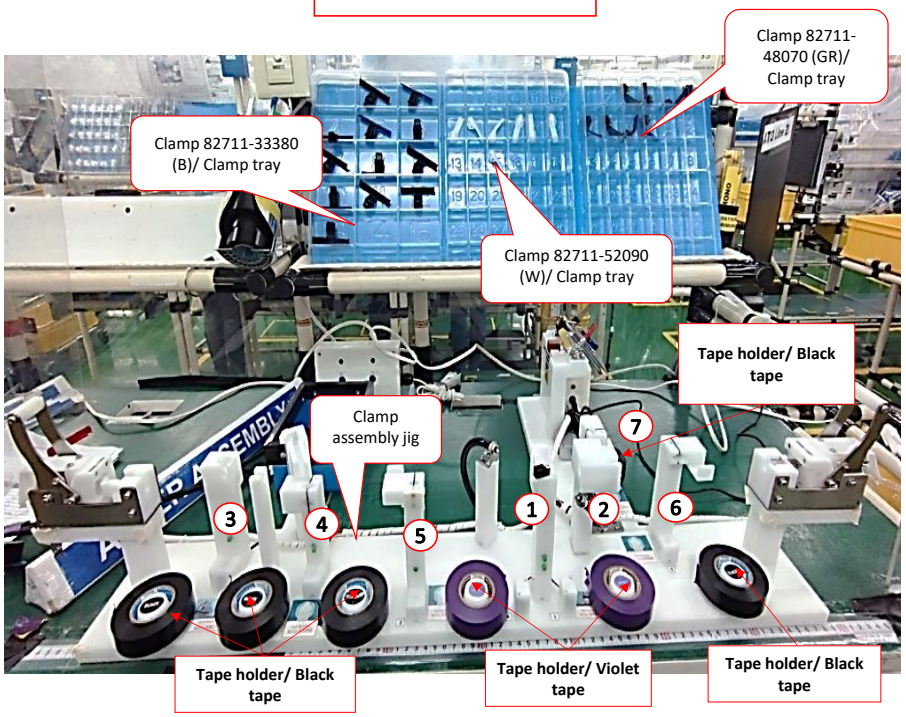
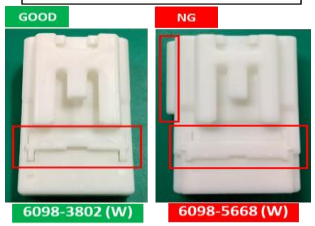
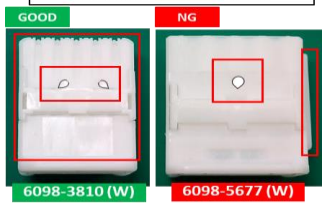
NBC	WORK INSTRUCTION			Effectivity Date:	July 31, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 900B/ 910B / 7N0072-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-677
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 1	Page No.: 1 of 6

PARTS:	1.Clamp 82711-33380 (B); Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Violet tape (2pcs); Black tape (5pcs)	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Clamp assy	Table Lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools. 2. No excess parts/tools. ***Document reference/s:*** *1. Refer to **WI-ENG-PDE-461A-D** for Tapng assemmbly process* CONNECTOR ILLUSTRATION  CONNECTOR ILLUSTRATION 

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
07/31/24	1	Inclusion of Car model "LEXUS-NX/RX". Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A
08/15/23	0	Excluded process from P2. Cahnge Process name/Title from TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS" due to separation of process	M.Ariola	J.Loterte	C.Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C.Villanueva	A. Arañes	N/A
Est. Date:	August 15, 2023		

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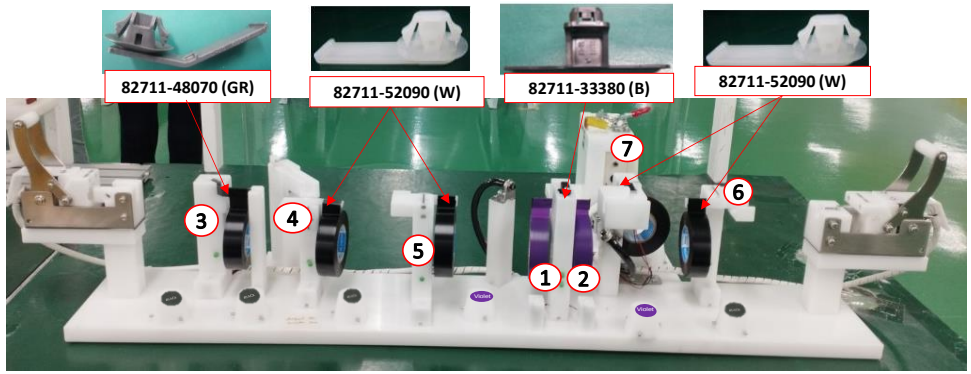
DCC Stamp

