
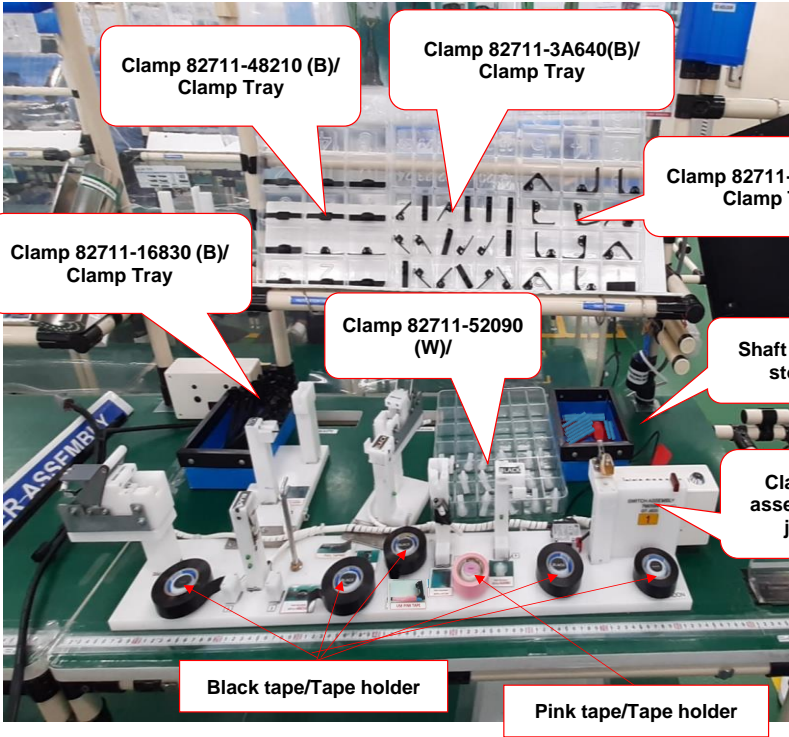



|   |   |  |                      |                            |                   |               |                       |         |
|---|---|--|----------------------|----------------------------|-------------------|---------------|-----------------------|---------|
|  | <b>WORK INSTRUCTION</b><br><b>CLAMP ASSEMBLY PROCESS</b>  |  |                      |                            | Effectivity Date: | July 10, 2024 |                       |         |
|   | Process Name/Title:   |  |                      |                            | Validity Date:    | n/a           |                       |         |
|   | Model code/Part number: <b>100B / 7M0594-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS US</b> | Document No.:     |               | <b>WI-ENG-PDE-902</b> |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                            | Revision No.:     | 0             | Page No.:             | 1 of 11 |

|               |                     |   |  |  |  |   |
|---------------|---------------------|---|--|--|--|---|
| <b>PARTS:</b> |                     | 1. Assy parts: Clamp 82711-48210 (B); Clamp 82711-3A640(B); Clamp 82711-16830 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Blue Shaft webbing stopper 7H0738-0200; Black tape [5pcs.]; Pink tape [1pc.] |  |  | JIG:   | 1. Clamp assembly jig                                 |
| <b>NO.</b>    | <b>PROCESS NAME</b> | <b>WORK PROCEDURE/ ILLUSTRATION</b>   |  |  | <b>TOOLS/PPE</b>   | <b>QUALITY POINTERS</b>                               |
| 1             | Clamp Assy          | <div style="text-align: center;"> <b>TABLE LAYOUT</b> </div>   |  |  | <div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b><br/>           Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Housekeeping</b><br/>           1. Maintain and always practice 5's.<br/>           2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b><br/>           For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div> <div style="text-align: center;"> <br/> <b>BANDO GUN</b> </div> | 1. No missing parts/tools<br>2. No excess parts/tools |

|                  |         |                   |            |              |             |             |             |               |
|------------------|---------|-------------------|------------|--------------|-------------|-------------|-------------|---------------|
| Revision History |         |                   |            |              | Prepared by | Reviewed by | Approved by | Noted by      |
| 07/10/24         | 0       | Initial issue     | D.Castillo | C.Villanueva | A. Arañes   | N/A         |             |               |
| Eff. Date        | Rev. No | Details of Change | Revised    | Reviewed     | Approved    | Noted       | Est. Date:  | July 10, 2024 |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

**WORK INSTRUCTION**

Process Name/Title:

**CLAMP ASSEMBLY PROCESS**

Effectivity Date:

July 10, 2024

Model code/Part number:

**100B / 7M0594-7021**

Customer:

**TRJ**

Car Model:

**LEXUS US**

Document No.:

