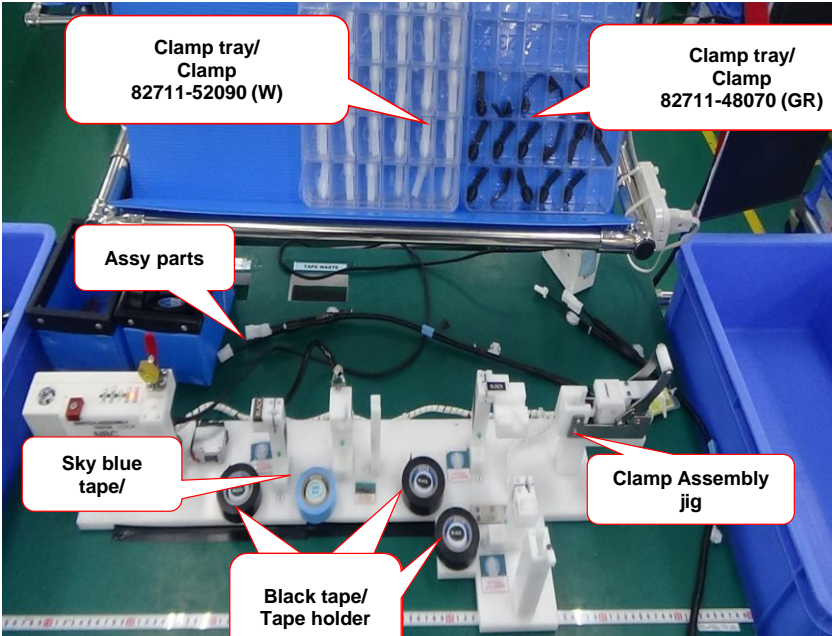




	WORK INSTRUCTION					Effectivity Date:		October 21, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS					Validity Date:		n/a	
	Model code/Part number: 900B.910B / 7N0104-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX		Document No.:		WI-ENG-PDE-1138	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		1	Page No.:


PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [3pcs.]; Sky Blue tape				JIG:		1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	CLAMP ASSY	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>Document reference/s:</div> <p>1. Refer to WI-ENG-PDE-1137A-C for Taping assembly process</p> <div>CLAMP ILLUSTRATION</div> 	

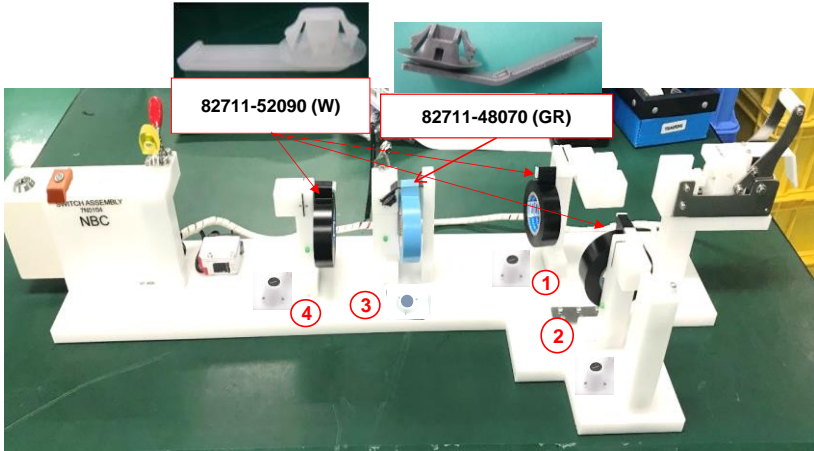
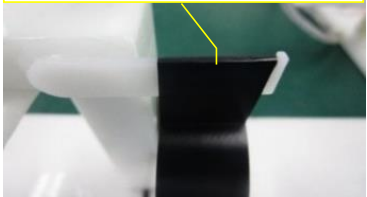
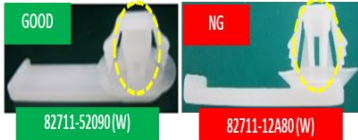
Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/21/24	1	Change from Pre-launch to Masspro.				 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/17/24	0	Initial issue.							
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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

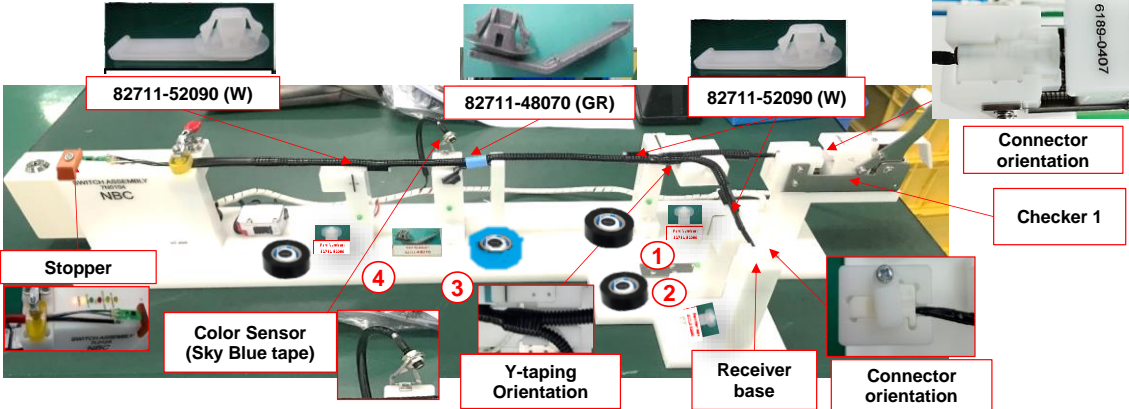

PARTS:	1.Clamp 82711-52090(W) [3pcs] 2.Clamp 82711-48070 (GR) 3. Black tape [3pcs.] 4. Sky Blue tape			JIG:	1. Clamp assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	CLAMP ASSY	<div></div> <div>1. Get the clamp 82711-52090 (W) using right hand and put to location 1 and 2 using both hands.</div> <div>2. Get the clamp 82711-52090 (W) using right hand and put to location 4 using both hands.</div> <div>3. Get the clamp 82711-48070 (W) using right hand and put to location 3 using both hands.</div> <div>4. Initially attach Sky blue tape to location 3 using both hands.</div> <div>5. Initially attach Black tape to location 1, 2 and 4 using both hands.</div>			n/a	<div>One wind for under tape</div>  <div>Important reminders/Note/s:</div> <div>1. Check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>CLAMP ILLUSTRATION</div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>

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	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	<div></div> <div>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6189-0407 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the Y-taping into Y-taping guide. Third, set the connector 6098-3810 (W) to Receiver base then lock. Continue to set the harness in jig. Last, set the hotmelted wires and terminal end together within the stopper then press by Toggle clamp.</div> <div>2. Check if all LED light for Power On and Clamp On was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process. Check if the sequence light of location 1 was ON.</div> <div>3. Hold the tape on clamp location 1. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 2 was ON.</div> <div>4. Hold the tape on clamp location 2. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Continue the process if sequence light in clamp location 3 was ON.</div>				<div>Important reminders/Note/s:</div> <div>1. Make sure no gap between stopper jig and PCB.</div> <div>2. Make 2-3 windings for Clamp taping.</div> <div>1. No damaged clamp</div> <div>2. No wrong usage of parts</div> <div>3. No missing clamp</div> <div>4. No missing tape</div> <div></div>	

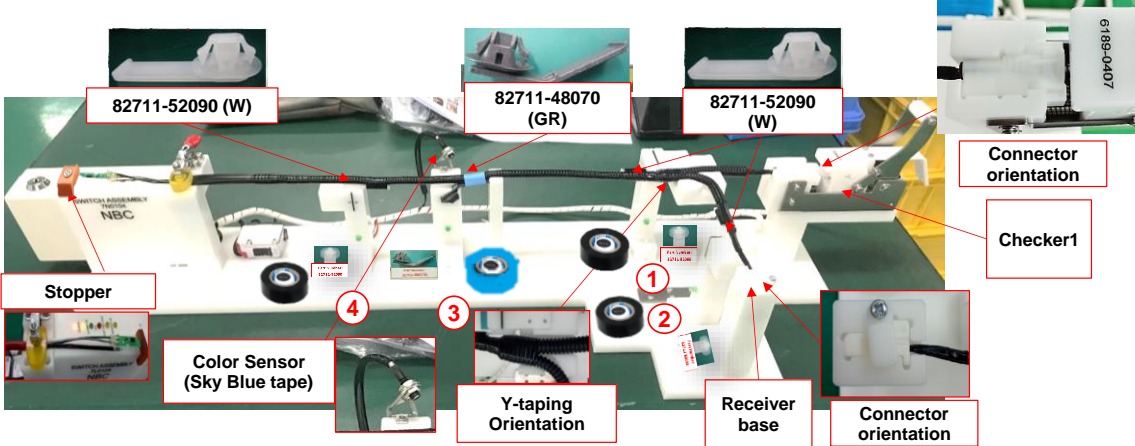


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 6

PARTS:	1. Assy parts. 2. Black tape [3pcs] 3. Sky Blue tape			JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	CLAMP ASSY	Clamp Assembly (Continuation)			
<div></div> <div><p>5. Hold the Sky blue tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Clamp assembly jig will beep/buzz if color sensor detects Sky blue tape. Press the SW button after taping. Continue the process if sequence light in clamp location 4 was ON.</p><p>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. GO sound will be heard.</p><p>7. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p><p>8. For removal of harness from jig. First, remove the toggle clamp up to Checker 1 and Connector Receiver base. Last, remove the harness to Y-taping guide.</p></div> <div><p>Important reminders/Note/s:</p><p>1. Make sure no gap between stopper jig and PCB 2. Make 2-3 windings for clamp tapinf</p><p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape</p><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></div>					

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**WORK INSTRUCTION**

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CLAMP ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

900B.910B / 7N0104-7020C

Customer:

TRJ

Car Model:

LEXUS-NX/RX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 6

PARTS:

1. Assy parts

JIG:

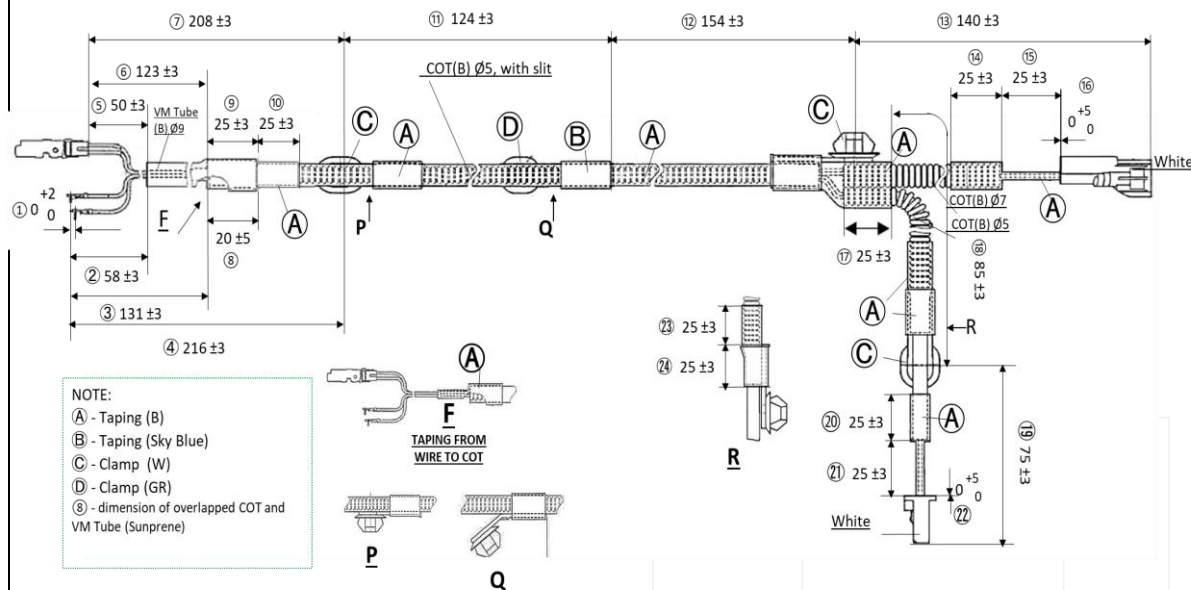
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

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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Document No.:

WI-ENG-PDE-1138

Purpose:

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Revision No.:

1

Page No.:

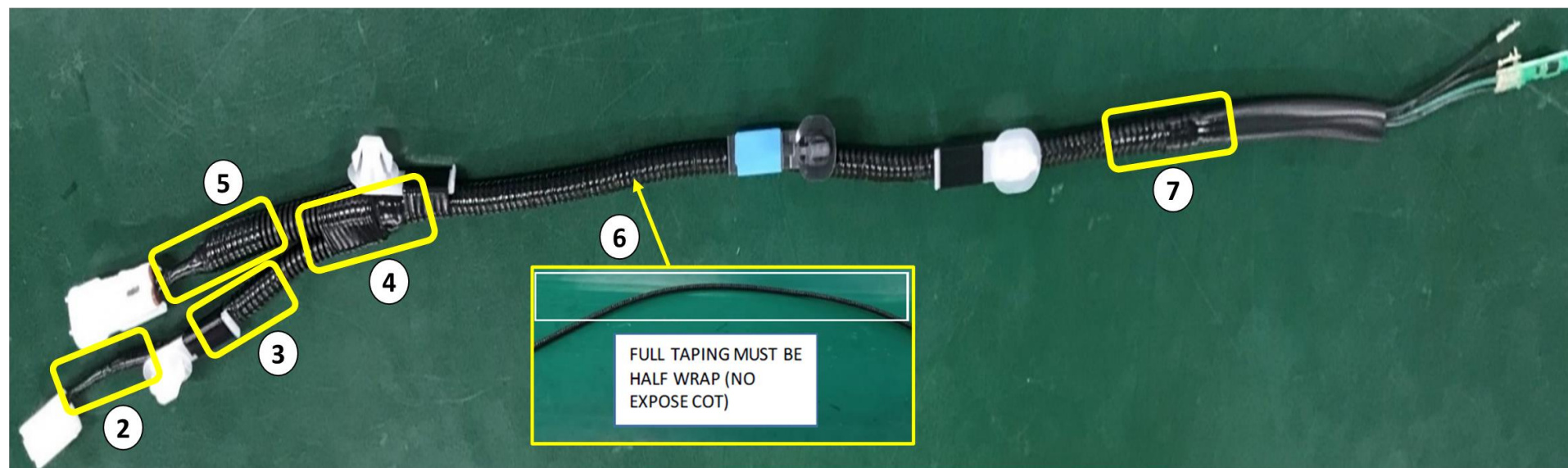
6 of 6

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7N0104-7020C****1 No Wrong facing of clamp****2 3 4 5 6 7 No Missing Tape (Black tape)**

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