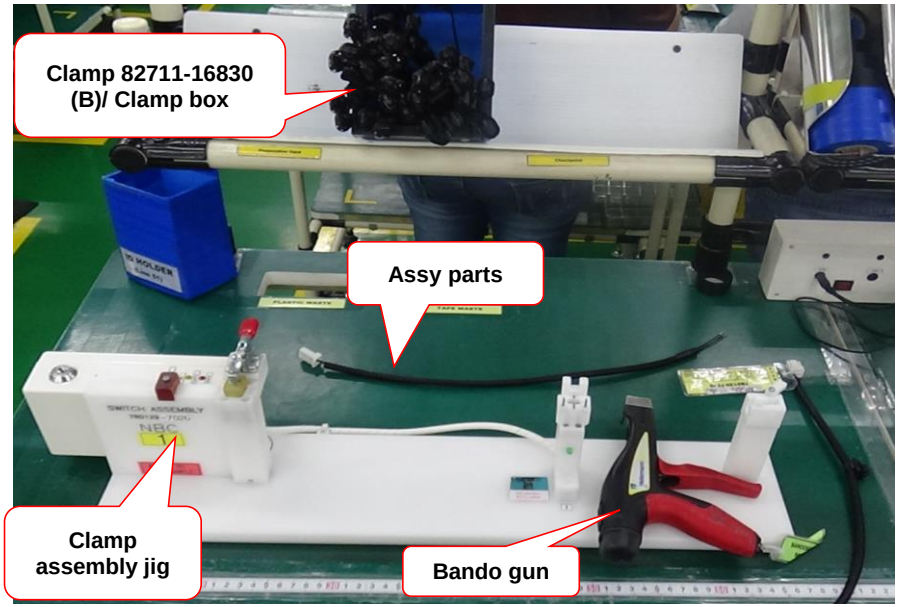
	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 200D / 7R0129-7020	Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.:	WI-ENG-PDE-772		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	1 of 5

PARTS:	1. All parts: Assy parts; Clamp 82711-16830 (B)	JIG:	1. Clamp Assembly 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 prescribed 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. **BANDO GUN** 	***Document references:*** ***1. Refer to WI-ENG-PDE-437 Taping Assembly Process*** 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.Transfer Clamp setting to Measurement process from Taping assembly process (WI-ENG-PDE-437) due to process improvement.	D.Castillo	C.Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 11, 2024		

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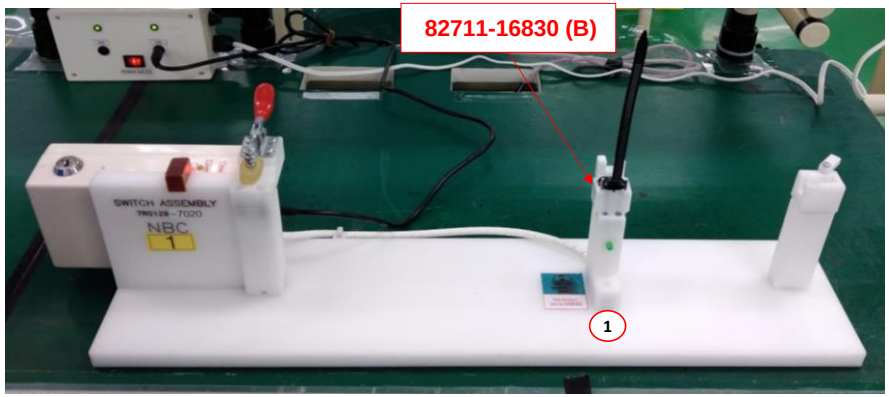
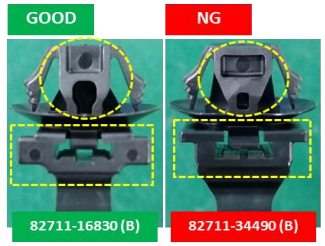
	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	200D / 7R0129-7020	Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.:	WI-ENG-PDE-772	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 2 of 5