**WI-ENG-PDE-902**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


2 of 11

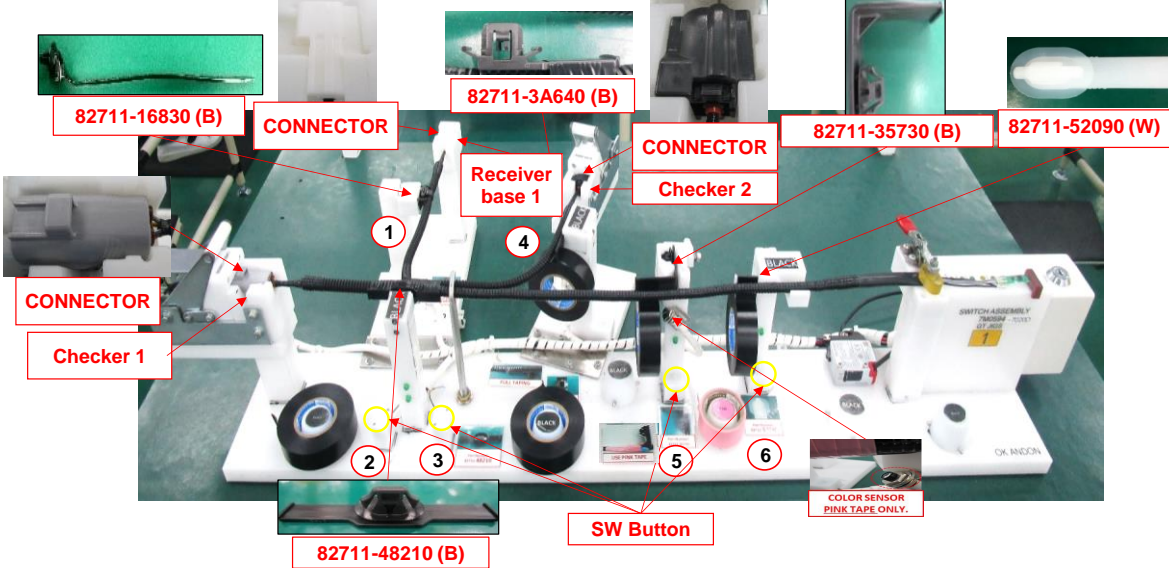

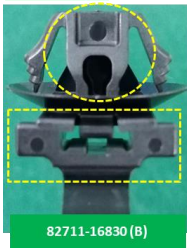

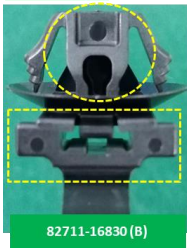

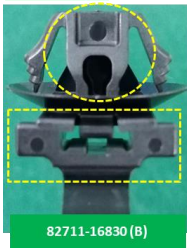

|               |  |  |                  |  |
|---------------|--|--|------------------|--|
| <b>PARTS:</b> | 1. Clamp 82711-48210 (B)<br>2. Clamp 82711-3A640 (B)<br>3. Clamp 82711-35730 (B) | 4. Clamp 82711-52090 (W)<br>5. Black tape [5pcs.]<br>6. Pink tape [1pc.]   | JIG:             | 1. Clamp Assembly Jig  |
| <b>NO.</b>    | <b>PROCESS NAME</b>  | <b>WORK PROCEDURE/ ILLUSTRATION</b>  | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |
| 2             | Clamp Assy<br><br>Clamp setting  | <div>1. Get 1pc. of clamp <b>82711-48210 (B)</b> using right hand then set to clamp location <b>2 and 3</b> using both hands.</div> <div>2. Get 1pc. of clamp <b>82711-3A640 (B)</b> using right hand then set to clamp location <b>4</b> using both hands.</div> <div>3. Get 1pc. of clamp <b>82711-35730 (B)</b> using right hand then set to clamp location <b>5</b> using both hands.</div> <div>4. Get 1pc. of clamp <b>82711-52090 (W)</b> using right hand then set to clamp location <b>6</b> using both hands.</div> <div>5. Initially attach <b>Black tape</b> on clamp location <b>2, 3, 4, 5 and 6</b> using both hands.</div> |                  | <div><b>STANDARD TAPING FOR CLAMP</b></div> <div>One wind for under clamp</div> <div>1. No damaged clamp<br/>2. No wrong use of parts<br/>3. No wrong use of tape<br/>4. No wrong insertion of clamp</div> <div><b>Important reminders/Note/s:</b><br/><b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></div> <div><b>CLAMP ILLUSTRATION</b></div> <div></div> |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp

|   |   |  |                      |                            |                   |                       |           |         |
|---|---|--|----------------------|----------------------------|-------------------|-----------------------|-----------|---------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                            | Effectivity Date: | <b>July 10, 2024</b>  |           |         |
|   | Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>   |  |                      |                            | Validity Date:    | n/a                   |           |         |
|   | Model code/Part number: <b>100B / 7M0594-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS US</b> | Document No.:     | <b>WI-ENG-PDE-902</b> |           |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                            | Revision No.:     | 0                     | Page No.: | 3 of 11 |

