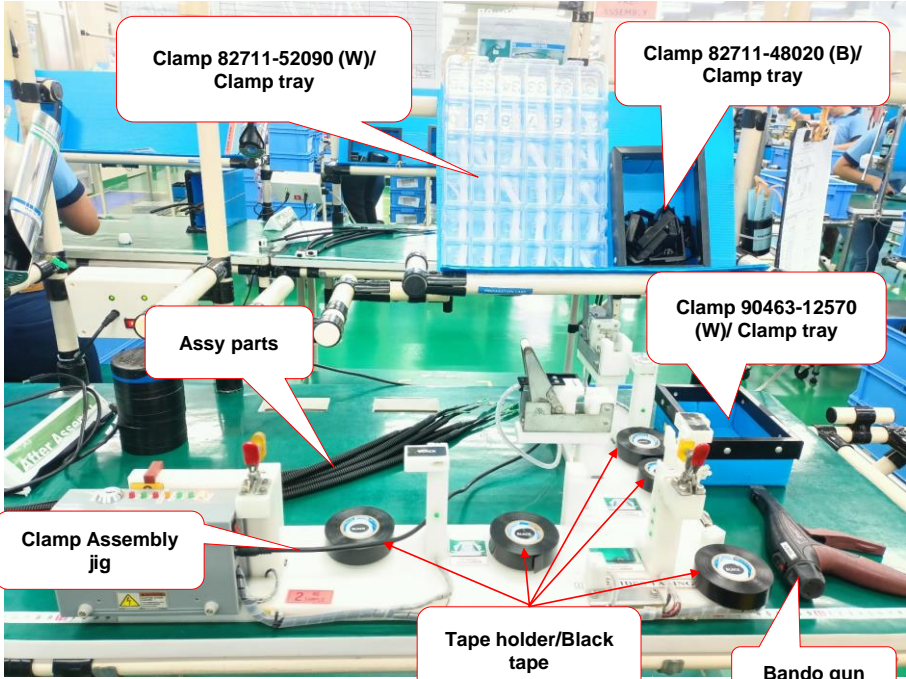

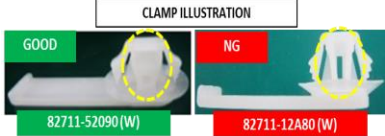
	WORK INSTRUCTION				Effectivity Date:	April 20, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 420/440 / A7446C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:	WI-ENG-PDE-873		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 6


PARTS:		1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48020 (B); Clamp 90463-12570 (W); 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> <div> Safety Instruction Be sure to wear prescribed 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> <div> BANDO GUN  </div> </div>	<div> 1. No missing parts/tools 2. No excess part/tools Important reminders/Note/s: 1. Please check the clamp before start of assembly to avoid wrong use of clamp </div> <div> <div>CLAMP ILLUSTRATION</div>  </div>	

