



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

February 7, 2025

Model code/Part number:

400D / 7L0165-7020A

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1199

Purpose:

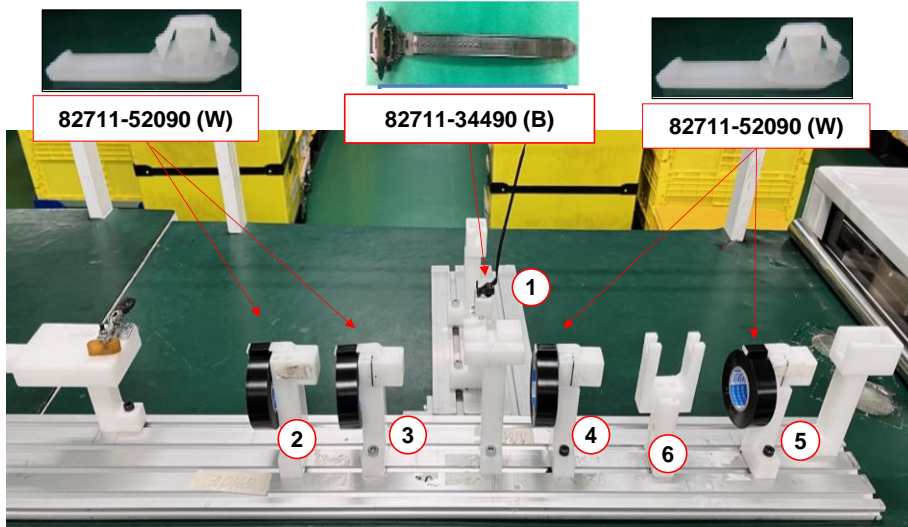

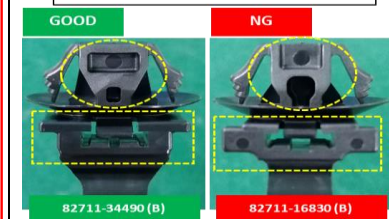
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

1 of 5

PARTS:		1. Clamp 82711-34490 (B) 2. Clamp 82711-52090 (W) [4pcs]		3. Black tape [4pcs]		JIG:	1. Temporary Clamp assembly jig																								
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS																								
1	CLAMP ASSY	<div><p>1. Get 1pc. of clamp 82711-34490 (B) using right hand and set to clamp location 1 using both hands.</p><p>2. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 2 and 3 using both hands.</p><p>3. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 4 and 5 using both hands.</p><p>4. Initially attach Black tape to clamp location 2, 3, 4 and 5 using both hands.</p></div>				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>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-1198 for Taping assembly process</div> <div>CLAMP ILLUSTRATION  GOOD 82711-52090 (W) NG 82711-12A80 (W)</div> <div>BAND CLAMP ILLUSTRATION  GOOD 82711-34490 (B) NG 82711-16830 (B)</div>																								
Revision History																															
<table border="1"><thead><tr><th>Eff. Date</th><th>Rev. No</th><th>Details of Change</th><th>Revised</th><th>Reviewed</th><th>Approved</th><th>Noted</th><th>Prepared by</th><th>Reviewed by</th><th>Approved by</th><th>Noted by</th></tr></thead><tbody><tr><td>02/07/25</td><td>0</td><td>Initial issue.</td><td>D.Castillo</td><td>C. Villanueva</td><td>A. Arañes</td><td>n/a</td><td></td><td></td><td></td><td>n/a</td></tr></tbody></table>										Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by	02/07/25	0	Initial issue.	D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
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DCC Stamp



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☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:

1. Assy parts

JIG:

1. Temporary Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

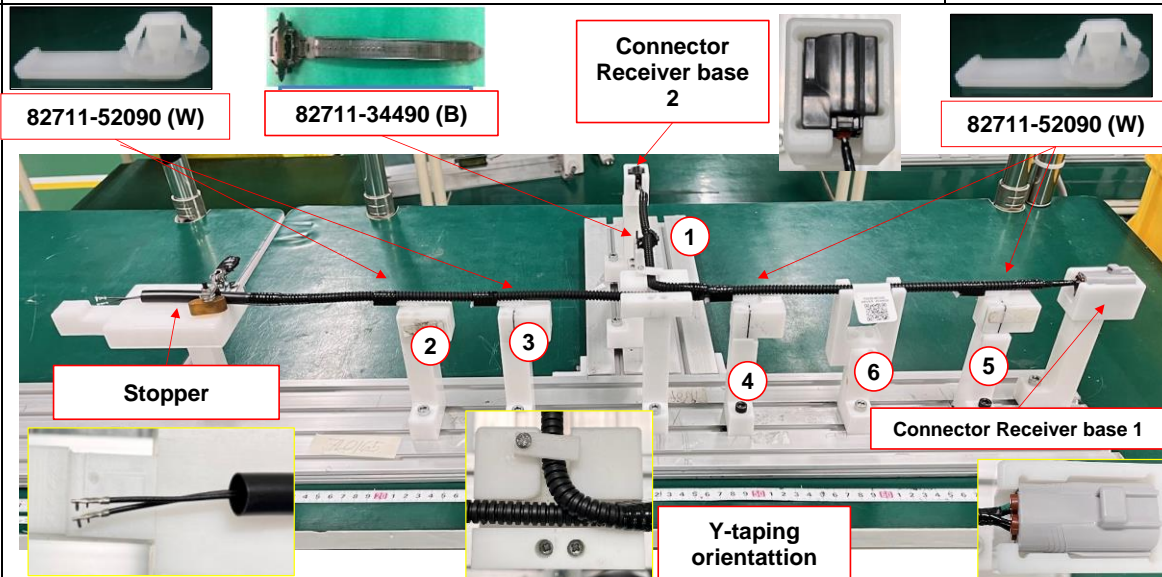
TOOLS/PPE

QUALITY POINTERS

2

CLAMP
ASSY

Clamp assembly



1. Get the assy part and set to clamp assembly jig. First put the connector 6188-0066 (GR) into connector receiver base **1** using right hand. Second, put connector 6188-1161 (B) into connector receiver base **2** using right hand. Set the Y-atping in y-taping guide then lock. Last, set the terminal to stopper jig using left hand and pull down the toggle clamp using right hand.
Note: Refer to above illustration for the correct setting.

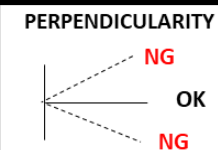
2. Initially tighten the Clamp **location 1** using both hands.

3. Get the bando gun using right hand then cut the clamp on **Location 1**.

BAND CLAMP CUT POSITION FOR LOCATION 1 & 2



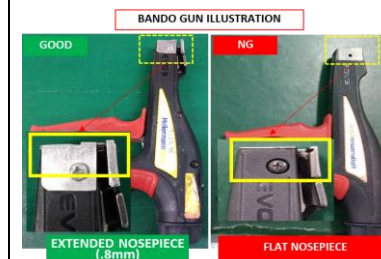
BANDO GUN ALIGNMENT



Important reminders/Note/s:

1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).
2. Make sure no gap between the terminal and stopper jig.

