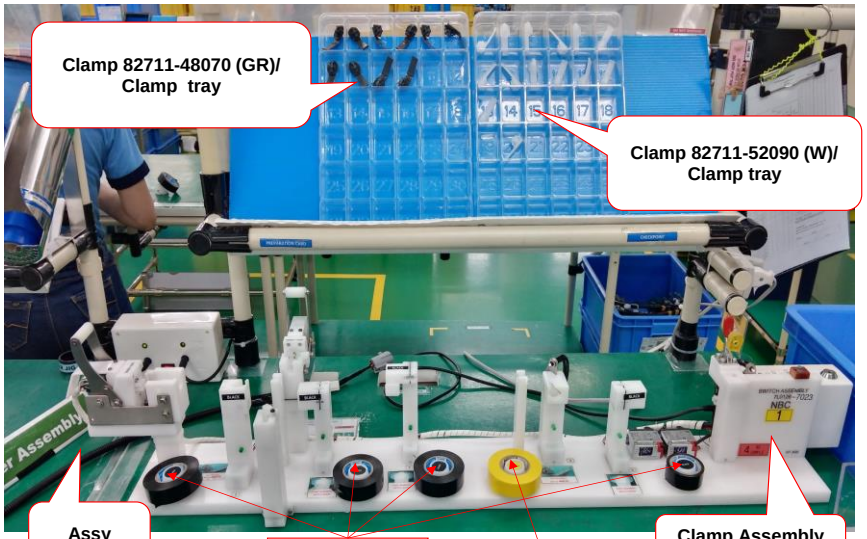
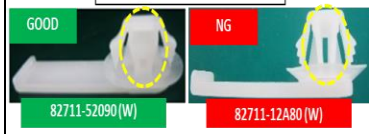
	WORK INSTRUCTION			Effectivity Date:	August 29, 2024	
	Process Name/Title:	CLAMP ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 910B / 7L0126-7023	Customer: TRQSS	Car Model: LEXUS-RX	Document No.:	WI-ENG-PDE-692	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 6

PARTS:	1. Assy parts; Clamp 82711-52090 (W); Clamp 82711-48070 (GR); Black tape [4pcs]; Yellow tape	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 required 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.	***Document reference/s:*** *1. Refer to WI-ENG-PDE-636A-C for Taping assembly process* 1. No missing parts/tools 2. No excess parts/tools CLAMP ILLUSTRATION 

Revision History							Prepared by	Reviewed by	Approved by	Noted by
08/29/24	1	Change process sequence of assembly jig due to jig improvement. Change connector setting sequence. Inclusion of car model "LEXUS-RX". Improved Measurment and Visual inspection/ Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a				
06/06/23	0	Initial issue. Change Part Name/Title from "TAPING ASSEMBLY PROCESS" to "CLAMP ASSEMBLY PROCESS"; Changed Document control number from WI-ENG-PDE-636D to WI-ENG-PDE-692; Improve Work procedure/Illustration on process (process no.3)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 06, 2023		

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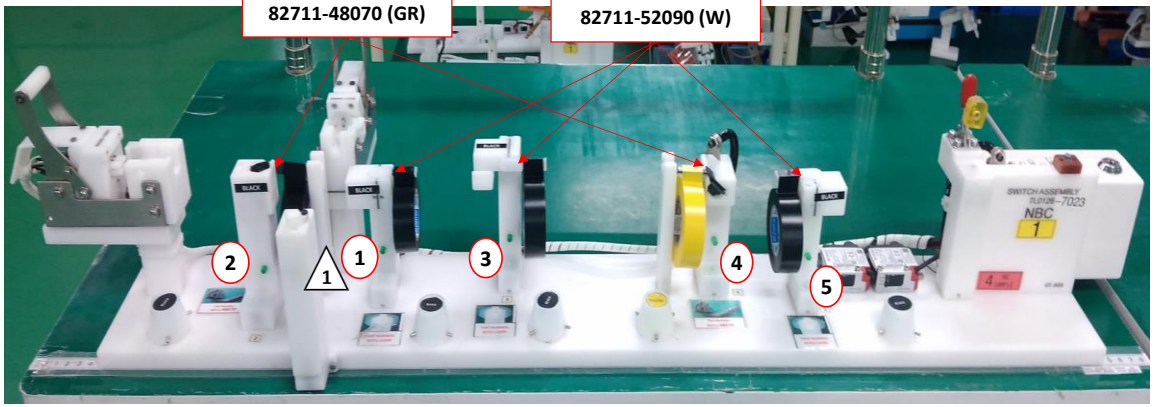
	Model code/Part number: 910B / 7L0126-7023	Customer: TRQSS	Car Model: LEXUS-RX	Document No.:	WI-ENG-PDE-692		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	2 of 6

