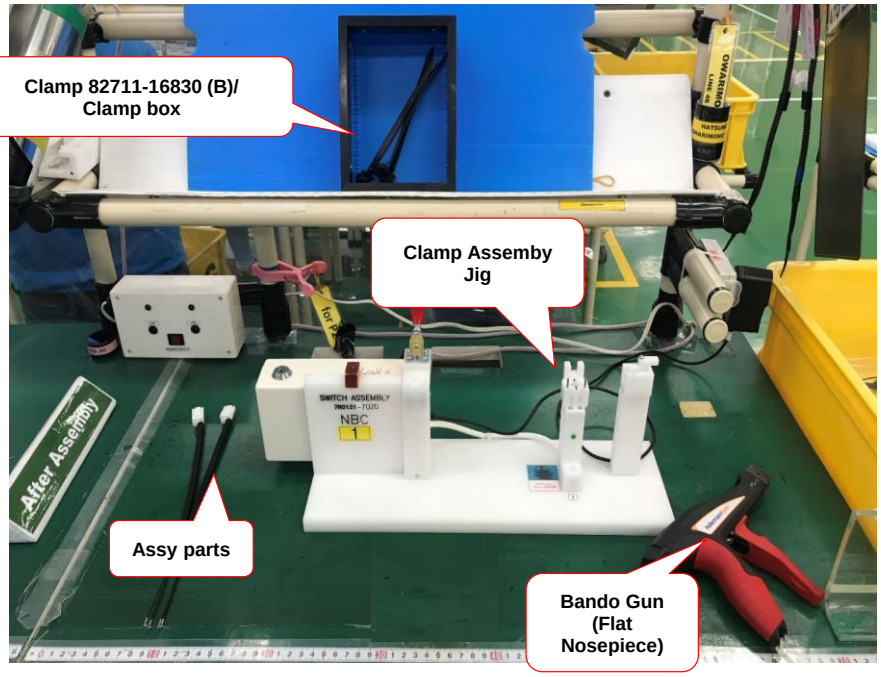
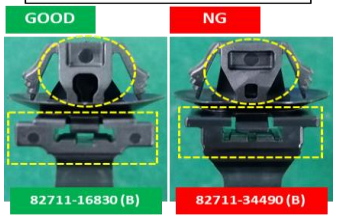
	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0131-7021	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-775		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	1 of 6

PARTS:	1. All parts: Assy parts; Clamp 82711-16830 (B)	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. **BANDO GUN** FLAT NOSEPIECE	1. No missing parts/tools 2. No excess parts/tools ***Document references:*** ***1. Refer to WI-ENG-PDE-592 Taping Assembly Process*** BAND CLAMP ILLUSTRATION 

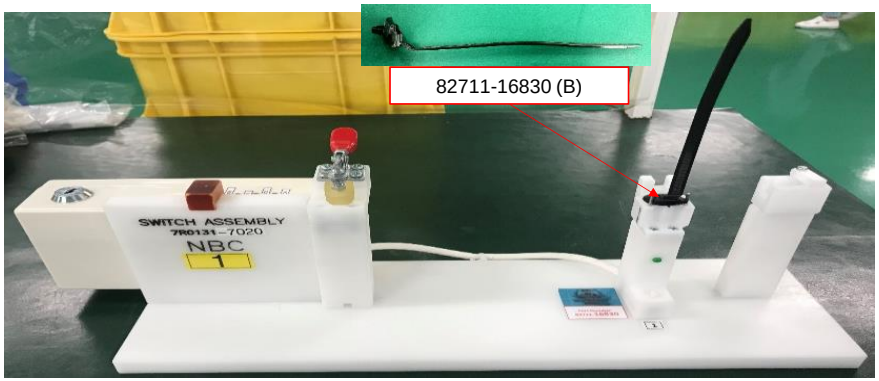
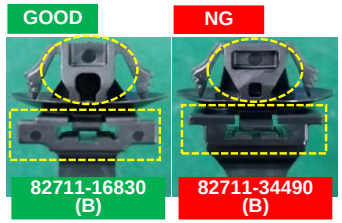
Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.Transfer Clamp setting to Measurement process from Taping assembly process (WI-ENG-PDE-592) due to process improvement.	D.Castillo	C.Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 11, 2024		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0131-7021	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-775		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	2 of 6

