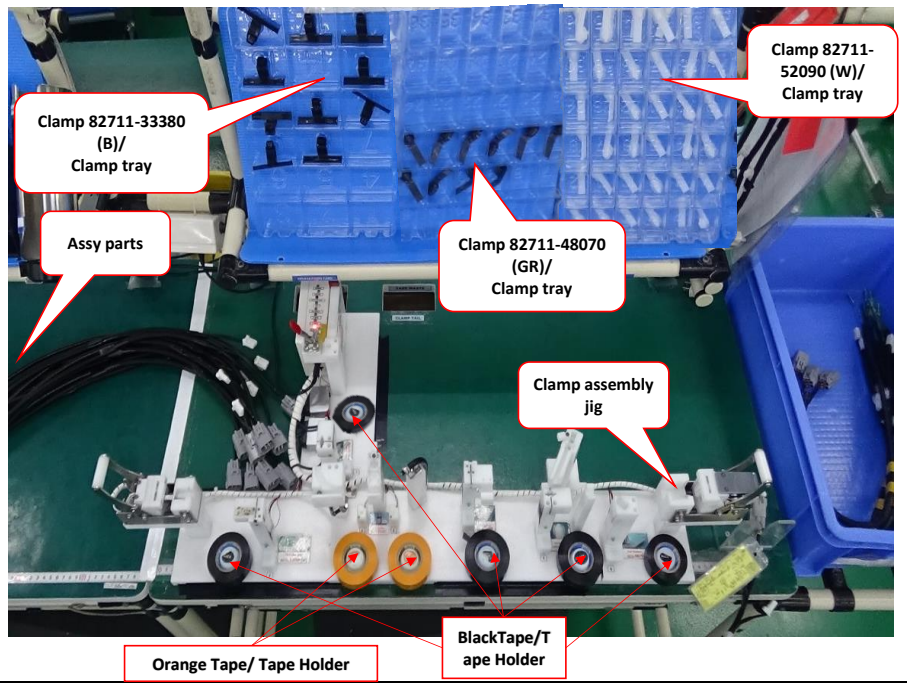
| | WORK INSTRUCTION | | | Effectivity Date: | October 22, 2024 | |
|---|---|---|---|---|---|---|
| | Process Name/Title: | CLAMP ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: 800B/900B/910B / 7N0101-7020D | Customer: TRJ | Car Model: LEXUS-NX/RX | Document No.: | WI-ENG-PDE-1135 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 1 of 7 |

| PARTS: | 1. Assy parts;Clamp 82711-33380 (B); Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Orange Tape; Black Tape | JIG: | 1. Clamp assembly jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 1 | Clamp assy | Table lay-out | **TABLE LAY-OUT**<br>  <br> | **Safety Instruction**<br>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)<br><br>**Housekeeping**<br>1. Maintain and always practice 5's.<br>2. Personal things on the workplace is prohibited. Keep it in your locker.<br><br>**Alert level**<br>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. | 1. No missing parts/tools<br>2. No excess parts/tools |

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted |
|---|---|---|---|---|---|---|
| | | | | | | |
| | | | | | | |
| 10/22/24 | 1 | Change from Pre-Launch to Masspro. Improvement in Measurement pg. 6 | A. Hernandez | C. Villanueva | A. Arañes | n/a |
| 10/16/24 | 0 | Initial Issue. | A. Hernandez | C. Villanueva | A. Arañes | n/a |

| Prepared by | Reviewed by | Approved by | Noted by |
|---|---|---|---|
| A. Hernandez | C. Villanueva | A. Arañes | n/a |
| Est. Date: | October 22, 2024 | | |

