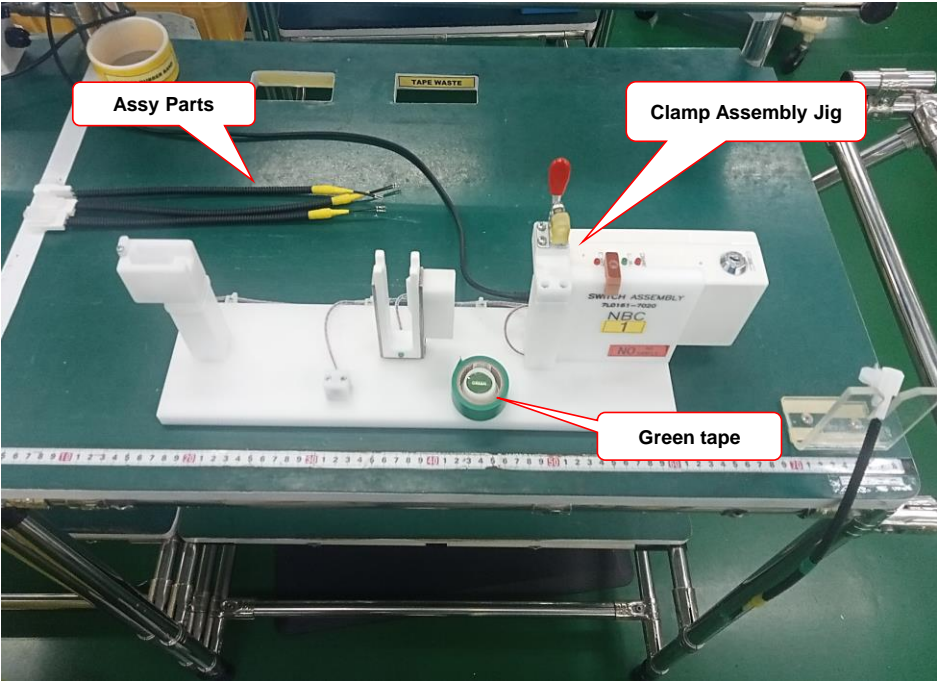



	WORK INSTRUCTION						Effectivity Date:		May 15, 2025		
	Process Name/Title: CLAMP ASSEMBLY PROCESS						Validity Date:		n/a		
	Model code/Part number: 400D / 7L0161-7020			Customer: TRQSS		Car Model: TOYOTA-bZ4X(BEV)		Document No.:		WI-ENG-PDE-1264	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							Revision No.:		0      Page No.:      1 of 4	

PARTS:		1.Assy parts 2.Green tape				JIG:		1.Clamp Assembly Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Clamp Assy	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		1.No missing parts/tools 2.No excess parts/tools	

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
															
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



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## CLAMP ASSEMBLY PROCESS

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:		1.Assy Parts 2.Green Tape		JIG:	1.Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Spot Taping	<div></div> <div>1. Get the assy parts and set to tester jig using both hands. <b>(See above picture for correct setting)</b>. First, set the <b>6098-3802 (W)</b> to <b>Receiver base 1</b> then lock. Continue to set the harness, last set the <b>B-B wires</b> together within the stopper jig then press by toggle clamp. Continue if the sequence light in location <b>1</b> was <b>ON</b>.</div> <div>2. Check if the Clamp is <b>ON</b>. Check if location <b>1</b> sequence light 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.</div> <div>3. Get the <b>Green tape (20mm)</b> using right hand then conduct spot taping using both hands on location <b>1</b>. Make <b>3 windings</b> then cut the tape. Press the <b>SW button</b> using right index finger. <b>Go</b> sound will be heard.</div> <div>4. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div>		<p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-ASY -056 for sub-assembly Hatsumono, Nakamono, and Owarimono</b></p> <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>

