



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

February 28, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

339D / 7N0161-7020B

Customer:

TRJ

Car Model:

TOYOTA-BZ4X

Document No.:

WI-ENG-PDE-1220

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-3A540 (W); Clamp 82711-48070 (GR); Black tape; White tape

JIG:

1. Assembly jig with locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

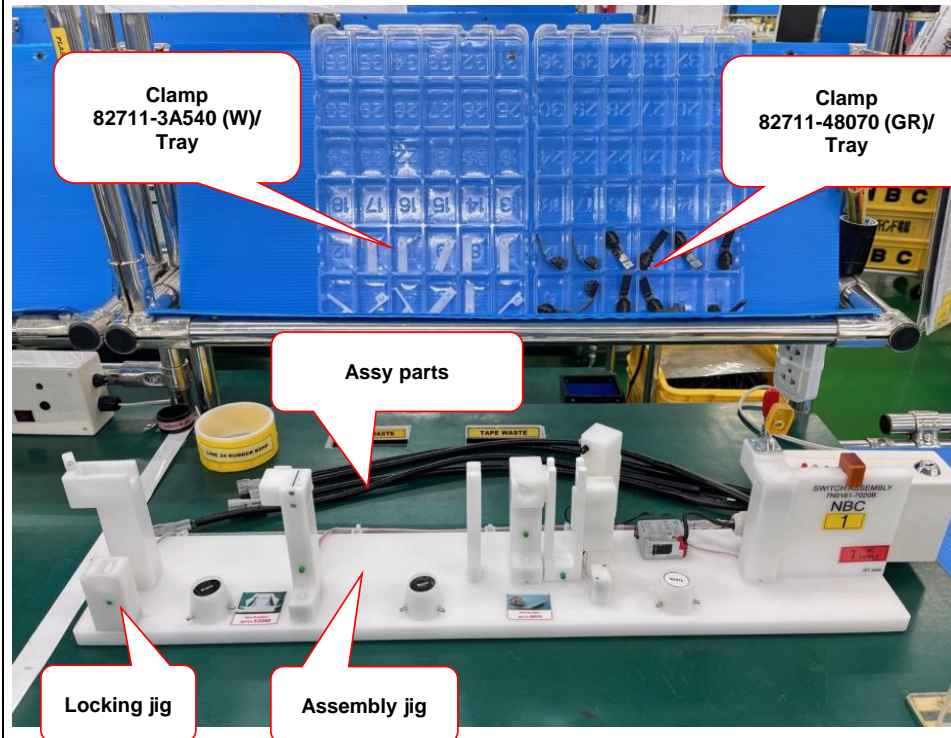
QUALITY POINTERS

1

CLAMP
ASSY

Table lay-out

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 references:

1. Refer to WI-ENG-PDE-1172 for Taping assembly process

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

Revision History

Prepared by

Checked by

Reviewed by

Approved by

02/28/25 0 Initial issue. Separate process from Taping assembly process.

D.Castillo J. Loterte C.Villanueva A. Arañes

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J. Loterte

C. Villanueva

A. Arañes

Eff. Date Rev. No Details of Change

Revised Checked Reviewed Approved

Est. Date:

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Clamp 82711-3A540 (W)
2. Clamp 82711-48070 (GR)

3. Black tape [2pcs]

JIG:

1. Assembly jig with locking jig

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

2

CLAMP
ASSY

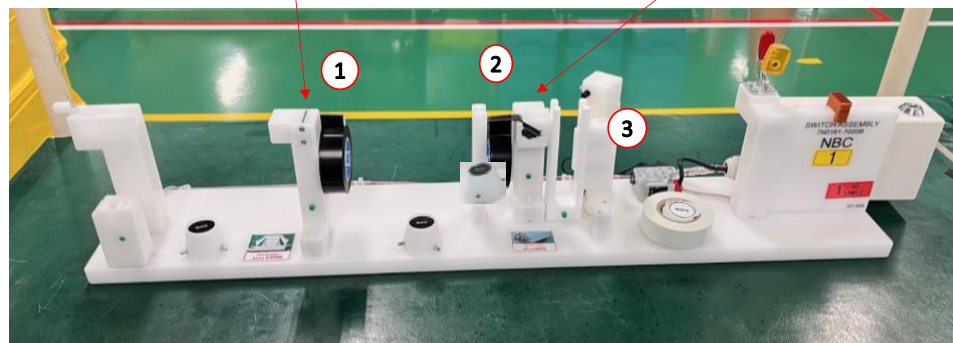
Clamp Setting



82711-3A540 (W)



82711-48070 (GR)



1. Get 1pc of clamp **82711-3A540 (W)** using right hand and set to clamp location **1** using both hands.

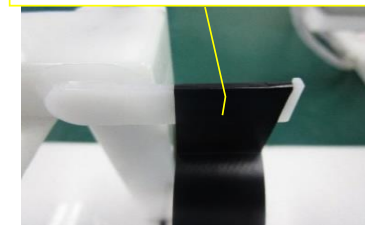
2. Get 1pc of clamp **82711-48070 (GR)** using right hand and set to clamp location **2** using both hands.