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| | | | | | |
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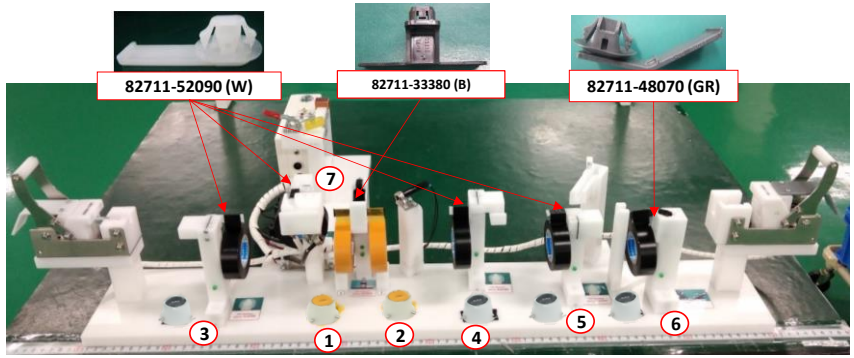
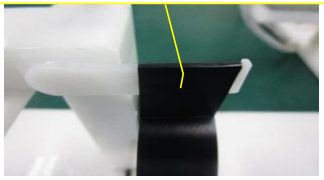
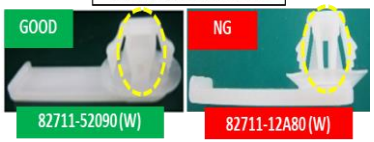
| NBC | WORK INSTRUCTION | | | Effectivity Date: | October 22, 2024 |
| | Process Name/Title: | CLAMP ASSEMBLY PROCESS | | Validity Date: | n/a |
| | Model code/Part number: | 800B/900B/910B / 7N0101-7020D | Customer: TRJ / Car Model: LEXUS-NX/RX | Document No.: | WI-ENG-PDE-1135 |
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: 1 | Page No.: 2 of 7 |

| | | | |
|---|---|---|---|
| **PARTS:** | 1. Clamp 82711-48070 (GR)<br>2. Clamp 82711-52090 (W) [4pcs.]<br>3. Clamp 82711-33380 (B)<br>4. Black tape [5pcs.]<br>5. Orange tape [2pcs.] | JIG: | 1. Clamp assembly jig |

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 2 | Clamp assy | Clamp setting |  <br>1. Get 1pc. of clamp **82711-33380 (B)** using right hand then set to clamp location **1** and **2** using both hands.<br>2. Get 1pc. of clamp **82711-48070 (W)** using right hand and set to clamp location **6** using both hands.<br>3. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **3 and 7** using both hands.<br>4. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **4 and 5** using both hands.<br>5. Initially attach **Orange tape** to clamp location **1 and 2** using both hands.<br>6. Initially attach **Black tape** to clamp location **3, 4, 5, 6 and 7** using both hands. | n/a | 1. No wrong use of parts<br>2. No wrong use of tape<br>3. No damaged clamp<br>4. No wrong clamp position<br><br>***Important reminders/Note/s:***<br>***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.***<br><br>**STANDARD TAPING FOR CLAMP**<br>One side tape under clamp<br>  <br>**CLAMP ILLUSTRATION**<br>  |

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| | WORK INSTRUCTION | | | Effectivity Date: | October 22, 2024 | |
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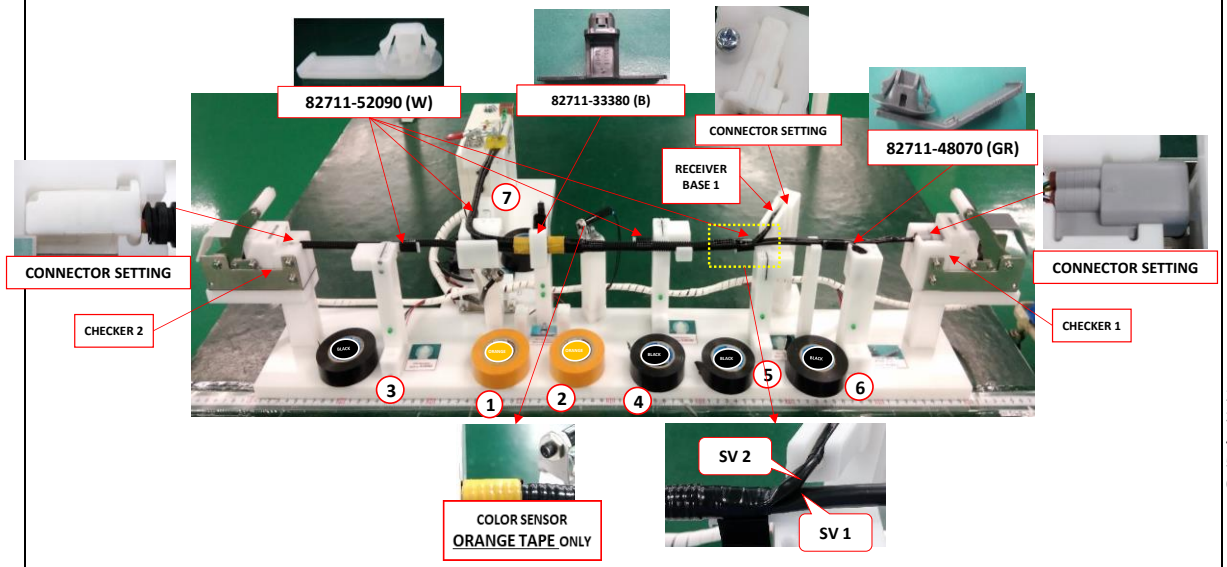
| | Process Name/Title: | CLAMP ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: 800B/900B/910B / 7N0101-7020D | Customer: TRJ | Car Model: LEXUS-NX/RX | Document No.: | WI-ENG-PDE-1135 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 3 of 7 |