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



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PROTOTYPE



PRE-LAUNCH



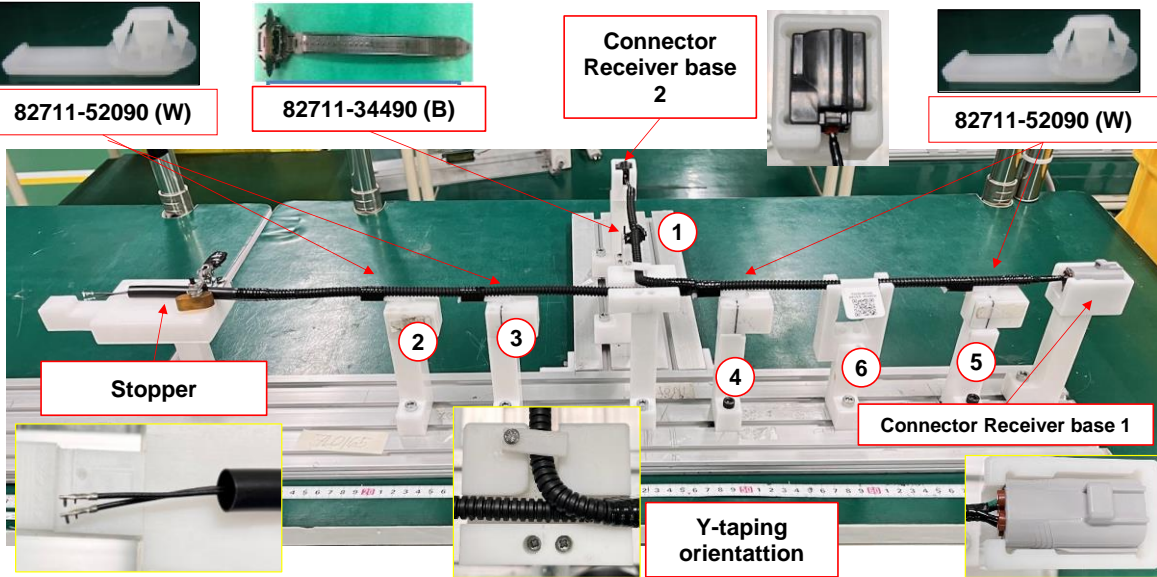
MASSPRO

Revision No.:

0

Page No.:

3 of 5

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 (Continuation)	<div></div> <div><div>4. On clamp location 2, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 3.</div><div>5. On clamp location 3, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 4.</div><div>6. On clamp location 4, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to Clamp location 5.</div><div>7. On clamp location 5, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 6.</div><div>8. On location 6, please refer to the next page for label attachment.</div><div>9. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div><div>10. Remove the harness from jig. Start, remove the connector to connector receiver base 1 thenk continue to connector receiver base 2. Unlock the y-taping lock and remove the harness. Last, release the toggle clamp and remove the harness.</div></div>			<p>Important reminders/Note/s:</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> <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>

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0

Page No.:

4 of 5

PARTS:

1. Assy parts

JIG:

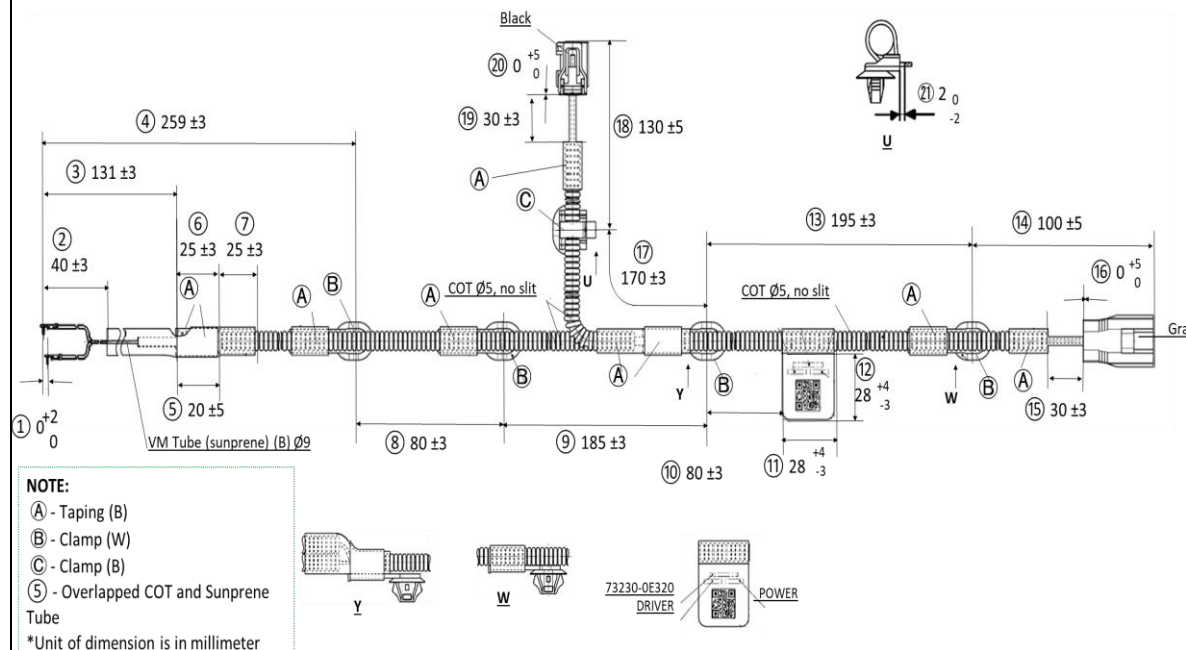
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