PARTS:	1. Clamp 82711-16830 (B)			JIG:	1. Clamp Assembly Jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	Clamp Assy	Clamp Setting	 1. Get 1pc of band clamp **82711-16830 (B)** then attach to clamp location ①.	N/A	1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp **BAND CLAMP ILLUSTRATION** 

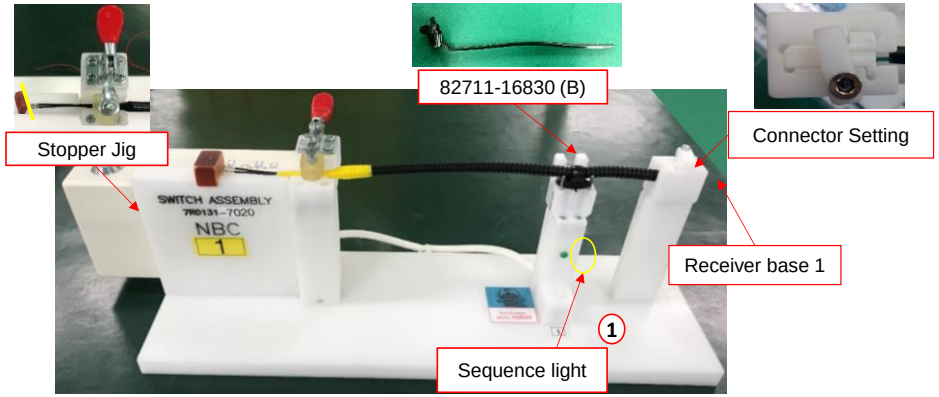
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0131-7021	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-775		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	3 of 6

PARTS:	1. Assy part 2. Clamp 82711-16830 (B)	JIG:	1. Clamp Assembly Jig

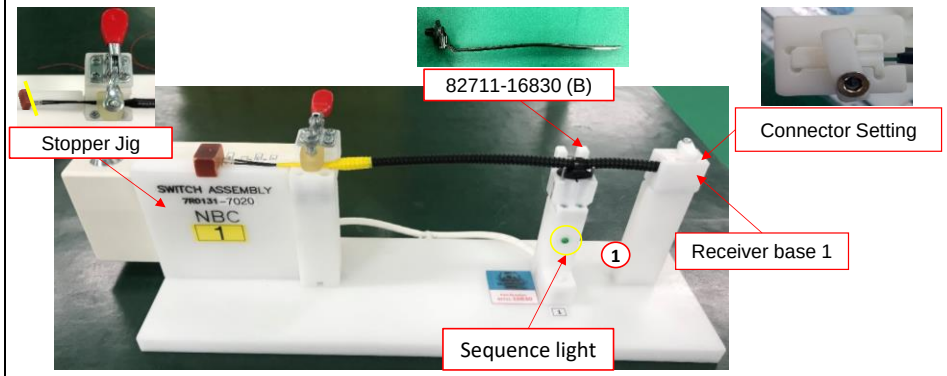
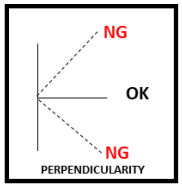
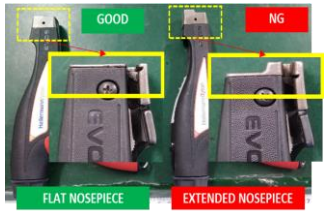
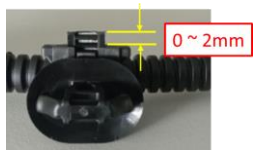
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly	 1.Get the assy parts and set into jig. *(See above picture for correct setting).* First, set the connector **6098-3810(W)** to **Receiver base 1**. Continue to set the harness then last, set the **B-B wires** together within the stopper then press by **Toggle clamp**. Continue if the sequence light of **location** ① was on. 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 and continue the process. 3. Initially tighten the band clamp on **location 1** using both hands.	N/A	1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun ***Important reminders/note/s:*** *1. Make sue no gap between stopper jig and terminal.*