3. Initially attach **Black tape** to clamp location **1 and 2** using both hands.

Important reminders/Note/s:
1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

One wind for under tape



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PARTS:

1. Assy parts

JIG:

1. Assembly jig with locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

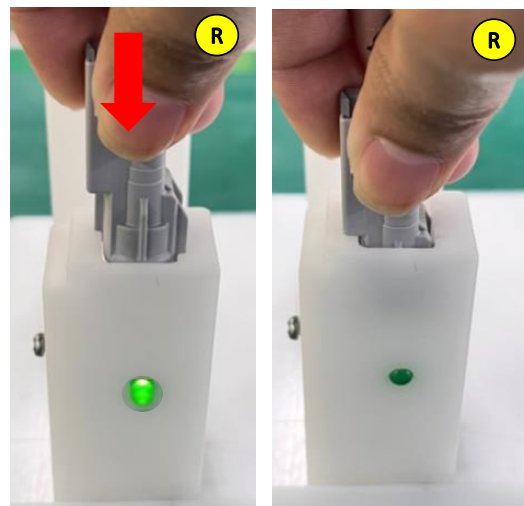
TOOLS/PPE

QUALITY POINTERS

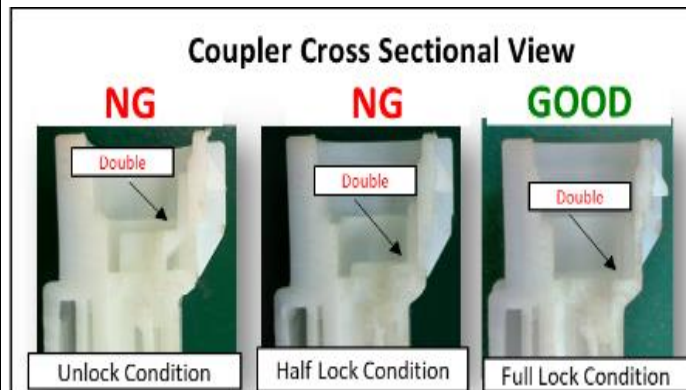
3

CLAMP
ASSY

Connector Lock



1. Put the connector into locking jig using right hand then press **2x** to lock using both hands. Check the lock if properly locked.



