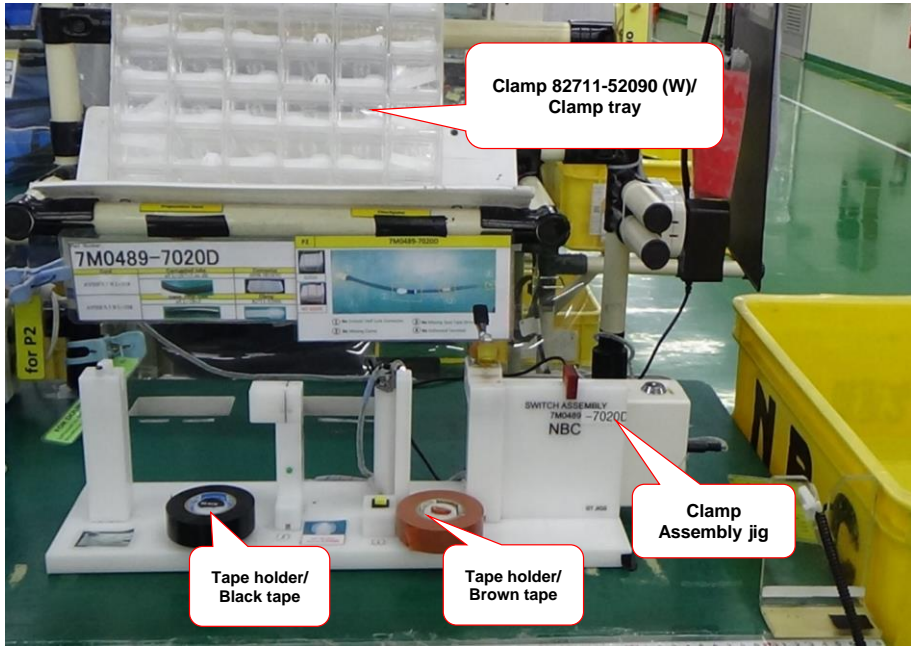

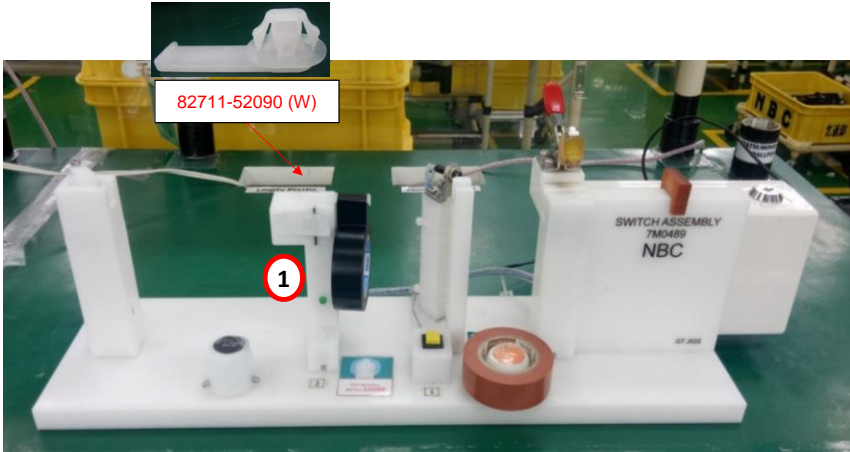
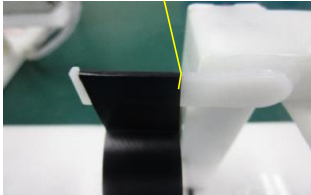


	WORK INSTRUCTION			Effectivity Date:	May 24, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-838		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	1 of 5


PARTS:		1. Assy parts; Clamp 82711-52090 (W); Black tape; Brown tape		JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	Table Lay-out		<div>TABLE LAY-OUT</div>  <div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div> <div>2. Refer to WI-ENG-PDE-073 for Taping Assdembly process</div> <div>1. No missing parts/tools</div> <div>2. No excess parts/tools</div> <div>CONNECTOR ILLUSTRATION</div> <div>GOOD NG</div> <div>6098-3810 (W) 6098-5677 (W)</div>

