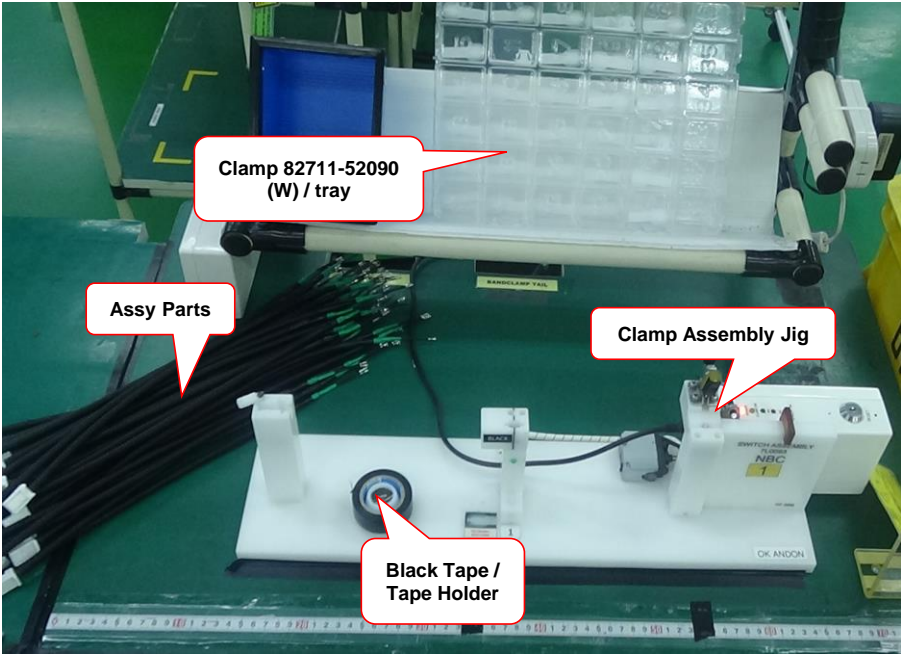


	WORK INSTRUCTION				Effectivity Date:		September 4, 2024	
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 707B / 7L0093-7021		Customer: TRQSS		Car Model: Lexus-ES (Hybrid)		Document No.: WI-ENG-PDE-934	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5


PARTS:		1. Assy parts: Clamp 82711-52090 (W); Black 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> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) <div>Safety Instruction</div> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) <div>Alert level</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.		<div>Document references:</div> 1. Refer to WI-ENG-PDE-218 for Taping assembly process <div>1. No missing parts/tools</div> <div>2. No excess parts/tools</div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-52090 (W)</div><div>NG</div><div>82711-12A80 (W)</div></div>	

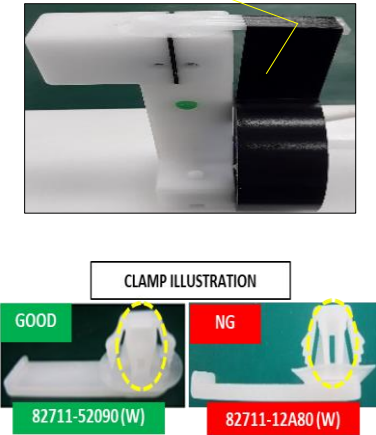
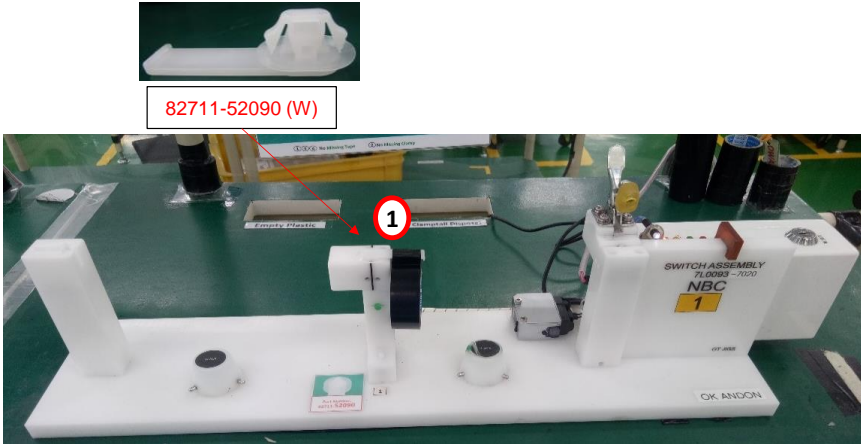
Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/04/24 0 Initial issue. Separate Clamp assy to Clamp assembly process.								D. Castillo		C. Villanueva		A. Arañes		n/a	
Eff. Date Rev. No Details of Change								Revised		Reviewed		Approved		Noted	
								Est. Date:		September 4, 2024					

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 5

PARTS:	1. Clamp 82711-52090 (W) 2. Black tape			JIG:	1. Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
2	CLAMP ASSY	Clamp setting		n/a	<div>1. No wrong use of clamp 2. No damaged clamp 3. No wrong use of tape 4. No missing tape</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>STANDARD TAPING FOR CLAMP</div> <div>One wind for under tape</div> <div></div> <div>GOOD 82711-52090 (W) NG 82711-12A80 (W)</div>		
		<div></div> <div>1. Get the clamp 82711-52090 (W) using right hand and set to location 1 using both hands.</div> <div>2. Get Black tape using right hand and conduct pre-taping on clamp using both hands.</div>					