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PRE-LAUNCH



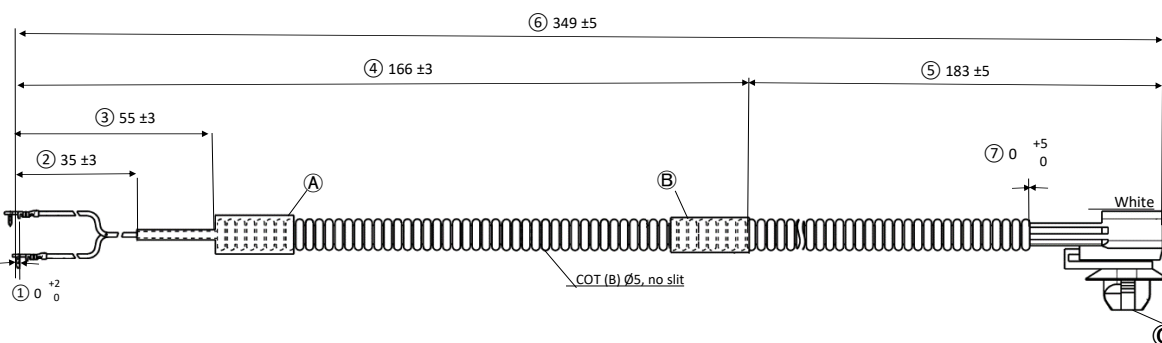
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PARTS:	1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy  Measurement	<div><p><b>NOTE:</b> Ⓐ - Taping (Y) Ⓑ - Taping (G) Ⓒ - Clamp (W) *Unit of dimension is in millimeter (mm)</p></div>		<p>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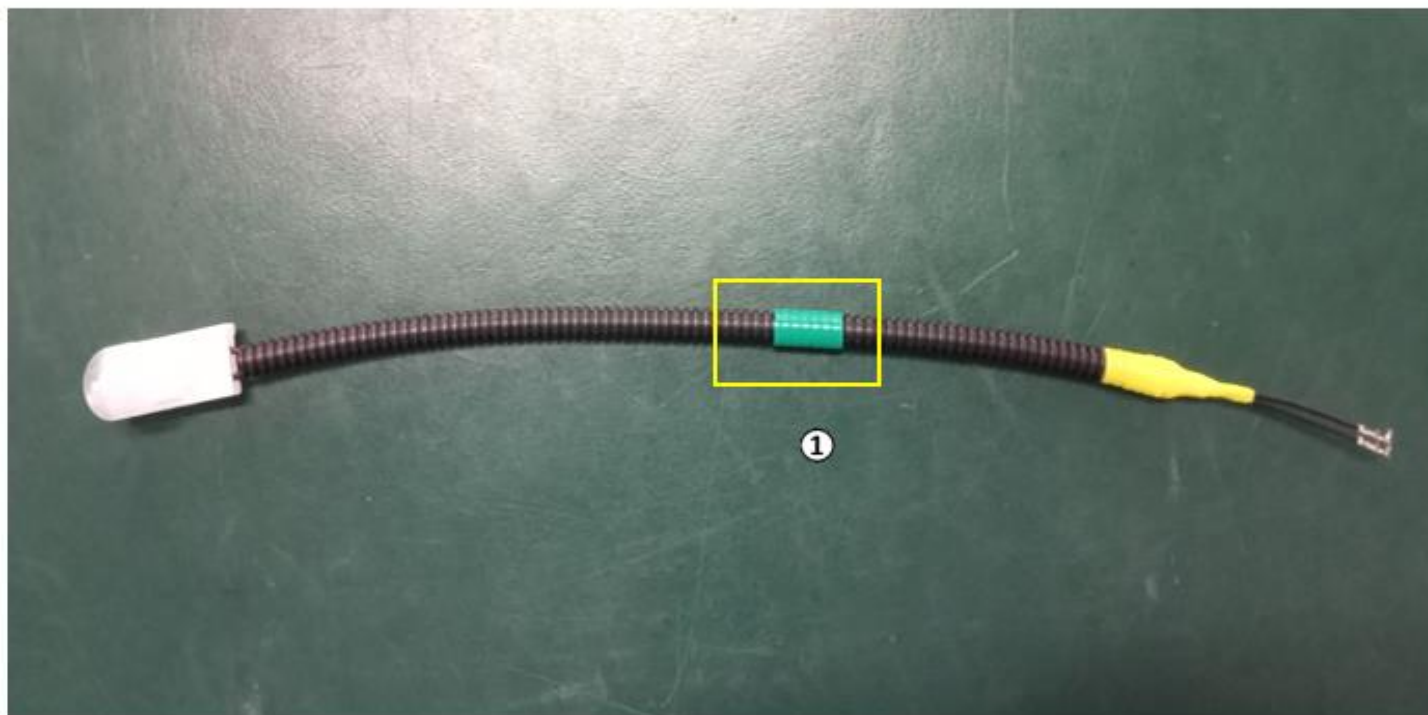
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**PARTS:**

Assy Parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****CLAMP ASSY****7L0161-7020**

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

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