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0131-7021	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-775		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.:	4 of 6

PARTS:	1. Assy part 2. Clamp 82711-16830 (B)			JIG:	1. Clamp Assembly Jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	Clamp Assy	Clamp Assembly (Continuation)	 4. Get the bando gun using right hand then cut the band clamp on Location ①. Press the **SW button** after cutting. **GO** sound will be heard . 5. Conduct **POINT CHECKING** before removing the harness from jig. **Fixed setting of band clamp cutter: 1~ 2** **BANDO GUN ALIGNMENT** 	**BANDO GUN** **FLAT NOSEPIECE**	1. No wrong setting of clamp 2. No wrong use of clamp 3. No Loose attachment of clamp 4. No wrong setting of Bando gun ***Important reminders/note/s:*** *1. Make sue no gap between stopper jig and terminal.* **BANDO GUN ILLUSTRATION**  ***Important reminders/Note/s:*** *1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).* 

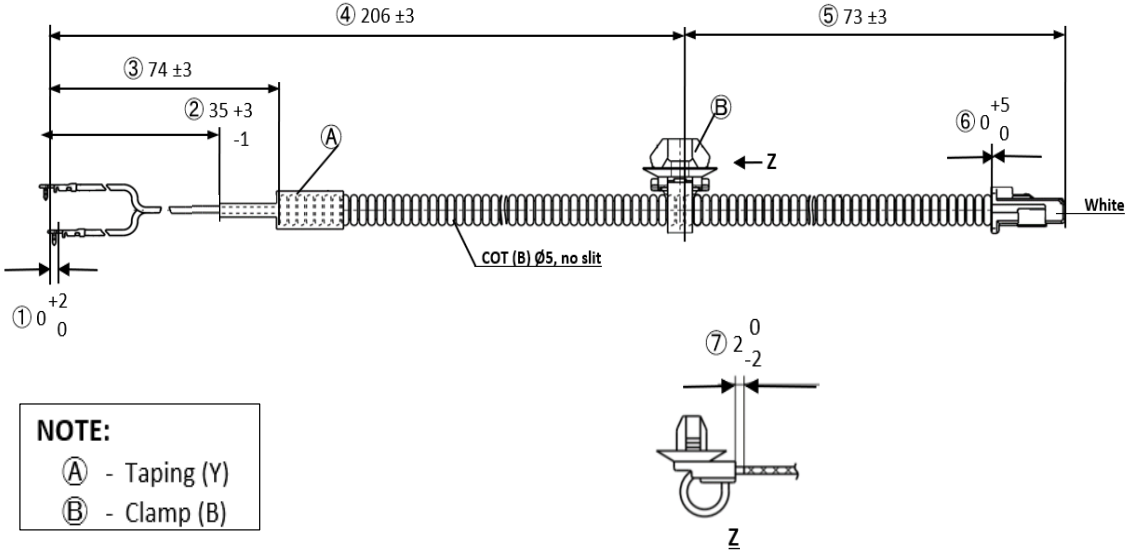
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	June 11, 2024
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	200D/220D / 7R0131-7021	Customer: TRMX / Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-775
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0
				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		MEASURING TAPE	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*

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

PARTS:	n/a	JIG:	n/a

VISUAL INSPECTION

CLAMP ASSY	7R0131-7021

1 **No Loose clamp**

2 **No NG cut**

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp