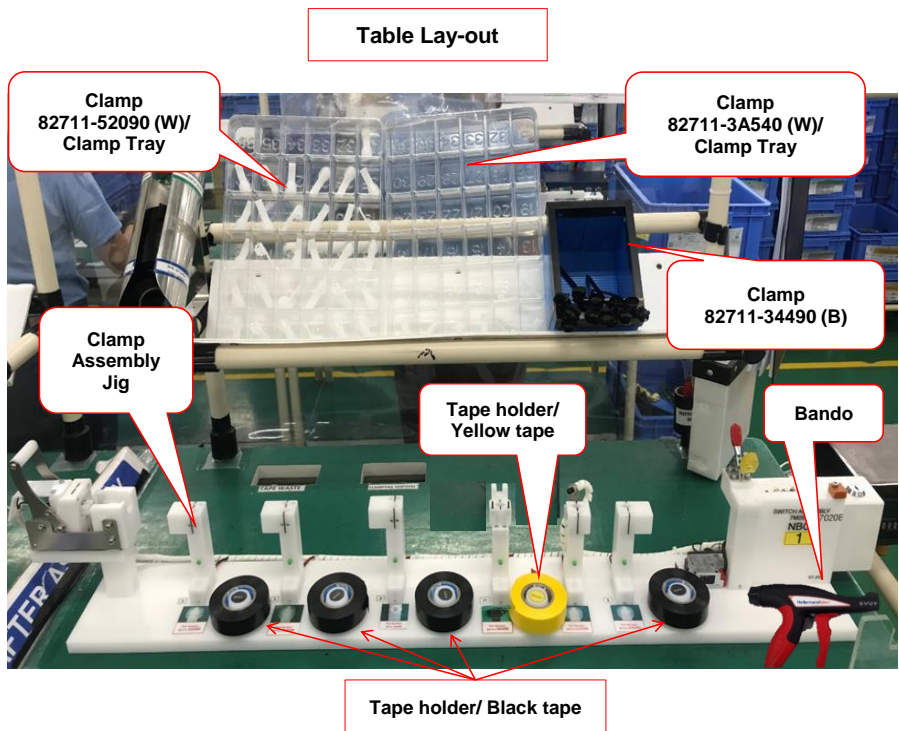


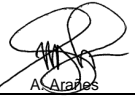

	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS				Effectivity Date:	October 21, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1126		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 6






PARTS:	1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-3A540 (W); 82711-34490 (B); Yellow tape; Black tape [4pcs]				JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	CLAMP ASSY	<p>Table Lay-out</p>  <p>Clamp 82711-52090 (W)/ Clamp Tray</p> <p>Clamp 82711-3A540 (W)/ Clamp Tray</p> <p>Clamp 82711-34490 (B)</p> <p>Clamp Assembly Jig</p> <p>Tape holder/ Yellow tape</p> <p>Bando</p> <p>Tape holder/ Black tape</p>	<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s:</p> <p>1. Refer to WI-ENG-PDE-1125A-C for Taping assembly process</p> <p>1. No missing parts in assy parts 2. No excess tape/tape holder 3. No wrong position of tape holder</p> <p>BAND CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-34490 (B) 82711-16830 (B)</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-52090 (W) 82711-12A80 (W)</p>			

Revision History								Prepared by	Reviewed by	Approved by	Noted by
10/21/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
10/17/24	0	Initial issue.	D.Castillo	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted					Est. Date:

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 6


PARTS:	1.Clamp 82711-52090(W) [4pcs] 2.Clamp 82711-3A540 (W) 3.Clamp 82711-34490 (B) 3. Black tape [4pcs.] 4. Yellow tape			JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	Clamp setting		n/a	<div>One wind for under tape</div>  <p>Important reminders/Note/s:</p> <p>1. Check the Clamp first before start of assembly to avoid wrong use of clamp.</p> <p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p> <div>BAND CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-34490 (B)</div></div> <div><div>NG</div><div>82711-16830 (B)</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>

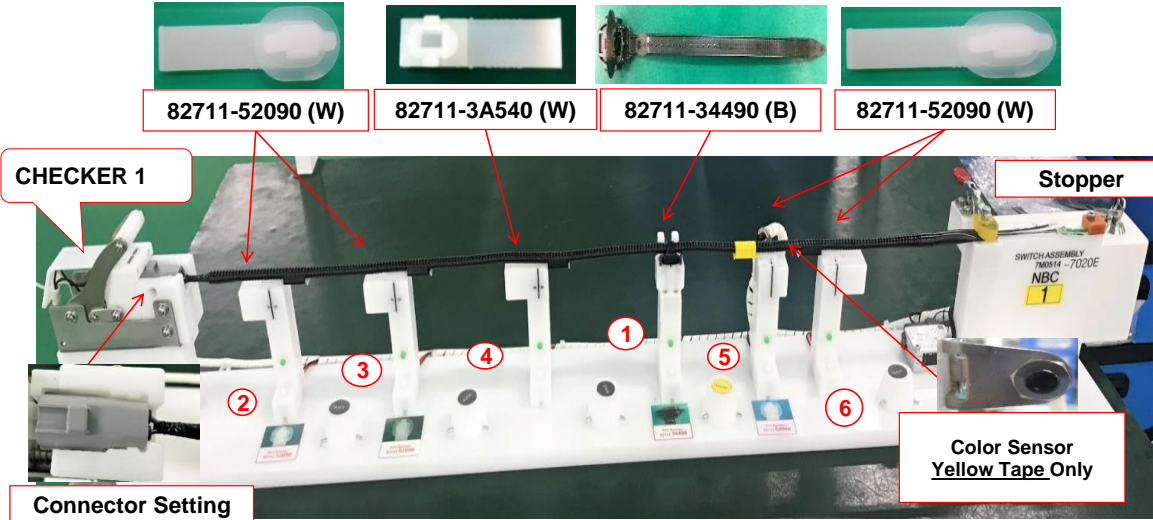






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	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-1126		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	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	<div></div> <div><p>1. Get the assy parts then put into jig. (See above picture for correct setting). First, set the connector 6188-0066 (GR) to Checker 1 then close the checker fixture for continuity checking. Continue to set the harness in the jig up to the end of B-B wires and G/BW hotmelted wires within the stopper, then pull down the Toggle clamp.</p><p>2. On clamp location 1, Initially tighten the band clamp using both hands. Continue if the sequence light in location 1 was ON.</p><p>3. Get the bando gun using right hand then cut the band clamp. Press the SW button after cut. Continue if the sequence light on clamp location 2 was ON.</p></div> <div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>NG</p><p>OK</p><p>NG</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div>	<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and hotmelted.</p> <p>2. Make 2-3 windings for clamp taping.</p> <p>1. No loose/tight clamp attached</p> <p>2. No damage clamp</p> <p>3. No missed tape</p> <p>4. No missing parts</p> <p>5. Make sure no clearance between PCB and stopper jig</p> <div><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div>			

