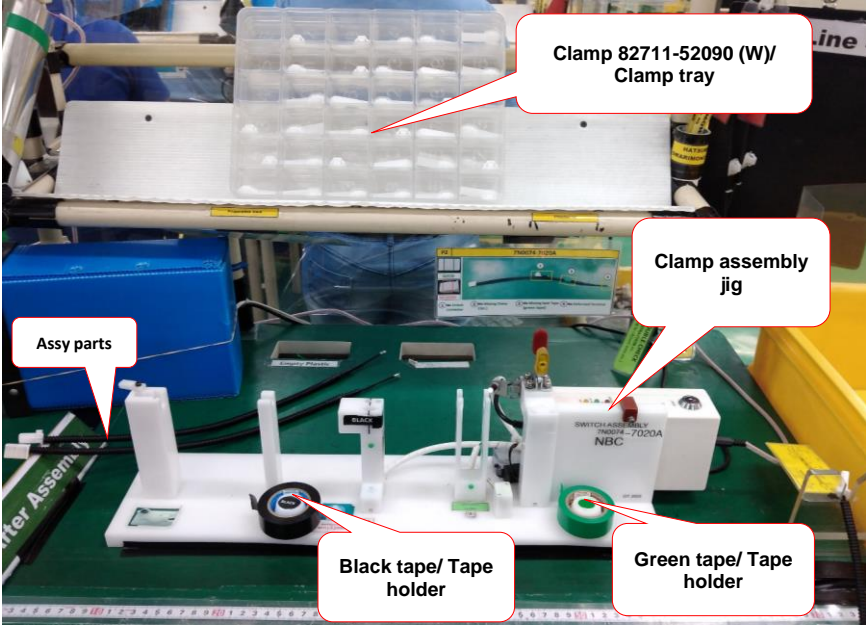
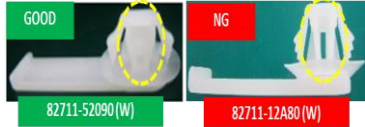
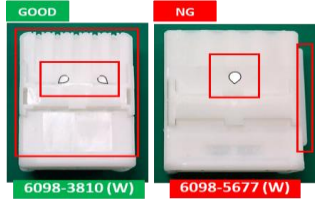

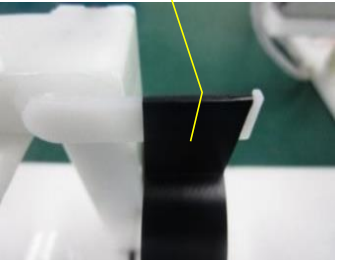


	WORK INSTRUCTION			Effectivity Date:	May 24, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	946B / 7N0074-7020A	Customer:	TRJ	Car Model:	LEXUS-ES	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.:	WI-ENG-PDE-848	
				Revision No.:	0	Page No.:	1 of 5

PARTS:		1. Clamp 82711-52090 (W); Assy parts; Black tape; Green tape		JIG:	1.Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div>Table Lay-out</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-122 for Taping assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p> <div>CLAMP ILLUSTRATION</div>  <div>CONNECTOR ILLUSTRATION</div> 

Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/24/24	0	Initial issue.				D. Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: May 24, 2024

	WORK INSTRUCTION			Effectivity Date:	May 24, 2024		
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	Model code/Part number: 946B / 7N0074-7020A		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-848		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 5

PARTS:	1. Clamp 82711-52090 (W) 2. Black tape 3. Green tape			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting				<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div>  <div>Important reminders/Note/s:</div> <div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-52090 (W)</div><div>NG</div><div>82711-12A80 (W)</div></div>

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WORK INSTRUCTION

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

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n/a

Model code/Part number:

946B / 7N0074-7020A

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-848

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

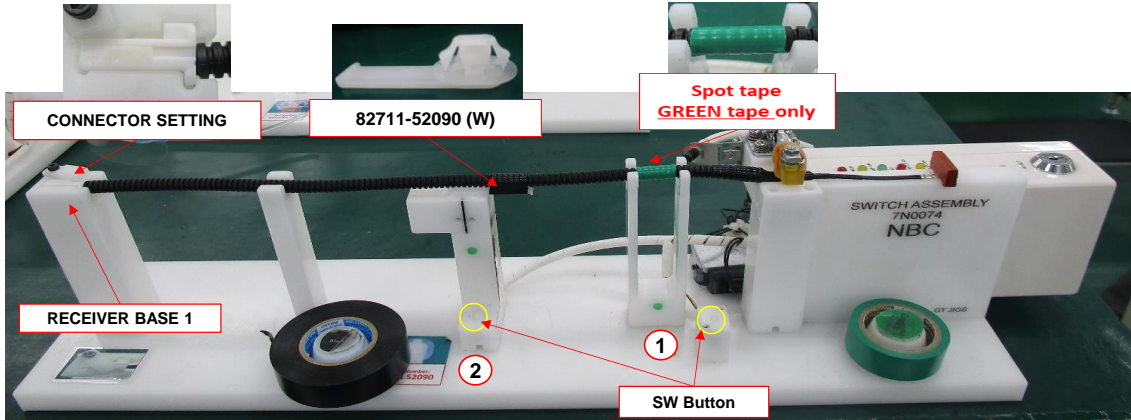



☒ MASSPRO

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PARTS:		1. Assy parts 2. Green tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY Clamp assembly	<div></div> <div><p>1. Get the assy parts and set to jig using both hands. (See above picture for correct setting). First, set the connector 6098-3810 (W) to Receiver base 1 then lock. Continue to set the harness in jig. 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.</p><p>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.</p><p>3. Get the GREEN tape and conduct spot taping (2~3 winds) on location 1 using both hands. Go sound will be heard if color sensor detects Green tape. Press the SW button after taping. Continue to clamp location 2 if sequence light was ON.</p><p>4. Hold the tape on clamp location 2 then start taping using both hands then cut the tape. Press the SW button after taping. Go sound will be heard.</p><p>5. Conduct POINT CHCKING before removing the harness from jig</p></div>			<div></div> <div>STOPPER</div> <div>Important reminders/Note/s:</div> <div><p>1. Make sure no gap between the terminal and stopper jig.</p><p>2. Make 2-3 windings for clamp taping.</p></div> <div><p>1. No damaged clamp 2. No wrong use of clamp 3. No wrong use of tape 4. No missing clamp</p></div> <div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div>6098-3810 (W) 6098-5677 (W)</div></div>

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Car Model:

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Validity Date:

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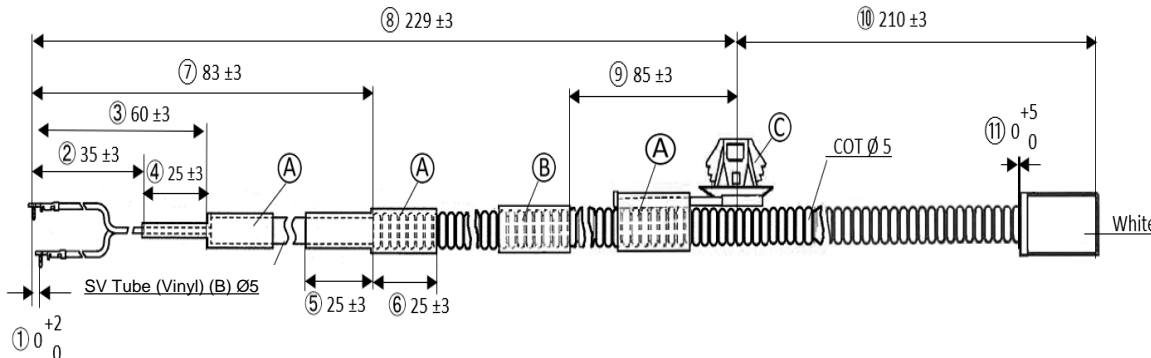