CLAMP
ASSY

Measurement

**Important reminders and note/s:**

1. Please use calibrated /verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.

1. No wrong dimension

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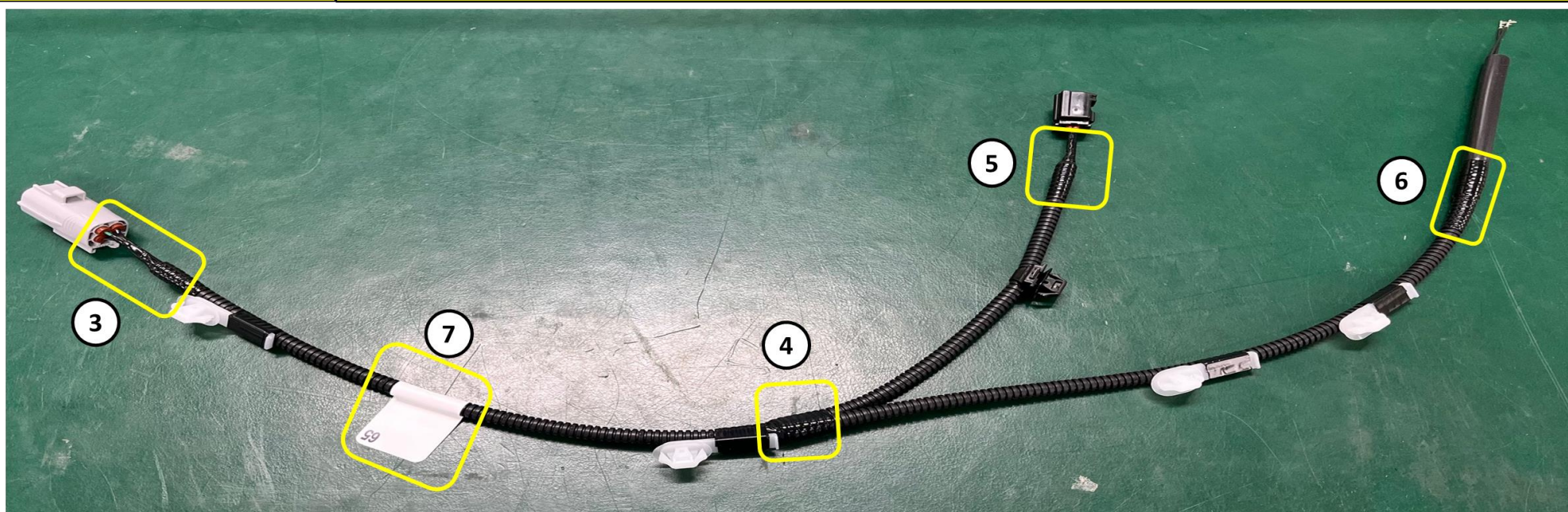
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0165-7020A****1** No Wrong Facing of Clamp**2** No Missing Clamp**3** **4** **5** **6** No Missing Tape (Black Tape)**7** No Missing QR code label

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