



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 15, 2025

Validity Date:

n/a

Model code/Part number:

400D / 7L0162-7020A

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1269

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts
2. Brown tape

JIG:

1. Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

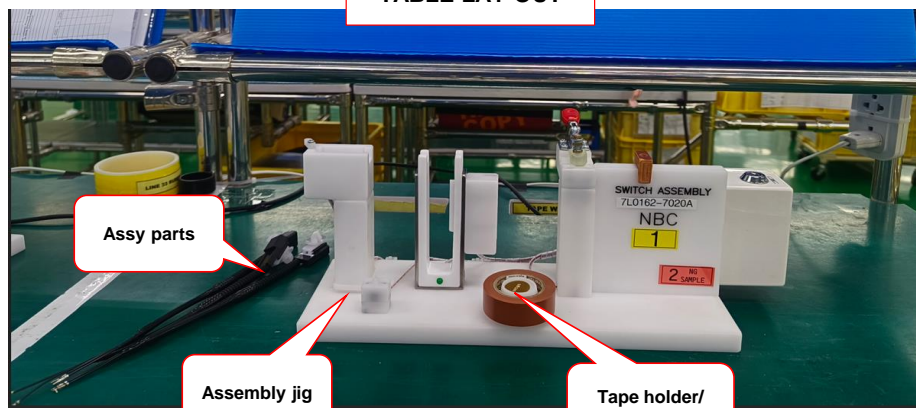
TOOLS/PPE

QUALITY POINTERS

1

Clamp
Assy

Table lay-out

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to WI-PDE-1239 for TAPING ASSEMBLY PROCESS

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
05/15/25	0	Initial issue. Excluded process from WI-ENG-PDE-1239 TAPING ASSEMBLY PROCESS ; Change purpose from Pre-launch to Masspro. Update the Work Procedure/Illustration and Visual inspection/Quality checkpoints.	M. Ariola	n/a	C. Villanueva	A. Arañes	M. Ariola	n/a	C. Villanueva	A. Arañes

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DCC Stamp



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1. Assembly jig

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PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

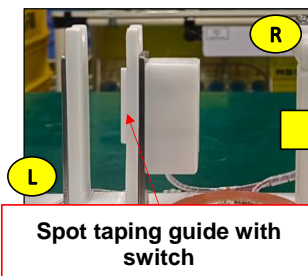
2

Clamp
Assy

Assembly
(Spot taping)

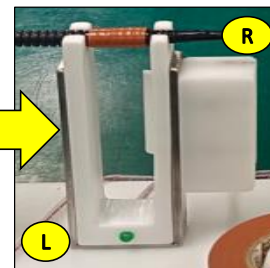
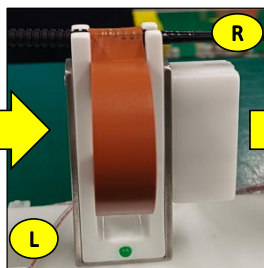


1. Put the assy parts into jig (**See above photos**). First, set the **connector 6098-3803 (B)** to **receiver base 1** then lock. Last, set the **B-B wires** together within the stopper jig then press by the toggle clamp.



3. Get the **Brown tape** and attach to **location 1**, make **3 windings** of tape cut the tape using both hands. Press the **SW** button. **Go** sound will be heard.

Note: Jig will alarm if lacking and excess windings.



2. Check the **LED** light for **POWER ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for the further instruction then continue the process.