| PARTS: | 1. Assy parts<br>2. Black tape [5pcs] | 3. Orange tape [2pcs]<br>4. Clamp 82711-33380 (B) | 5. Clamp 82711-52090 (W) [4pcs.]<br>6. Clamp 82711-48070 (GR) | JIG: | 1. Clamp assembly jig |
|---|---|---|---|---|---|

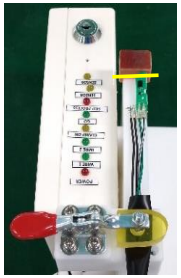
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 3 | Clamp assy | Clamp assembly | | | |




1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0175 (GR)** to **Checker 1 then pull the checker fixture for continuity checking**. Second, set the **6098-3810 (W)** to **Receiver base 1** then lock. Continue the harness in jig. Next, set the connector **6098-2220 (W)** to **Receiver base 2** the pull the checker fixture for continuity checking. Last, set the terminal and PCB end within the stopper jig then press by toggle clamp. Continue if clamp location **1** was **ON.**

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.

3. Hold the tape on clamp location **1** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the **SW button** after taping. Continue if sequence light in location **2** was **ON.**



***Important reminders/Note/s:***
***1. Make sure no gap between stopper and PCB***

1. No flip-out tape
2. No peel-off tape
3. No wrong use of tape
4. No damaged clamp
5. No wrong usage of parts
6. No missing clamp

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| | WORK INSTRUCTION | | | Effectivity Date: | October 22, 2024 | |
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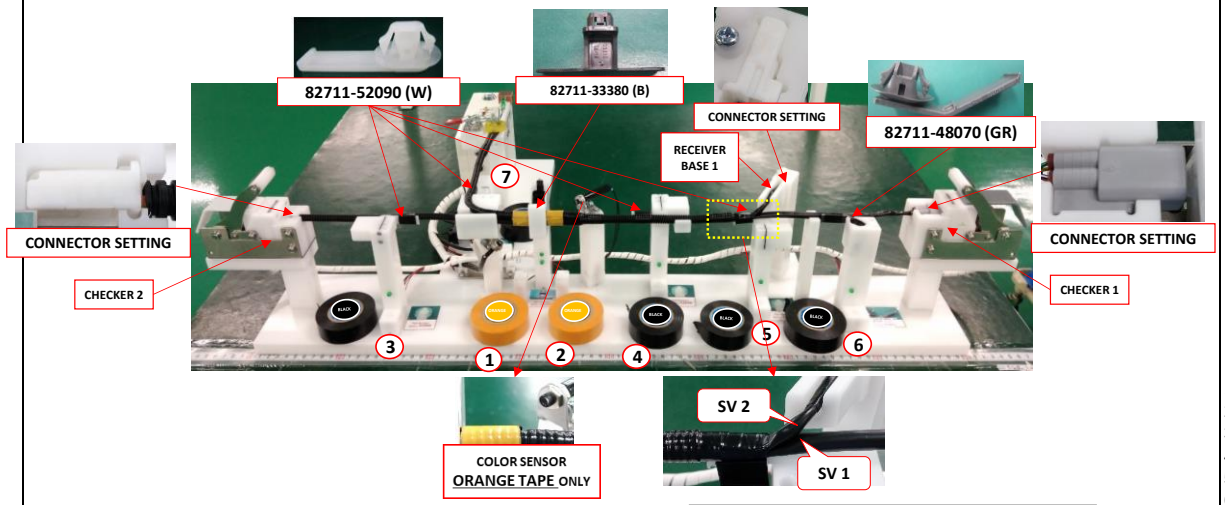
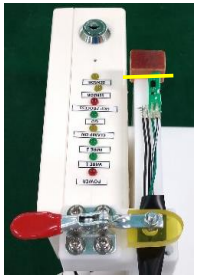
| | Process Name/Title: | CLAMP ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: 800B/900B/910B / 7N0101-7020D | Customer: TRJ | Car Model: LEXUS-NX/RX | Document No.: | WI-ENG-PDE-1135 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 4 of 7 |