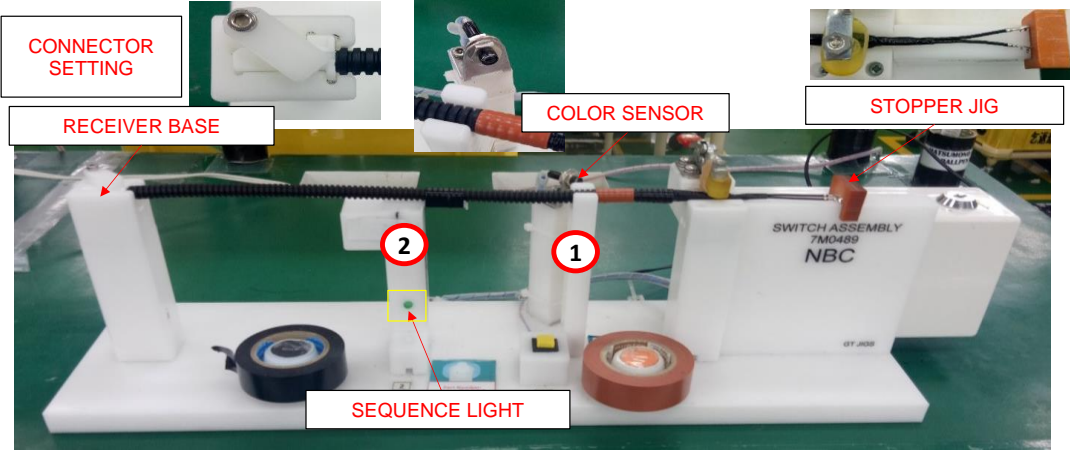
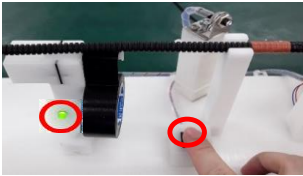

Revision History				Prepared by	Reviewed by	Approved by	Noted by
05/24/24	0	Initial issue.		D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: May 24, 2024

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	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. Brown tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp setting	<div style="text-align: center;">  </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the clamp 82711-52090 (W) using right hand and set to location 1 using both hands. </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 2. Get Black tape using right hand and conduct pre-taping on clamp using both hands. </div>	n/a	<div> 1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px; text-align: center;"> STANDARD TAPING FOR CLAMP </div> <div style="border: 1px solid black; padding: 5px; margin-top: 5px; text-align: center;"> One wind for under tape </div> <div style="text-align: center;">  </div> <div style="margin-top: 10px;"> Important reminders/Note/s: 1. Please Check the clamp before start of assembly to avoid wrong use of clamp. </div> <div style="text-align: center; margin-top: 10px;"> CLAMP ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px;">GOOD</div>  <div style="background-color: green; color: white; padding: 2px 5px;">82711-52090(W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px;">NG</div>  <div style="background-color: red; color: white; padding: 2px 5px;">82711-12A80 (W)</div> </div> </div>

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	WORK INSTRUCTION				Effectivity Date:	May 24, 2024		
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	Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-838		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 5

PARTS:	1. Assy parts 2. Brown tape			JIG:	1. Clamp Asembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	CLAMP ASSY Clamp Assembly	<div><p>1. Get the harness using both hands and set to jig. First, put the connector into receiver base then lock. Last, put the terminal to stopper jig and pull down the toggle clamp. <i>Refer above illustration for proper setting.</i></p><p>2. Check the LED light for Power, Clamp and SEQUENCE LIGHT is ON. If encountered abnormality, STOP the process, CALL the immediate superior and WAIT for instructions.</p><p>3. Get the BROWN TAPE and conduct spot taping on location 1. Make 2 winds. Beep sound will be heard if the Brown tape is detected. Press the button after taping. You will notice the sequence light on the next location.</p><p>4. Conduct taping on location 2 using both hands. Press the button after taping. Go buzzer will be heard.</p><p>5. Conduct POINT CHECKING before removal from jig.</p></div>		<p>1. No wrong use of tape 2. No loose tape 3. No flip-out tape 4. No peel-off tape 5. No missing tape 6. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between the terminal and stopper jig.</p> <p>2. Make 2-3 windings for clamp taping.</p>	