PARTS:	1. Clamp 82711-48070 (GR) [2pcs.] 2. Clamp 82711-52090 (W) [3pcs.]	3. Black tape [4pcs.] 4. Yellow tape	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp Assy	Clamp setting			

82711-48070 (GR)

82711-52090 (W)



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

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

3. Initially attach **Yellow tape** to clamp location **4** using both hands.

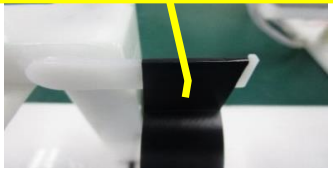
4. Initially attach **Black tape** to clamp location **1, 2, 3, and 5** using both hands.

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

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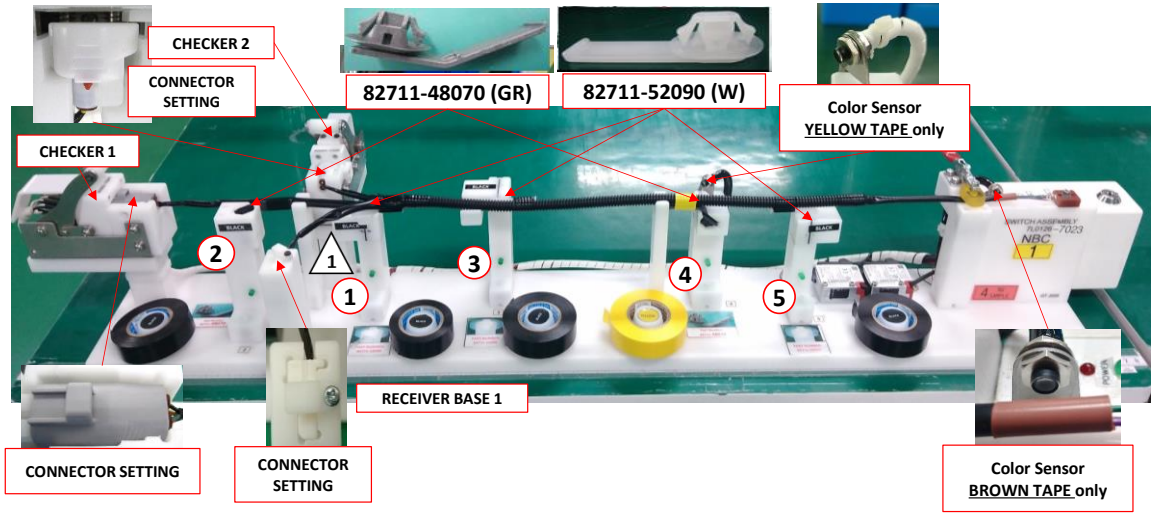
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	3 of 6

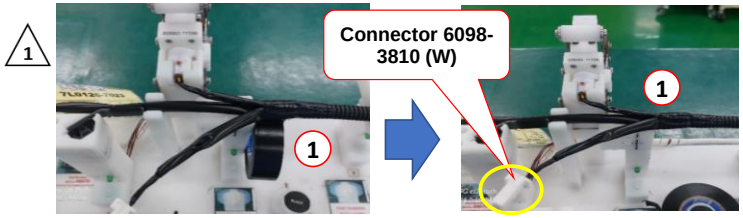
PARTS:	1. Assy parts 2. Black tape	JIG:	1. Clamp Assembly Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Clamp Assy	Clamp Assembly			

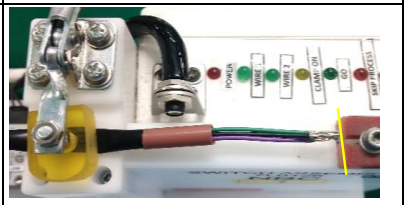


1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Continue to set the harness in jig. **Color sensor light** will beep/buzz if sensor detects **Brown tape.** Last, set the terminals end together within the stopper then press by **Toggle clamp**. Continue if the sequence light on clamp location **1** was ON.

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.



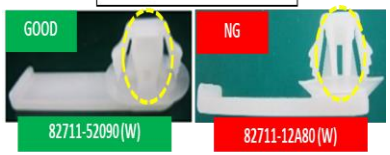
3. Hold the tape on clamp location **1.** Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping.
Note: SV tube (Vinyl) with connector 6098-3810 (W) should be not yet set in connector receiver base while taping.



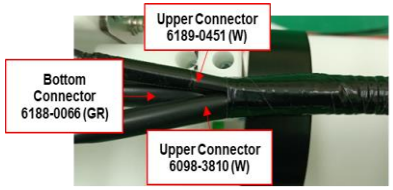
Important reminders/note/s:
1. Make sure no gap between stopper jig and terminals.
2. Make 2-3 windings for clamp taping

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape
5. No loose attachment of clamp

CLAMP ILLUSTRATION



CLAMP POSITION



Note: Follow the correct arrangement of SV tube (Vinyl) before taping.

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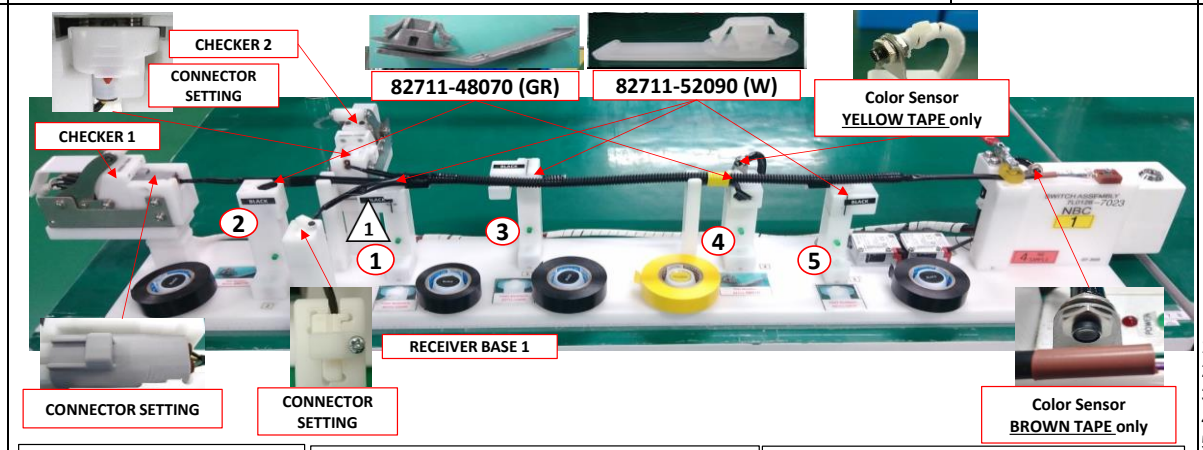
	Model code/Part number:	910B / 7L0126-7023	Customer: TRQSS / Car Model: LEXUS-RX	Document No.:	WI-ENG-PDE-692		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	4 of 6

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)			