|   |   |  |                  |   |                       |             |           |   |   |                 |                 |
|---|---|--|------------------|---|-----------------------|-------------|-----------|---|---|-----------------|-----------------|
| <b>PARTS:</b>   | 1. Assy parts<br>2. Clamp 82711-16830 (W)<br>3. Black tape                            |  |                  | JIG:  | 1. Clamp Assembly Jig |             |           |   |   |                 |                 |
| <b>NO.</b>  | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>  | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>   |                       |             |           |   |   |                 |                 |
| 3   | Clamp Assy<br><br>Clamp setting   | <div></div> <div>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector <b>6188-0066 (GR)</b> to <b>Checker 1</b> then pull the checker fixture for continuity checking. Second, set the connector <b>6098-3802 (W)</b> to <b>Receiver base 1</b>. Third, set the connector <b>6189-1161 (B)</b> to <b>Checker 2</b> then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the hotmelted wire and <b>B-B wires</b> together within stopper then press by toggle clamp.</div> <div>2. Check if all <b>LED light</b> for <b>POWER ON, WIRE1, WIRE2 and CLAMP ON</b> was <b>ON</b>. If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process.</div> <div>3. Get 1pc. of clamp <b>82711-16830 (W)</b> using right hand then set to clamp location <b>1</b> using both hands.</div> |                  | <div><br/><b>Important reminders/Note/s:</b><br/><b>1. Make sure no gap between stopper and PCB</b><br/><b>2. Make 2-3 windings for clamp taping</b><br/><br/>1. No loose/tight clamp attached<br/>2. No damage clamp<br/>3. No missed tape<br/>4. No missing parts<br/>5. Make sure no clearance between PCB and stopper jig</div> <div><b>BAND CLAMP ILLUSTRATION</b><br/><table><tr><td><b>GOOD</b></td><td><b>NG</b></td></tr><tr><td></td><td></td></tr><tr><td>82711-16830 (B)</td><td>82711-34490 (B)</td></tr></table></div> |                       | <b>GOOD</b> | <b>NG</b> |  |  | 82711-16830 (B) | 82711-34490 (B) |
| <b>GOOD</b>   | <b>NG</b>   |  |                  |   |                       |             |           |   |   |                 |                 |
|  |  |  |                  |   |                       |             |           |   |   |                 |                 |
| 82711-16830 (B)   | 82711-34490 (B)   |  |                  |   |                       |             |           |   |   |                 |                 |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp





## WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Model code/Part number:

100B / 7M0594-7021

Customer:

TRJ

Car Model:

LEXUS US

Document No.:

WI-ENG-PDE-902

Purpose:

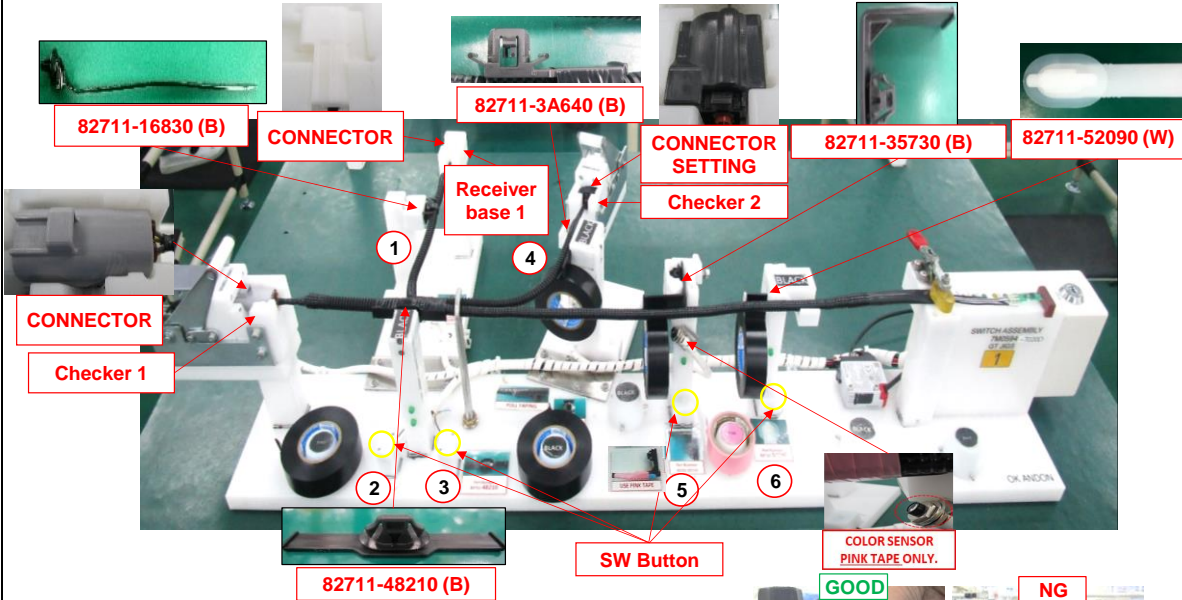


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

4 of 11

|        |              |  |  |  |                       |
|--------|--------------|--|--|--|-----------------------|
| PARTS: |              | 1. Assy parts<br>2. Black tape   |  | JIG:   | 1. Clamp Assembly Jig |
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE  | QUALITY POINTERS      |
| 3      | Clamp Assy   | Clamp setting  |  |  |                       |
|        |              | <div><div>4. Initially tighten the band clamp on clamp location <b>1</b> using right hand.</div><div>5. Get the bando gun using right hand then cut the band clamp on location <b>1</b>. Press the <b>SW button</b> after taping. Continue if the sequence light on clamp location <b>2</b> was <b>ON</b>.</div></div> |  | <div><p><b>Important reminders/Note/s:</b></p><p>1. Make sure no gap between stopper and PCB</p><p>2. Make 2-3 windings for clamp taping</p><p>1. No loose/tight clamp attached<br/>2. No damage clamp<br/>3. No missed tape<br/>4. No missing parts<br/>5. Make sure no clearance between PCB and stopper jig</p><div><p><b>BANDO GUN ILLUSTRATION</b></p></div></div> |                       |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp



# WORK INSTRUCTION

Process Name/Title:

## CLAMP ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Validity Date:

n/a

Model code/Part number:

100B / 7M0594-7021

Customer:

TRJ

Car Model:

LEXUS US

Document No.:

