receiver base</div></div><div></div></div> <div><p>1. Get the assy part and set to clamp assembly jig. First put the connector with clip into receiver base using left hand. Second, put the terminal to stopper jig using left hand and pull down the toggle clamp using right hand. <i>Note: Refer to above illustration for the correct setting.</i></p><p>2. Initially tighten the Clamp <b>location 1</b> using both hands.</p><p>3. Get the bando gun using right hand then cut the clamp on <b>Location 1</b>.</p></div> <div><div><div>BAND CLAMP CUT POSITION FOR LOCATION 1 &amp; 2</div></div><div><div>BANDO GUN ALIGNMENT</div><div><div>PERPENDICULARITY</div></div></div></div> <div><p>4. Conduct <b>POINT CHECKING</b>, before removing of harness from jig.</p><p>5. Remove the harness from jig. Start from toggle clamp up to clamp up to connector receiver base.</p></div>	<div><p><b>Important reminders/Note/s:</b></p><p>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p><p>2. Make sure no gap between the terminal and stopper jig.</p></div> <div><p>1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun 5. No missing Spot tape 6. No wrong color of tape</p></div> <div><div><div>BANDO GUN ILLUSTRATION</div></div></div>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 4

<b>PARTS:</b>	1. Assy parts			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	CLAMP ASSY	<div>Measurement</div> <div></div> <div><b>NOTE:</b> Ⓐ - Taping (B) Ⓑ - Clamp (B) Ⓒ - Clamp (W) *Unit of dimension is in millimeter (mm)</div>			<div><b>MEASURING TAPE</b></div> 	<div><b>Important reminders and note/s:</b></div> <div>1.Please use calibrated /verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono,Nakamono and Owarimono.</div> <div><b>Document reference/s:</b></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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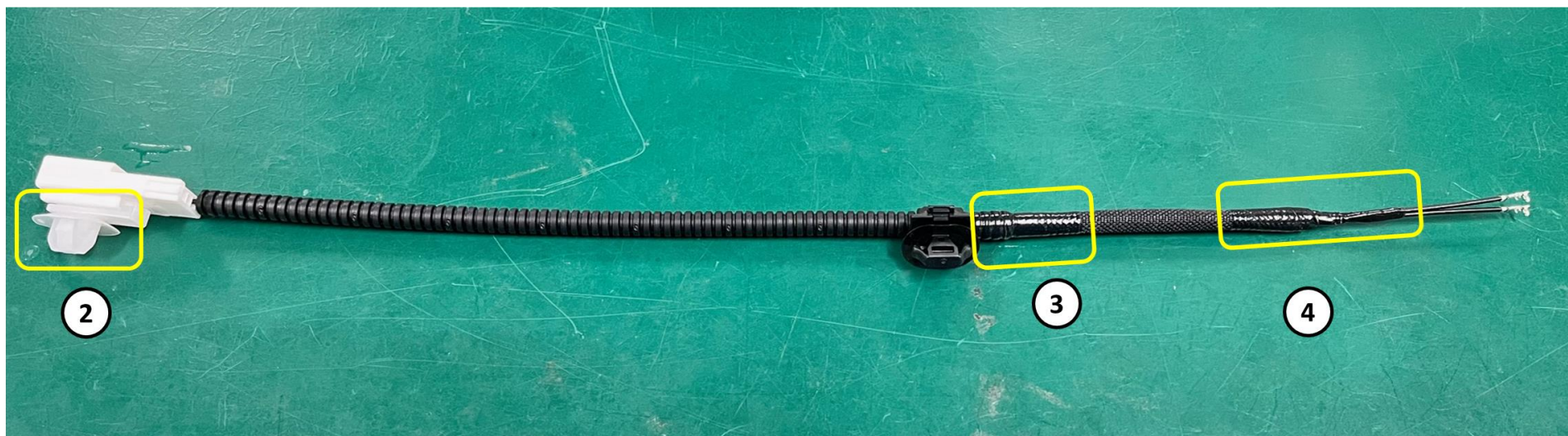
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0160-7020A****(1) No Wrong Facing of Clamp****(2) No Missing Clamp****(3) (4) No Missing Tape ( Black Tape )**

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