
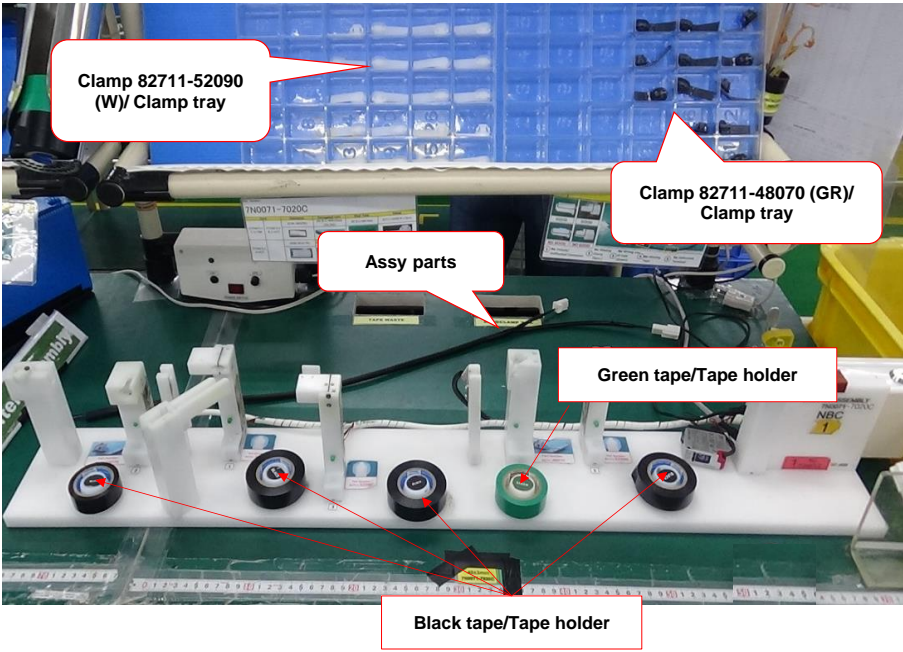


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|---|---|--|----------------------|-------------------------------|-------------------|-----------------------|-----------|---------------|
|  | WORK INSTRUCTION | | | | Effectivity Date: | June 3, 2024 | | |
| | Process Name/Title: CLAMP ASSEMBLY PROCESS | | | | Validity Date: | n/a | | |
| | Model code/Part number: 800B/900B/910B / 7N0071-7020C | | Customer: TRJ | Car Model: LEXUS-NX/RX | Document No.: | WI-ENG-PDE-805 | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | 0 | Page No.: | 1 of 6 |

| | | | | | |
|---------------|---------------------|---|--|---|--|
| PARTS: | | 1. Assy parts: Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [4pcs.]; Green tape [1pc.] | | JIG: | 1. Clamp assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 1 | Clamp Assy | <div style="text-align: center;"> TABLE LAY-OUT </div>  | | <div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> | Document references: 1. Refer to WI-ENG-PDE-456A-C for Taping Assembly Process 1. No missing parts/tools 2. No excess parts/tools |

| | | | | | | | | | | | |
|------------------|---------|-------------------|--|--|--|-------------|---------------|-------------|-------------|-------------------------|----------|
| Revision History | | | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
| 06/03/24 | 0 | Initial issue. | | | | D. Castillo | C. Villanueva | A. Arañes | n/a | n/a | |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted | Est. Date: June 3, 2024 | |

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CLAMP ASSEMBLY PROCESS

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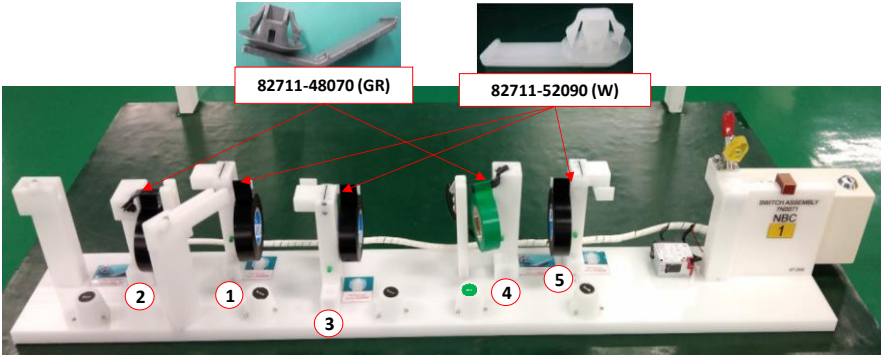
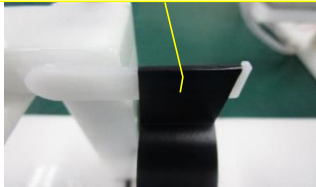