WI-ENG-PDE-902

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

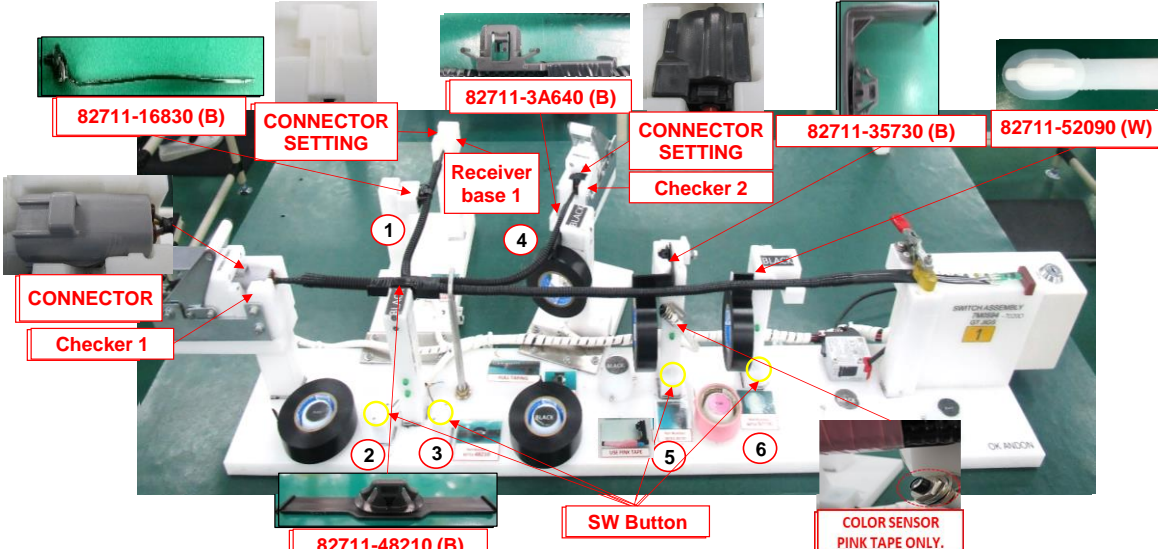
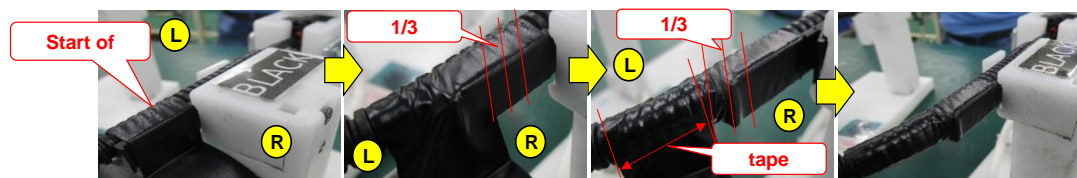

☒ MASSPRO

Revision No.:

0

Page No.:


5 of 11

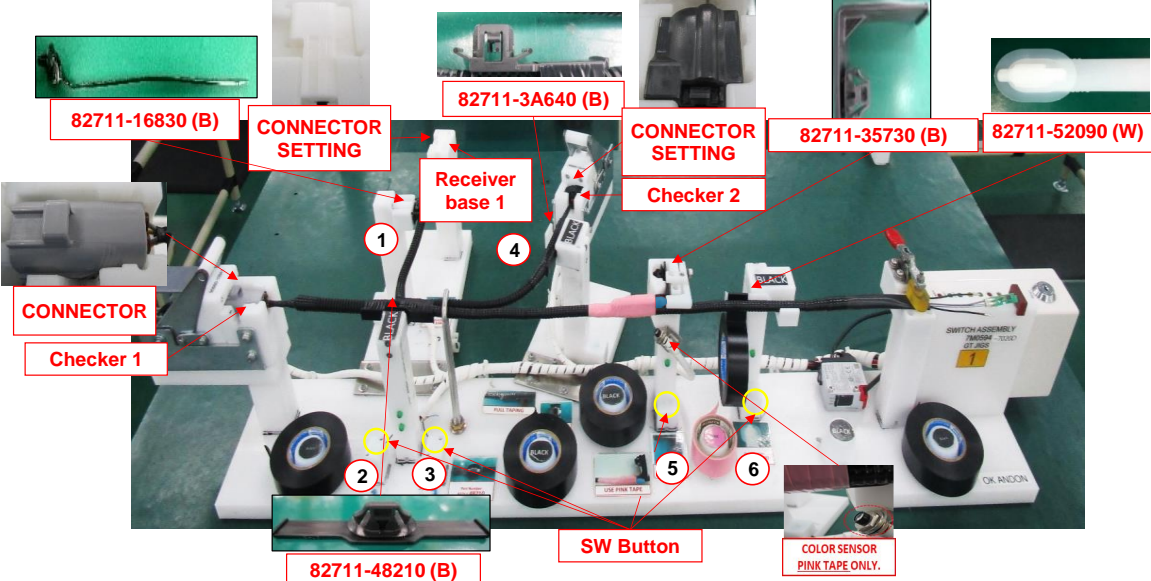
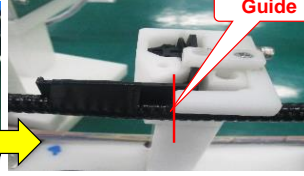
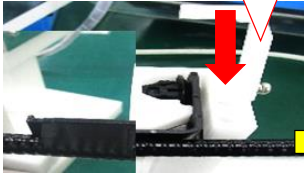
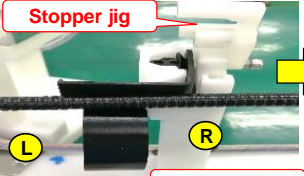

