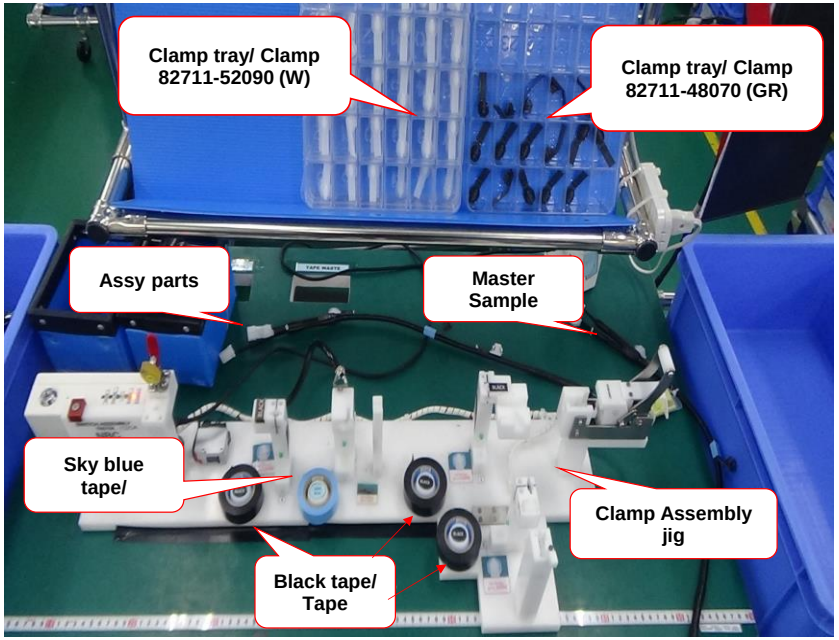
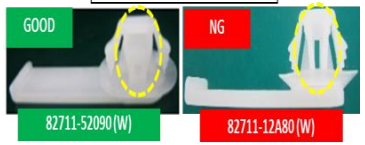
	WORK INSTRUCTION			Effectivity Date:	June 18, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 900B.910B / 7N0104-7020A	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-809		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	1 of 6

PARTS:	1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [3pcs.]; Sky Blue tape	JIG:	1. 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.	***Document reference/s:*** ***1. Refer to WI-ENG-PDE-809A-C for Taping assembly process*** 1. No missing parts in assy parts 2. No excess tape/tape holder 3. No wrong position of tape holder CLAMP ILLUSTRATION 

Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/18/24	0	Initial issue.	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 18, 2024		

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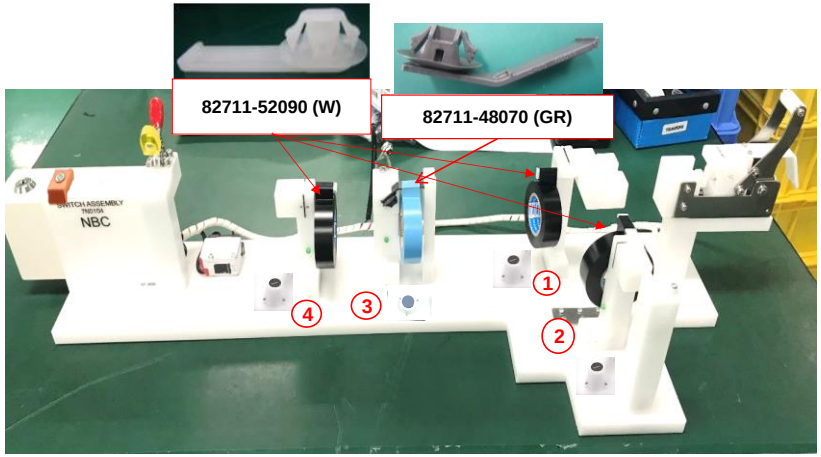
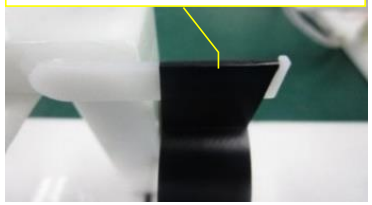
	WORK INSTRUCTION			Effectivity Date:	June 18, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 900B.910B / 7N0104-7020A	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-809		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	2 of 6