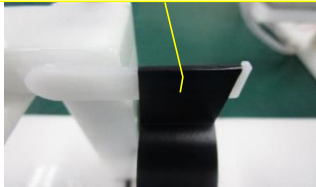


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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|--------|--------------|---|--|--|--|-----------|---|
| PARTS: | | 1. Clamp 82711-52090 (W) [3pcs.] 2. Clamp 82711-48070 (GR) [2pcs.] | | 3. Black tape [4pcs.] 4. Green tape | | JIG: | 1. Clamp assembly jig |
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 2 | Clamp Assy | Clamp Setting | <div><div></div><div>1. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 1 and 3 using both hands.</div><div>2. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 5 using both hands.</div><div>3. Get 2pcs. of clamp 82711-48070 (GR) using right hand and set to clamp location 2 and 4 using both hands.</div><div>4. Initially attach Green tape to clamp location 4 using both hands.</div><div>5. Initially attach Black tape to clamp location 1, 2, 3, and 5 using both hands.</div></div> <td>n/a</td> <td><div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</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><div>Important reminders/Note/s:</div><div>1. <i>Please check the Clamp first before start of assembly to avoid wrong use of clamp.</i></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div><div>ING</div><div></div><div>82711-12A80 (W)</div></div></div></div></td> | | | n/a | <div><div>STANDARD TAPING FOR CLAMP</div><div>One wind for under tape</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><div>Important reminders/Note/s:</div><div>1. <i>Please check the Clamp first before start of assembly to avoid wrong use of clamp.</i></div><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-52090 (W)</div><div>ING</div><div></div><div>82711-12A80 (W)</div></div></div></div> |

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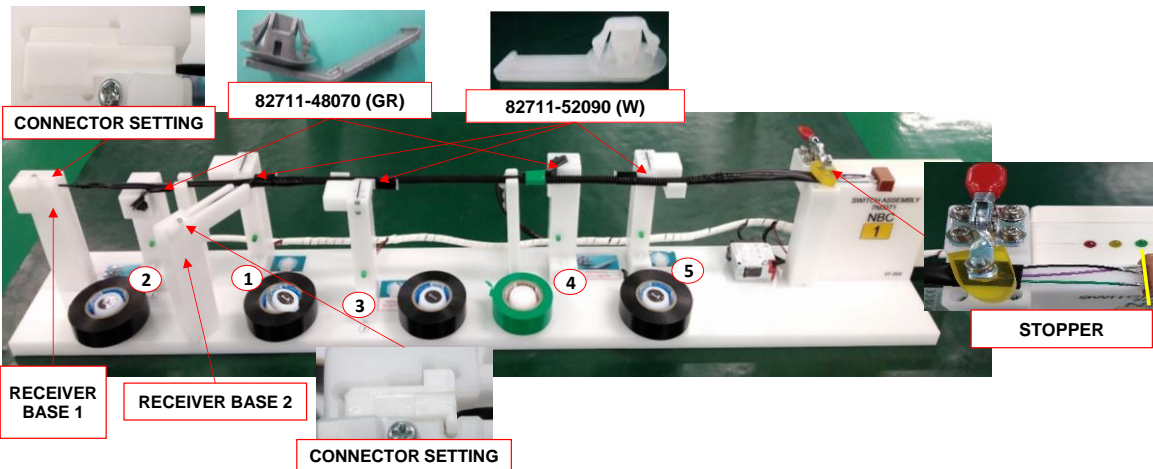
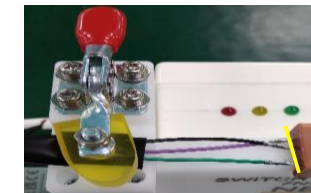
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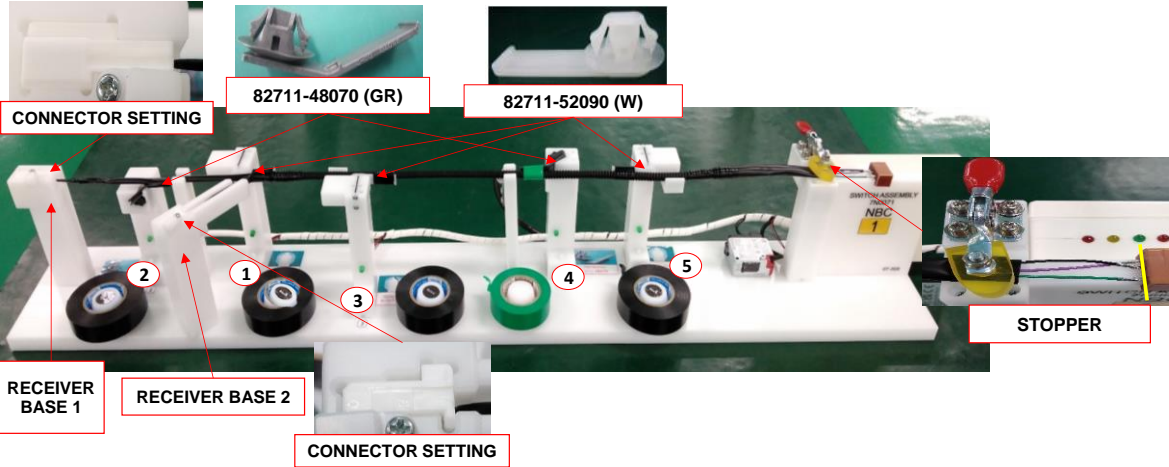
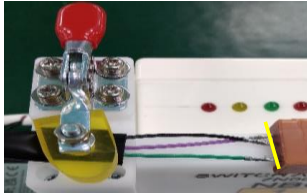
| | | | | |
|--------|---------------|------------------------------|---|---|
| PARTS: | 1. Assy parts | | JIG: | 1. Clamp assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 3 | Clamp Assy | Clamp Assembly | <div></div> | <div> Important reminders/Note/s: <i>1. Make sure no gap between stopper and terminals</i> <i>2. Make 2-3 windings for clamp taping</i></div> <div><div>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 6098-3802 (W) to Receiver Base 1 then lock. Continue to set the harness in jig. Set the terminal end within the stopper then press by Toggle clamp. Last, set the connector 6098-3810 (W) to Receiver base 2 then lock. Continue if the sequence light on clamp location 1 was ON.</div><div>2. Check if all LED light for POWER ON, WIRE1 and WIRE2, CLAMP ON, SENSOR was ON. Check also if clamp location ① sequence light is ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</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>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.</div></div> |

