



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

400D / 7L0167-7020D

Customer:

TRQSS

Car Model:

TOYOTA bZ4x (BEV)

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

April 16, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1244

Revision No.:

0

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PARTS:

1. Clamp 82711-34490 (B)
2. Clamp 82711-52090 (W) [3pcs]

3. Clamp 82712-12080 (B)
4. Black tape [4pcs]

JIG:

1. Temporary Clamp assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp	Clamp setting	<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><ol style="list-style-type: none">1. No damaged clamp2. No wrong use of clamp3. No missing clamp4. No wrong orientation of clamp</div> <div>CLAMP ILLUSTRATION BAND CLAMP ILLUSTRATION </div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
04/16/25	0	Initial issue.	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes
Est. Date:	March 26, 2025									

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PARTS:		1. Assy Parts 2. Black Tape	JIG:	1. Temporary Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp	Clamp Assembly		<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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PARTS:		1. Assy Parts 2. Black Tape		JIG:	1. Temporary Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Clamp Assembly (Continuation)	<div><div></div><div></div><div></div><div></div><div><p>82711-52090 (W)</p><p>82711-34490 (B)</p><p>82712-12080 (B)</p><p>82711-52090 (W)</p><p>2</p><p>5</p><p>4</p><p>1</p><p>6</p><p>3</p></div></div> <div><p>5. Initially tighten the Clamp location 2 using both hands.</p></div> <div><p>6. Get the bando gun using right hand then cut the clamp on Location 2.</p></div> <div><p>7. 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.</p></div> <div><p>8. 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.</p></div> <div><p>BAND CLAMP CUT POSITION FOR LOCATION 1 & 2</p><p>GOOD NG</p></div> <div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>NG OK NG</p></div> <div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>EXTENDED NOSEPIECE (.8mm)</p><p>FLAT NOSEPIECE</p></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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PARTS:		1. Assy Parts 2. Black Tape		JIG:	1. Temporary Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp Clamp Assembly (Continuation)	<div></div> <div>9. 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>10. On location 6, please refer to the next page for label attachment.</div> <div>11. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div> <div>12. Remove the harness from jig. Start, remove the connector to connector receiver base 1 then 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>			<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> <div><p>BANDO GUN ILLUSTRATION</p></div>

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PARTS:

1. Assy Parts
2. QR Code Label 7V8280-0020

JIG:

n/a

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

3

Clamp

Label attachment

Model	Item No	Item Name
7L0165-7020A	73230-0E320	Driver POWER
7L0166-7020A	73230-0E360	Passenger POWER
7L0167-7020C	73230-0E310	Driver PWR+MEM



Model code

Item no. & name

1. Get the label.
Note: Check the model code, item no. & name



2. Align the end part of label in the jig.



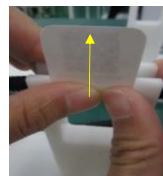
3. Fold the center part of the label



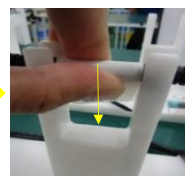
4. Align both end part of label



5. After alignment, Press the label with both fingers.



6. Press the label upside down using finger.



Acceptable overlap



NG

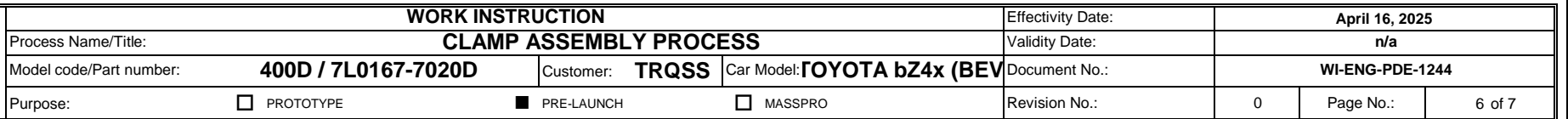
n/a



1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label

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PARTS:

n/a

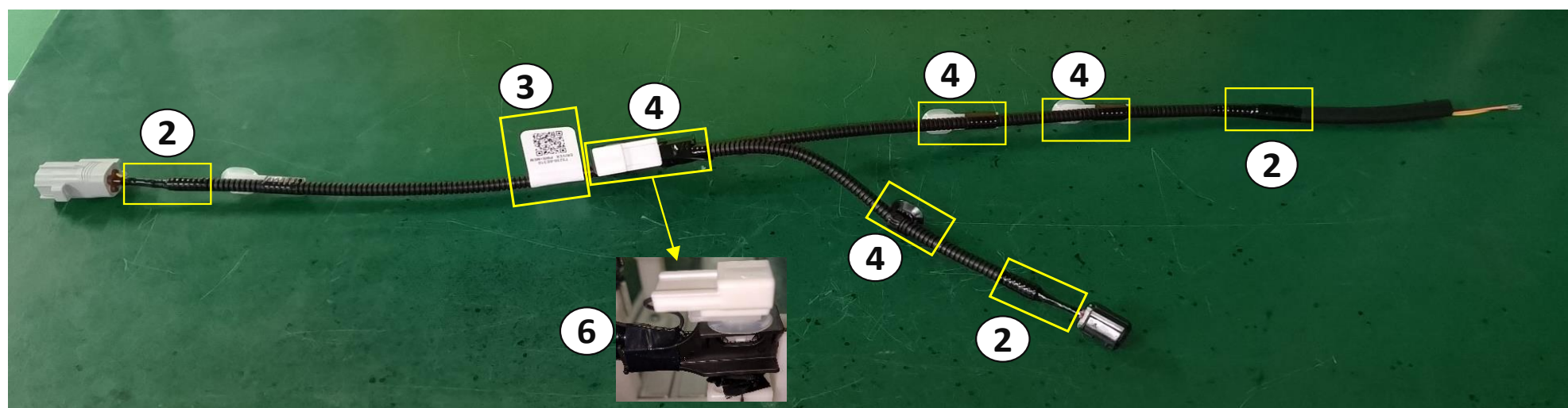
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7L0167-7020D



- ① Check the Clamp Alignment
- ② No Missing Tape
- ③ No Wrong Facing of QR code

- ④ No Missing Clamp
- ⑤ No Wrong Facing of Y-Taping
- ⑥ No Missing Clip Clamp Attachment to Clamp 82712-12080

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