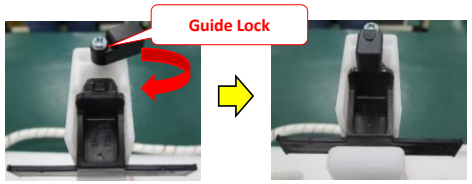
	WORK INSTRUCTION			Effectivity Date:	July 31, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 900B/ 910B / 7N0072-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-677	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 6

PARTS:	1.Clamp 82711-52090 (W) [4pcs] 2.Clamp 82711-48070 (GR)	3. Clamp 82711-33380 (B) 4 .Black tape [5pcs]	5.Violet tape [2pcs]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	Clamp setting			



1. Get 1pc. of clamp **82711-33380 (W)** using right hand and set to clamp location **1** and **2** using both hands.



2. After setting of clamp **82711-33380 (B)**, hold the guide lock then lock using right hand.

3. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **4 and 5** using both hands.

4. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **6** and **7** using both hands.

5. Get 1pc. of clamp **82711-48070 (GR)** using right hand and set to clamp location **3** using both hands.

6. Initially attach **Violet Tape** to clamp location **1** and **2** using both hands.

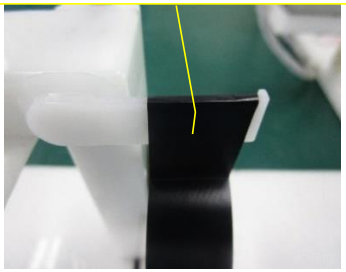
7. Initially attach **Black tape** to clamp location **3, 4, 5, 6 and 7** using both hands.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

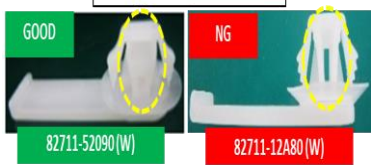
Important reminders/note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

One wind for under clamp



CLAMP ILLUSTRATION



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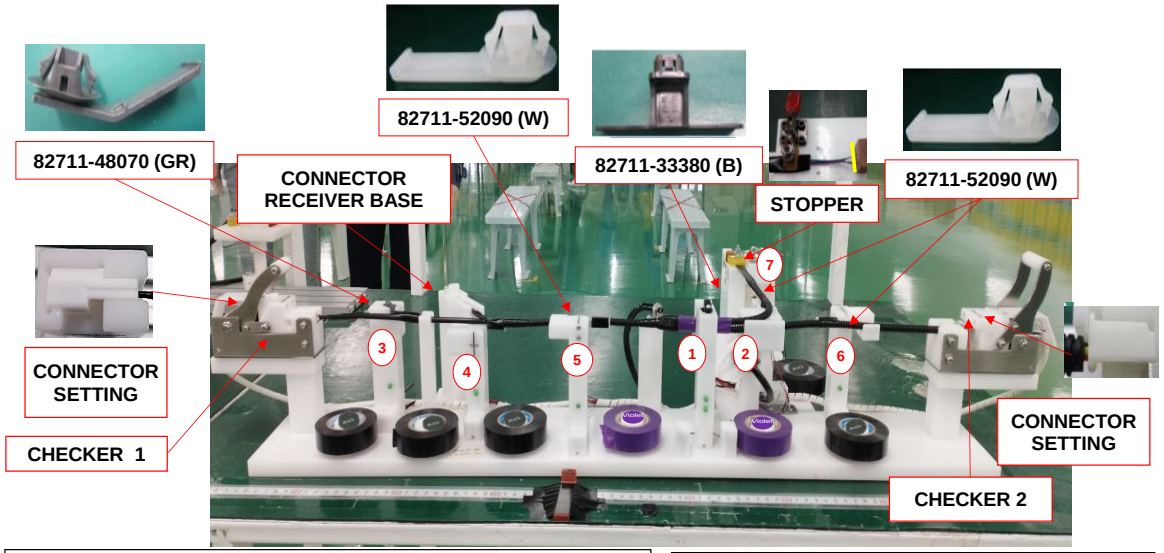
	WORK INSTRUCTION			Effectivity Date:	July 31, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 900B/ 910B / 7N0072-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-677	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page 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	 1. Put the assy into jig. ***(See above picture for the correct setting).*** First, set the connector **6098-3802 (W)** to **Checker 1.** Second, set the next connector **6098-3810 (W)** to **Connector receiver base**. Third, set the connector **6098-2220 (W)** to **Checker 2.** Continue to set the harness in jig. Last, set the **B-G-V wires** together within stopper then press by toggle clamp. 2. Hold the tape on clamp location **1,** make **3 windings** of tape then cut the tape using both hands. Continue to clamp location **2.** 3. Hold the tape on clamp location **2,** make **3 windings** of tape then cut the tape using both hands. Continue to clamp location **3.** 4. Hold the tape on clamp location **3,** make **3 windings** of tape then cut the tape using both hands. Continue to clamp location **4.**		 ***Important reminders/Note/s:*** *1. Make sure no gap between the terminal and stopper jig.* *2. Make 2-3 windings for clamp taping.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape

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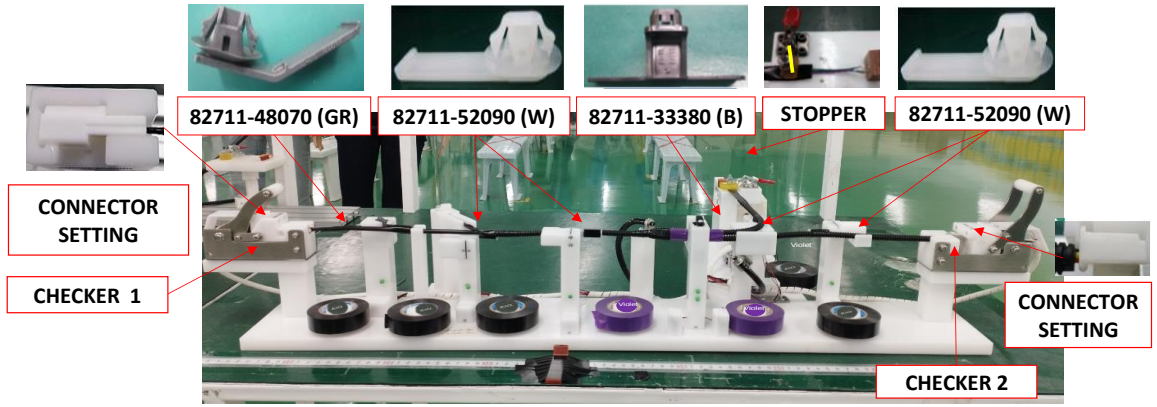
PARTS:	1. Assy parts			JIG:	1. Clamp assembly jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	Clamp assy	Clamp assembly (Continuation)			



5. Hold the tape on clamp location **4**, make **3 windings** of tape on combined **COT 1** and **COT 2** then cut the tape using both hands. Continue to clamp location **5.**

7. Hold the tape on clamp location **6,** make **3 windings** of tape then cut the tape using both hands.Continue to clamp location **7.**

6. Hold the tape on clamp location **5,** make **3 windings** of tape then cut the tape using both hands. Continue to clamp location **6.**

8. Hold the tape on clamp location **7,** make **3 windings** of tape then cut the tape using both hands.

9. Conduct **POINT CHECKING** before removing the harness from jig.

Important reminders/Note/s:

1. Make sure no gap between the terminal and stopper jig.

2. Make 2-3 windings for clamp taping.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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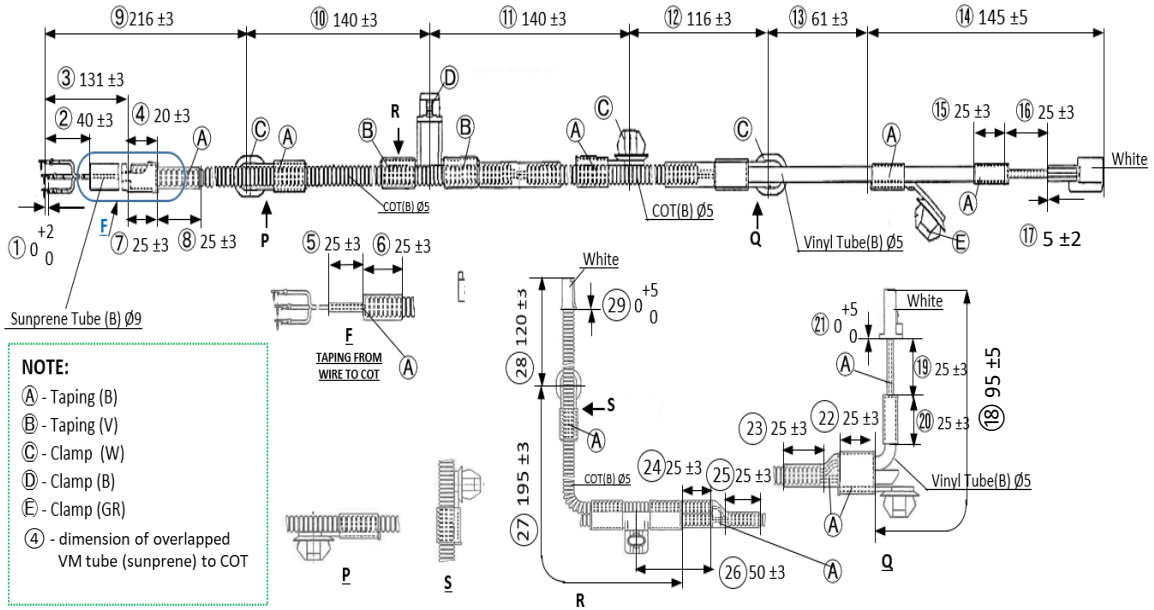
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 6

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp assy	Measurement		MEASURING TAPE	***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* 1. No wrong dimension

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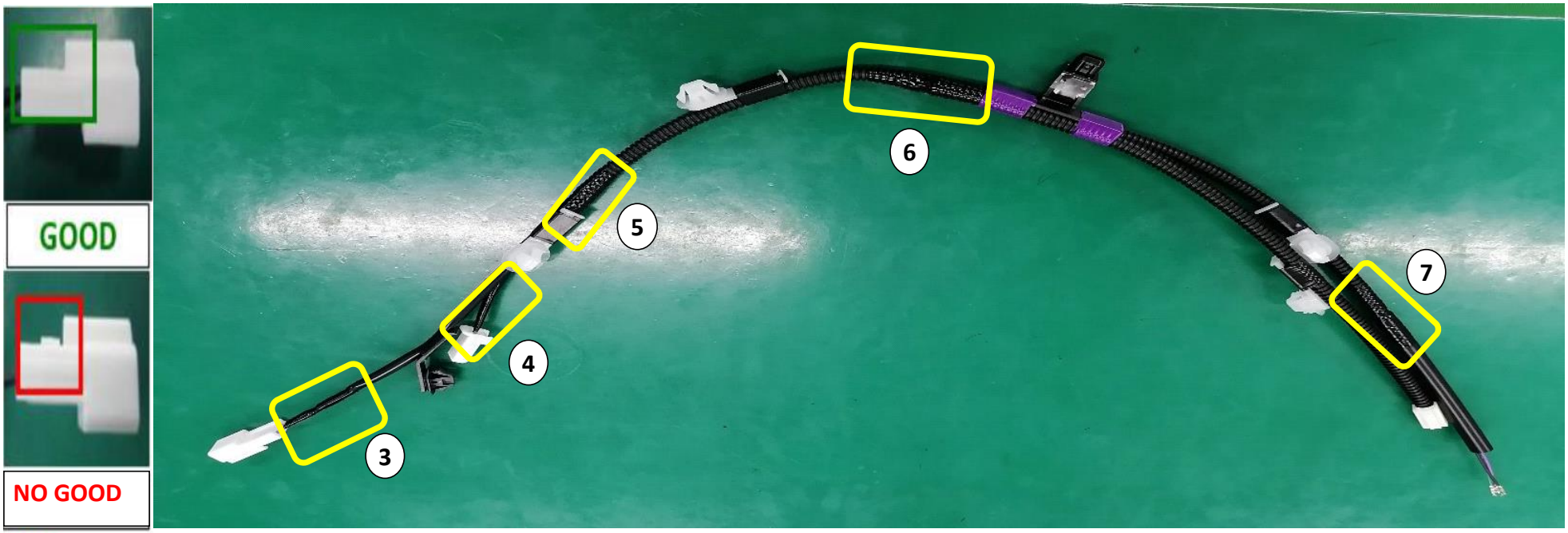
PARTS:	1. Assy parts	JIG:	n/a

1 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

CLAMP ASSY	**7N0072-7020C**



1 No Wrong facing of clamp

2 No Unlock/Halflock connector

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

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