Before lock



After lock

LOCKING JIG

**Important reminders/Note/s:**

1. **MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.**

1. Use the provided locking jig per model
2. No unlock/half-locked connector
3. No skip of locking process

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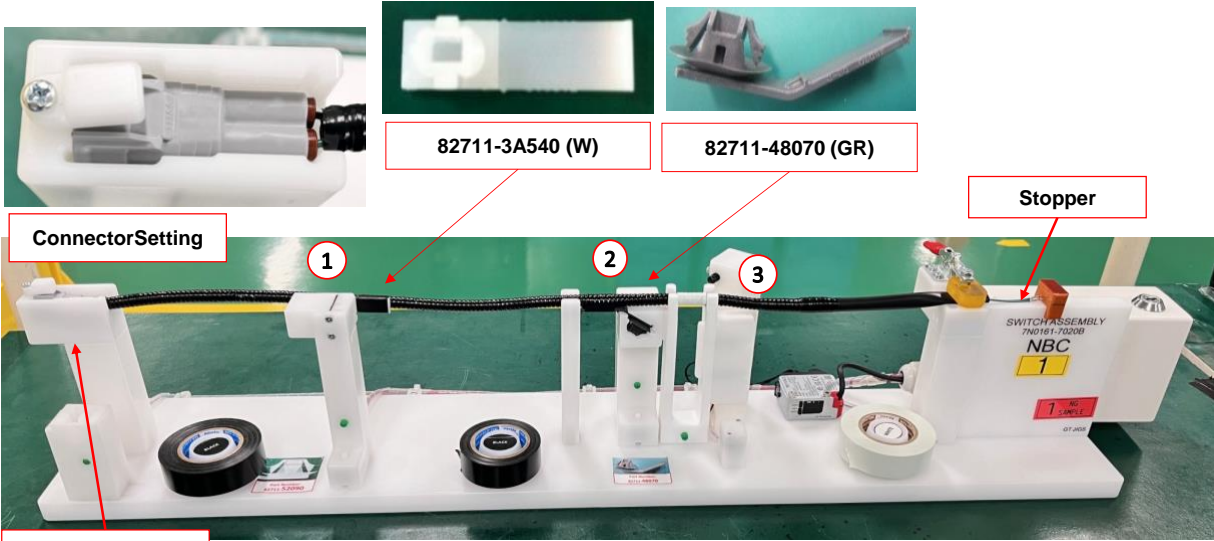
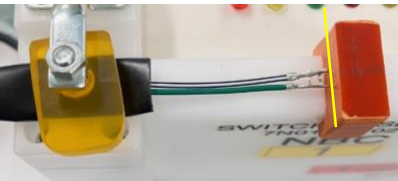
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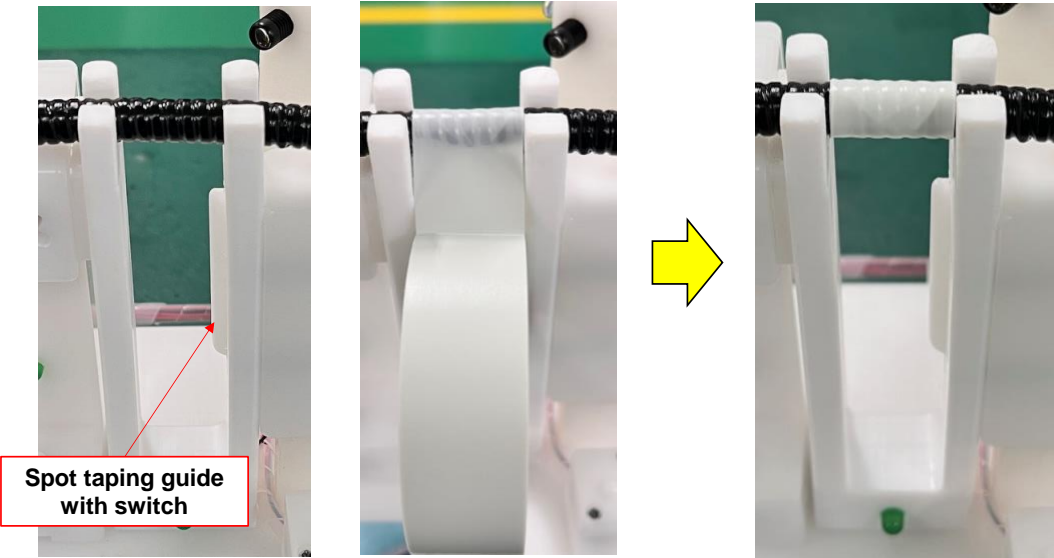
PARTS:	1. Assy parts 2. White tape		JIG:	1. Assembly jig with locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY Clamp Assembly	 <p>1. Put the assy into jig. (See above picture for the correct setting). First, set the connector 6188-0266 (GR) to Receiver base 1 then lock. Last, set the terminals together within stopper then press by toggle clamp. Continue if the sequence light of location 1 was on.</p> <p>2. Checked if all LED light for POWER ON and CLAMP ON was ON. IF encountered problem, STOP and immediately CALL the attention of leader. WAIT for further instruction nad continue the process.</p> <p>3. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands. Press the SW button after tape. Continue the process if clamp location 2 was on.</p> <p>4. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Press the SW button after tape. Continue the process if clamp location 3 was on.</p>		1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	5 of 7

PARTS:		1. Assy parts 2. White tape		JIG:	1. Assembly jig with locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY Clamp Assembly (Continuation)	<div>  </div> <div> <p>5. Get the White tape and start taping to Location 3. Make 3 windings only of tape. Press the SW button after taping. Go sound will be heard. Note: Jig will alarm if lacking and excess winding.</p> </div> <div> <p>6. Conduct POINT CHECKING, before removing of harness from jig.</p> </div> <div> <p>7. Remove the harness from jig. Start from toggle clamp up to clamp up to connector receiver base.</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). 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