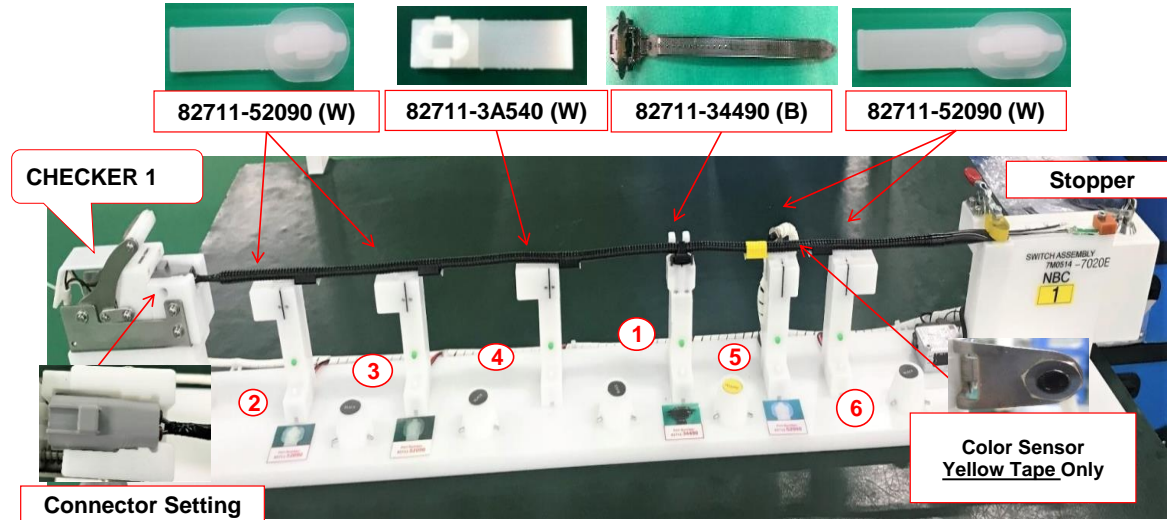
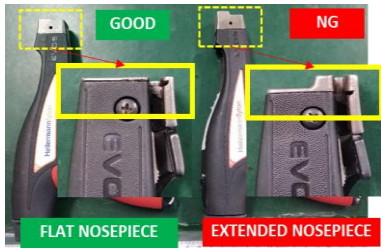
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	Process Name/Title:		Model code/Part number: 240B / 7M0514-7021B	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1126	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.: 4 of 6

PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	<div>Clamp assembly (Continuation)</div> <div></div> <div><div>4. Hold the tape on clamp location 2 then start taping using both hands. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light in location 3 was ON.</div><div>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 the sequence light in location 4 was ON.</div><div>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 the sequence light in location 5 was ON.</div><div>7. Hold the Yellow 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 the sequence light in location 6 was ON.</div><div>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. GO sound will be heard.</div><div>9. After taping, Conduct POINT CHECKING before removing the harness from the jig.</div><div>10. After point checking, remove the harness from toggle clamp up to Checker.</div></div>		<div>Important reminders/Note/s: 1. Make sure no gap between stopper and hotmelted. 2. Make 2-3 windings for clamp taping.</div> <div>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</div> <div></div>

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**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Model code/Part number:

240B / 7M0514-7021B

Customer:

TRJ

Car Model:

LEXUS-ES

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

WI-ENG-PDE-1126

Revision No.:

1

Page No.:

5 of 6

PARTS:

1. Assy parts

JIG:

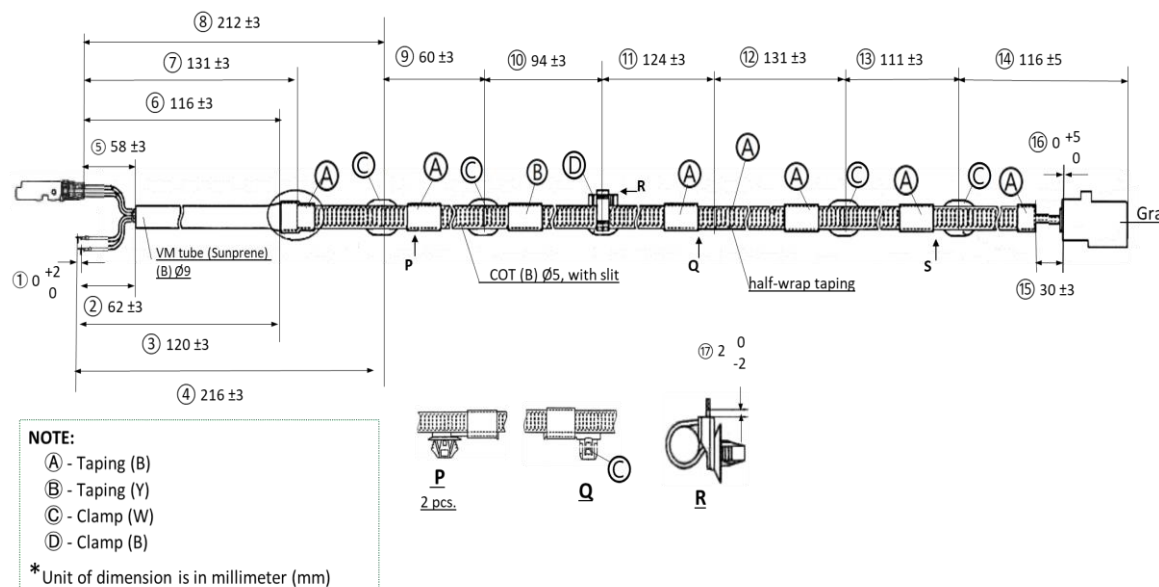
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