|        |  |   |  |           |   |
|--------|--|---|--|-----------|---|
| PARTS: |  | 1. Assy parts<br>2. Black tape  |  | JIG:      | 1. Clamp Assembly Jig   |
| NO.    | PROCESS NAME                                       | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE | QUALITY POINTERS  |
| 3      | Clamp Assy<br><br>Clamp Assembly<br>(Continuation) | <div></div> <div><p>6. Hold the Black tape using right hand then start taping using both hands on clamp location 2. Make <b>3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location 3 was <b>ON</b>.</p><p>7. Hold the Black tape using right hand and then start taping using both hands on clamp location 3. Make <b>3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location 4 was <b>ON</b>.</p><p>8. Hold the Black tape using right hand and then start taping using both hands on clamp location 4. Make <b>3 windings</b> of tape then cut the tape. Press the <b>SW button</b> after taping. Continue if the sequence light on location 5 was <b>ON</b>. <b>Note: Follow below taping procedure for location 4.</b></p></div> <div></div> |  |           | <div></div> <div><p><b>Important reminders/Note/s:</b></p><p><b>1. Make sure no gap between stopper and PCB</b></p><p><b>2. Make 2-3 windings for clamp taping</b></p></div> <div><p>1. No loose/tight clamp attached<br/>2. No damage clamp<br/>3. No missed tape<br/>4. No missing parts<br/>5. Make sure no clearance between PCB and stopper jig</p></div> |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp

|   |   |  |                      |                            |                   |                       |           |         |
|---|---|--|----------------------|----------------------------|-------------------|-----------------------|-----------|---------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                            | Effectivity Date: | <b>July 10, 2024</b>  |           |         |
|   | Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>   |  |                      |                            | Validity Date:    | n/a                   |           |         |
|   | Model code/Part number: <b>100B / 7M0594-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS US</b> | Document No.:     | <b>WI-ENG-PDE-902</b> |           |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                            | Revision No.:     | 0                     | Page No.: | 6 of 11 |


|               |   |   |   |                         |                       |
|---------------|---|---|---|-------------------------|-----------------------|
| <b>PARTS:</b> | 1. Assy parts<br>2. Black tape                  |   |   | JIG:                    | 1. Clamp Assembly Jig |
| <b>NO.</b>    | <b>PROCESS NAME</b>                             | <b>WORK PROCEDURE/ ILLUSTRATION</b>   | <b>TOOLS/PPE</b>  | <b>QUALITY POINTERS</b> |                       |
| 3             | Clamp Assy<br><br>Clamp Assembly (Continuation) | <div><div></div></div> | <div><p><b>Important reminders/Note/s:</b><br/><b>1. Make sure no gap between stopper and PCB</b><br/><b>2. Make 2-3 windings for clamp taping</b></p><p>1. No loose/tight clamp attached<br/>2. No damage clamp<br/>3. No missed tape<br/>4. No missing parts<br/>5. Make sure no clearance between PCB and stopper jig</p></div> <div><p>9. Hold the Black tape using right hand and then start taping using both hands on clamp location <b>5</b>. Make <b>3 windings</b> of tape then cut the tape.</p></div> <div><p>10. After spot taping, pull the stopper jig.</p></div> |                         |                       |

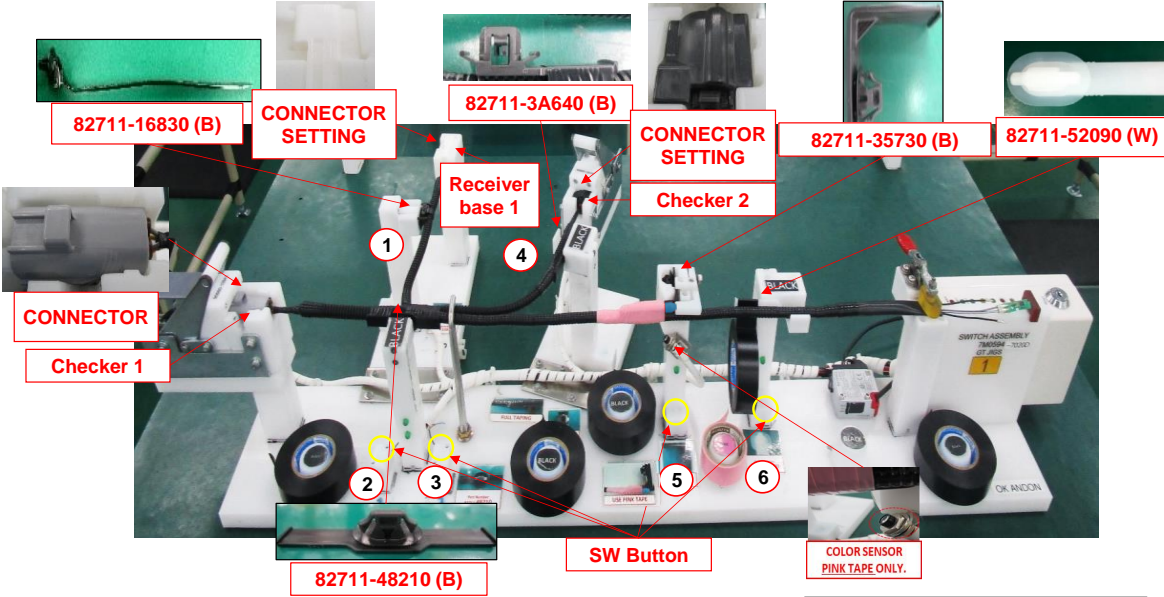
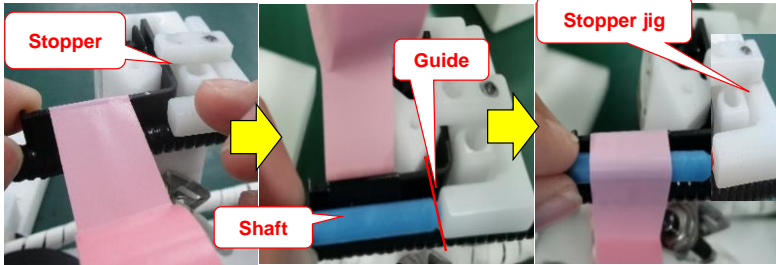