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

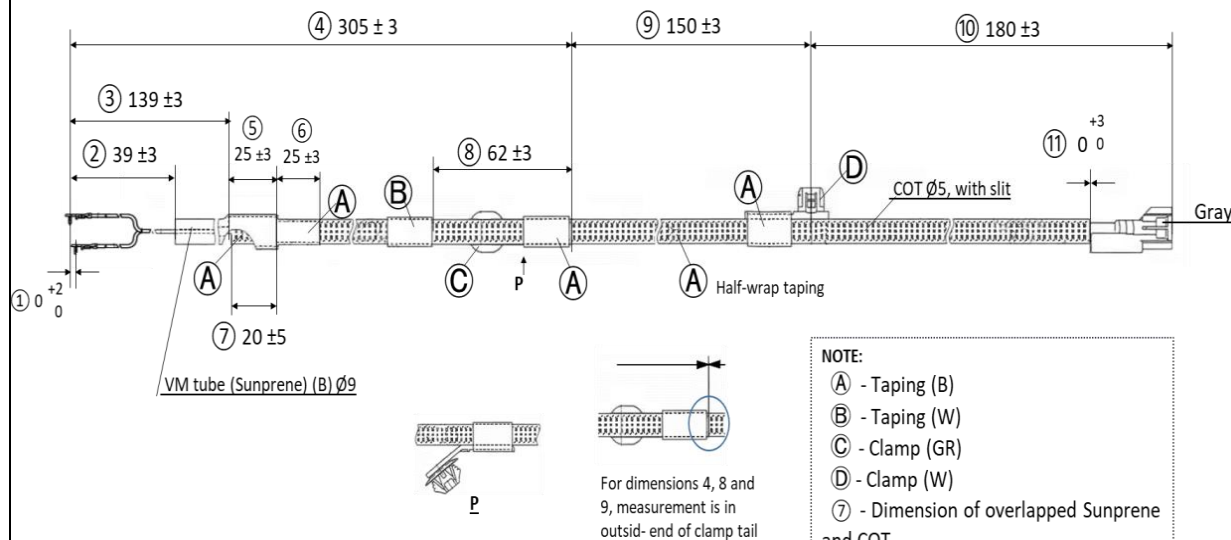
TOOLS/PPE

QUALITY POINTERS

5

CLAMP
ASSY

Measurement



MEASURING
TAPE



Important reminders and note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono and Owarimono.

Document reference/s:

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

1. No wrong dimension

NOTE:

- A - Taping (B)
 - B - Taping (W)
 - C - Clamp (GR)
 - D - Clamp (W)
 - ⑦ - Dimension of overlapped Sunprene and COT
- *Unit of dimension is in millimeter (mm)

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PARTS:

1. Assy parts

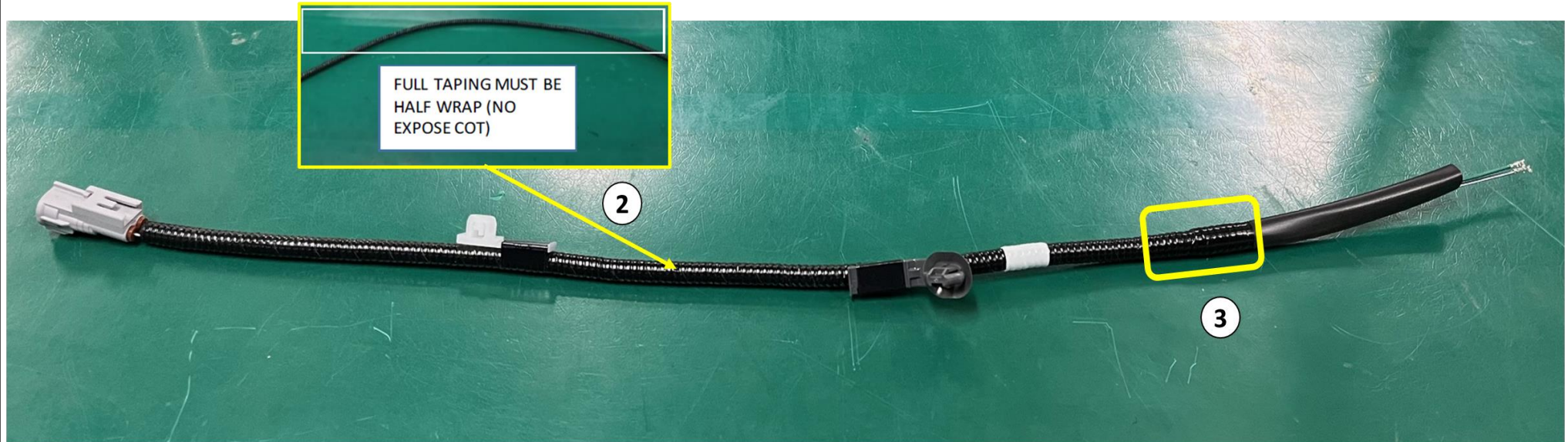
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7N0161-7020B



① No Wrong facing of clamp

② ③ No Missing Tape (Black tape)

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