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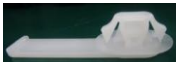

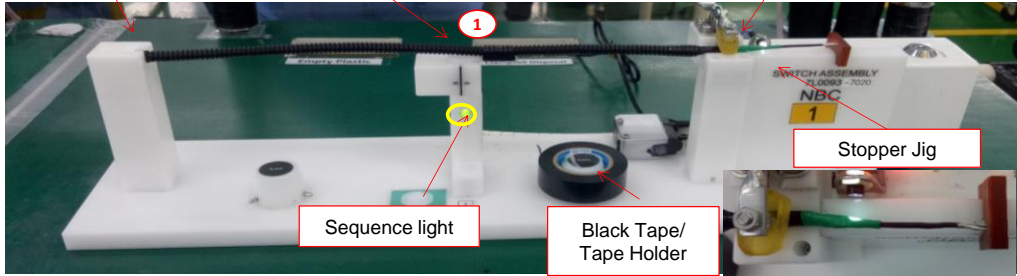




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	<div><div></div><div></div><div></div><div></div></div> <div><p>1. Get the assy parts (<i>see above picture for correct setting</i>) and then put it on jig using both hands. First, set the connector to receiver base then lock and set the B-B wires with terminal end together within the stopper then press by Toggle clamp. Continue if the sequence light in location 1 is ON. Note: Sequence light will ON if the color sensor detect the Green tape.</p></div> <div><p>2. Check if all LED light for POWER ON, CLAMP, and SENSOR was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><div></div><div><p>Color sensor light will on if tape was detected. Color tape: Green tape</p></div></div> <div><p>3. Hold the tape on clamp location 1 the start taping (3 winds) using both hands. Press the switch button after taping. GO buzzer will be heard.</p></div> <div><p>4. Conduct POINT CHECKING before removing the harness from jig</p></div>			<div></div> <p>Important reminders/Note/s:</p> <p>1. Make sure no gap between stopper and terminals</p> <p>2. Make 2-3 windings for clamp taping.</p> <ol style="list-style-type: none">1. No wrong use of tape2. No loose tape3. No flip-out tape4. No peel-off tape5. No missing tape6. No wrong dimension <div><div><div>CLAMP ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div></div><div><div>NG</div><div></div><div>82711-12A80 (W)</div></div></div></div></div>

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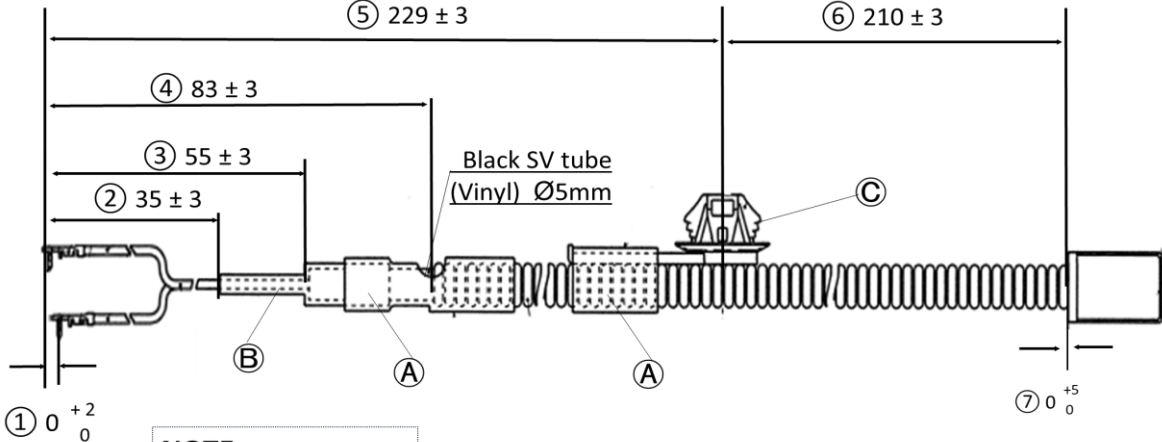
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	CLAMP ASSY	<div><div>MEASURING TAPE</div></div> <div><div>NOTE: A - Taping (B) B - Taping (G) C - Clamp (W)</div></div>		<p>Important reminders 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 <i>WI-PRO-ASY-056</i> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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PARTS:

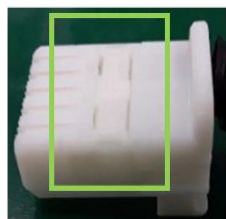
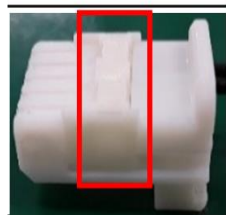
1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**CLAMP ASSY****7L0093-7021**

①

**GOOD****NO GOOD**

②

① No Unlocked/ Halflock Connector

② No Missing Tape (Black Tape)

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