4. Conduct **POINT CHECKING** before removing the harness from jig.

5. After point checking, remove the harness from toggle clamp up to connector receiver base.

1. No Wrong used of tape
2. No excess/lacking tape windings.
3. No missing spot tape.

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PROTOTYPE



PRE-LAUNCH



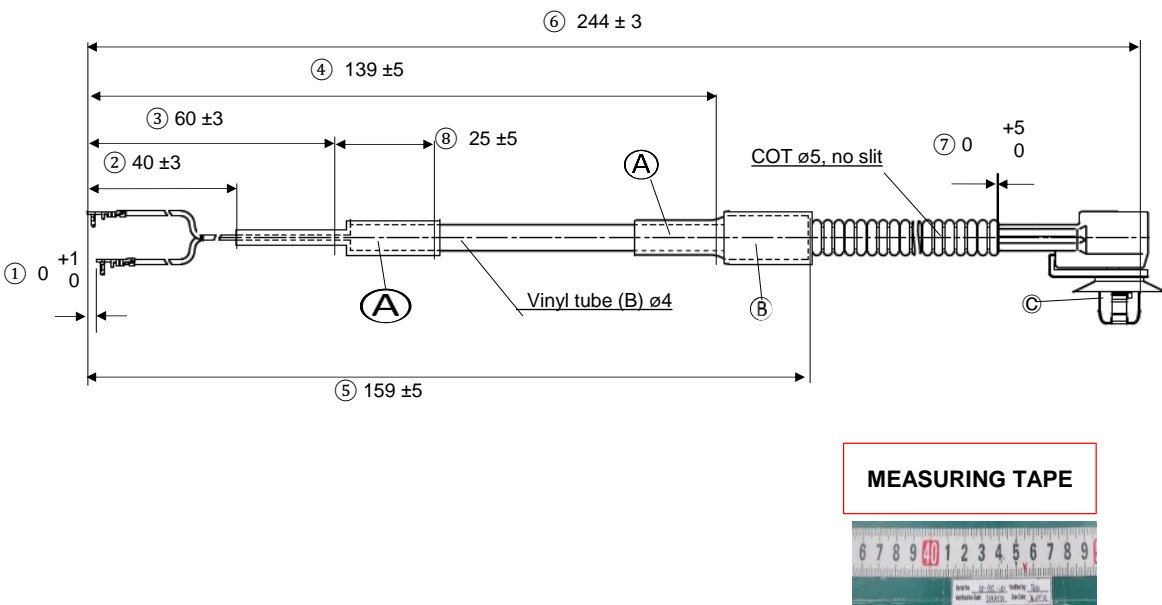
MASSPRO

Revision No.:

0

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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></div>		<p>1. No wrong dimension.</p> <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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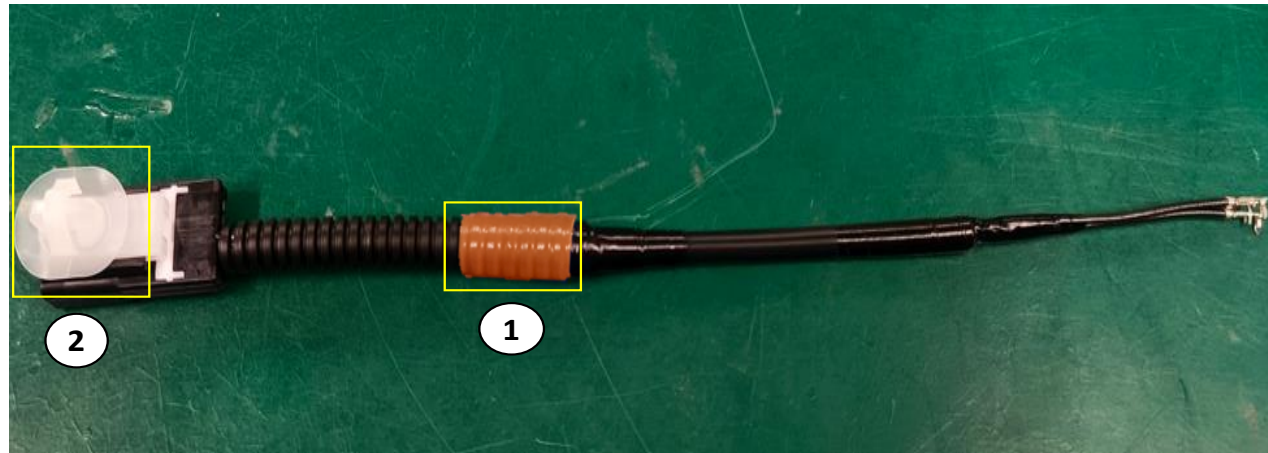
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0162-7020A**

① No Wrong color of tape/Missing spot tape (Brown tape)

② No Missing clip type clamp

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