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| | CLAMP ASSEMBLY PROCESS | | | | Validity Date: | n/a | | | | | |
| | Process Name/Title: | | Model code/Part number: 800B/900B/910B / 7N0071-7020C | | Customer: TRJ | Car Model: LEXUS-NX-RX | | Document No.: | WI-ENG-PDE-805 | | |
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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 | <div><div><div>6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Color sensor will beep/buzz if sensor detects Green tape. Press the SW button after r taping. ntinue the process if sequence light in clamp location 5 was ON.</div><div>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.</div><div>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div></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><p>1. No wrong use of parts</p><p>2. No wrong use of tape</p><p>3. No damaged clamp</p><p>4. No wrong clamp position</p></div> | | |

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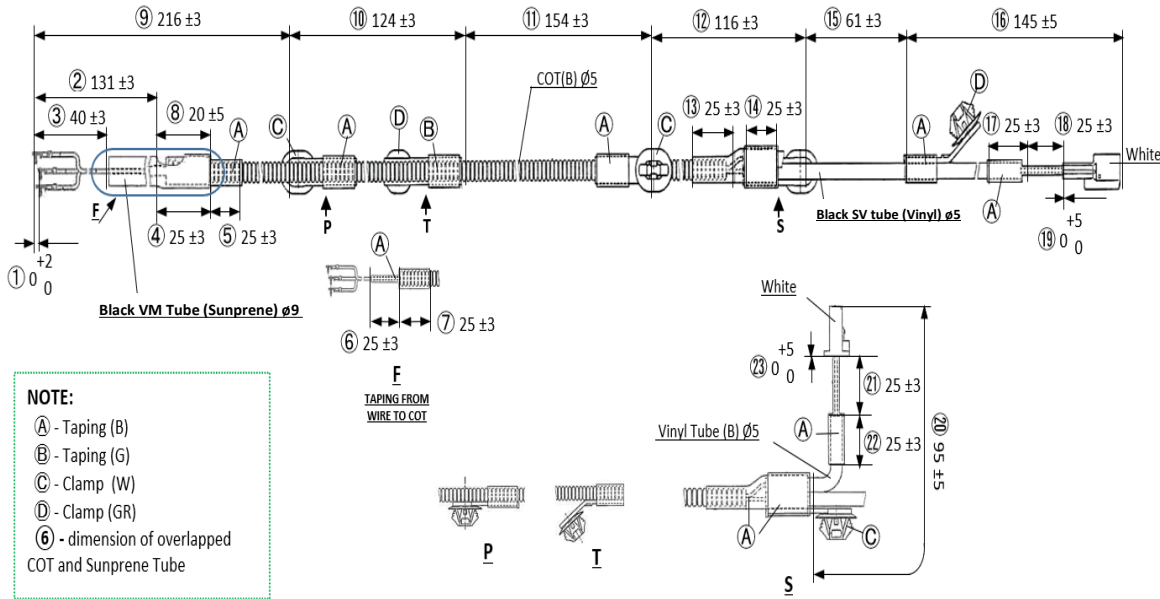