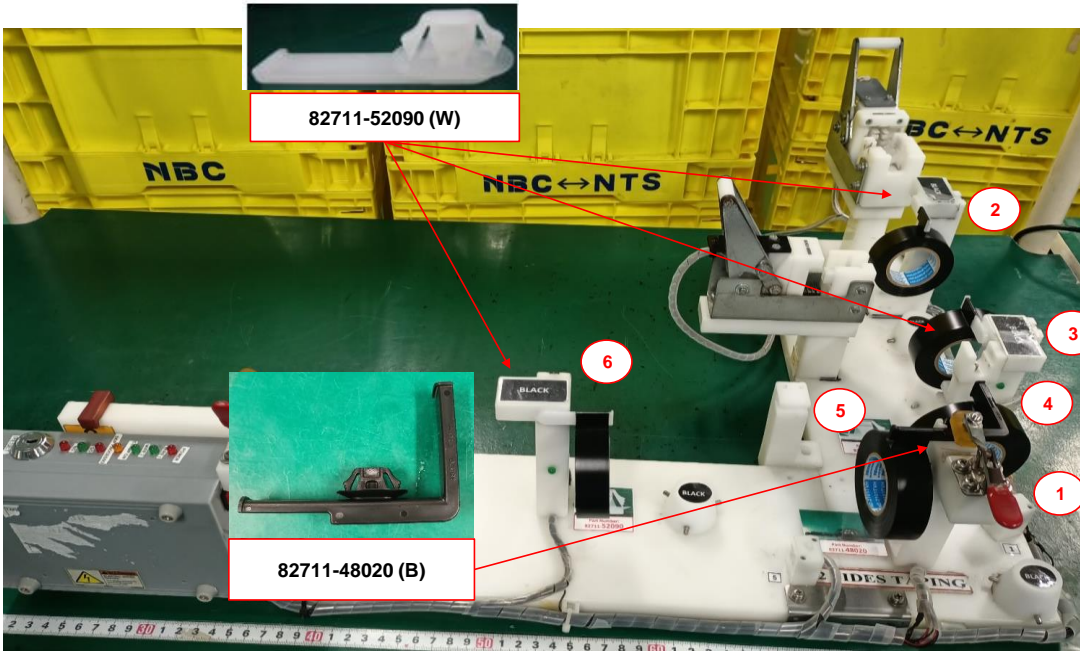
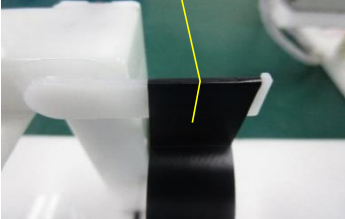
Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/20/24	1	Change from Pre-launch to Masspro. Inclusion of table lay-out. Update Visual inspection.				D.Castillo	C. Villanueva	A. Arañes	n/a		
04/16/24	0	Initial Issue.				D.Castillo	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	April 20, 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:	April 20, 2024				
	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 420/440 / A7446C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER		Document No.:	WI-ENG-PDE-873	
	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 82711-48020 (B)		3. Black tape [5pcs]	JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Clamp assy	<div></div> <div><div>1. Get 2 pcs. of clamp 82711-52090 (W) using both hands then insert to clamp location 2 and 3 using both hands.</div><div>2. Get 1pc. of clamp 82711-52090 (W) using both hands then insert to clamp location 6 using both hands.</div><div>3. Get 2pcs. of clamp 82711-48020 (B) using both hands then insert to clamp location 4 and 5 and press by toggle clamp using both hands.</div><div>4. Get the Black tape then initially attach to clamp location 2, 3, 4, 5 and 6 using both hands.</div></div>			<div><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p><p>Important reminders/Note/s: 1. Please check the clamp before start of assembly to avoid wrong use of clamp</p><div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div><div>NG</div><div>82711-12A80 (W)</div></div></div><div><div>One wind for under tape</div><div></div></div></div>

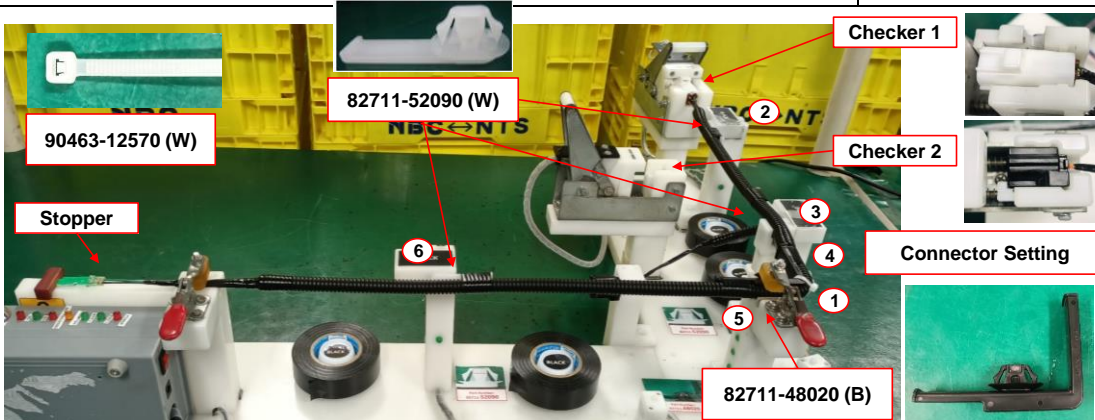
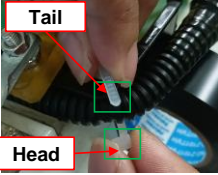
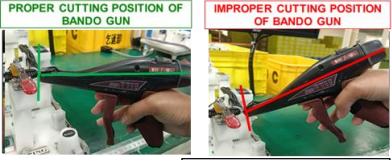

