

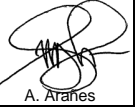
	WORK INSTRUCTION CLAMP ASSEMBLY PROCESS				Effectivity Date:	September 13, 2024	
	Process Name/Title:				Validity Date:	n/a	
	Model code/Part number: 922B / 7L0123-7022A		Customer: TRQSS	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-1043	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.: 1 of 6

PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [5pcs]		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Clamp Assy	<div> <div>Table Lay-out</div> <div> <div>Clamp 82711-52090 (W)/ Clamp Tray</div> <div>Clamp 82711-48070 (GR)/ Clamp Tray</div> <div>Assy parts</div> <div>Black tape holder/ Black tape</div> <div>Assembly jig</div> </div> </div>		<div> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-ENG-PDE-429A-C for Taping assembly process 1. No missing parts/tools 2. No excess parts/tools <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>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
09/13/24	1	Change pre launch to mass pro.	A.Hernandez	C. Villanueva	A. Arañes	n/a	 A. Hernandez	 C. Villanueva	 A. Arañes	n/a	
09/10/24	0	Initial issue. Separate clamp assembly from Taping assembly jig	A.Hernandez	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change				Revised					Reviewed
								Est. Date:	September 10, 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.	<div> NBC (Philippines) MASTER COPY </div>	DCC Stamp



WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Process Name/Title:

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1043

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 6

PARTS:

1. Clamp 82711-48070 (GR) [2pcs.]
2. Clamp 82711-52090 (W) [3pcs.]

3. Black tape [5pcs.]

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

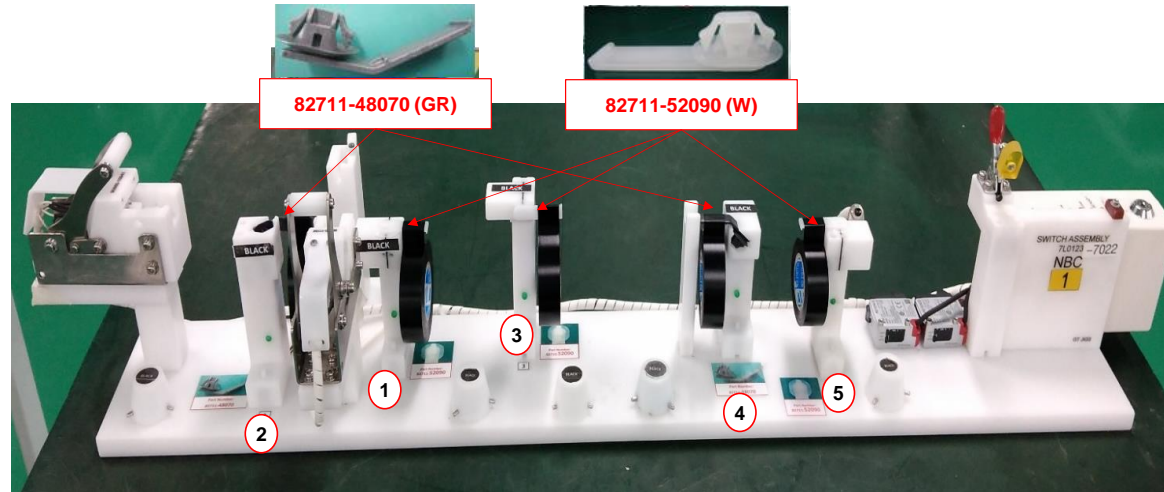
TOOLS/PPE

QUALITY POINTERS

2

Clamp
Assy

Clamp setting



1. Get **3pcs.** of clamp **82711-52090 (W)** using right hand then set to clamp location **1, 3 and 5** using both hands.

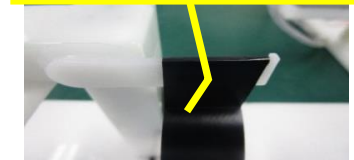
2. Get **2pcs.** of clamp **82711-48070 (GR)** using right hand then set to clamp location **2 and 4** using both hands.