| PARTS: | 1. Assy parts<br>2. Black tape [5pcs] | 3. Orange tape [2pcs]<br>4. Clamp 82711-33380 (B) | 5. Clamp 82711-52090 (W) [4pcs.]<br>6. Clamp 82711-48070 (GR) | JIG: | 1. Clamp assembly jig |
|---|---|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 4 | Clamp assy | Clamp assembly (Continuation) |  <br>4. Hold the tape on clamp location **2** then start taping using both hands. Make **3 windings** of tape then cut the tape. **Color sensor** light will beep/buzz if sensor detects **Orange tape.** Press the **SW button** after taping. Continue if sequence light in location **3** was **ON.**<br>5. Hold the tape on clamp location **3** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location **4** was **ON.**<br>6. Hold the tape on clamp location **4** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location **5** was **ON.** | |  <br>***Important reminders/Note/s:***<br>***1. Make sure no gap between stopper and PCB***<br>1. No flip-out tape<br>2. No peel-off tape<br>3. No wrong use of tape<br>4. No damaged clamp<br>5. No wrong usage of parts<br>6. No missing clamp |

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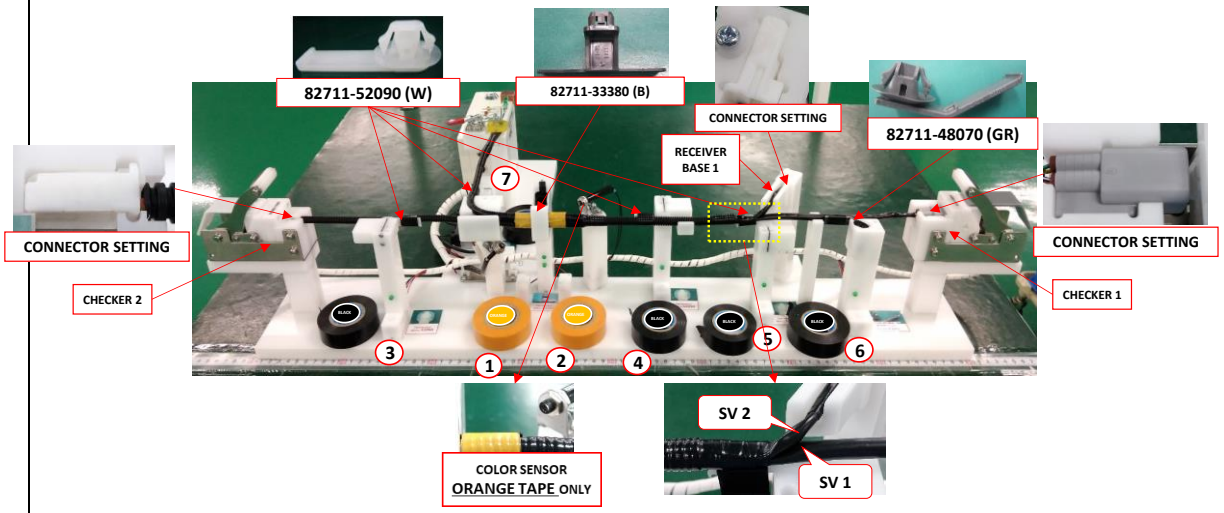
| | Process Name/Title: | CLAMP ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: 800B/900B/910B / 7N0101-7020D | Customer: TRJ | Car Model: LEXUS-NX/RX | Document No.: | WI-ENG-PDE-1135 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 5 of 7 |

| PARTS: | 1. Assy parts<br>2. Black tape [5pcs] | 3. Orange tape [2pcs]<br>4. Clamp 82711-33380 (B) | 5. Clamp 82711-52090 (W) [4pcs.]<br>6. Clamp 82711-48070 (GR) | JIG: | 1. Clamp assembly jig |
|---|---|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 5 | Clamp assy | Clamp assembly (Continuation) | | | |

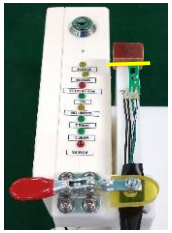



7. Hold the tape on clamp location **5** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location **6** was **ON.**

8. Hold the tape on clamp location **6** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. Continue if sequence light in location **7** was **ON.**

9. Hold the tape on clamp location **7** then start taping using both hands. Make **3 windings** of tape then cut the tape. Press the SW button after taping. **Go** sound will be heard.