PARTS:	1. Clamp 82711-16830 (B) [1pc.]			JIG:	1. Clamp Assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	CLAMP ASSY	Clamp setting	  1. Get 1pc. of clamp **82711-16830 (B)** using right hand and set to clamp location **1** using both hands.	n/a	***Important reminders/Note/s:*** ***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.*** 1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp **BAND CLAMP ILLUSTRATION** 

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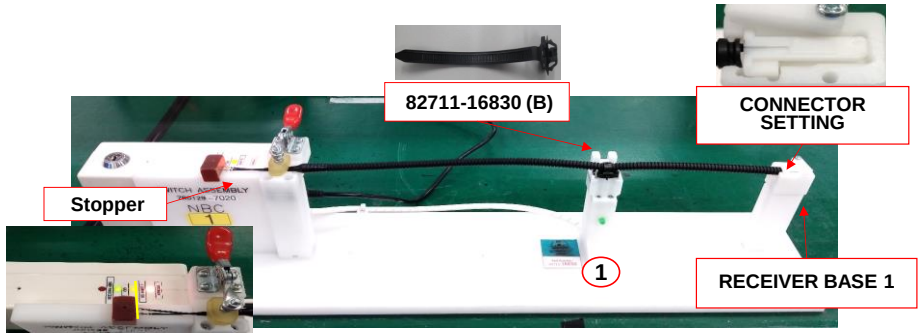
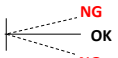
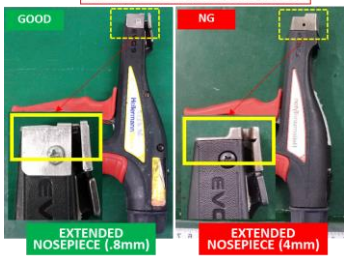
	WORK INSTRUCTION			Effectivity Date:	June 11, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 200D / 7R0129-7020	Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.:	WI-ENG-PDE-772	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 3 of 5

PARTS:	1. Assy parts	JIG:	1. Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	CLAMP ASSEMBLY	 1.Get the assy parts and set into jig. *(See above picture for correct setting).* First, set the connector **6098-3810 (W)** to **Receiver base 1**. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of **location ①** was on. 2. Check if all **LED light** for **POWER ON, and CLAMP ON** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process. 3. Initially tighten the band clamp on location **1** using both hands. 4. Get the bando gun using right hand then cut the band clamp on location **1** using both hands. Press the **SW button** after cut. **Go** sound will be heard. 5. Conduct **POINT CHECKING** before removing the harness from jig. BANDO GUN POSITION ON CLAMP Location 1 **Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.** **For: ø5 - 1~2, ø7 - 3~4** PERPENDICULARITY  Fixed setting of band clamp cutter: 1~ 2	BANDO GUN 	 ***Important reminders/Note/s:*** ***1. Make sure no gap between stopper and terminals*** 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts BANDO GUN ILLUSTRATION 

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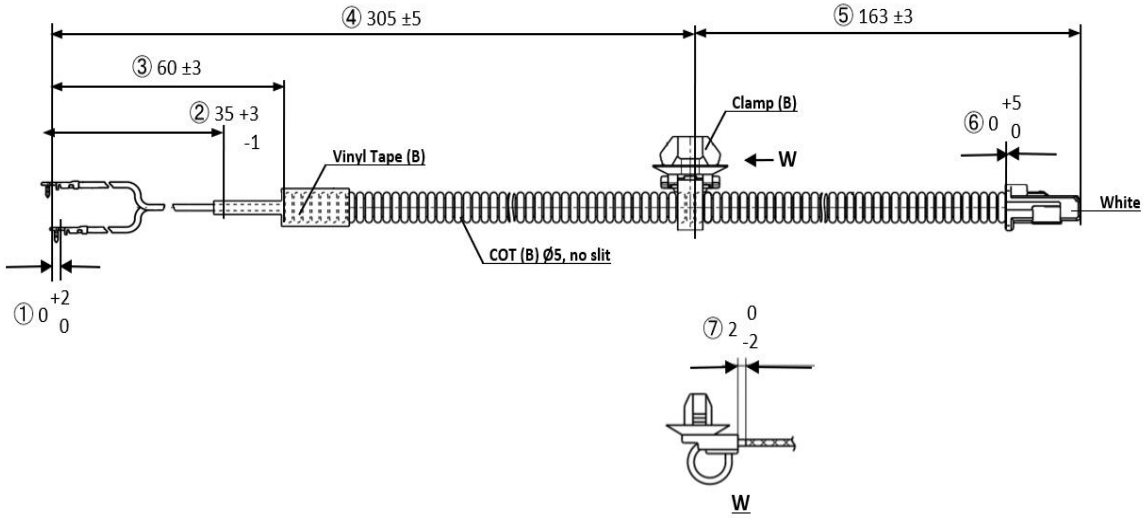
	Model code/Part number: 200D / 7R0129-7020	Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.:	WI-ENG-PDE-772	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 4 of 5

PARTS:	1.Assy Part			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	CLAMP ASSY	Measurement		**MEASURING TAPE**	***Important reminders and note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* *2. For Hatsumono, Nakamono and Owarimono.* ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension

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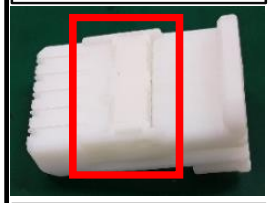
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.: 0	Page No.: 5 of 5

PARTS:	1.Assy Part	JIG:	n/a

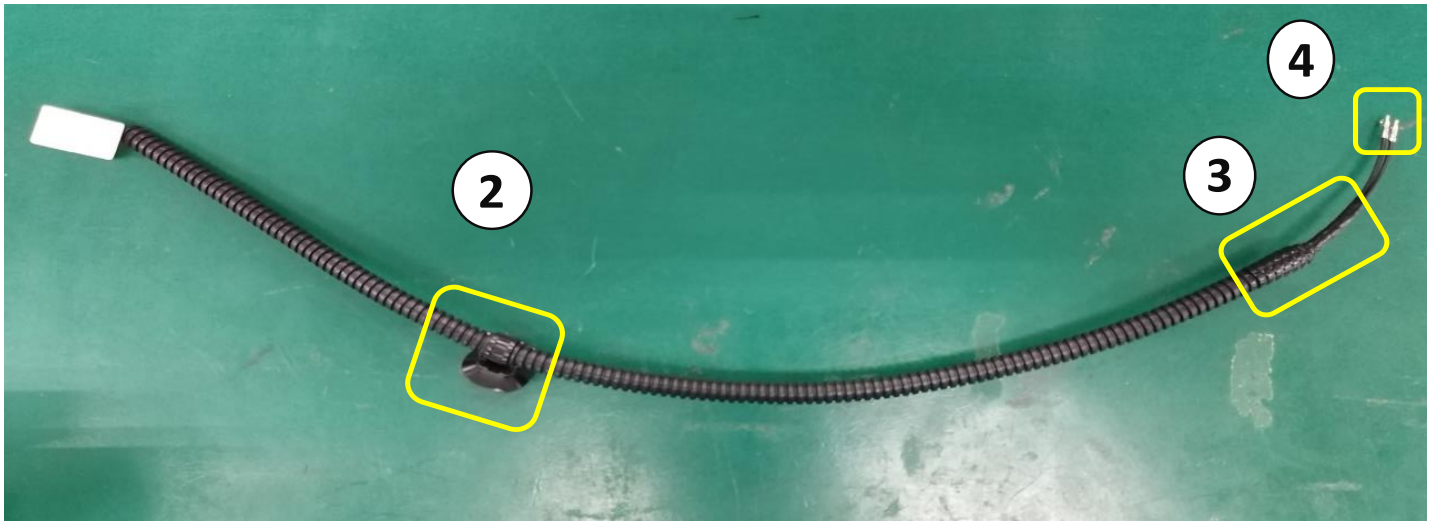
VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY **7R0129-7020**

GOOD



NO GOOD



GOOD

NO GOOD

1. No Unlock/ Halflock Connector
2. No Missing band clamp
3. No Missing Tape
4. No Deformed Terminal
5. No Terminal Backing Out

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