



WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Model code/Part number:

400D / 7L0167-7020C

Customer:

TRQSS

Car Model:

TOYOTA bZ4x (BEV)

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

March 25, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1224

Revision No.:

0

Page No.:

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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
02/25/25	0	Initial issue.	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	February 25, 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	<div><p>82711-52090 (W) 82711-34490 (B) 82712-12080 (B) 82711-52090 (W)</p><p>2</p><p>5 4 1 6 3</p></div> <div><p>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. Last, set the terminal to stopper jig using left hand and pull down the toggle clamp using right hand.</p><p><i>Note: Refer to above illustration for the correct setting.</i></p></div> <div></div> <div><p>2. Conduct 2 winds taping on clamp location 1 using both hands. (Do not cut the tape).</p></div> <div><p>3. Combine the Assy parts (Connector 6098-3802 W) using left hand and hold the tape using right hands and make 3 windings of tape and then cut the tape.</p></div> <div><p>4. Get the Connector 6098-3802 (W) with clip clamp 82711-1E360 (W) then attached to clamp 82712-12080(B).</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 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></div></div> <div><div>5. Initially tighten the Clamp location 2 using both hands.</div><div>6. Get the bando gun using right hand then cut the clamp on Location 2.</div><div>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.</div><div>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.</div></div> <div><div>BAND CLAMP CUT POSITION FOR LOCATION 1 & 2</div><div></div><div>BANDO GUN ALIGNMENT</div><div></div><div>BANDO GUN ILLUSTRATION</div><div></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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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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5 of 7**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.



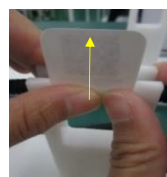
3. Fold the center part of the label



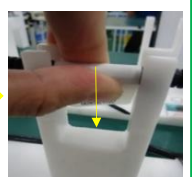
4. Align both end part of label



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



6. Press the label upside down using finger.

**GOOD**

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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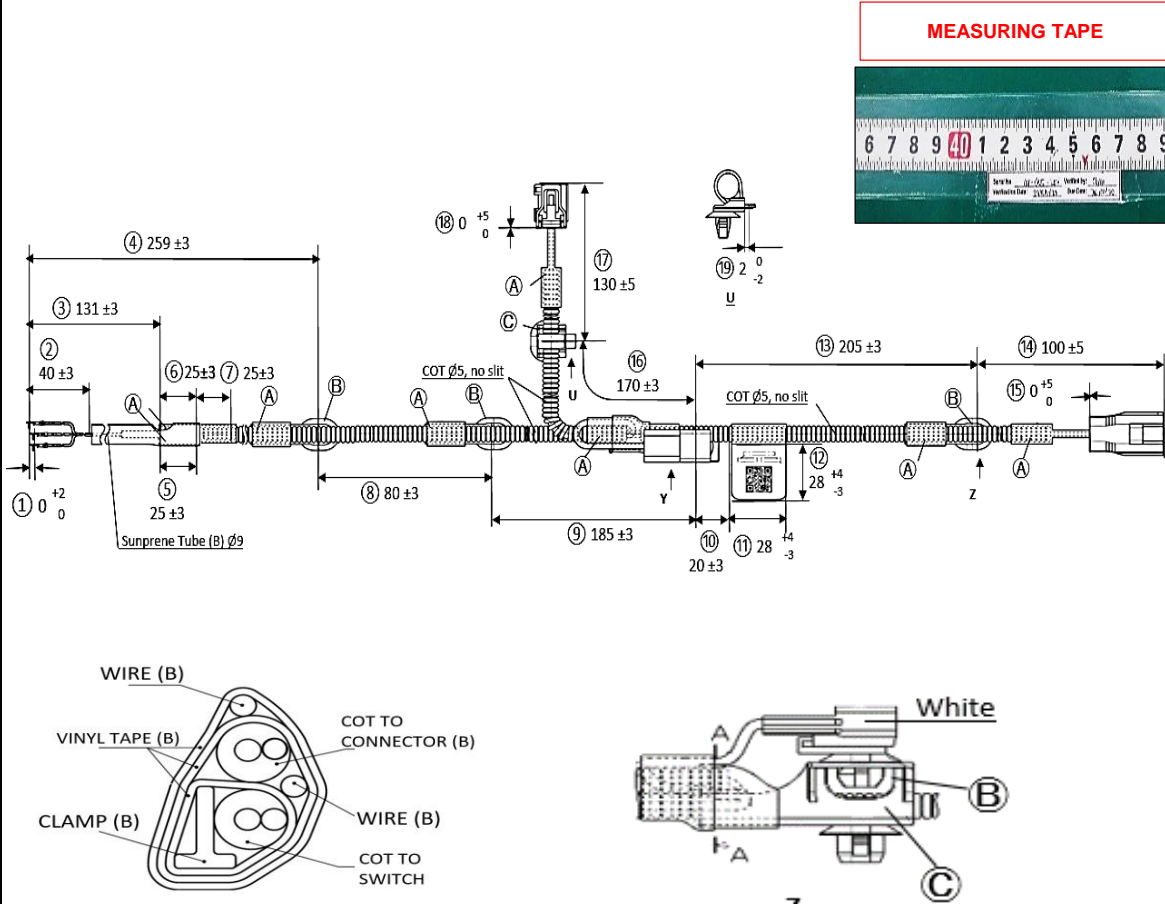