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div>Measurement</div> <div><p>⑧ 229 ±3</p><p>⑩ 210 ±3</p><p>⑦ 83 ±3</p><p>③ 60 ±3</p><p>② 35 ±3</p><p>④ 25 ±3</p><p>⑤ 25 ±3</p><p>⑥ 25 ±3</p><p>⑨ 85 ±3</p><p>⑪ 0 +5 / 0</p><p>SV Tube (Vinyl) (B) Ø5</p><p>COT Ø5</p><p>White</p><p>NOTE:</p><ul style="list-style-type: none">① - Taping (B)② - Taping (G)③ - Clamp (W)</div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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**WORK INSTRUCTION**

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Validity Date:

n/a

Model code/Part number:

946B / 7N0074-7020ACustomer: **TRJ**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-848

Purpose:

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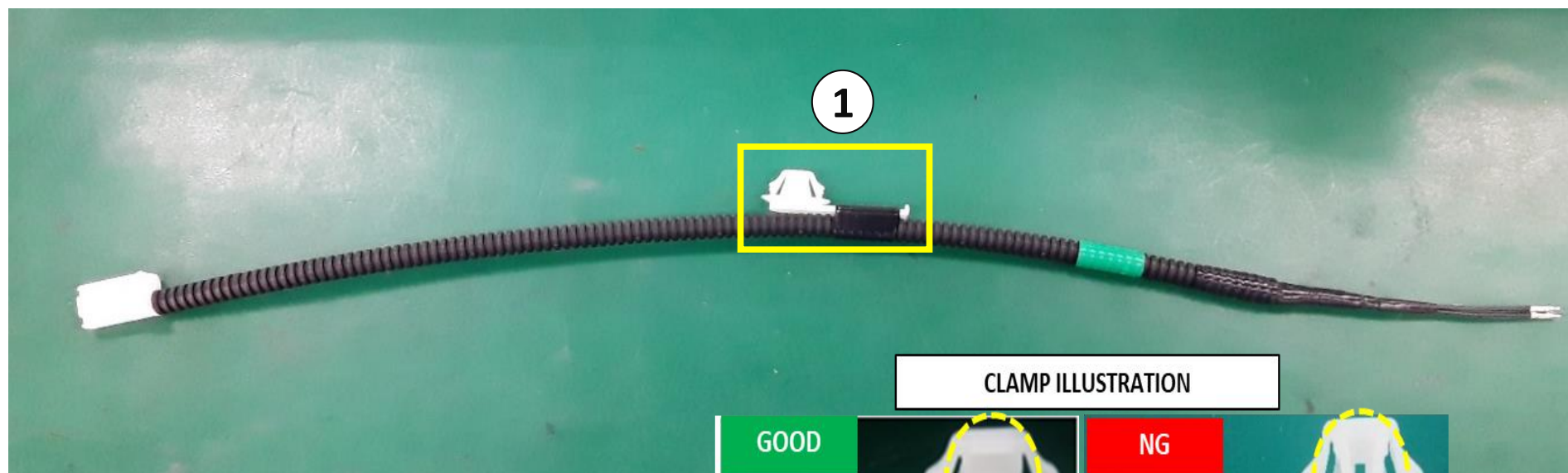
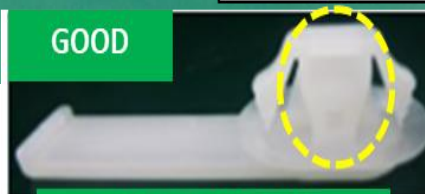
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**CLAMP ASSY****7N0074-7020A****CLAMP ILLUSTRATION****GOOD**

82711-52090 (W)

NG

82711-12A80 (W)

**1 Check the
Clamp appearance**

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