3. Initially attach Black tape to clamp location **1, 2, 3, 4 and 5** using both hands.

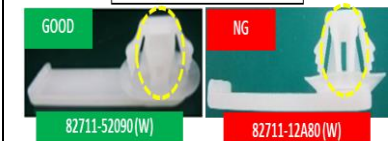
Important reminders/Note/s:
1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

STANDARD TAPING FOR CLAMP

One wind for under tape



CLAMP ILLUSTRATION



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

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

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Validity Date:

n/a

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Document No.:

WI-ENG-PDE-1043

Purpose:

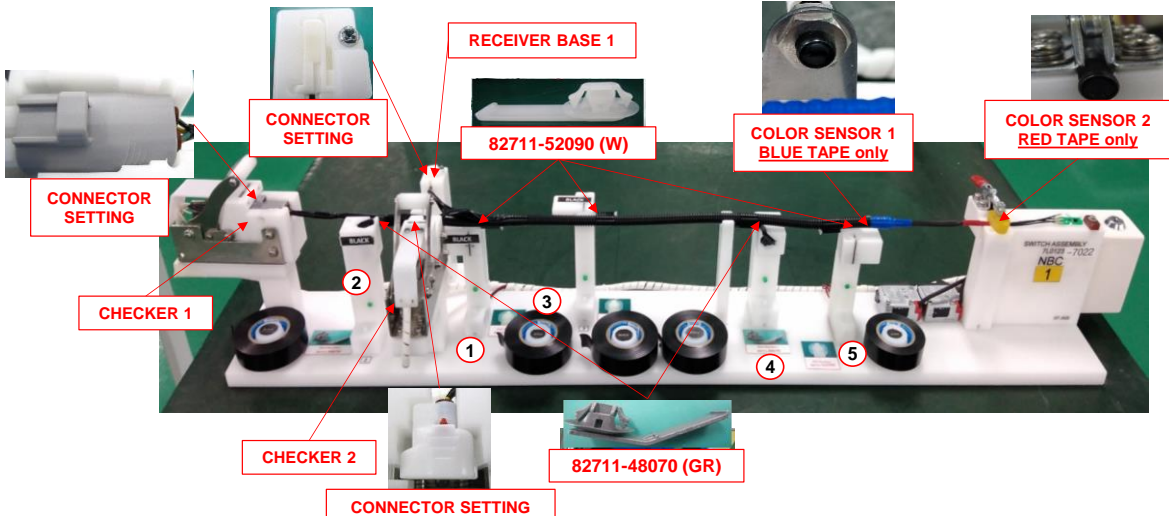



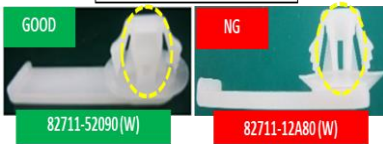
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 6

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	 <p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Third, set the connector 6098-3810 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor 1 will beep/buzz if sensor detects Blue tape. Color sensor 2 will beep/buzz if sensor detects Red tape. Last, set the hotmelted wires and terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of location 1</p> <p>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p> <p>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.</p> <p>Note: Follow the correct arrangement of SV tubes before taping.</p>  		 <p>Important reminders/note/s:</p> <p>1. Make sure no gap between stopper jig and terminals.</p> <p>2. Make 2-3 windings for clamp taping</p> <p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape 5. No loose attachment of clamp</p> <p>CLAMP ILLUSTRATION</p> 	

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

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1043

Revision No.:

1

Page No.:

4 of 6

PARTS:	1. Assy parts 2. Black tape		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy Clamp Assembly (Continuation)	<p>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.</p> <p>5. Hold the tape on clamp location 3. 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 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. Continue the process if sequence light in clamp location 5 was ON.</p> <p>7. Hold the tape on clamp location 5. 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>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p>	<p>Important reminders/note/s:</p> <p>1. Make sure no gap between stopper jig and terminals.</p> <p>2. Make 2-3 windings for clamp taping</p> <p>1. No damaged clamp 2. No wrong usage of parts 3. No missing clamp 4. No missing tape 5. No loose attachment of clamp</p> <p>CLAMP ILLUSTRATION</p> <p>GOOD NG</p> <p>82711-52090 (W) 82711-12A80 (W)</p>	

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**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1043

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	<div>Measurement</div> <div></div> <div><p>NOTE:</p><p>A - Taping (R)</p><p>B - Taping (L)</p><p>C - Taping (B)</p><p>D - Clamp (W)</p></div>	<div>MEASURING TAPE</div> <div></div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1043

Revision No.:

1

Page No.:

6 of 6**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0123-7022A****① No Wrong facing of clamp****② ③ ④ ⑤ No Missing Tape (Black**

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