PARTS:	1.Clamp 82711-52090(W) [3pcs] 2.Clamp 82711-48070 (GR)	3. Black tape [3pcs.] 4. Sky Blue tape	JIG:	1.Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting	 1. Get the clamp **82711-52090 (W)** using right hand and put to location **1 and 2** using both hands. 2. Get the clamp **82711-52090 (W)** using right hand and put to location **4** using both hands. 3. Get the clamp **82711-48070 (W)** using right hand and put to location **3** using both hands. 4. Initially attach sky blue tape to location **3** using both hands. 5. Initially attach black tape to location **1, 2 and 4** using both hands.	n/a	One wind for under tape  ***Important reminders/Note/s:*** ***1. 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

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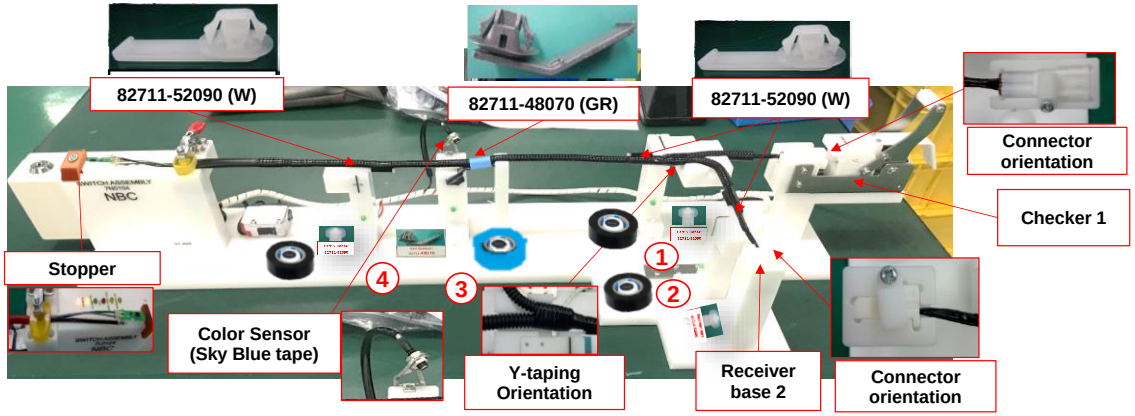
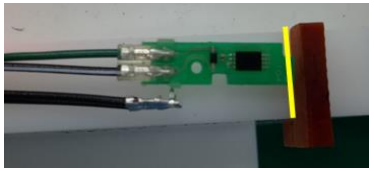
	WORK INSTRUCTION			Effectivity Date:	June 18, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 900B.910B / 7N0104-7020A	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-809		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	3 of 6

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 of harness).*** First, set the connector **6189-0407 (W)** to **Checker 1** then lock. Second, set the Y-taping into Y-taping guide. Third, set the connector **6098-3810 (W)** to **Receiver base 2** then lock. Continue to set the harness in jig. Last, set the hotmelted wires and terminal end together within the stopper then press by **Toggle clamp**. 2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2,** was **ON.** If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Check if the sequence light of **location 1** was **ON.** 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 taping. Continue the process if sequence light in clamp **location 2** was **ON.** 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 taping. Continue the process if sequence light in clamp **location 3** was **ON.**		 ***Important reminders/Note/s:*** ***1. Make sure no gap between stopper jig and PCB.*** 1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape

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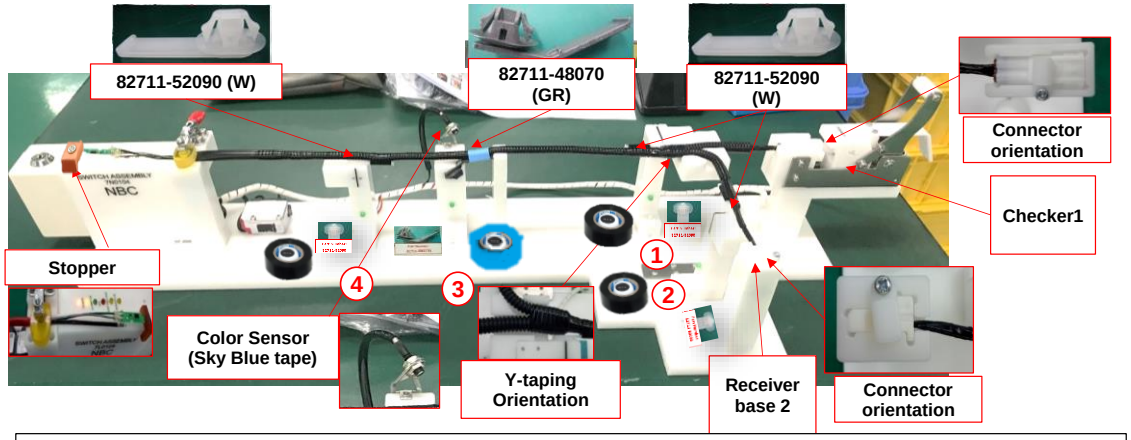
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0

PARTS:	1. Assy parts. 2. Black tape [3pcs]	3. Sky Blue tape	JIG:	1.Clamp Assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)			

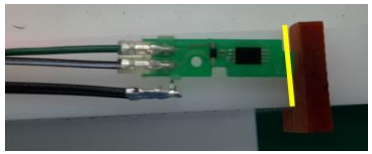


5. Get the **sky blue tape** on clamp **location 3.** Make **3 windings** of tape then cut the tape using both hands. Clamp assembly jig will beep/buzz if color sensor detects **Sky blue tape.** Press the **SW button** after taping. Continue the process if sequence light in clamp **location 4** was **ON.**

6. Hold the tape on clamp **location 4.** Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **GO** sound will be heard.

7. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

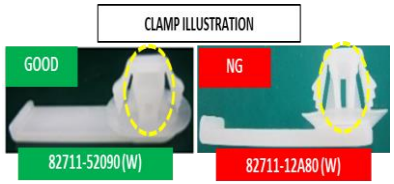
8. For removal of harness from jig. First, remove the connector to **Checker 1** and **Receiver base 2**. Then, release the wire to toggle clamp. Last, remove the harness to Y-taping guide.



Important reminders/Note/s:

1.Make sure no gap between stopper jig and PCB

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape



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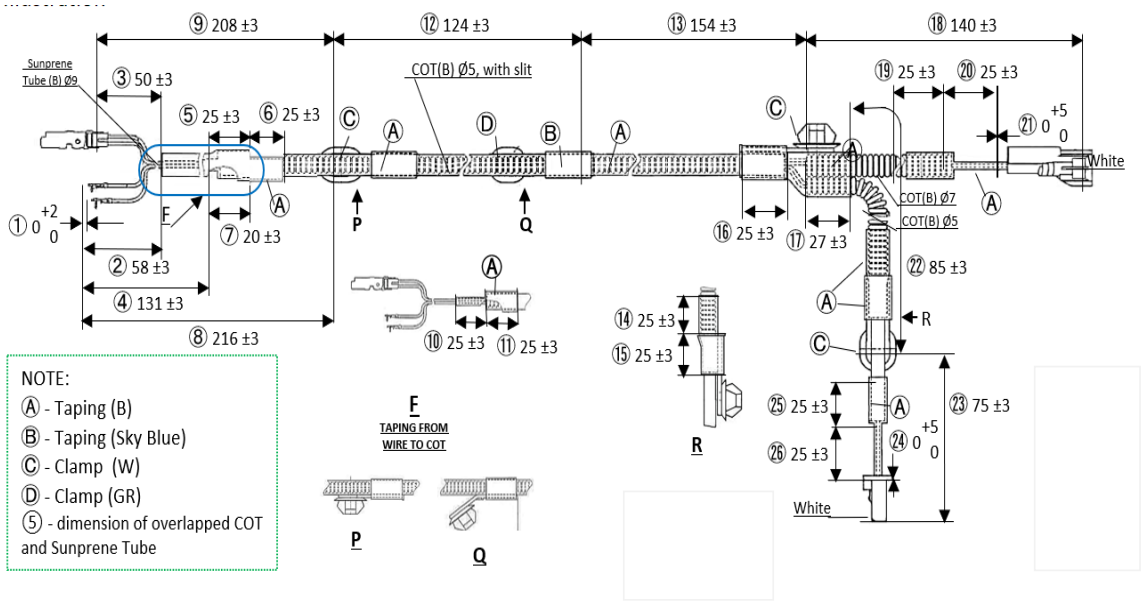
PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	CLAMP ASSY	Measurement		MEASURING TAPE	1. No wrong dimension.



