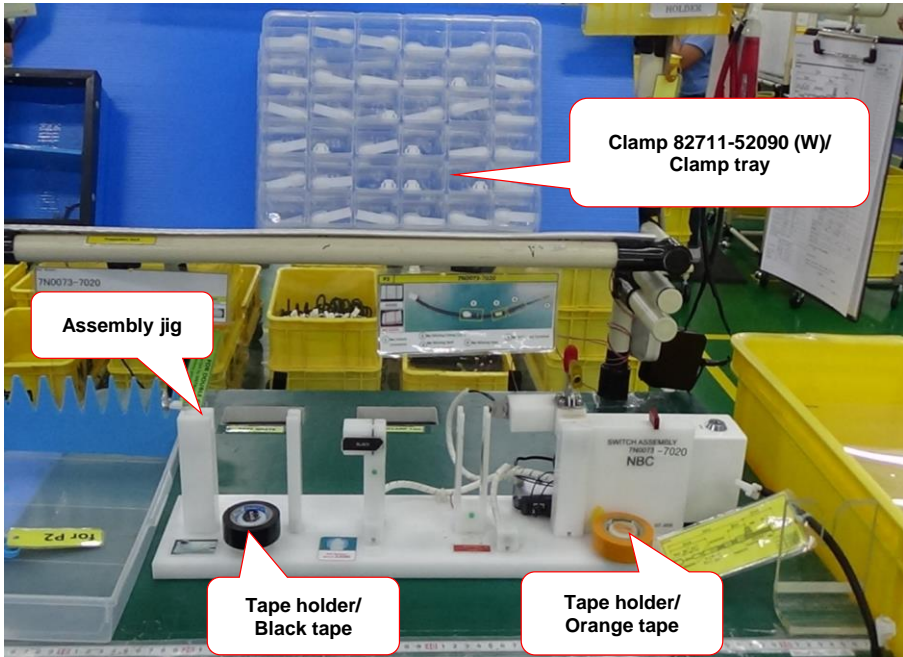

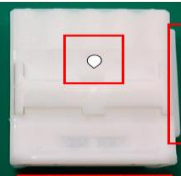
	WORK INSTRUCTION				Effectivity Date:	May 24, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 946B / 7N0073-7020		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-841		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> 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; Orange tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	CLAMP ASSY	<div style="text-align: center;"> TABLE LAY-OUT </div>  <div style="position: absolute; top: 251px; left: 401px; border: 1px solid red; padding: 2px;">TABLE LAY-OUT</div> <div style="position: absolute; top: 351px; left: 511px; border: 1px solid red; padding: 2px;">Clamp 82711-52090 (W)/ Clamp tray</div> <div style="position: absolute; top: 481px; left: 271px; border: 1px solid red; padding: 2px;">Assembly jig</div> <div style="position: absolute; top: 661px; left: 351px; border: 1px solid red; padding: 2px;">Tape holder/ Black tape</div> <div style="position: absolute; top: 661px; left: 501px; border: 1px solid red; padding: 2px;">Tape holder/ Orange tape</div>		<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div> Document references: 1. Refer to WI-ENG-PDE-121 for Taping assembly process </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div> <div style="text-align: center; margin-top: 10px;"> CONNECTOR ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">GOOD</div>  <div style="background-color: green; color: white; padding: 2px;">6098-3810 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">NG</div>  <div style="background-color: red; color: white; padding: 2px;">6098-5677 (W)</div> </div> </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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**WORK INSTRUCTION**

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Model code/Part number:

946B / 7N0073-7020

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

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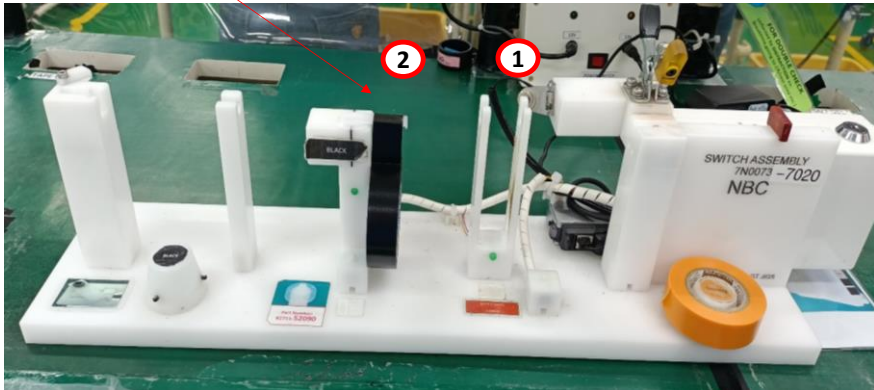
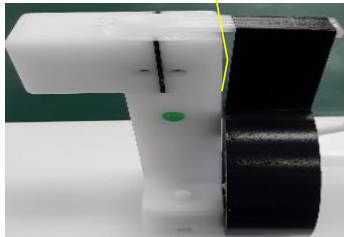


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

2 of 5

PARTS:		1. Clamp 82711-52090 (W) 2. Black tape		JIG:	1.Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY Clamp setting	<div> 82711-52090</div> <div></div> <div>1. Get the clamp 82711-52090 (W) using right hand and set to location 2 using both hands.</div> <div>2. Get Black tape using right hand and conduct pre-taping on clamp using both hands.</div>		n/a	<div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape 4. No missing tape</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div> 82711-52090(W)</div></div><div><div>NG</div><div> 82711-12A80(W)</div></div></div>

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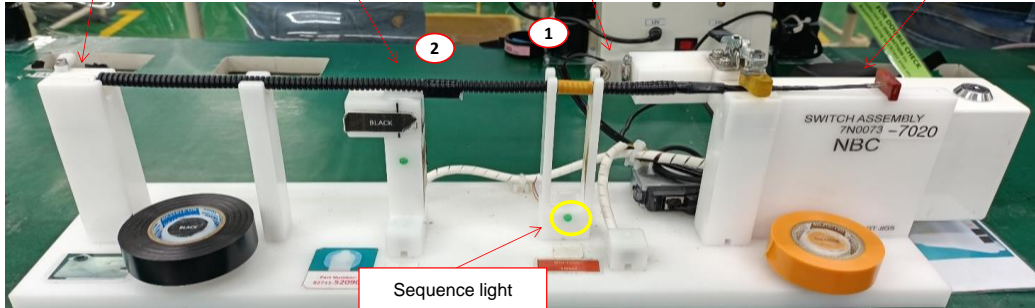
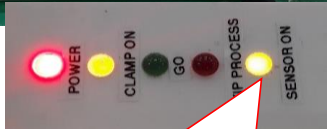



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Revision No.:

0

Page No.:

3 of 5

PARTS:		1. Assy part 2. Orange tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly	<div><div> Connector setting</div><div> 82711-52090 (W)</div><div> Color sensor</div><div> Stopper Jig</div><div> Sequence light</div><div><p>1. Get the harness and set to jig using both hands. First, place the connector into receiver base. Second, put the terminal to stopper jig then pull down the toggle clamp. <i>Refer to above illustration for proper setting.</i></p><p>2. Check if LED light for POWER ON, COLOR SENSOR and CLAMP ON is ON. If encountered abnormality, STOP the process, CALL the Leaders and WAIT for instructions.</p><p>3. Get ORANGE tape and conduct spot taping on location 1 using both hands, Make 3 winds and cut the tape. You will heard a buzz if the tape detected by the color sensor. Press the switch button after taping.</p><p>4. Hold the tape on clamp location 2 then start taping using both hands. Press the switch button after taping. GO buzzer will be heard.</p><p>5. Conduct POINT CHECKING before removing the harness from jig</p></div><div> Color sensor light will ON if tape was detected</div></div>		<div></div> <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> <p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process</p> <div><div>CONNECTOR ILLUSTRATION</div><div><div> GOOD 6098-3810 (W)</div><div> NG 6098-5677 (W)</div></div></div>

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

code/Part number:

946B / 7N0073-7020

Customer:

TRJ Car Model:**LEXUS-ES**

Document No.:

WI-ENG-PDE-841

Purpose:

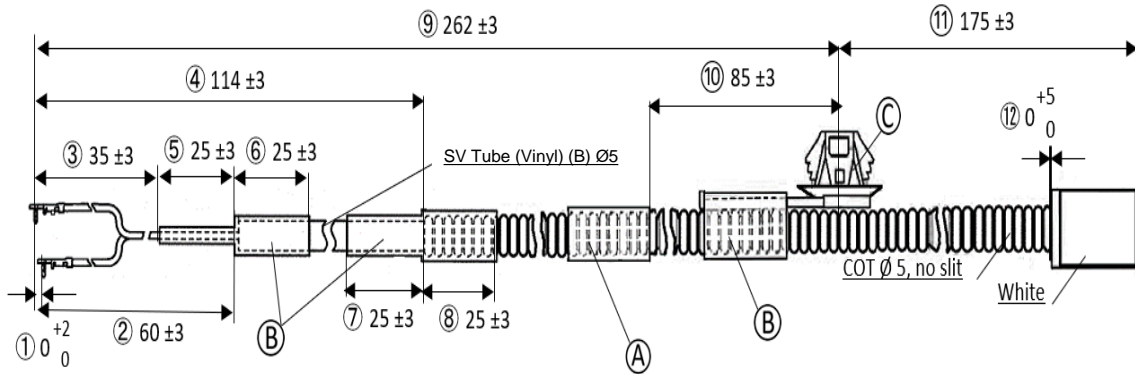

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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
4	CLAMP ASSY	Measurement	<div><div>MEASURING TAPE</div><div>NOTE: A - Taping (OR) B - Taping (B) C - Clamp (W)</div></div>		<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>

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946B / 7N0073-7020Customer: **TRJ**

Car Model:

LEXUS-ES

Document No.:

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Purpose:

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Revision No.:

0

Page No.:

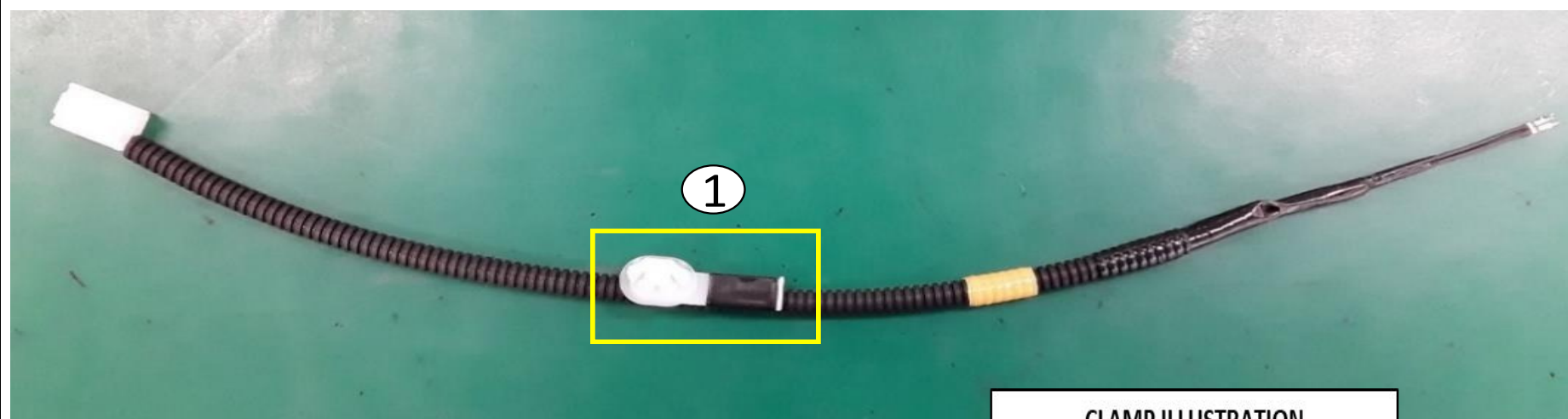
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**CLAMP ASSY****7N0073-7020****CLAMP ILLUSTRATION**

**1 Check the
Clamp appearance**



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