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp




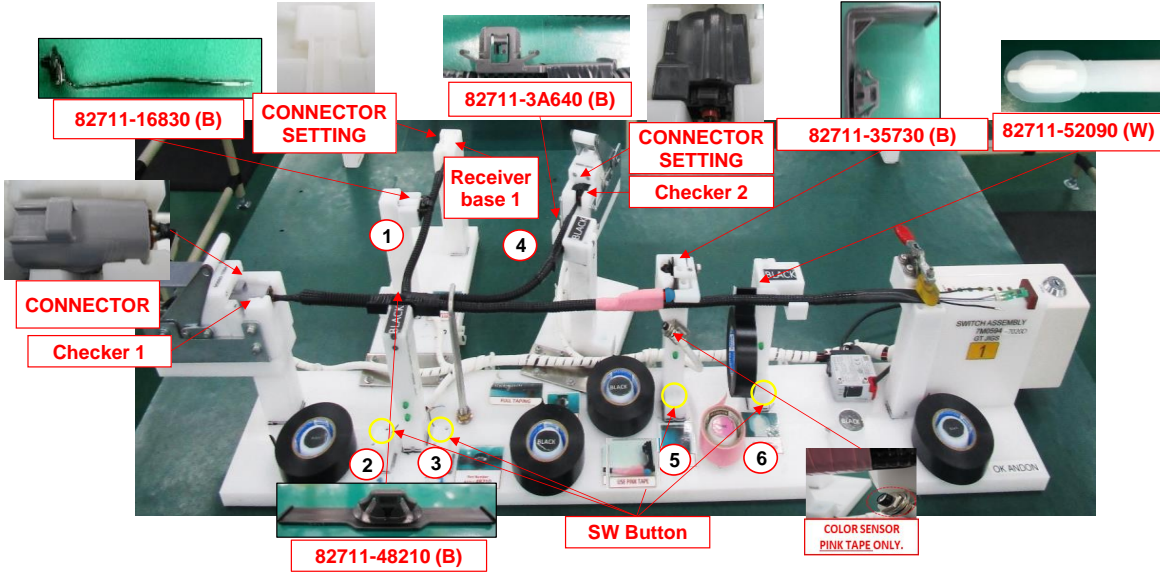
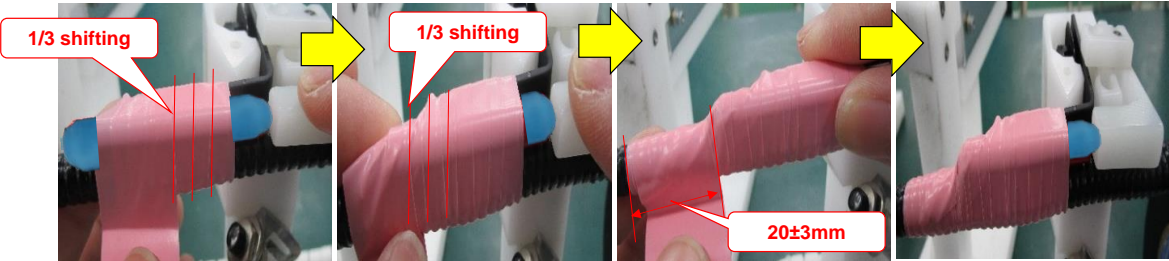

|   |   |  |                      |                            |                   |                       |           |         |
|---|---|--|----------------------|----------------------------|-------------------|-----------------------|-----------|---------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                            | Effectivity Date: | <b>July 10, 2024</b>  |           |         |
|   | Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>   |  |                      |                            | Validity Date:    | n/a                   |           |         |
|   | Model code/Part number: <b>100B / 7M0594-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS US</b> | Document No.:     | <b>WI-ENG-PDE-902</b> |           |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                            | Revision No.:     | 0                     | Page No.: | 7 of 11 |