CLAMP
ASSY

Measurement



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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WORK INSTRUCTION

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Customer: **TRJ**

Car Model: **LEXUS-ES**

Document No.:

WI-ENG-PDE-1126

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

6 of 6

PARTS:

1. Assy parts

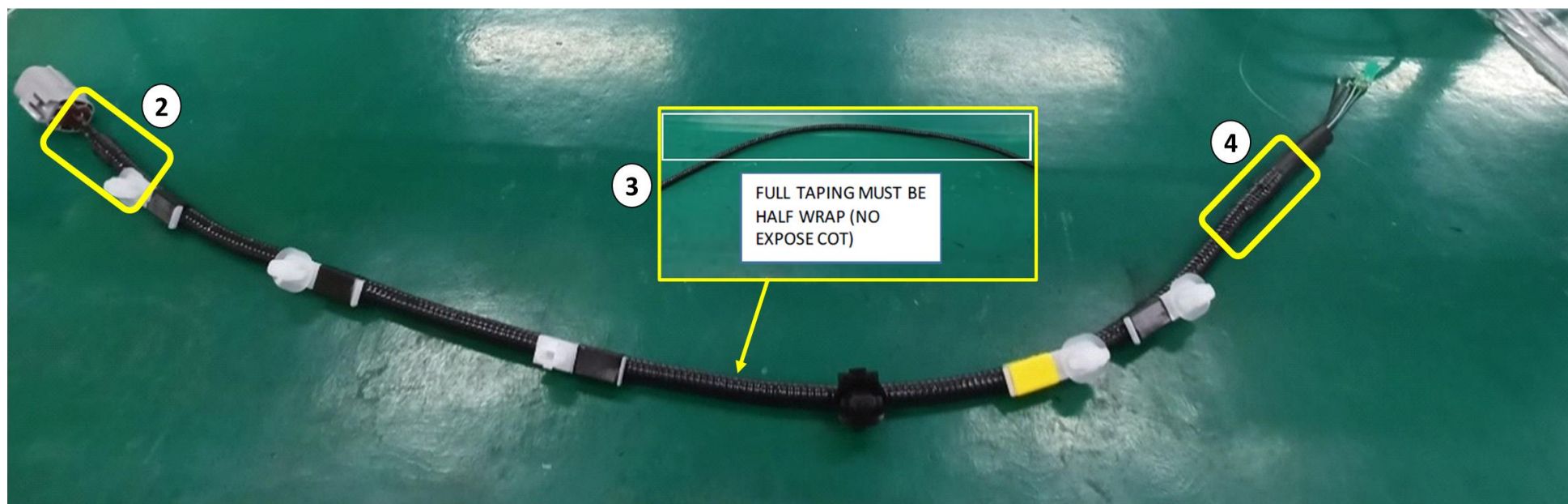
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

CLAMP ASSY

7M0514-7021B



① No Wrong facing of clamp

② ③ ④ No Missing Tape (Black tape)

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