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



***Important reminders/Note/s:***
***1. Make sure no gap between stopper and PCB***

1. No flip-out tape
2. No peel-off tape
3. No wrong use of tape
4. No damaged clamp
5. No wrong usage of parts
6. No missing clamp

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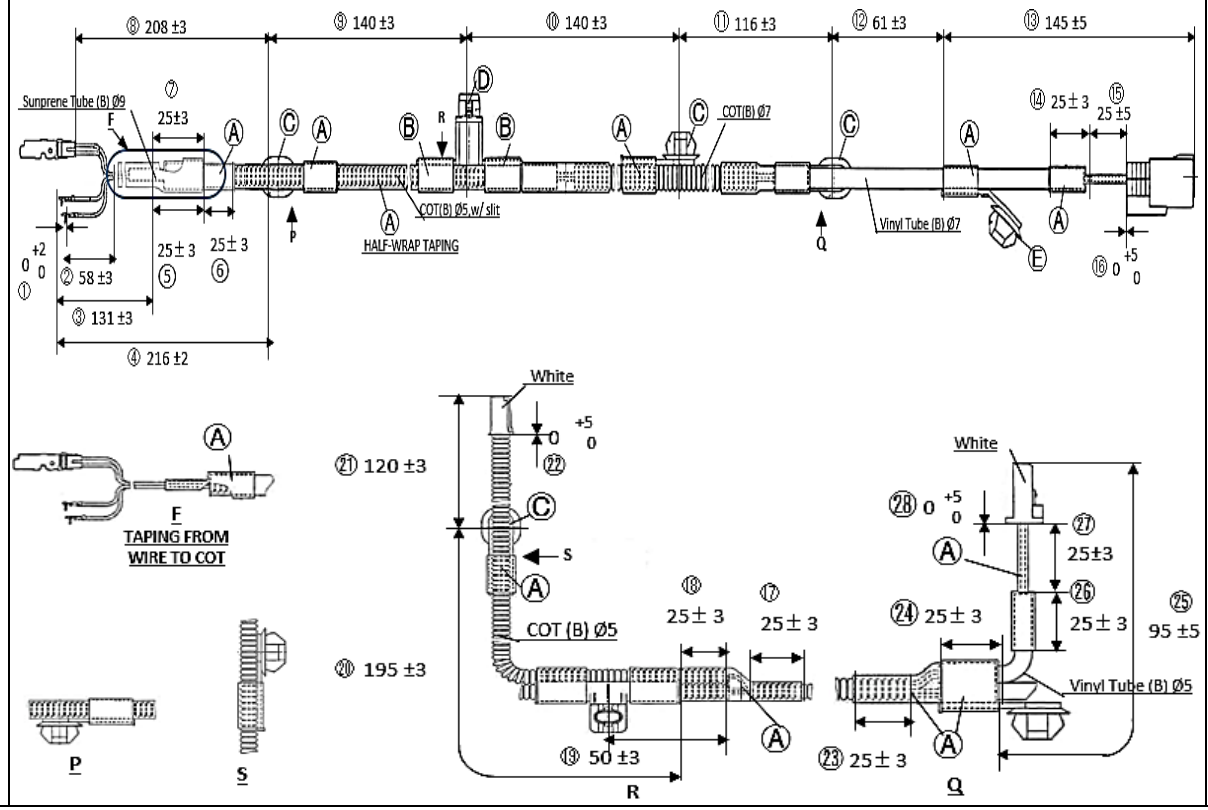
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: 1 | Page No.: 6 of 7 |

| | | | |
|---|---|---|---|
| **PARTS:** | 1. Assy parts | JIG: | n/a |

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 6 | Clamp assy | Measurement |  | | ***Important reminders/Note/s:***<br>***1. FOR HATSUMONO AND OWARIMONO***<br>***2. Please use calibrated/verified measuring tape when getting the measurement.***<br><br>1. No wrong dimension |



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| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: | 7 of 7 |

| | | | |
|---|---|---|---|
| **PARTS:** | 1. Assy parts | JIG: | n/a |

**VISUAL INSPECTION / QUALITY CHECKPOINTS**

# CLAMP ASSY 7N0101-7020D

1 **No Wrong facing of clamp**

2 3 4 5 6 7 **No Missing Tape (Black tape)**

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