|               |   |   |                  |  |                       |
|---------------|---|---|------------------|--|-----------------------|
| <b>PARTS:</b> | 1. Assy parts<br>2. Blue Shaft Webbing stopper 7H0738-0200<br>3. Black tape |   |                  | JIG:   | 1. Clamp Assembly Jig |
| <b>NO.</b>    | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>   | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |                       |
| 3             | Clamp Assy<br><br>Clamp Assembly<br>(Continuation)                          | <br> <div>11. Get the <b>PINK</b> tape using right hand then initially attach to clamp using both hands, get the <b>SHAFT (blue color)</b> and fit into guide then make <b>2 windings</b> of tape before shifting.<br/><b>Note: Color sensor will beep/buzz if sensor detects PINK TAPE and Initial black tape on the clamp must be cover by Pink tape; Follow taping procedure for location 5.</b></div> |                  | <br><b>Important reminders/Note/s:</b><br><b>1. Make sure no gap between stopper and PCB</b><br><br><b>2. Make 2-3 windings for clamp taping</b><br><br>1. No loose/tight clamp attached<br>2. No damage clamp<br>3. No missed tape<br>4. No missing parts<br>5. Make sure no clearance between PCB and stopper jig |                       |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

|   |   |  |                      |                            |                   |                       |           |         |
|---|---|--|----------------------|----------------------------|-------------------|-----------------------|-----------|---------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                            | Effectivity Date: | <b>July 10, 2024</b>  |           |         |
|   | Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>   |  |                      |                            | Validity Date:    | n/a                   |           |         |
|   | Model code/Part number: <b>100B / 7M0594-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS US</b> | Document No.:     | <b>WI-ENG-PDE-902</b> |           |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                            | Revision No.:     | 0                     | Page No.: | 8 of 11 |


|               |  |   |                  |  |
|---------------|--|---|------------------|--|
| <b>PARTS:</b> | 1. Assy parts<br>2. Black tape                     |   | JIG:             | 1. Clamp Assembly Jig  |
| <b>NO.</b>    | <b>PROCESS NAME</b>                                | <b>WORK PROCEDURE/ ILLUSTRATION</b>   | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |
| 3             | Clamp Assy<br><br>Clamp Assembly<br>(Continuation) | <br><br>12. Make <b>1/3 shifting</b> going to corrugated tube until it reach tape width then make <b>3 windings</b> of tape before cut. Press the <b>SW button</b> after taping. Continue if the sequence light on location <b>6</b> was <b>ON</b> . |                  | <br><b>Important reminders/Note/s:</b><br><b>1. Make sure no gap between stopper and PCB</b><br><b>2. Make 2-3 windings for clamp taping</b><br><br>1. No loose/tight clamp attached<br>2. No damage clamp<br>3. No missed tape<br>4. No missing parts<br>5. Make sure no clearance between PCB and stopper jig |

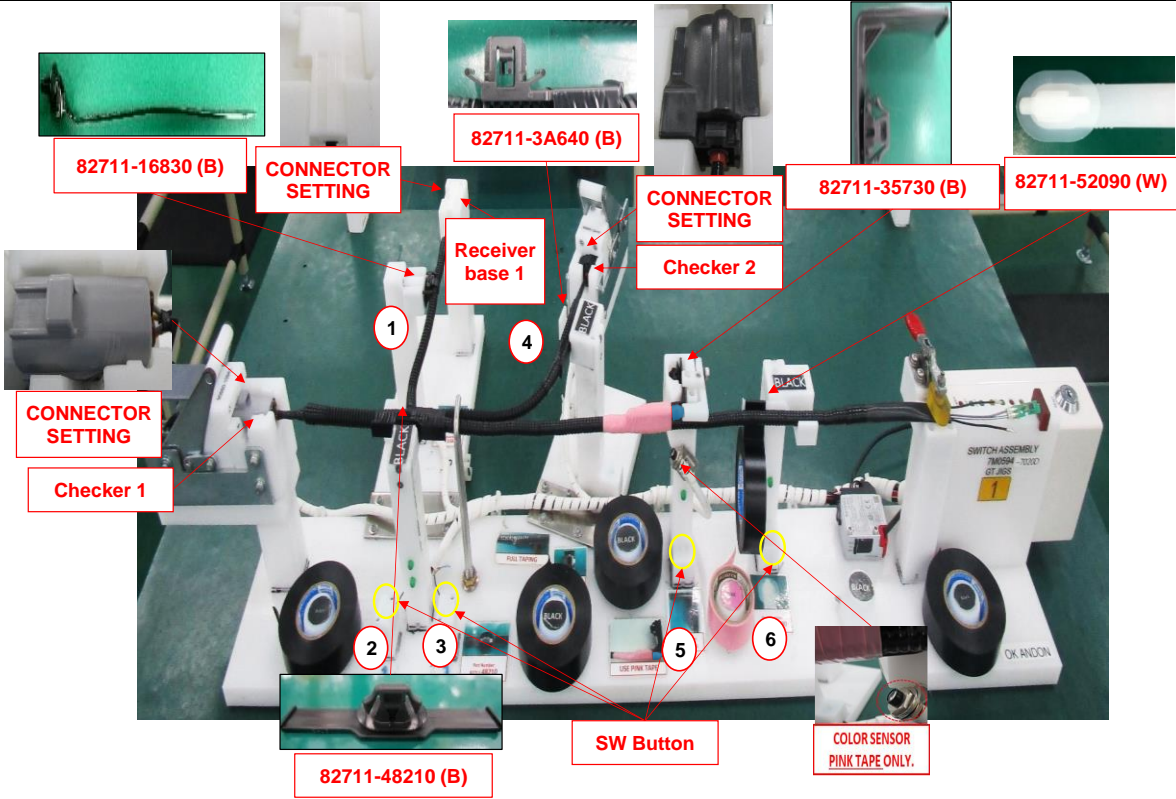
**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