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CLAMP ASSEMBLY PROCESS

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240B / 7M0489-7020D

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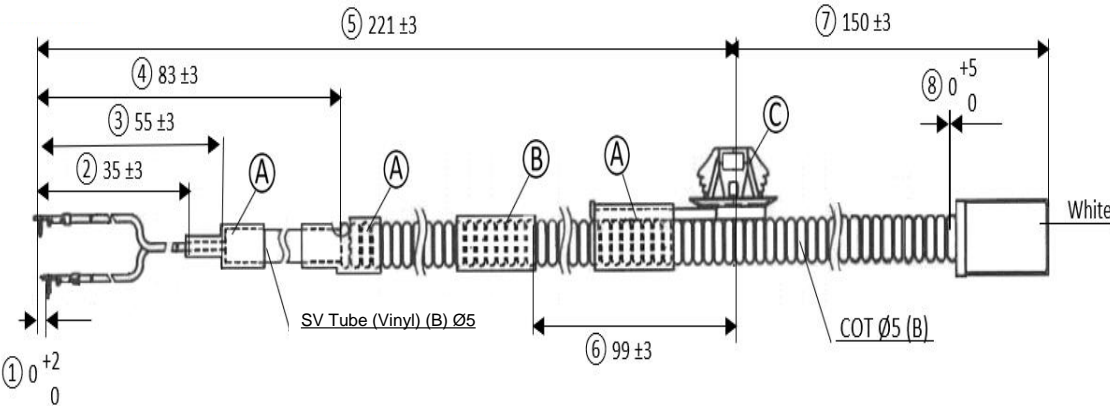
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	Measurement	<div>MEASURING TAPE</div>  <div>NOTE: A - Taping (B) B - Taping (BR) C - Clamp (W)</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 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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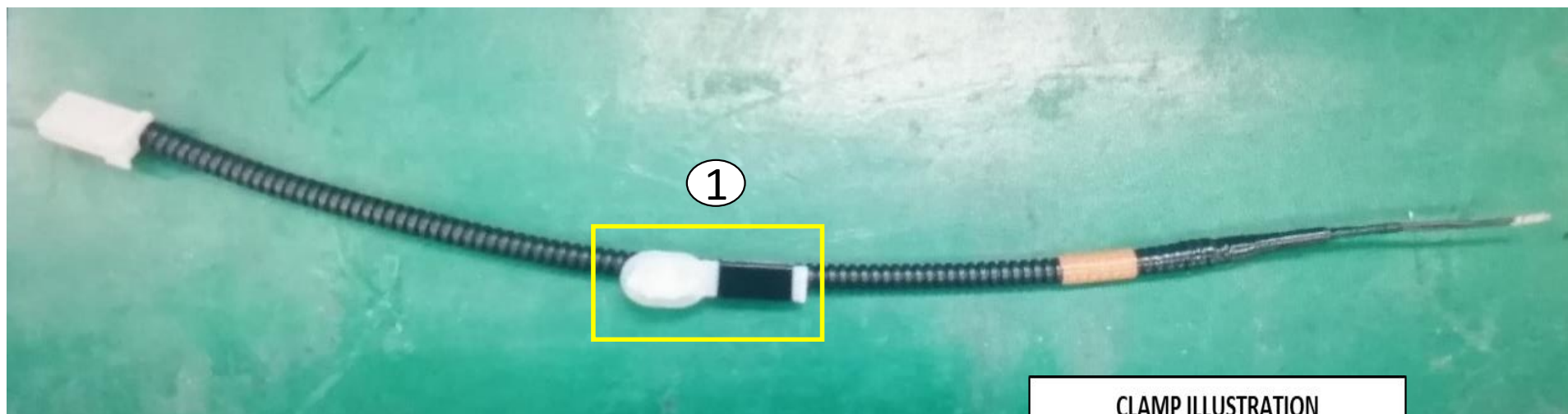
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PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS**CLAMP ASSY****7M0489-7020D****CLAMP ILLUSTRATION**

**1 Check the
Clamp appearance**



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