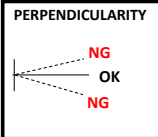
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	April 20, 2024				
	CLAMP ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 420/440 / A7446C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER		Document No.:	WI-ENG-PDE-873	
	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 2. Clamp 90463-12570 (W)			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. <i>(See above picture for correct setting of harness).</i> First, set the connector 6188-0093 (W) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-1161 (B) to Checker 2 then pull the checker fixture for continuity checking. Third, pull-up the toggle clamp and continue set the harness in jig. Last, set the PCB within the stopper then press by Toggle clamp. Continue if the sequence light of location 1 was ON.</div> <div>2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</div> <div><div>3. Get 1pc of band clamp 90463-12570 (W). Posotion to the center of black clamp and COT. Initially tighten the band clamp on clamp location 1 using both hands. Note: Follow the orientation of band clamp</div><div></div></div> <div><div>4. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue the process if sequence light on clamp location 2 was ON.</div><div></div></div> <div><div>5. Hold the tape in clamp location 2, make 2 windings of tape using both hands then cut the tape. Press the SW button after cut. Continue the process if sequence light on clamp location 3 was ON.</div><div></div></div> <div><div>BANDO GUN ALIGNMENT</div><div></div></div>						



2mm

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


Important reminder/Note/s:
1. Using steel rule, check if the band cut measurement is within the required dimension and should not lack and exceed the allowable range (2mm).

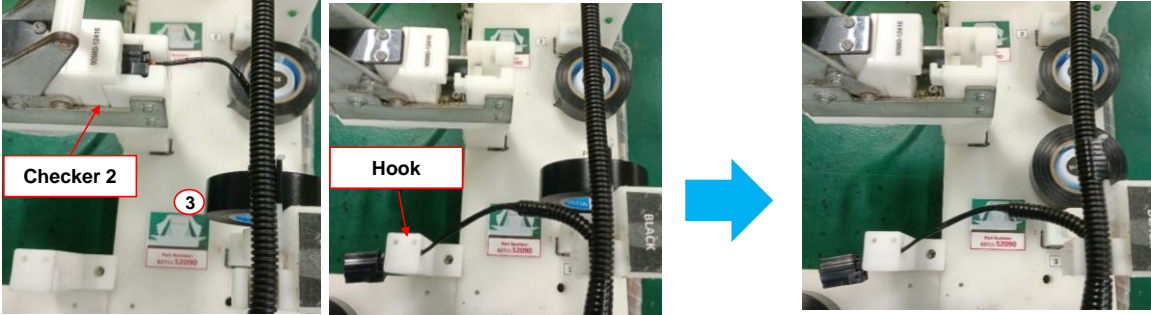
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	April 20, 2024		
	Process Name/Title: CLAMP ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 420/440 / A7446C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:	WI-ENG-PDE-873		
	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 [5pcs]			JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Clamp assy	Clamp assembly (Continuation)			
					
		6. Remove connector 6189-1161 (B) to checker 2 and set to hook .		7. Hold the tape in clamp location 3 , make 2 windings of tape using both hands then cut the tape. Press the SW button after cut. Continue the process if sequence light on clamp location 4 was ON .	
		8. 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 on clamp location 5 was ON .			
		9. 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. Continue the process if sequence light on clamp location 6 was ON .			
		10. Hold the tape on clamp location 6 , make 3 windings of tape then cut the tape using both hands. Press the SW button after taping. Go sound will be heard.			
		11. After taping, CONDUCT POINT CHECKING before removing the harness from jig.			
1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position					

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

NBC
cl
th
tu
31

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

April 20, 2024

Model code/Part number:

420/440**/ A7446C**

Customer:

TRQSS

Car Model:

TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-873

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 6

PARTS:

1. Assy parts

JIG:

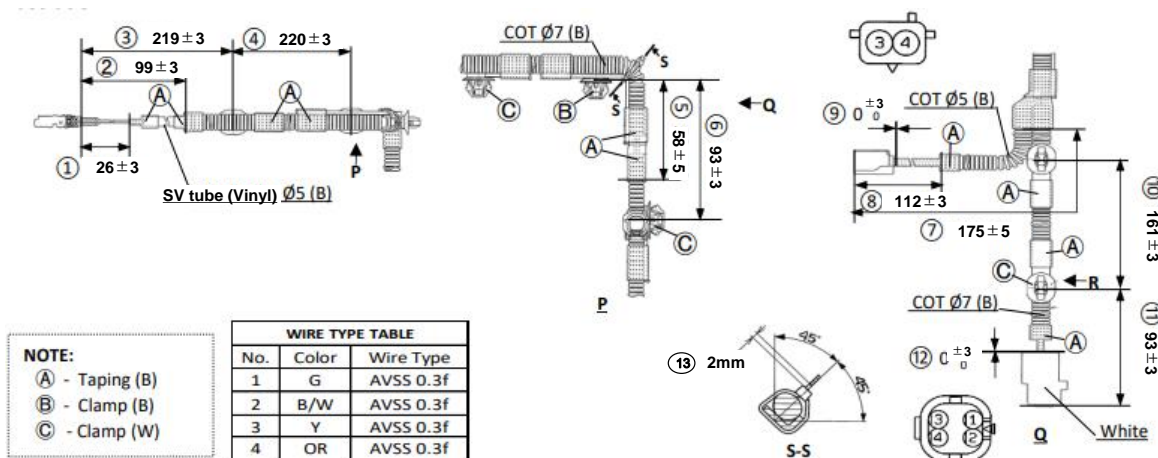
n/a

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

4

Clamp
assy

Measurement



**WORK INSTRUCTION**

Process Name/Title:

CLAMP ASSEMBLY PROCESS

Effectivity Date:

April 20, 2024

Validity Date:

n/a

Model code/Part number:

420/440 / A7446C

Customer:

TRQSS

Car Model:

TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-873

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

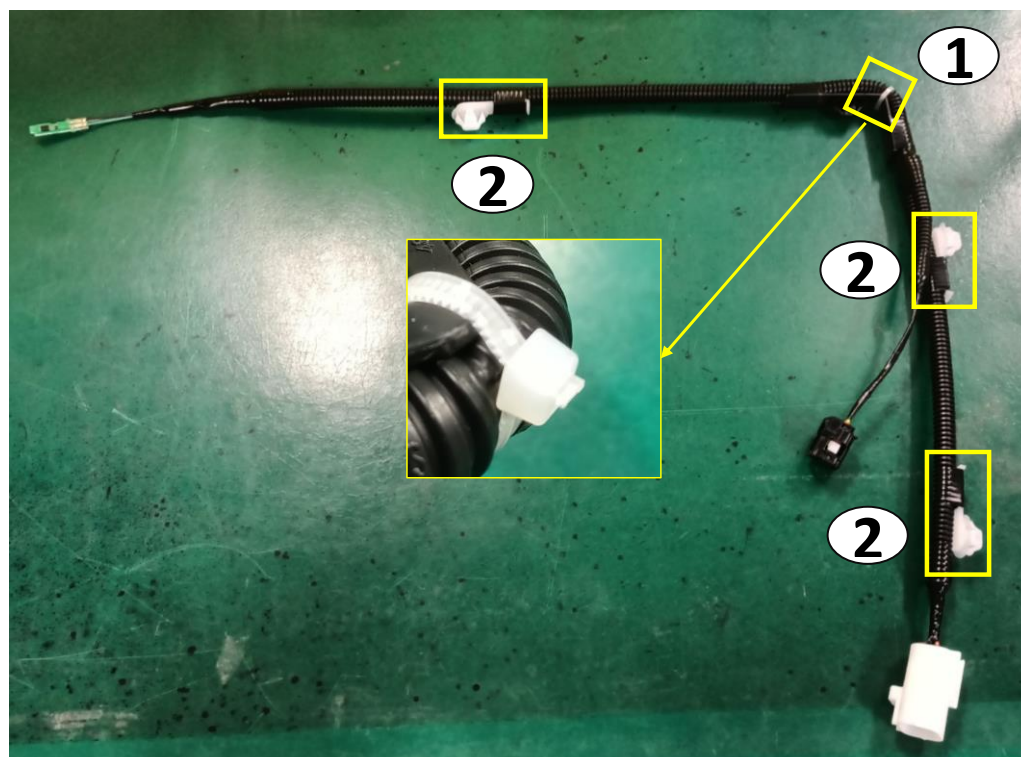
6 of 6

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****CLAMP ASSY****A7446C****CLAMP ILLUSTRATION****GOOD**

82711-52090 (W)

NG

82711-12A80 (W)

- ① No **Missing Band clamp**
- ② Check the **Band clamp facing**
- ③ Check the **clamp appearance**
- ④ No **Deformed terminal**
- ⑤ Check the **alignment**

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