|   |   |  |                      |                            |                   |                       |           |         |
|---|---|--|----------------------|----------------------------|-------------------|-----------------------|-----------|---------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                            | Effectivity Date: | <b>July 10, 2024</b>  |           |         |
|   | Process Name/Title: <b>CLAMP ASSEMBLY PROCESS</b>   |  |                      |                            | Validity Date:    | n/a                   |           |         |
|   | Model code/Part number: <b>100B / 7M0594-7021</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS US</b> | Document No.:     | <b>WI-ENG-PDE-902</b> |           |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                            | Revision No.:     | 0                     | Page No.: | 9 of 11 |

|               |                                |                                     |  |   |  |
|---------------|--------------------------------|-------------------------------------|--|---|--|
| <b>PARTS:</b> | 1. Assy parts<br>2. Black tape |                                     |  | JIG:  | 1. Clamp Assembly Jig  |
| <b>NO.</b>    | <b>PROCESS NAME</b>            | <b>WORK PROCEDURE/ ILLUSTRATION</b> |  | <b>TOOLS/PPE</b>  | <b>QUALITY POINTERS</b>  |
| 3             | Clamp Assy                     | Clamp Assembly (Continuation)       |  |  | <p><b>Important reminders/Note/s:</b></p> <p><b>1. Make sure no gap between stopper and PCB</b></p> <p><b>2. Make 2-3 windings for clamp taping</b></p> <p>1. No loose/tight clamp attached<br/>2. No damage clamp<br/>3. No missed tape<br/>4. No missing parts<br/>5. Make sure no clearance between PCB and stopper jig</p> |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

**MASTER COPY**

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

**CLAMP ASSEMBLY PROCESS**

Effectivity Date:

July 10, 2024

Model code/Part number:

**100B / 7M0594-7021**

Customer:

**TRJ**

Car Model:

**LEXUS US**

Document No.:

**WI-ENG-PDE-902**

Purpose:


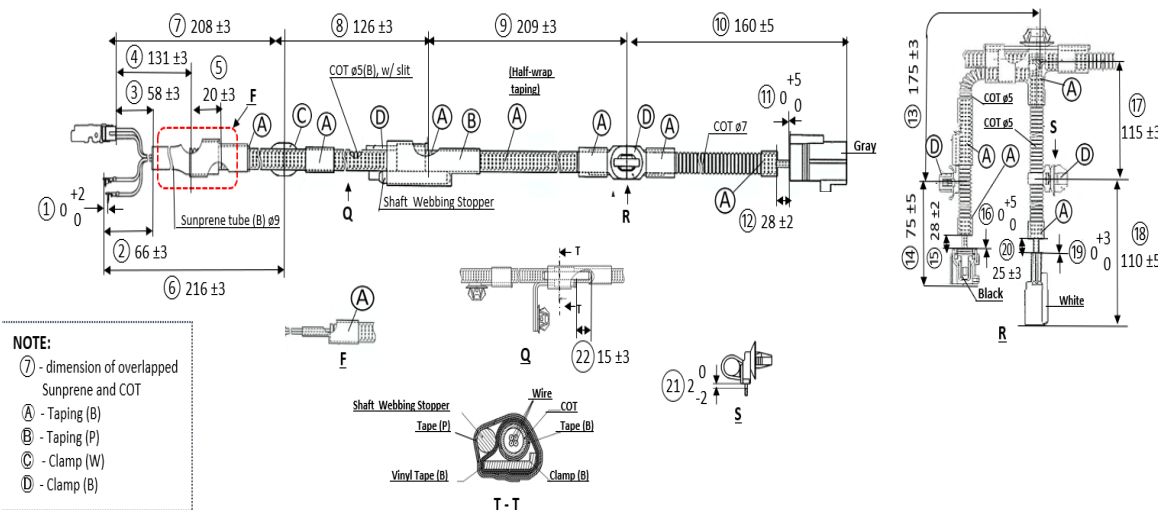
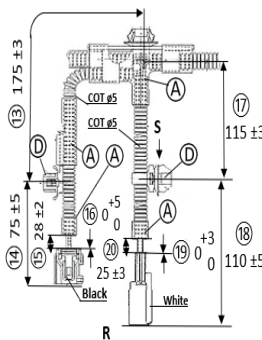
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

10 of 11

|        |                               |  |  |   |
|--------|-------------------------------|--|--|---|
| PARTS: | 1. Assy parts                 |  | JIG:   | n/a   |
| NO.    | PROCESS NAME                  | WORK PROCEDURE/ ILLUSTRATION   | TOOLS/PPE  | QUALITY POINTERS  |
| 4      | Clamp Assy<br><br>Measurement | <div><div>MEASURING TAPE</div></div>  <div><p><b>NOTE:</b></p><ul style="list-style-type: none"><li>⑦ - dimension of overlapped Sunprene and COT</li><li>A - Taping (B)</li><li>B - Taping (P)</li><li>C - Clamp (W)</li><li>D - Clamp (B)</li></ul></div> |  | <p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p> |

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Validity Date:

n/a

Model code/Part number:

100B / 7M0594-7021

Customer: TRJ

Car Model:

LEXUS US

Document No.:

WI-ENG-PDE-902

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

0

Page No.:

11 of 11

PARTS:

1. Assy parts

JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

Clamp  
Assy

# 7M0594-7021



**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp