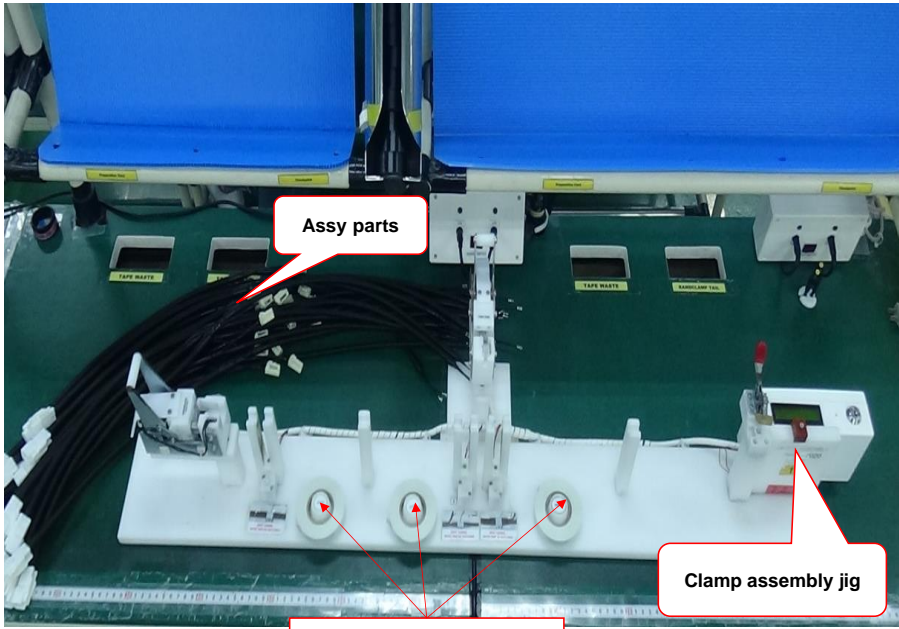
	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS				Effectivity Date:	June 3, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: YKC / 7N0034-7020		Customer: TRJ	Car Model: SUZUKI SOLIO	Document No.:	WI-ENG-PDE-908		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5

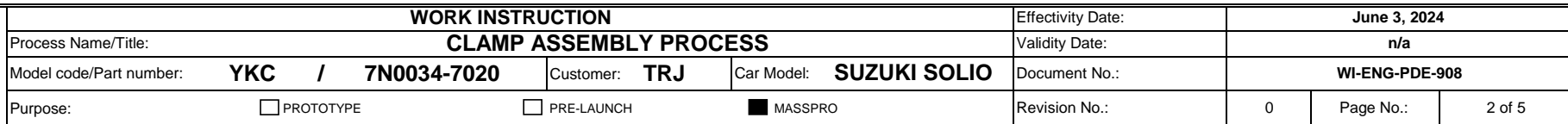
PARTS:	1. Assy parts; White tape			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp assy	<div style="border: 1px solid red; padding: 5px; text-align: center;">TABLE LAY-OUT</div>  <div style="border: 1px solid red; padding: 2px; display: inline-block;">Assy parts</div> <div style="border: 1px solid red; padding: 2px; display: inline-block;">Clamp assembly jig</div> <div style="border: 1px solid red; padding: 2px; display: inline-block;">White tape/ Tape Holder</div>		<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p>2. Refer to WI-ENG-PDE-373A-B for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/03/24	0	Initial issue. Separate Clamp assembly process due to process improvemnet. Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
							June 3, 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

DCC Stamp



<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.</p>	<p>NBC (Philippines) MASTER COPY</p>	<p>DCC Stamp</p>
---	--	------------------

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Model code/Part number:

YKC / 7N0034-7020

Customer:

TRJ

Car Model:

SUZUKI SOLIO

Document No.:

WI-ENG-PDE-908

Purpose:

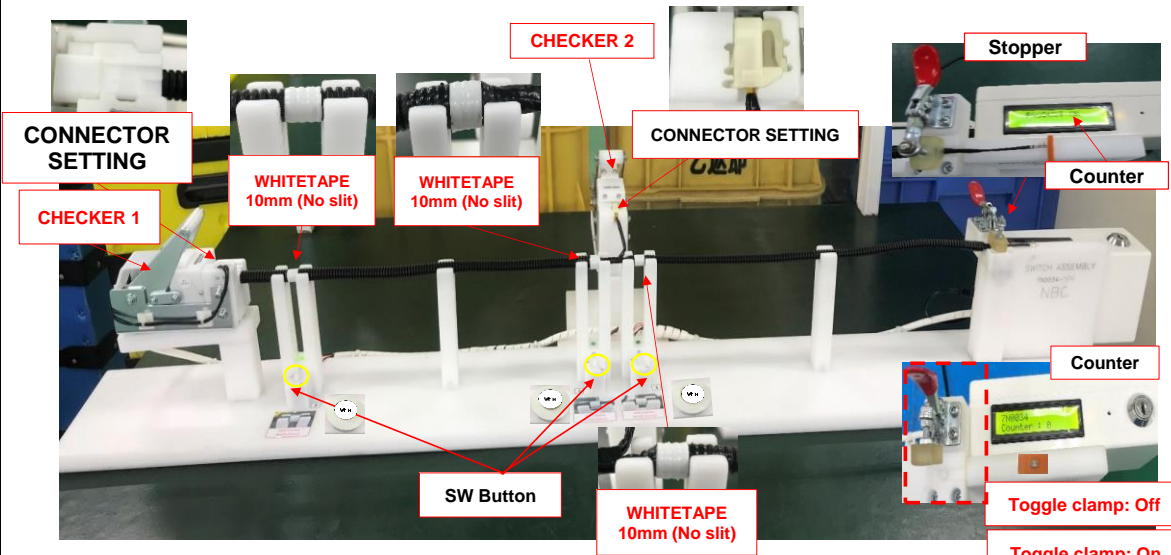
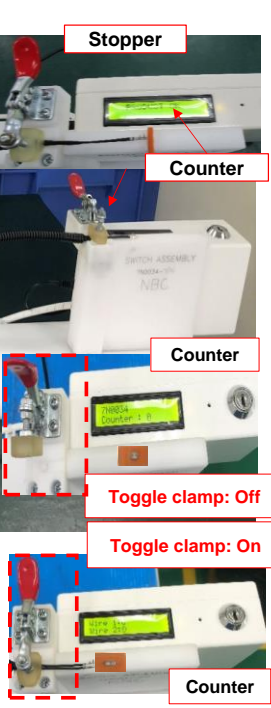

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Assy parts 2. White tape	JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy Clampa assembly (Continuation)	<div><p>3. Get the White tape 10mm (no slit) using right hand then conduct spot taping using both hands on location 1. Make 3 windings then cut the tape. Press the SW button using right hand. Continue if sequence light on location 2 was ON.</p><p>4. Get the White tape 10mm (no slit) using right hand then conduct spot taping using both hands on location 2. Make 3 windings then cut the tape. Press the SW button using right hand. Continue if sequence light on location 3 was ON.</p><p>5. Get the White tape 10mm (no slit) using right hand then conduct spot taping using both hands on location 3. Make 3 windings then cut the tape. Press the SW button using right hand. GO sound will be heard.</p><p>6. Conduct POINT CHECKING before removing the harness from jig.</p></div>	<div><p>Counter</p><p>Toggle clamp: Off</p><p>Toggle clamp: On</p><p>Counter</p></div>	<div><p>Important reminders/note/s:</p><p>1. Make sure no gap between terminal and stopper jig.</p><p>1. No wrong insert 2. Make sure no gap between terminal and stopper jig 3. No wrong use of tape 4. No excess windings 5. No missed tape</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

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number:

YKC / 7N0034-7020

Customer:

TRJ

Car Model:

SUZUKI SOLIO

Document No.:

WI-ENG-PDE-908

Purpose:


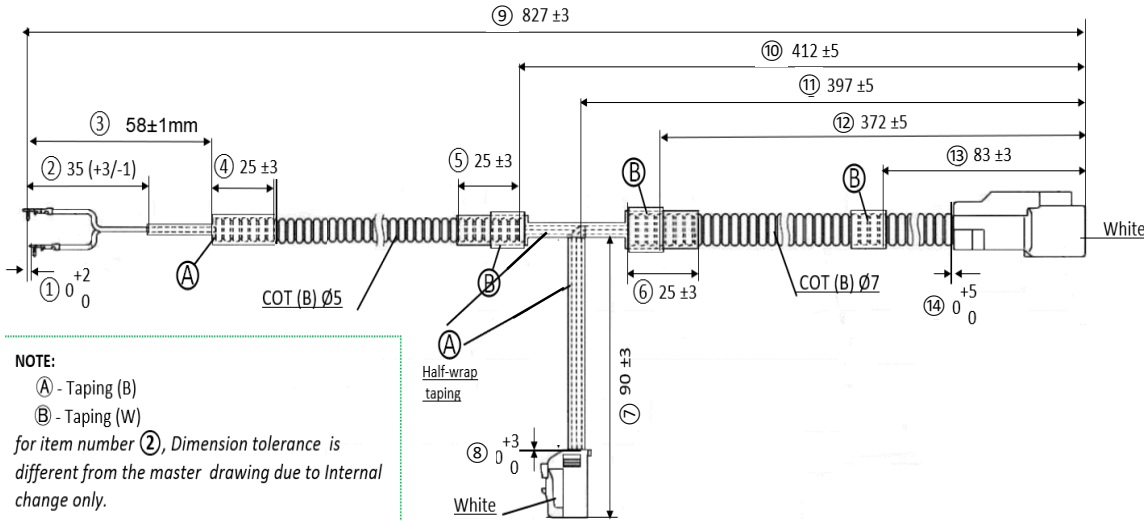
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

4 of 5

PARTS:	1. Assy parts		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Measurement	<div>MEASURING TAPE</div>   <p>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (W) for item number ②, Dimension tolerance is different from the master drawing due to Internal change only.</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> <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:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number:

YKC / 7N0034-7020

Customer: TRJ

Car Model:

SUZUKI SOLIO

Document No.:

WI-ENG-PDE-908

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

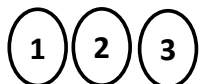
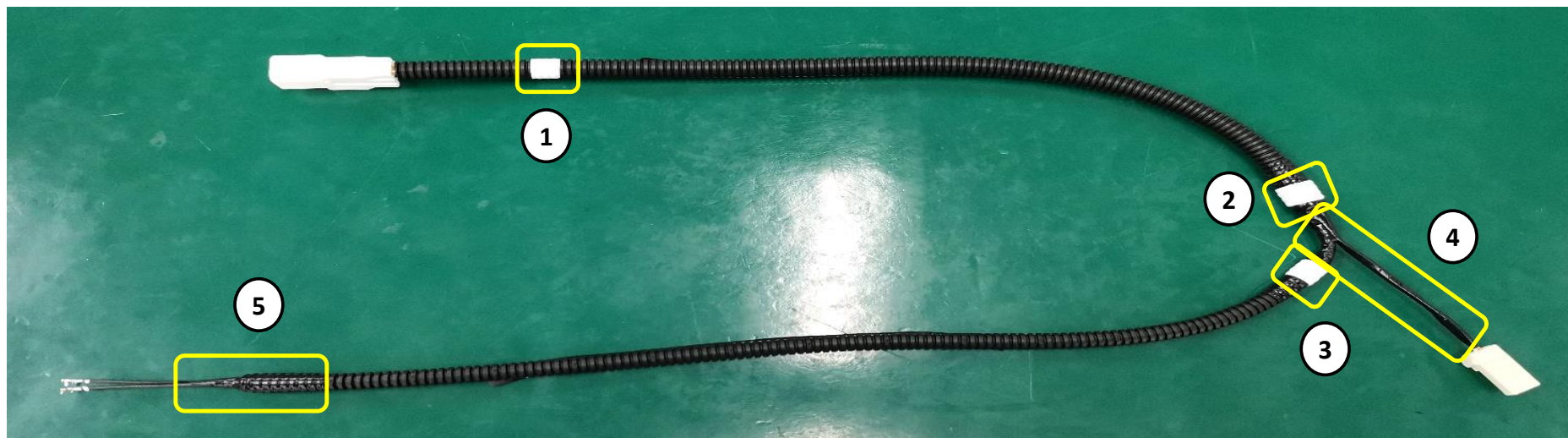
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0034-7020****No Missing Spot Tape
(White Tape)****No Missing Tape (Black Tape)**

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