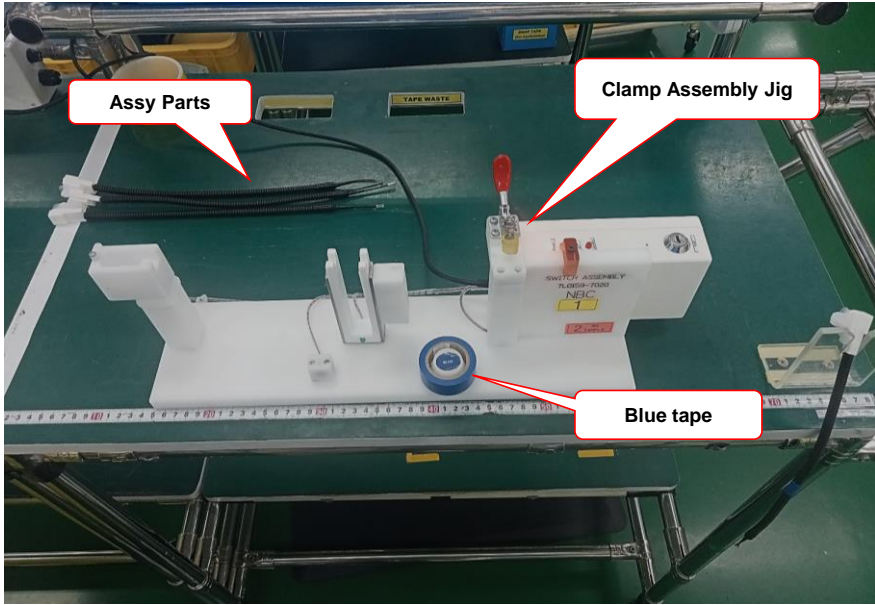



	WORK INSTRUCTION						Effectivity Date:		May 15, 2025		
	Process Name/Title: CLAMP ASSEMBLY PROCESS						Validity Date:		n/a		
	Model code/Part number: 400D / 7L0159-7020			Customer: TRQSS		Car Model: TOYOTA-bZ4X(BEV)		Document No.:		WI-ENG-PDE-1263	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		0		Page No.: 1 of 4

PARTS: 1. Assy parts 2. Blue tape						JIG:		1. Clamp Assembly Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy Table Lay out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">TABLE LAY-OUT</div> </div> 				<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed 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>		1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
								 A. Buban		 C. Villanueva		 A. Arañes			
05/15/25	0	Initial issue				A. Buban	n/a							C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Checked by	Reviewed by	Approved by	Est. Date:	May 15, 2025				

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DCC Stamp



WORK INSTRUCTION

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CLAMP ASSEMBLY PROCESS

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400D / 7L0159-7020

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TRQSS

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TOYOTA-bZ4X(BEV)

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Purpose:



PROTOTYPE



PRE-LAUNCH



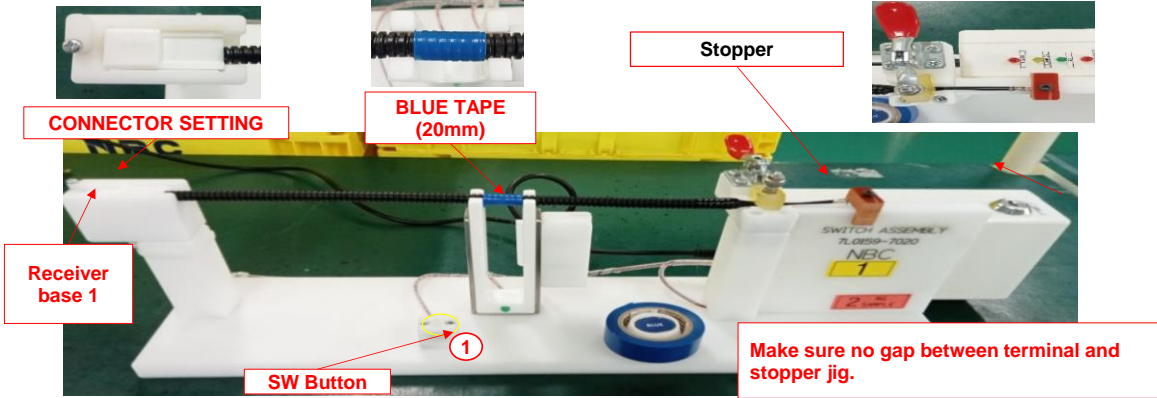
MASSPRO

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PARTS:		1.Assy Parts 2.Blue Tape		JIG:	1.Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp Assembly		<div></div>	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY -056 for sub-assembly Hatsumono, Nakamono, and Owarimono</p> <div><div><p>1. Get the assy parts and set to tester jig using both hands. (See above picture for correct setting). First, set the 6098-3802 (W) to Receiver base 1 then lock. Continue to set the harness, last set the B-B wires together within the stopper jig then press by toggle clamp. Continue if the sequence light in location 1 was ON.</p></div><div><p>2. Check if the Clamp is ON. Check if location 1 sequence light was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p></div><div><p>3. Get the Blue tape (20mm) using right hand then conduct spot taping using both hands on location 1. Make 3 windings then cut the tape. Press the SW button using right index finger. Go sound will be heard.</p></div><div><p>4. Conduct POINT CHECKING before removing the harness from jig.</p></div></div> <div><p>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4.No missing tape 5. No wrong use of tape 6. No wrong dimension 7. No insufficient tape</p></div>