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*

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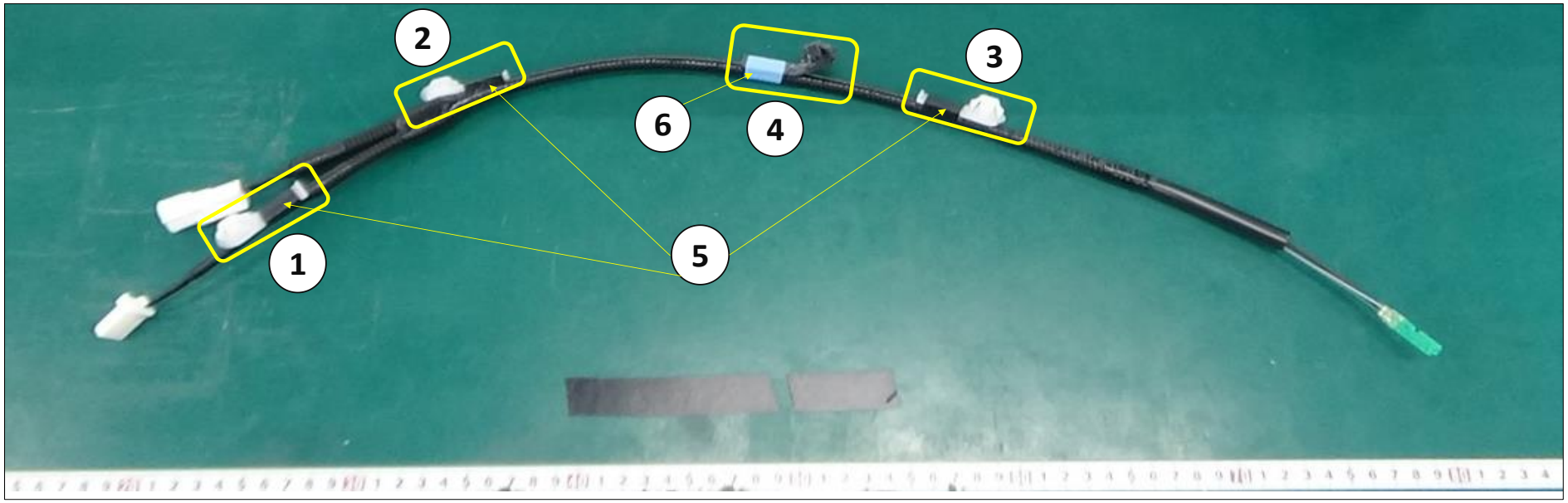
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY	7N0104-7020A



1 2 3 No Missing Clamp (W)

4 No Missing Clamp (GR)

5 No Missing Tape (Black)

6 No Missing Tape (Sky Blue)

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