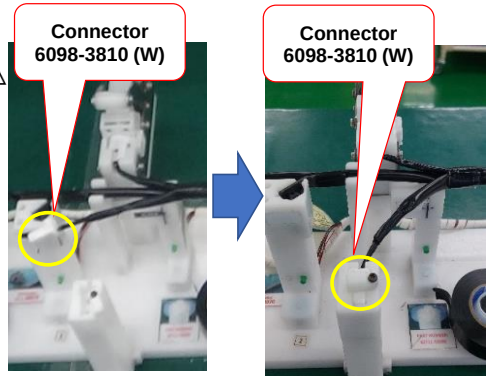


4. Set the connector **6098-3810 (W)** to **Receiver base** then lock. Continue the clamp taping process.

5. 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.**

6. 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.**

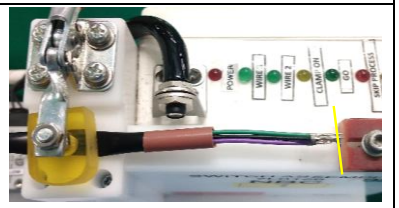
1



7. 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.**
Note: Color sensor will beep/buzz once the color sensor detect the Yellow tape.

8. 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.

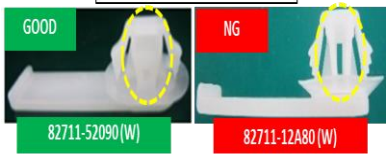
9. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



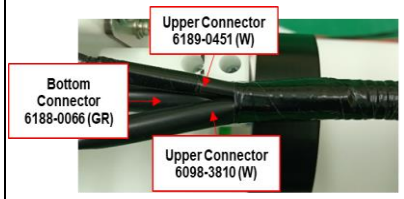
Important reminders/note/s:
1. Make sure no gap between stopper jig and terminals.
2. Make 2-3 windings for clamp taping

1. No damaged clamp
2. No wrong usage of parts
3. No missing clamp
4. No missing tape
5. No loose attachment of clamp

CLAMP ILLUSTRATION



CLAMP POSITION



Note: Follow the correct arrangement of SV tube (Vinyl) before taping.

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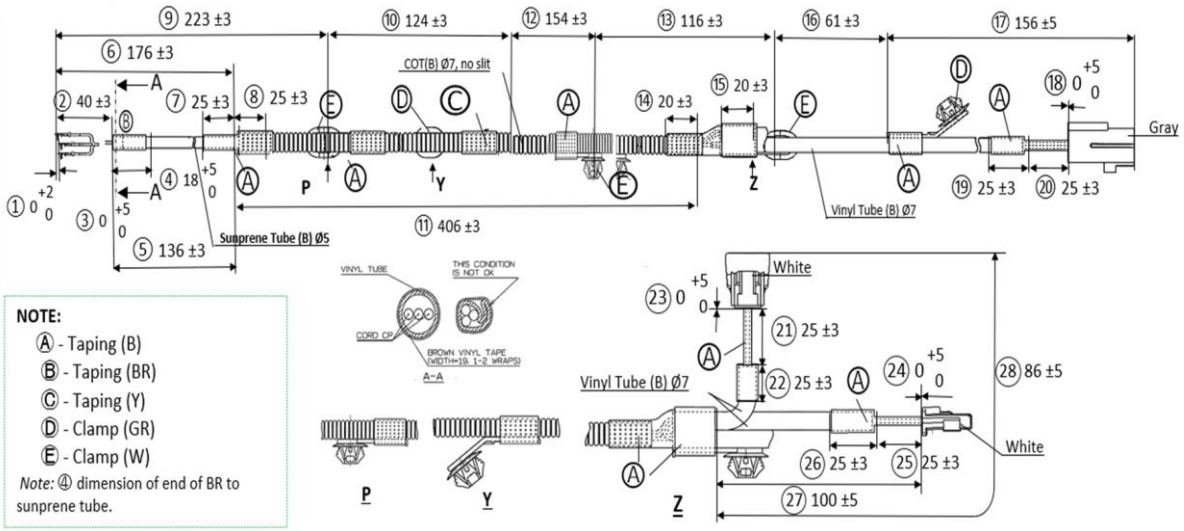
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	5 of 6

PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	Clamp Assy	Measurement		**MEASURING TAPE**	***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* 1. No wrong dimension

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PARTS:	1. Assy parts	JIG:	n/a

1 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

CLAMP ASSY	7L0126-7023

① No Wrong facing of clamp

②③④⑤⑥ No Missing Tape (Black tape)

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