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PROTOTYPE



PRE-LAUNCH



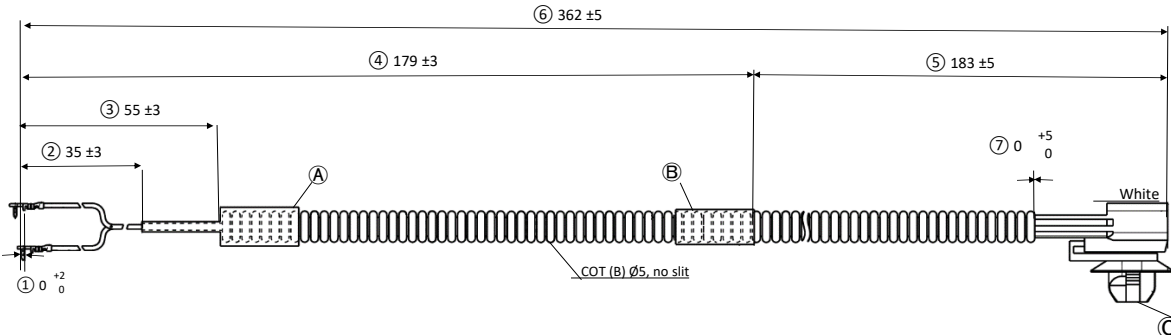
MASSPRO

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Measurement	<div><p>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (L) Ⓒ - Clamp (W) *Unit of dimension is in millimeter (mm)</p></div>		<p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono, and Owarimono .</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY -056 for sub-assembly Hatsumono, Nakamono, and Owarimono</p> <p>1. No wrong Dimension</p>

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PROTOTYPE



PRE-LAUNCH



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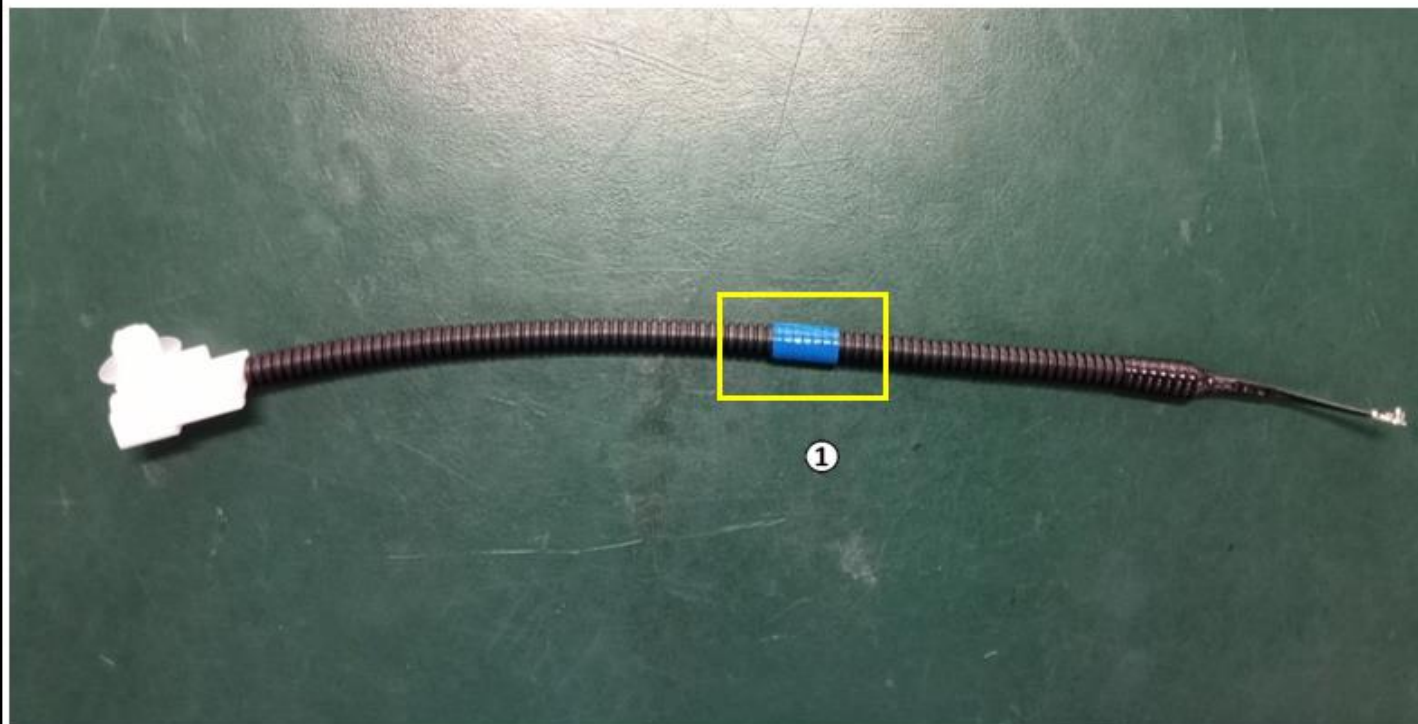
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0159-7020**

① **No Missing and No
Wrong used of tape**

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