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Measurement	<div></div>	<div><div>MEASURING TAPE</div></div>	<p>1. No wrong dimension</p> <p>Important reminders and note/s:</p> <p>1. Please 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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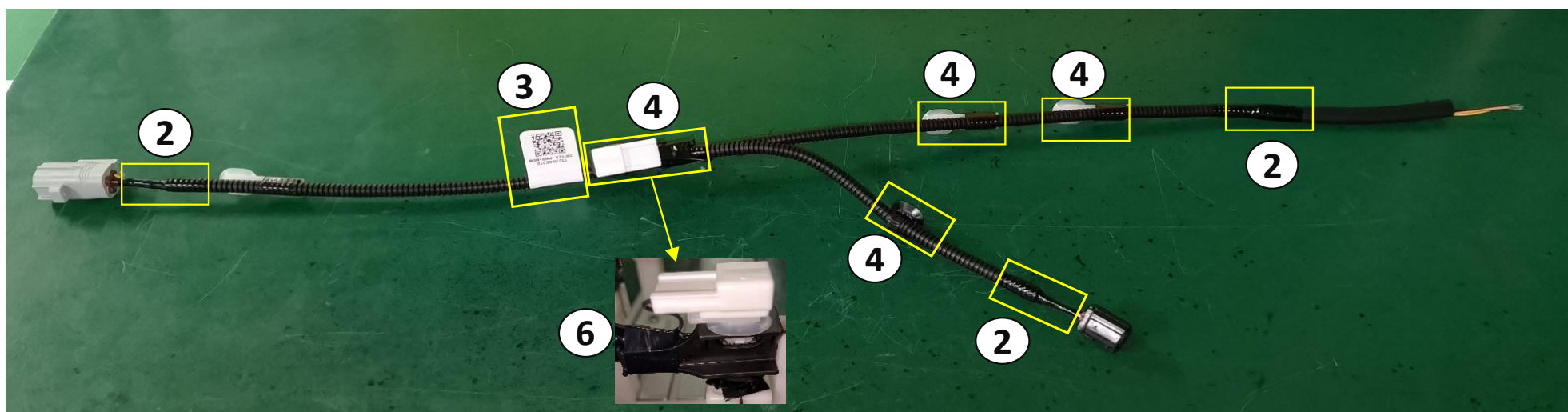
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0167-7020C****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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