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| PARTS: | | 1. Assy parts | | JIG: | n/a |
|--------|--------------|------------------------------|---|--|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Clamp Assy | Measurement | <div><p>MEASURING TAPE</p></div>  <div><p>NOTE:</p><ul style="list-style-type: none">A - Taping (B)B - Taping (G)C - Clamp (W)D - Clamp (GR)6 - dimension of overlapped COT and Sunprene Tube</div> | <p>MEASURING TAPE</p>  | <p>Important reminders and note/s:</p> <ol style="list-style-type: none">Please use calibrated/verified measuring tape when getting the measurement.For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p> |

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PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS

CLAMP
ASSY

7N0071-7020C

①



GOOD

②



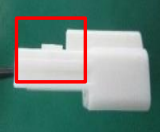
GOOD

③



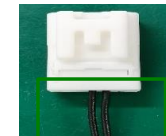
NO GOOD

④

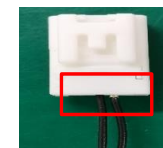


NO GOOD

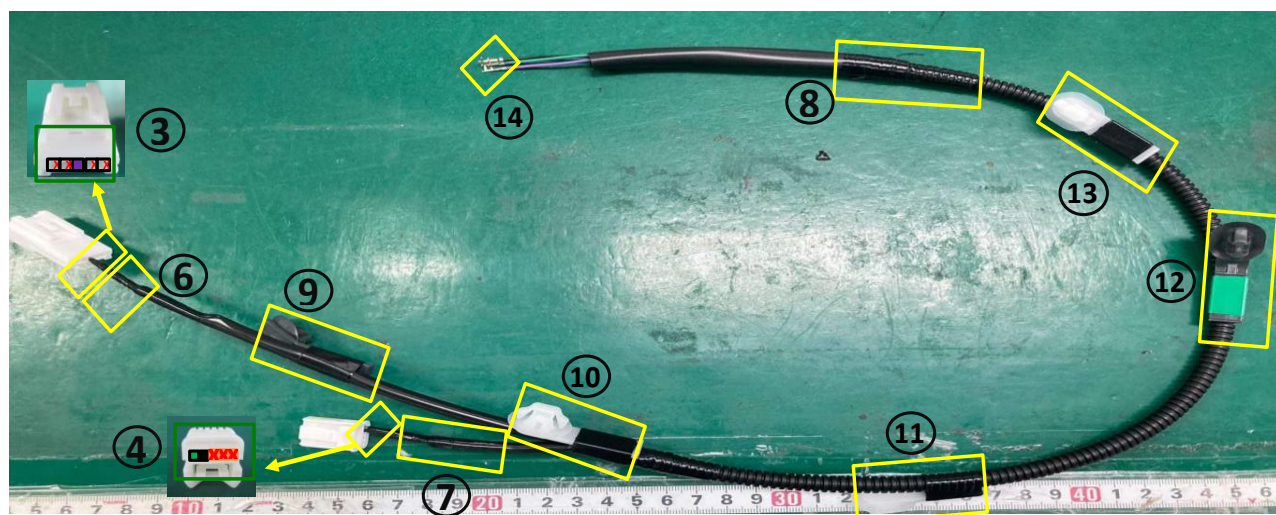
⑤



GOOD



NO GOOD



①② No Unlock/Halflocked Connector

③④ No Wrong insert

⑤ No Terminal Backing Out

⑥⑦⑧ No Missing Tape
⑨⑩⑪⑫⑬ No Missing Clamp
⑭ No Deform Terminal

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